

# BODY REPAIR MANUAL

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# Foreword

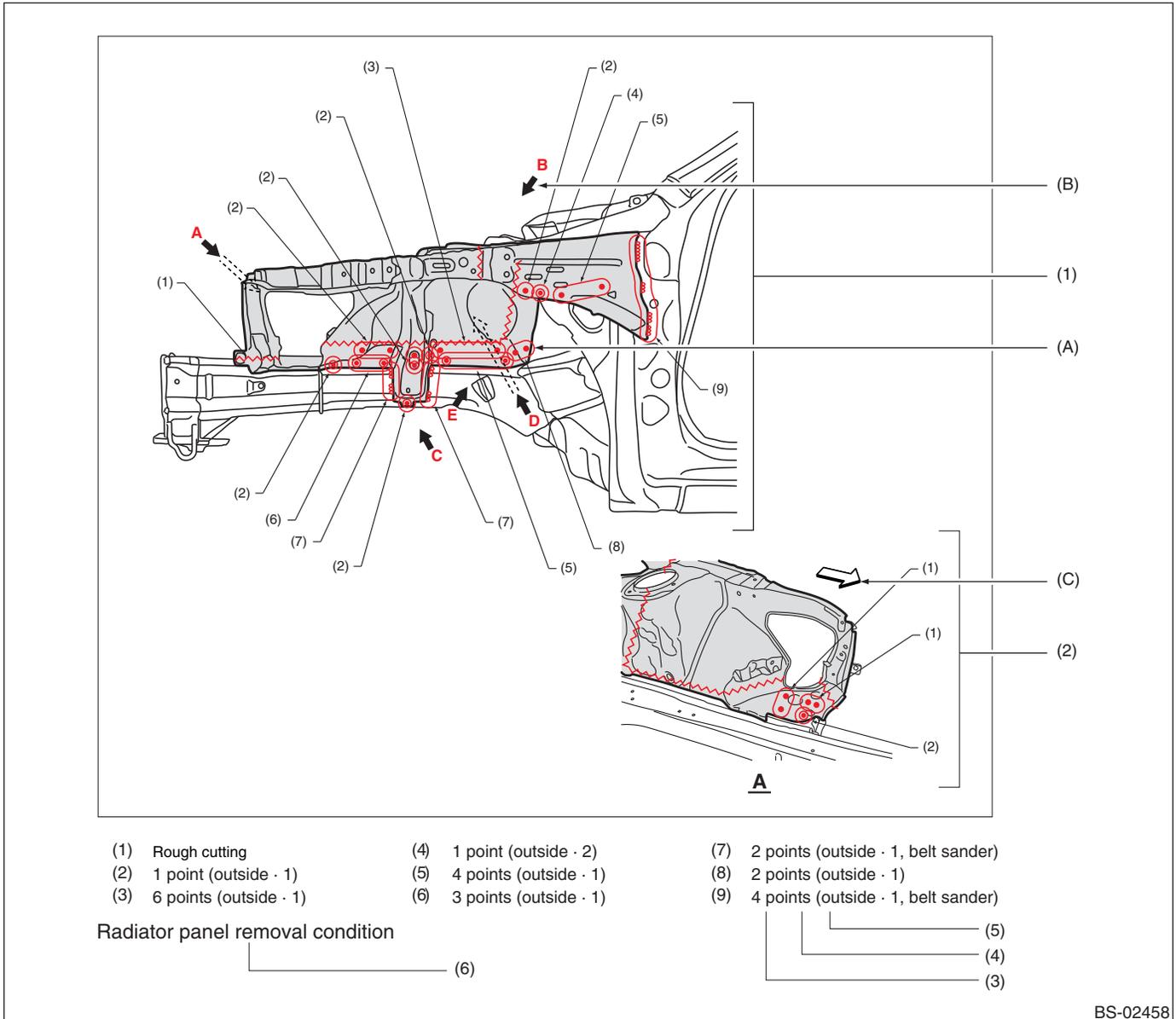
## 1. Foreword

### A: USE OF THIS MANUAL

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

#### 1. ILLUSTRATION EXAMPLE

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

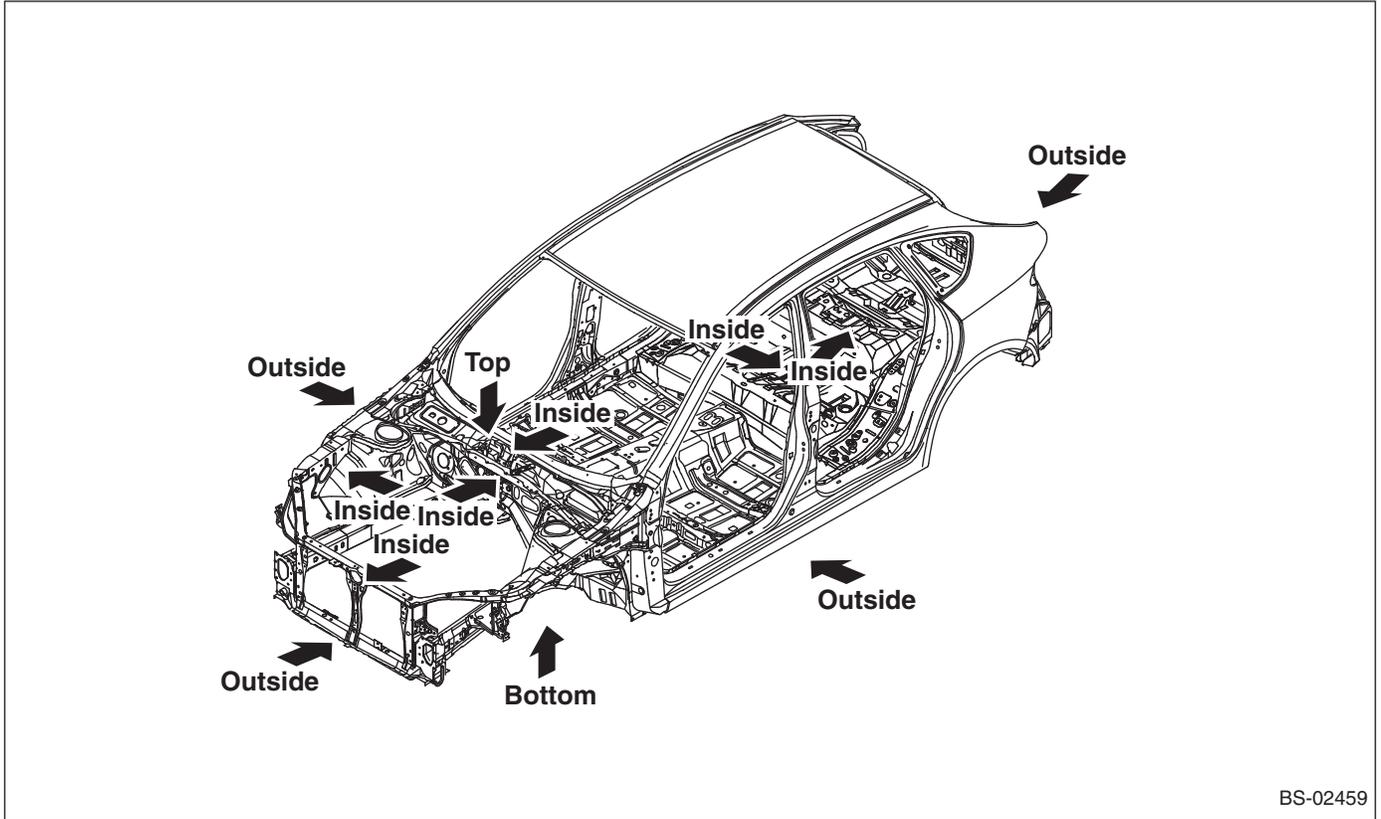


- |                                    |  |
|------------------------------------|--|
| (1) Overall view                   | (A) Welding method                             |
| (2) View                           | (B) View direction                             |
| (3) Number of welding points etc.  |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

# Foreword

## 2. REMOVAL DIRECTION

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

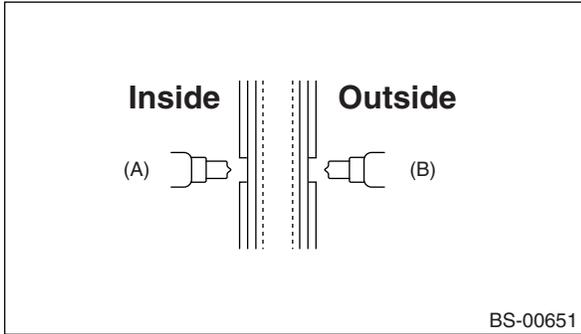


# Foreword

## 3. NUMBER OF PANELS TO BE DRILLED

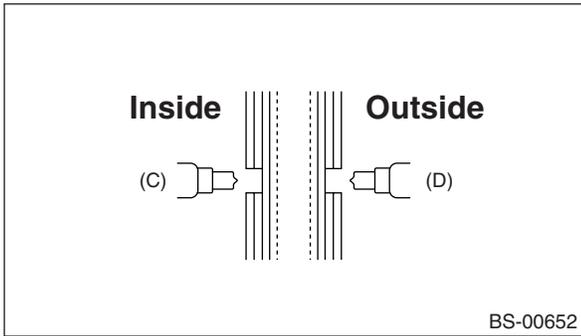
Depending on the number of panels, drilling is done through one panel or two panels, and this number is listed together with the removal direction.

### (1) Drilling through one plate



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

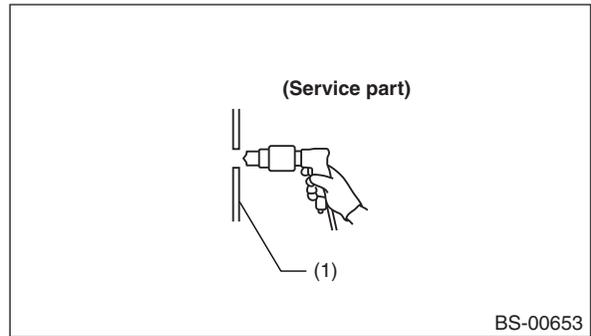
### (2) Drilling through two plates



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

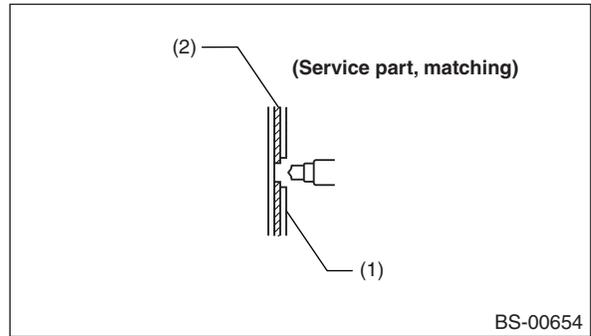
## 4. HOLE DRILLING FOR PLUG WELDING

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



- (1) Service part

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

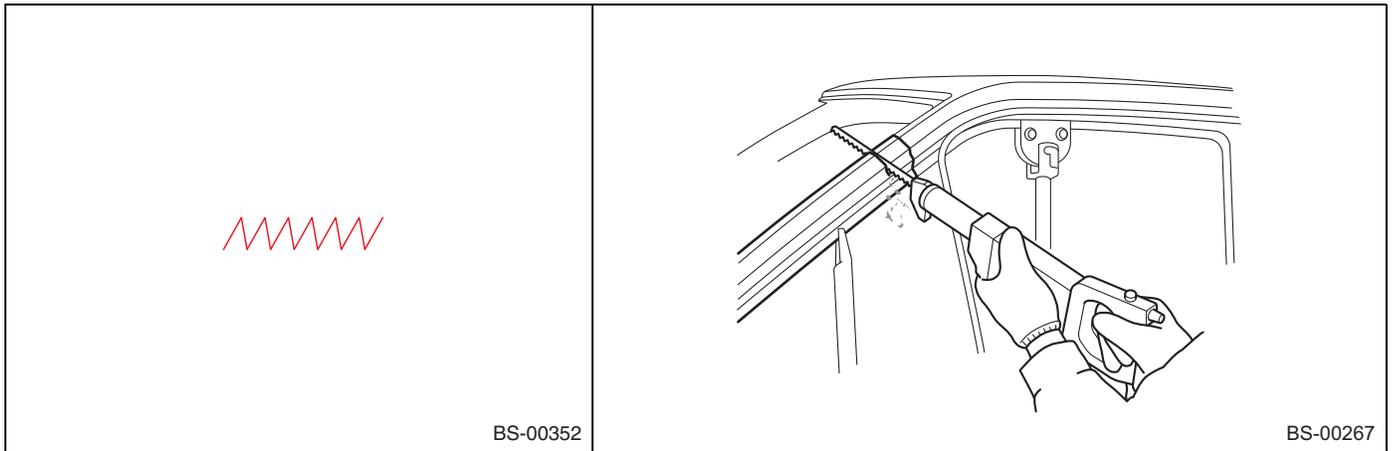


- (1) Vehicle side
- (2) Service part

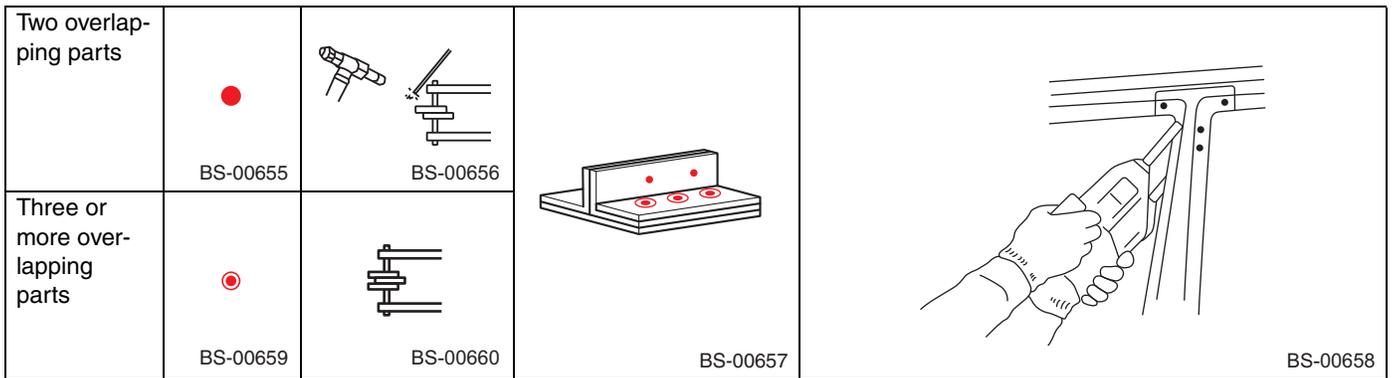
# Foreword

## 5. MEANING OF SYMBOLS

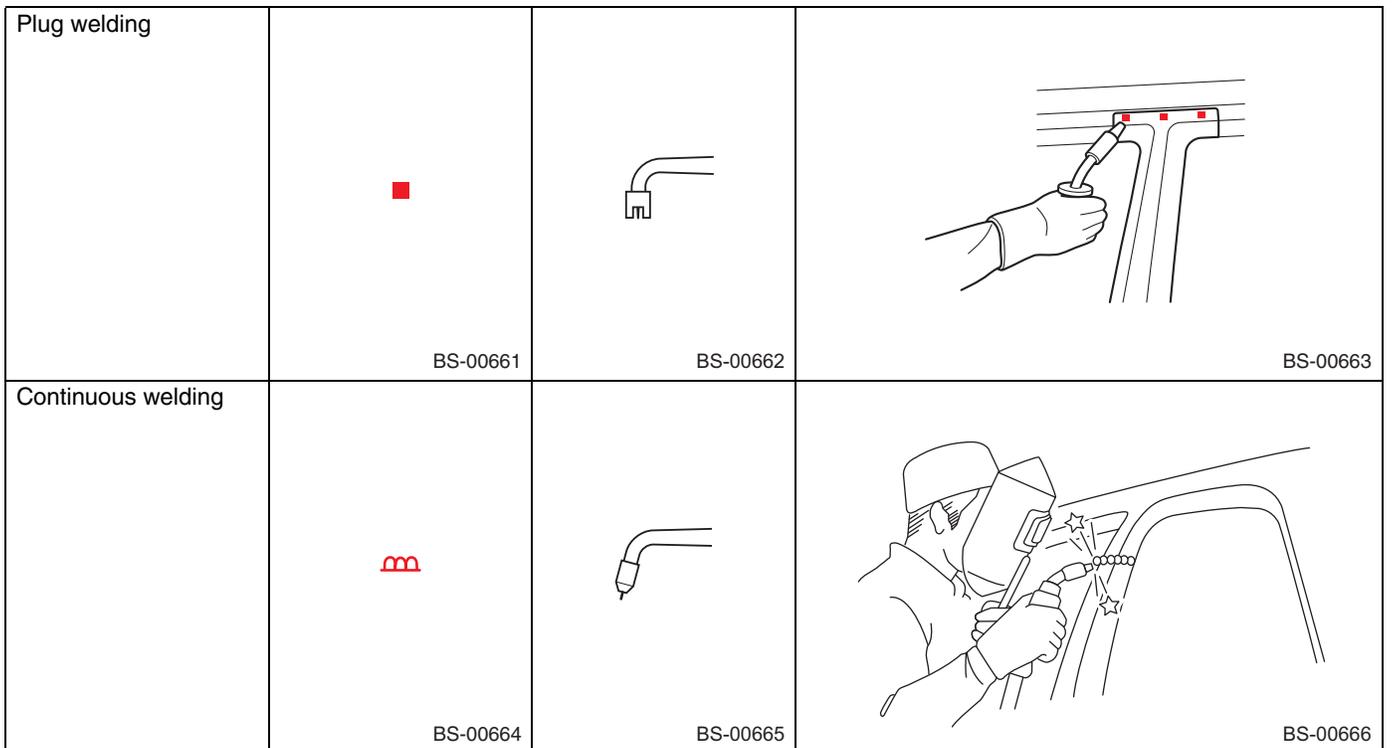
- Cutting



- Spot welding

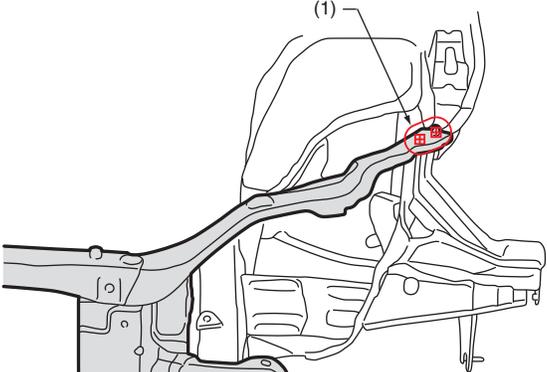
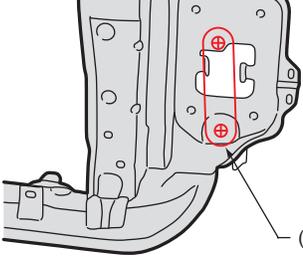


- Carbon dioxide gas arc welding (MIG welding)



# Foreword

- Bolt, nut tightening portion

Bolt	  BS-04481	
Nut	  BS-04482	  BS-04483 (1) Bolt (2) Nut

## B: CAUTION

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

## Foreword

### C: NOTE

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

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

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

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

Spot welding	[a]	Compression	3.5 kN	Total number of 2 overlapping sheets
		Current	7.0 kA	
		Welding time	25 cyc	
	[b]	Compression	3.5 kN	
		Current	7.5 kA	
		Welding time	25 cyc	
	[c]	Compression	3.0 kN	Total number of 3 overlapping sheets
		Current	6.5 kA	
		Welding time	25 cyc	
	[d]	Compression	3.5 kN	
		Current	7.5 kA	
		Welding time	25 cyc	
[e]	Compression	4.4 kN	Total number of 2 or 3 overlapping sheets	
	Current	8.0 kA		
	Welding time	20 cyc		
[f]	Compression	4.4 kN		
	Current	8.0 kA		
	Welding time	25 cyc		
Plug welding	[g]	A	Plug diameter	8.5 mm (0.33 in) or more
			Wire	YGW12
			Gas	CO2
		B	Plug diameter	8.5 mm (0.33 in) or more
			Wire	YGW16
			Gas	Gas mixture (argon: 80 %, CO2: 20 %)

#### CAUTION:

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

#### 2. Drill holes for plug welding of steel sheet

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

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

# Foreword

## 3. Repair work using foam

### CAUTION:

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

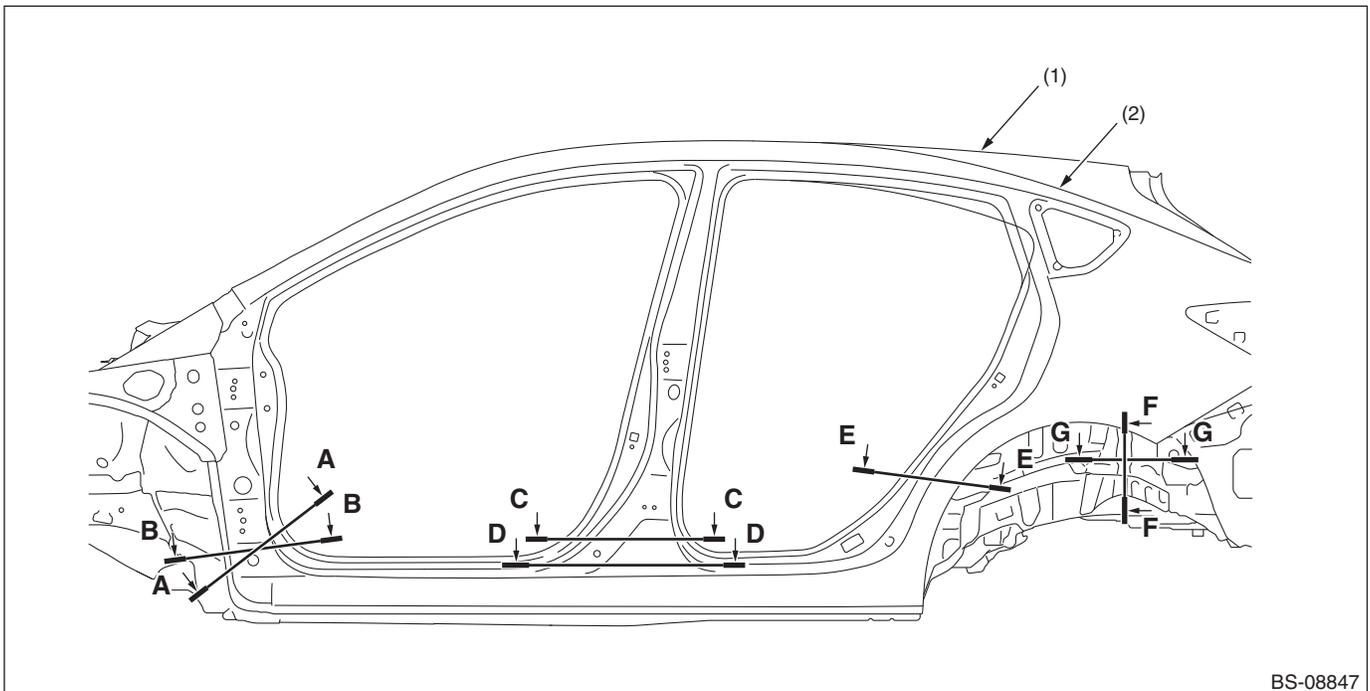
### Recommended materials: Equivalent to High Span Foam made by Cemedine

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

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

- Foam injection locations

### COMMON PARTS FOR 5 DOOR AND 4 DOOR

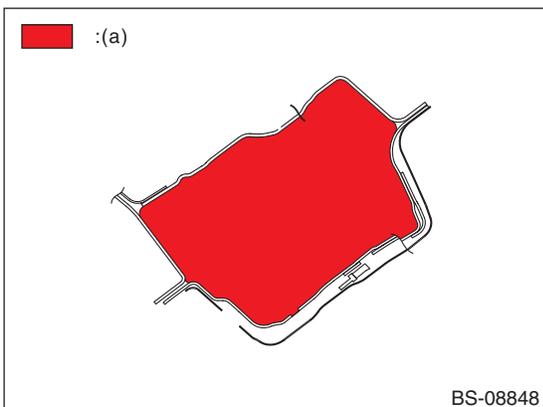


BS-08847

(1) 5 Door

(2) 4 Door

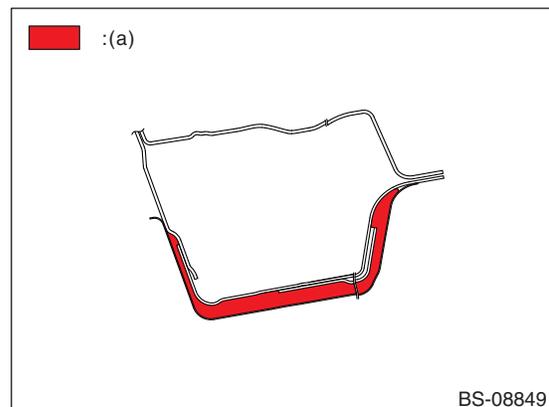
### Cross section A — A



BS-08848

(a) Urethane foam injection locations

### Cross section B — B

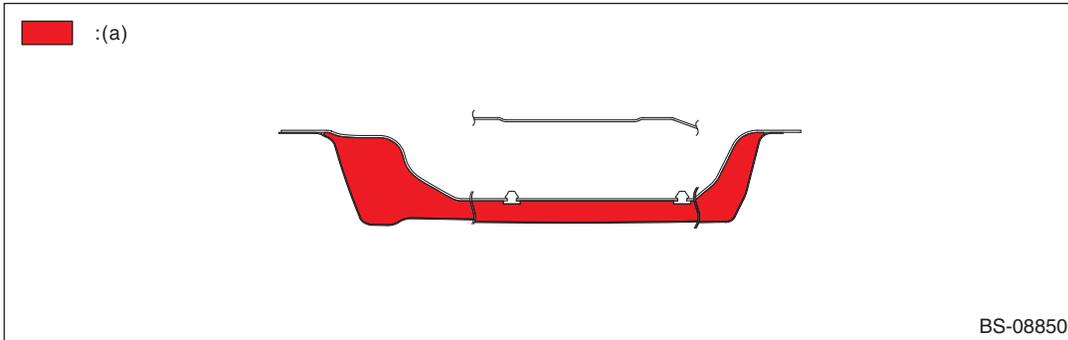


BS-08849

(a) Urethane foam injection locations

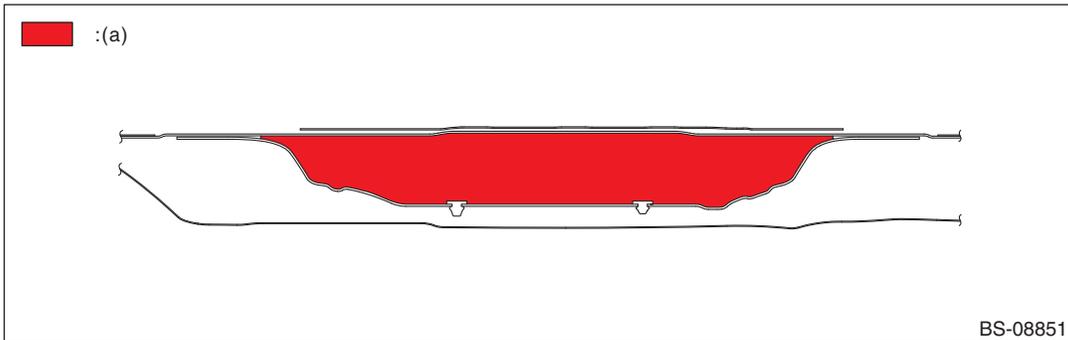
# Foreword

## Cross section C — C



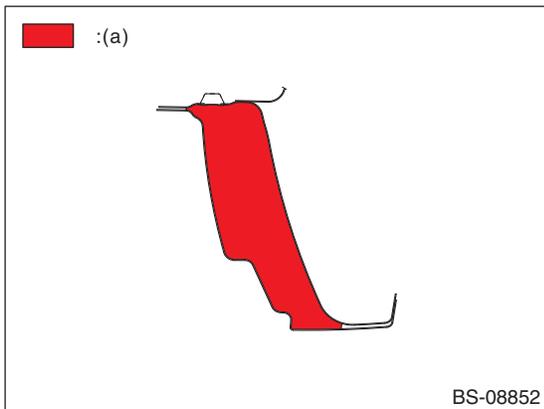
(a) Urethane foam injection locations

## Cross section D — D



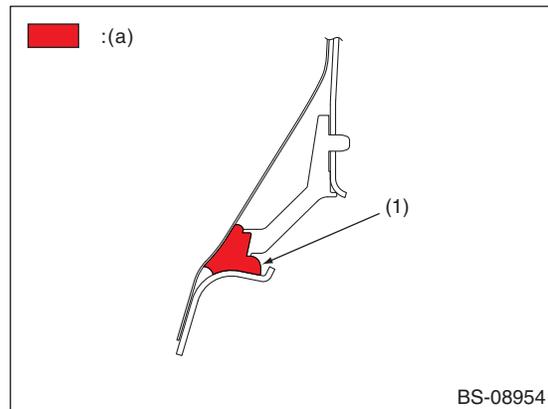
(a) Urethane foam injection locations

## Cross section E — E



(a) Urethane foam injection locations

## Cross section F — F

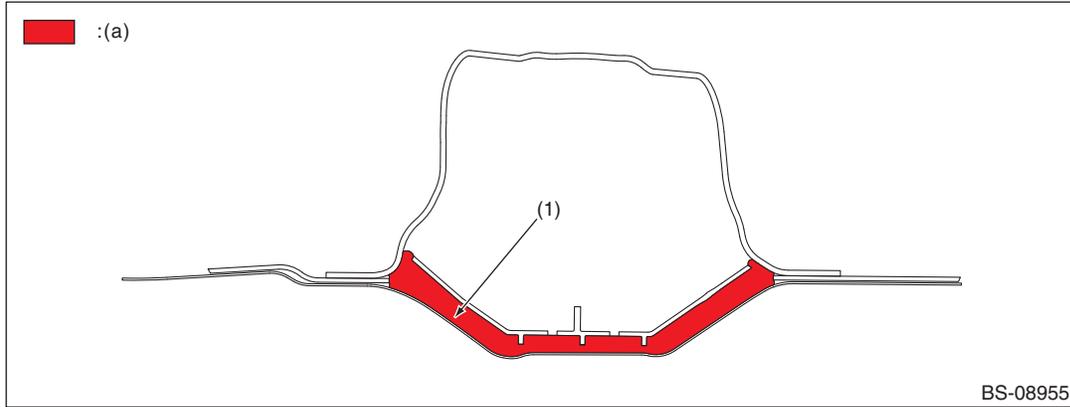


(a) Urethane foam injection locations

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

# Foreword

## Cross section G — G



(a) Urethane foam injection locations

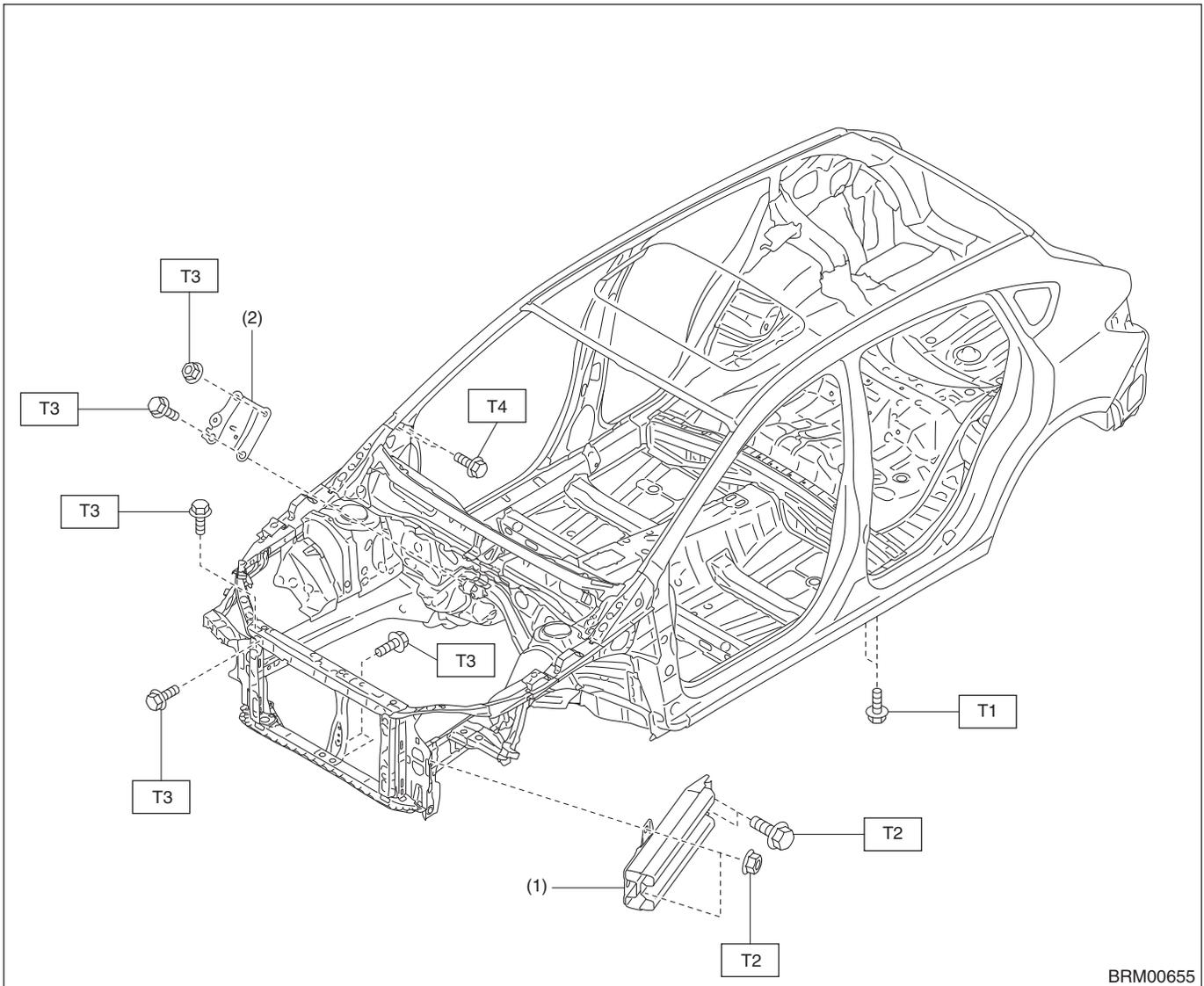
(1) Cut the foam to the shape of the body.

# Assembly of Exterior Parts

## 2. Assembly of Exterior Parts

### A: BODY REINFORCING PARTS

• Gasoline model



BRM00655

- (1) Gusset COMPL front side
- (2) Plate pitching stopper COMPL

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

**T1: 45 (4.59, 33.19)**

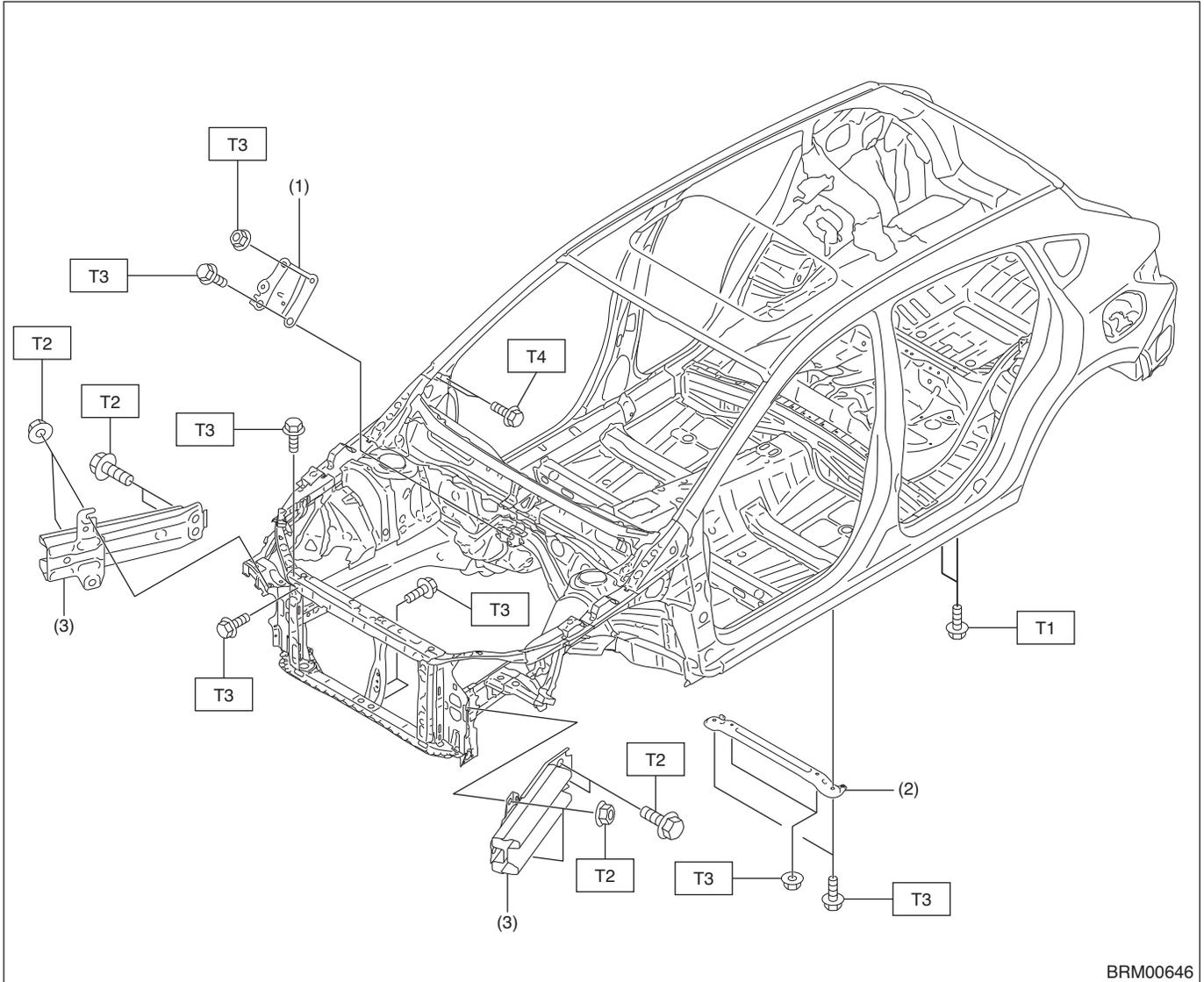
**T2: 37 (3.77, 27.3)**

**T3: 18 (1.84, 13.28)**

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

# Assembly of Exterior Parts

## • Hybrid model



BRM00646

- (1) Plate pitching stopper COMPL
- (2) Stay tunnel COMPL
- (3) Gusset COMPL front side

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

**T1: 45 (4.59, 33.19)**

**T2: 37 (3.77, 27.3)**

**T3: 18 (1.84, 13.28)**

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

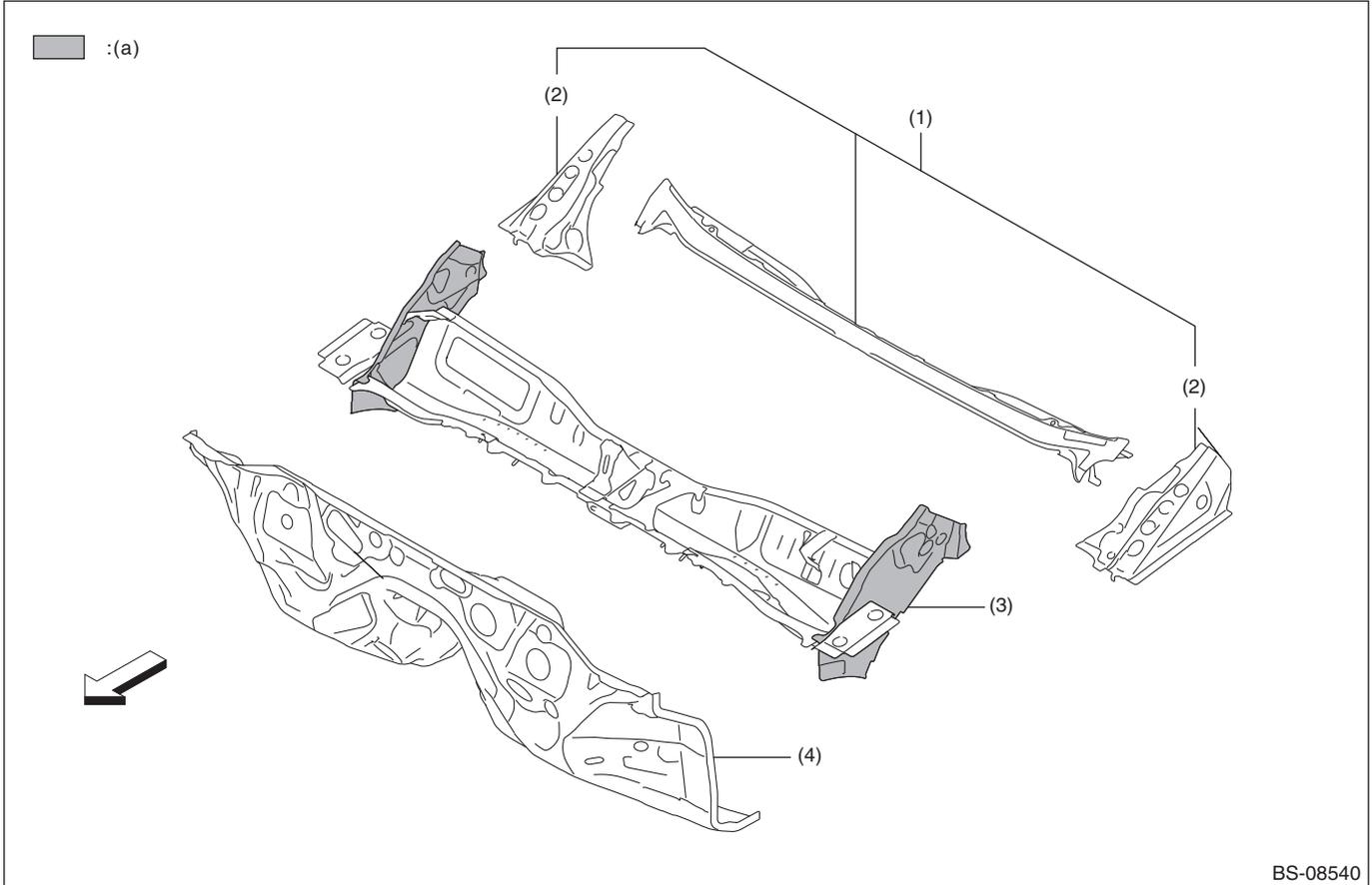
# Panel Components

## 3. Panel Components

### A: COMPONENTS

#### 1. TOE BOARD & FRONT PANEL

- Gasoline model



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

(1) Front panel

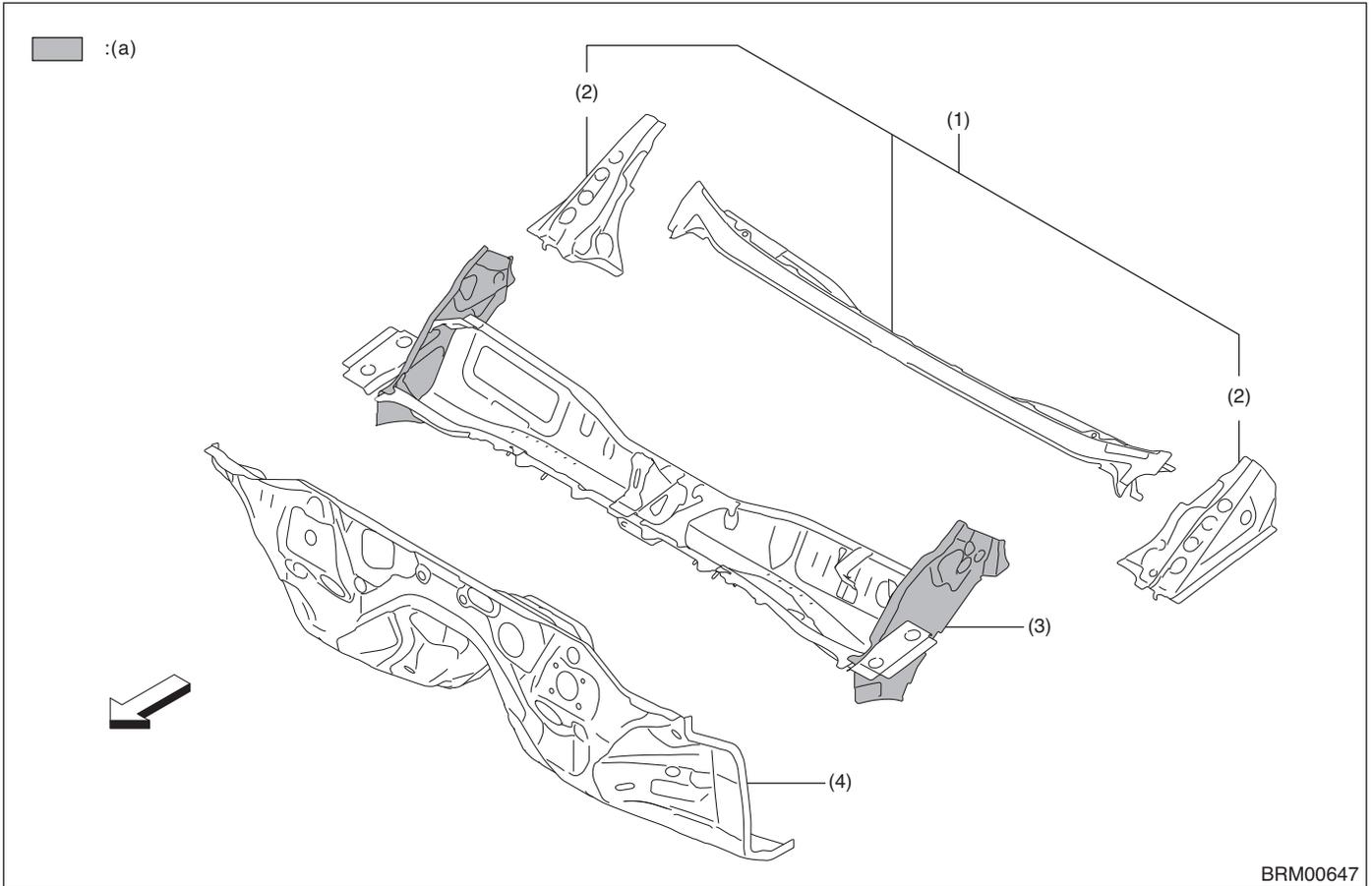
(3) Duct

(4) Toe board

(2) Front panel side reinforcement

# Panel Components

## • Hybrid model



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

(1) Front panel

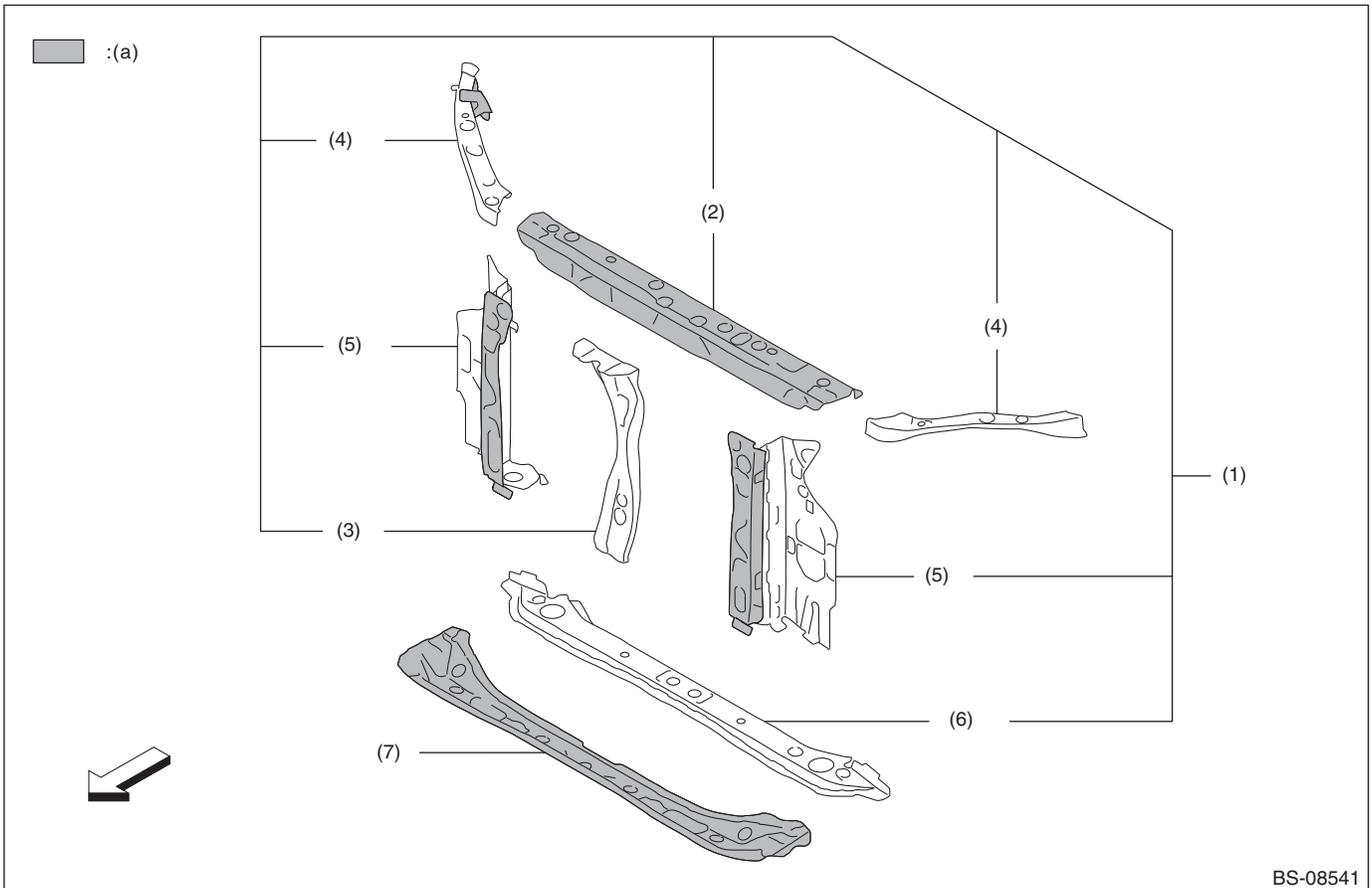
(3) Duct

(4) Toe board

(2) Front panel side reinforcement

# Panel Components

## 2. RADIATOR PANEL



BS-08541

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

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

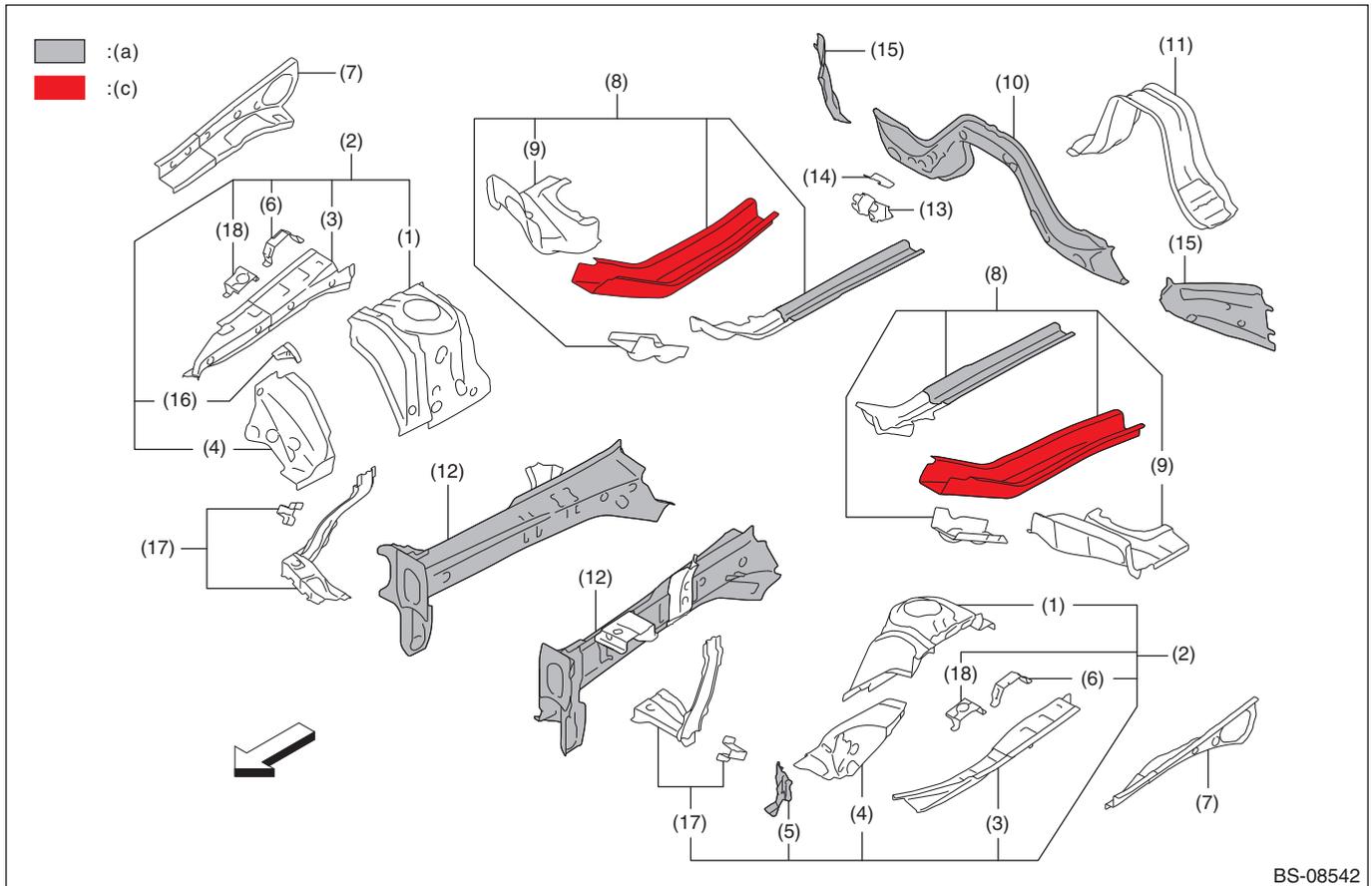
(4) Radiator side frame upper  
(5) Radiator panel side  
(6) Radiator frame lower A

(7) Radiator frame lower B

# Panel Components

## 3. FRONT WHEEL APRON

### • Gasoline model



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

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

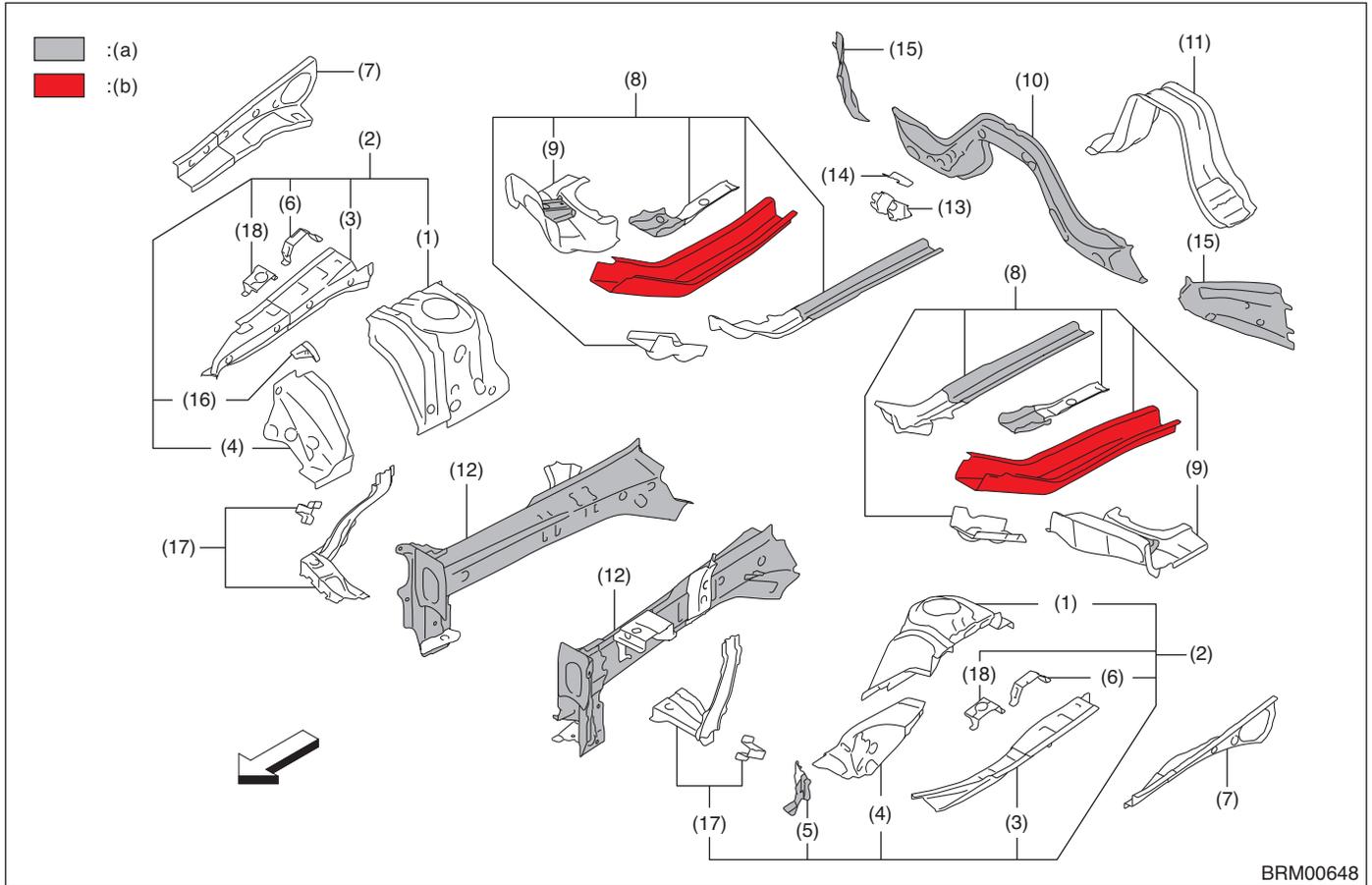
- (1) Front suspension bracket
- (2) Wheel apron
- (3) Side upper inner frame
- (4) Front wheel apron
- (5) Battery rod bracket
- (6) Bracket fender upper front

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

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

# Panel Components

## • Hybrid model



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

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

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

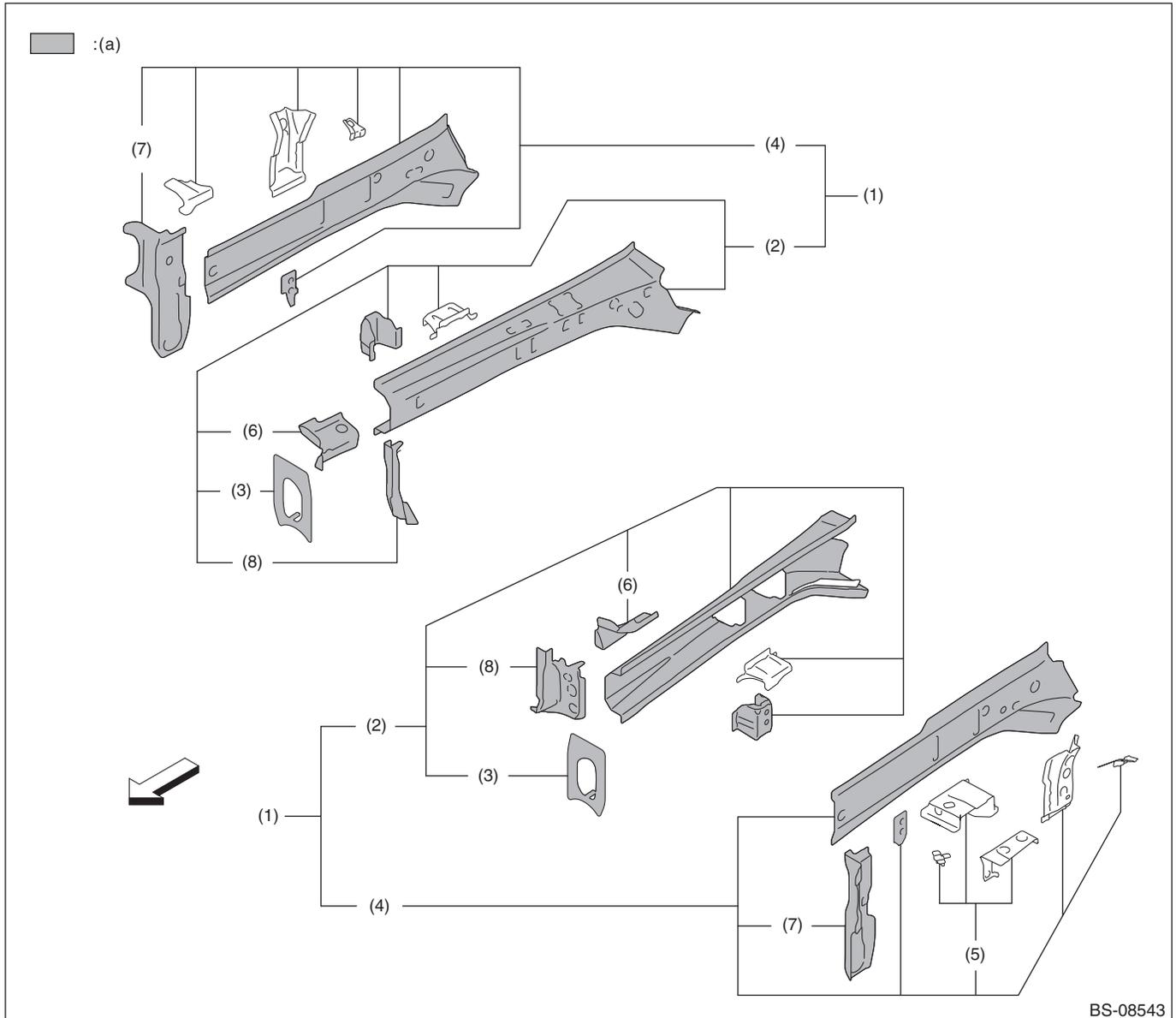
- (7) Side upper frame
- (8) Front side frame rear
- (9) Toe board reinforcement
- (10) Toe board crossmember center
- (11) Floor crossmember front
- (12) Front side frame front

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

# Panel Components

## 4. FRONT SIDE FRAME

### • Gasoline model



BS-08543

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

(1) Front side frame front

(4) Closing plate

(7) Front hook reinforcement

(2) Front side sub frame front

(5) Battery bracket

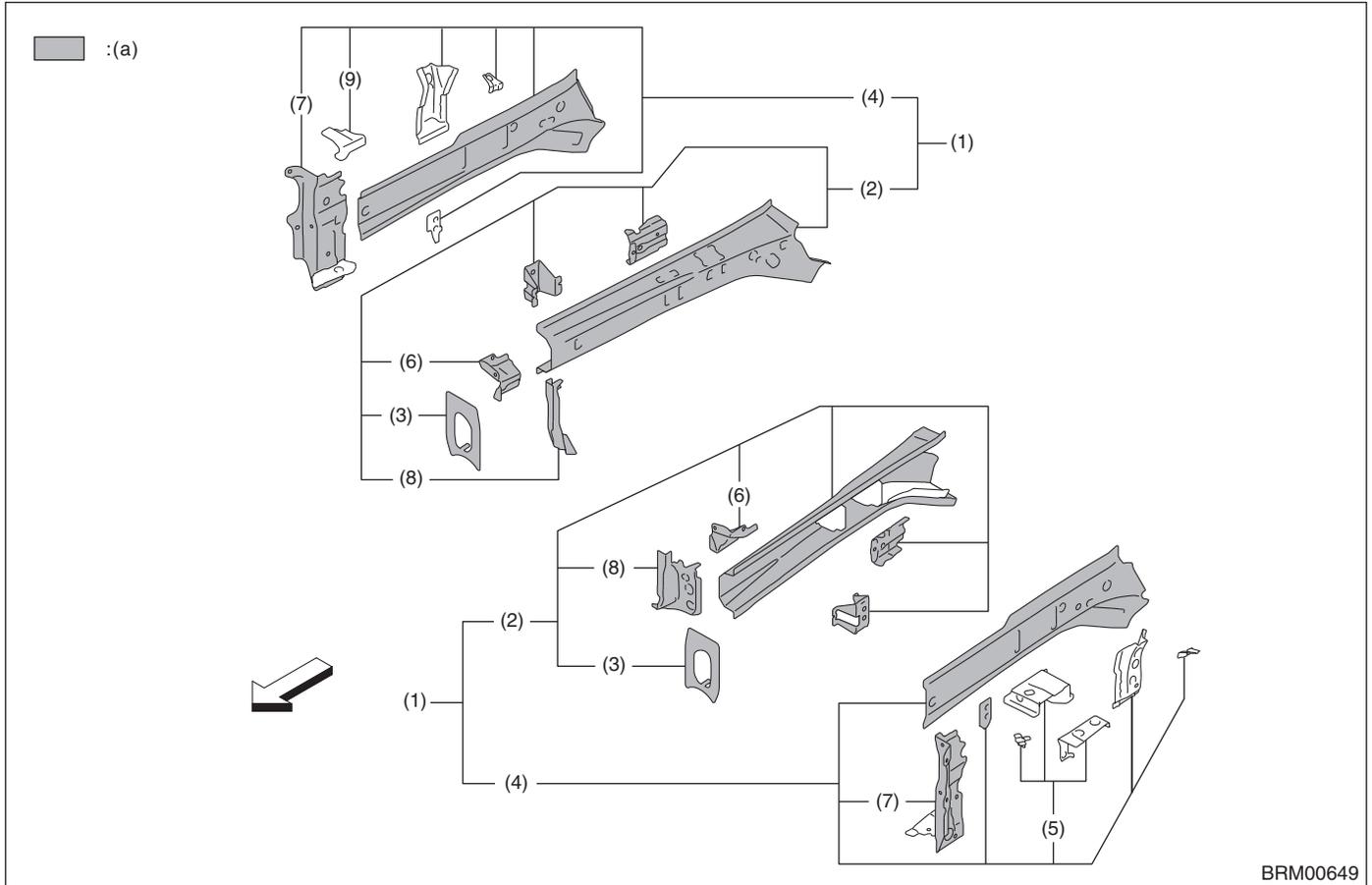
(8) Front frame gusset

(3) Front frame plate front

(6) Beam bracket

# Panel Components

## • Hybrid model



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

(1) Front side frame front

(2) Front side sub frame front

(3) Front frame plate front

(4) Closing plate

(5) Battery bracket

(6) Beam bracket

(7) Front hook reinforcement

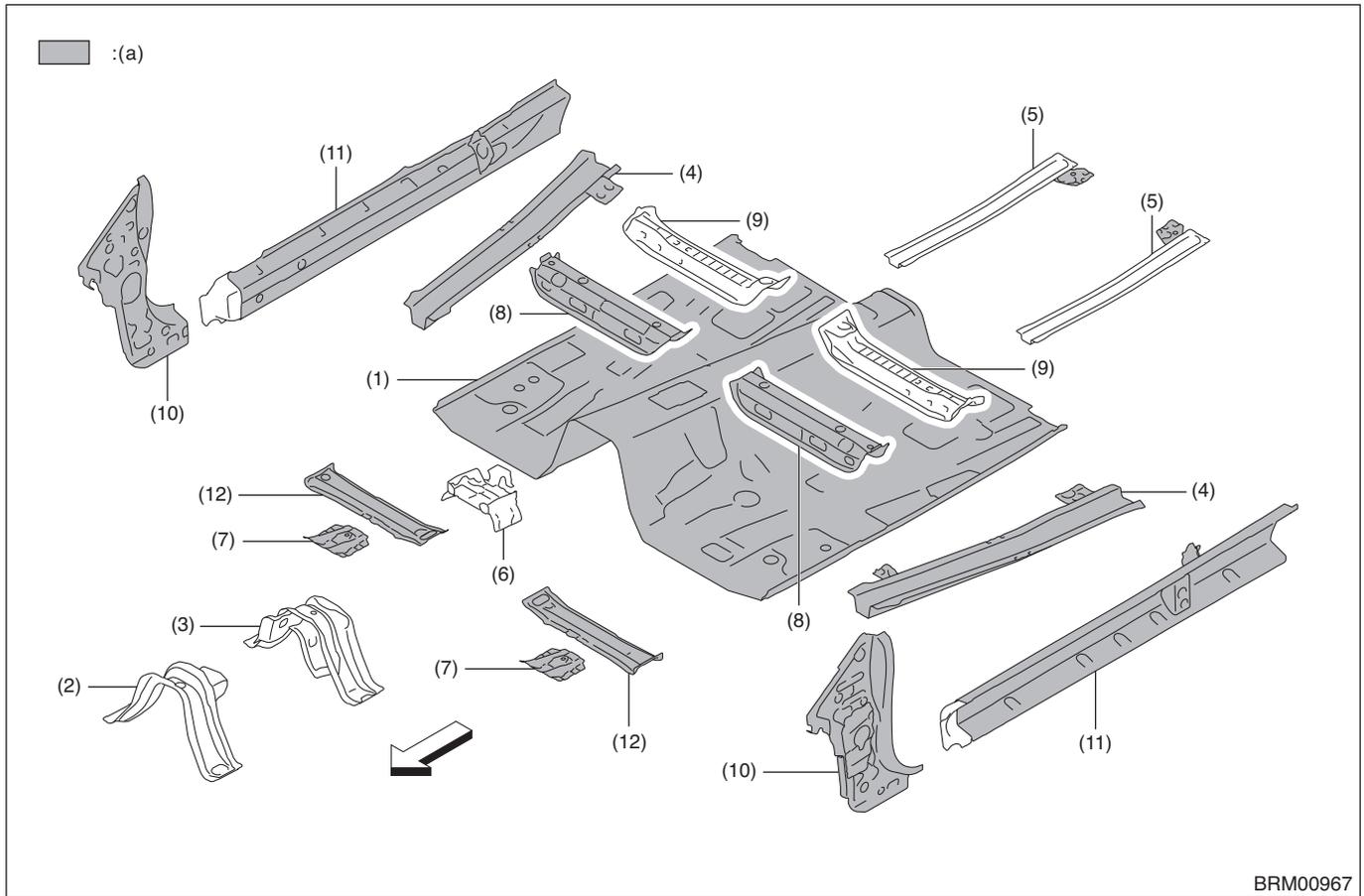
(8) Front frame gusset

(9) Extension apron FF

# Panel Components

## 5. FRONT FLOOR PANEL

### • Gasoline model



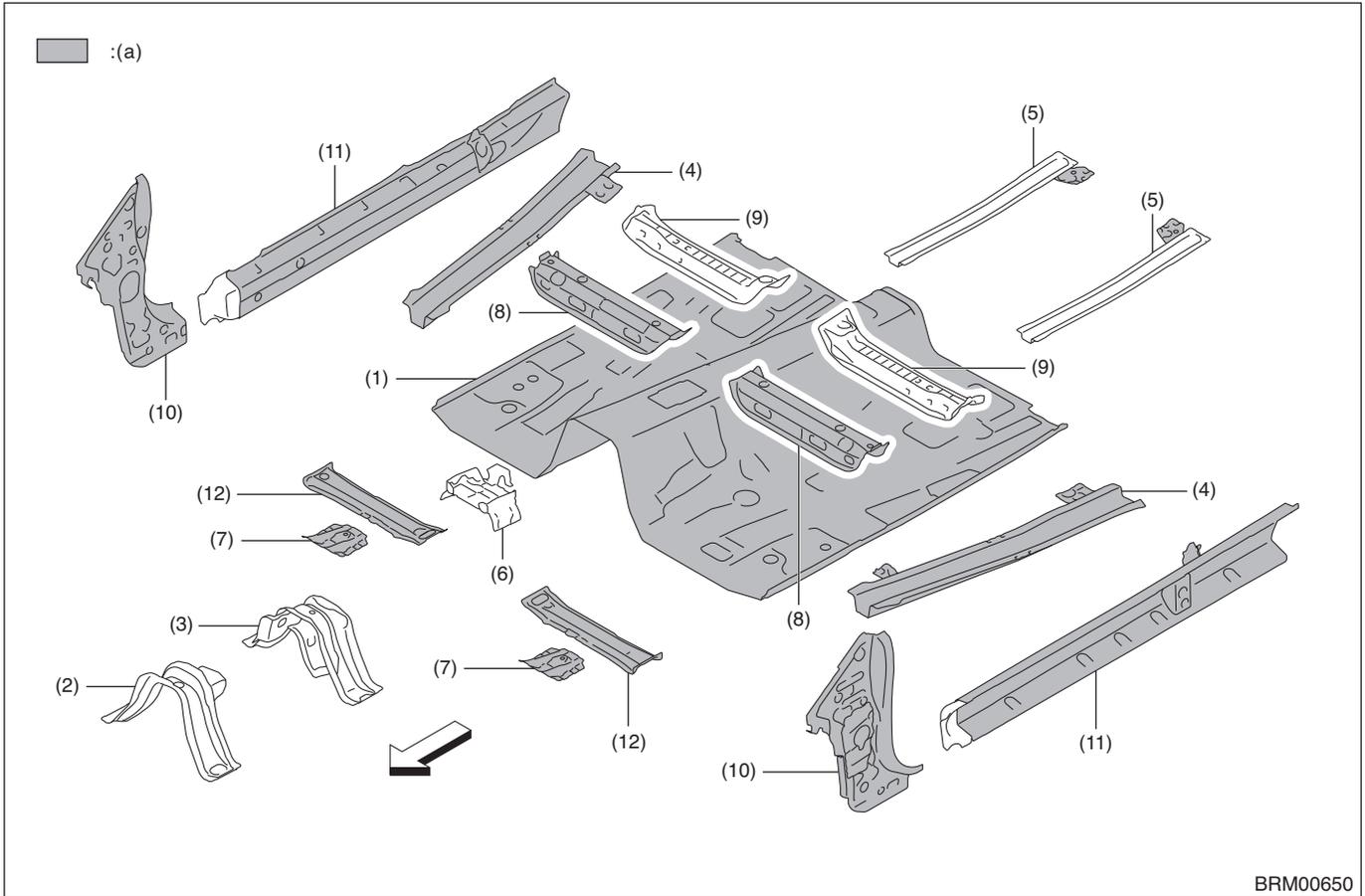
BRM00967

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

- |                              |                                  |                                 |
|------------------------------|----------------------------------|---------------------------------|
| (1) Floor pan front          | (5) Front floor frame rear B     | (9) Front seat crossmember rear |
| (2) Floor crossmember center | (6) Instrument panel bracket     | (10) Front pillar inner lower   |
| (3) Floor crossmember rear   | (7) Frame side F rear inner      | (11) Side sill inner front      |
| (4) Front floor frame rear A | (8) Front seat crossmember front | (12) Crossmember floor upper    |

# Panel Components

## • Hybrid model



BRM00650

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

- (1) Floor pan front
- (2) Floor crossmember center
- (3) Floor crossmember rear
- (4) Front floor frame rear A

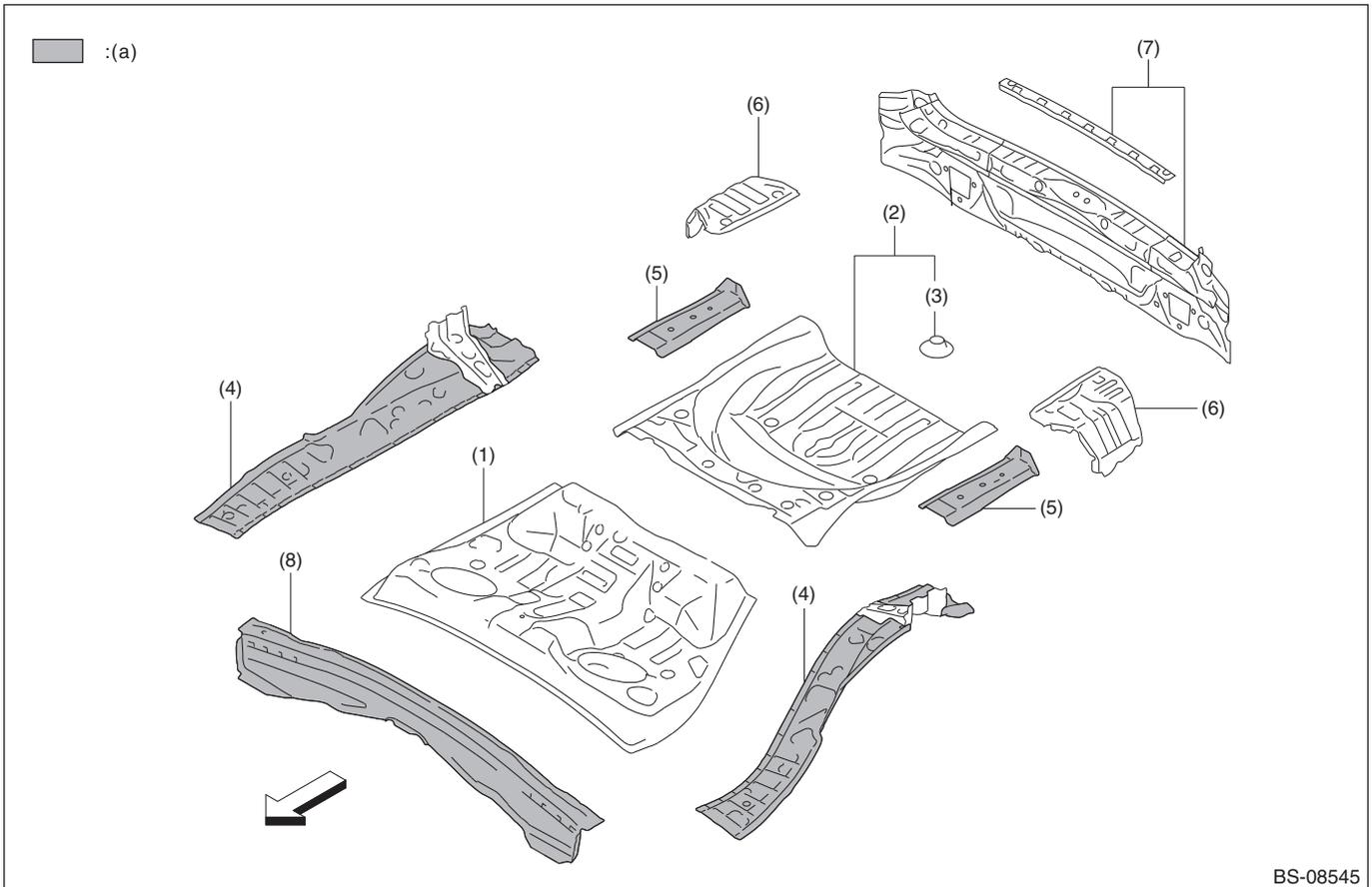
- (5) Front floor frame rear B
- (6) Instrument panel bracket
- (7) Frame side F rear inner
- (8) Front seat crossmember front

- (9) Front seat crossmember rear
- (10) Front pillar inner lower
- (11) Side sill inner front
- (12) Crossmember floor upper

# Panel Components

## 6. REAR FLOOR PANEL & REAR SKIRT

• 5 Door (Gasoline model)



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

(1) Rear floor pan front

(4) Damper bracket floor upper

(7) Rear skirt

(2) Rear floor pan rear

(5) Rear side frame upper rear

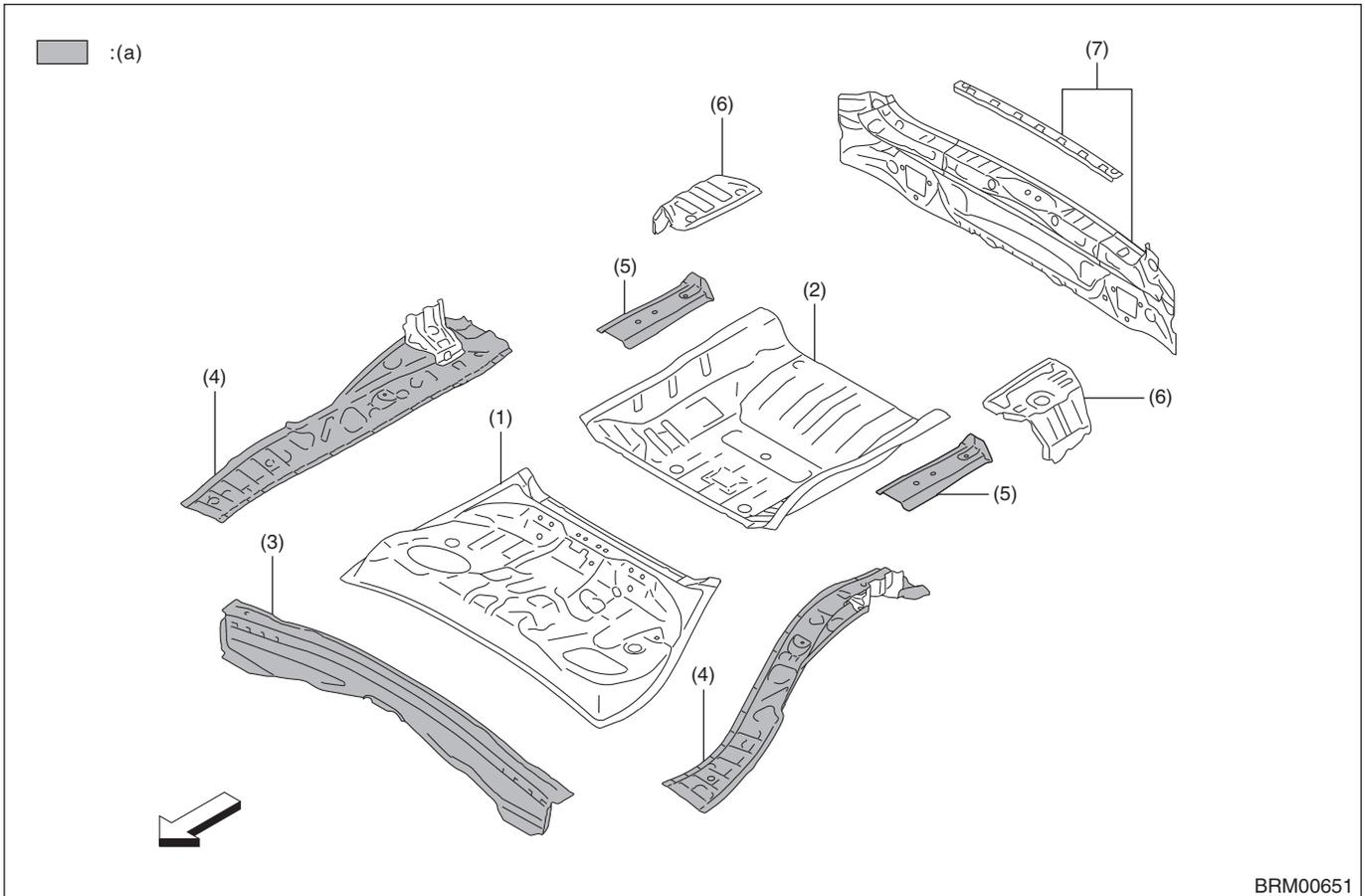
(8) Rear floor crossmember A front

(3) Spare tire bracket

(6) Floor side rear

# Panel Components

## • 5 Door (Hybrid model)



BRM00651

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

(1) Rear floor pan front

(4) Damper bracket floor upper

(7) Rear skirt

(2) Rear floor pan rear

(5) Rear side frame upper rear

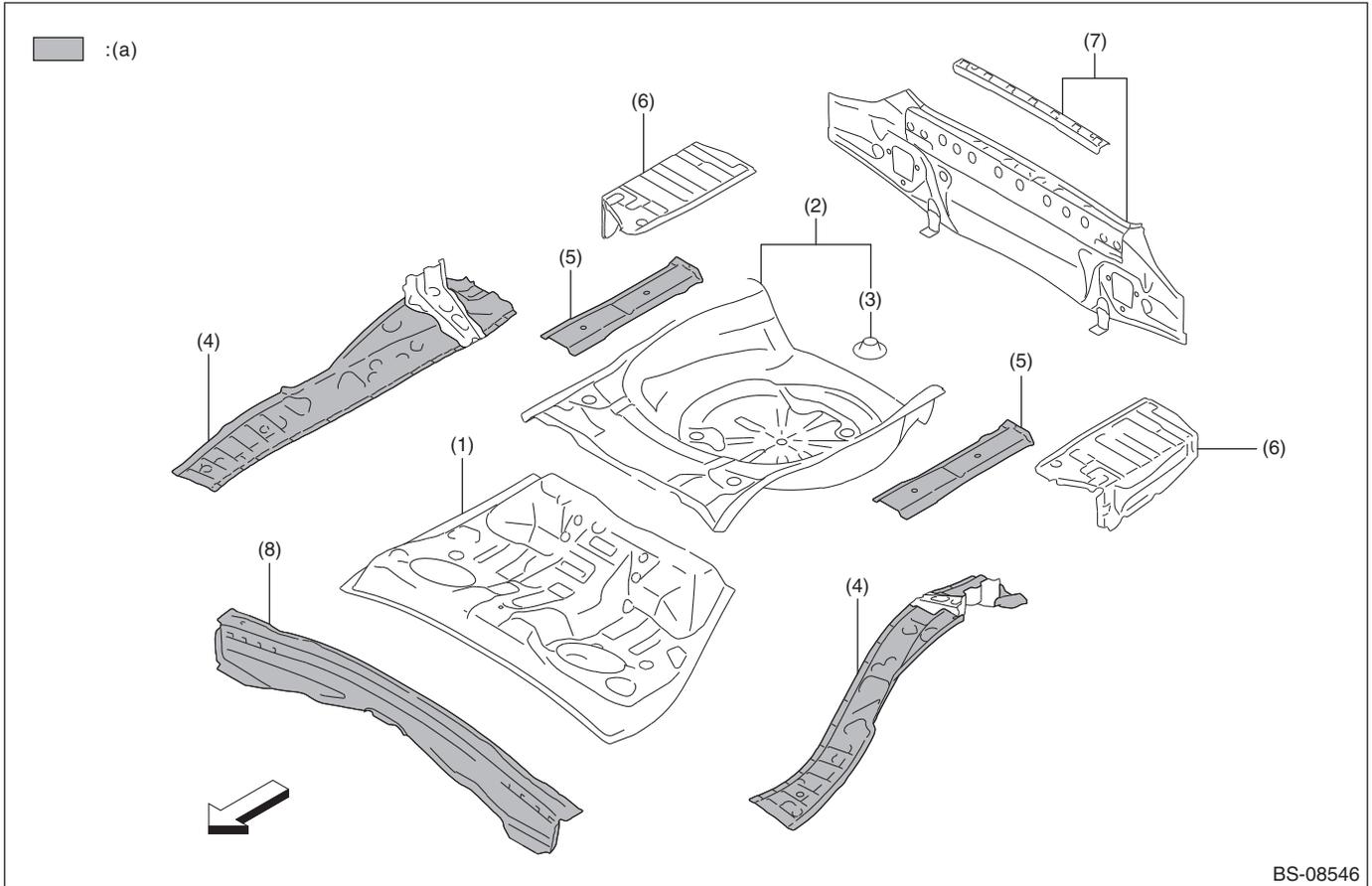
(8) Rear floor crossmember A front

(3) Rear crossmember A front

(6) Floor side rear

# Panel Components

## • 4 Door



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

(1) Rear floor pan front

(2) Rear floor pan rear

(3) Spare tire bracket

(4) Damper bracket floor upper

(5) Rear side frame upper rear

(6) Floor side rear

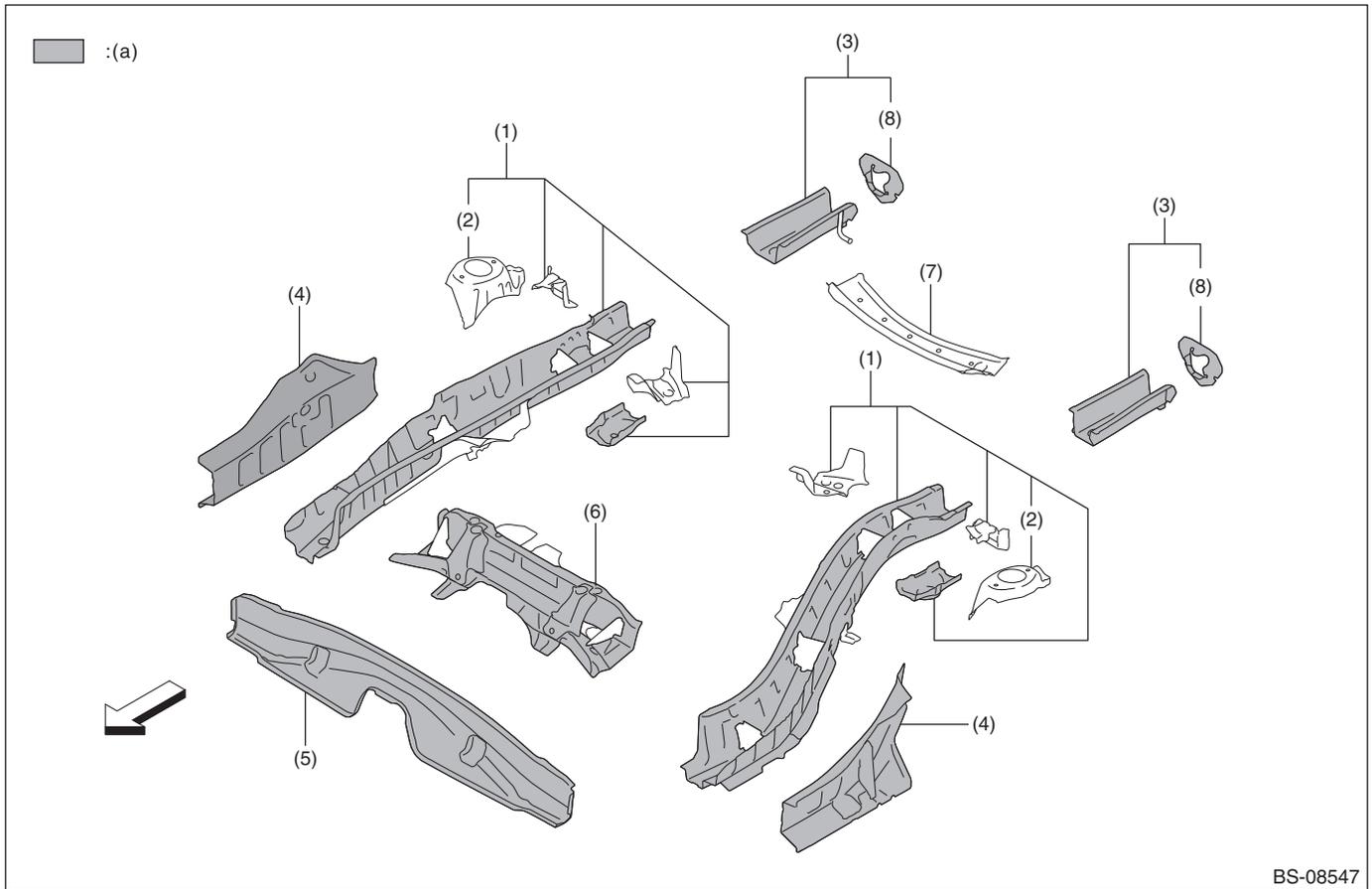
(7) Rear skirt

(8) Rear floor crossmember A front

# Panel Components

## 7. REAR FLOOR SIDE FRAME

• 5 Door (Gasoline model)



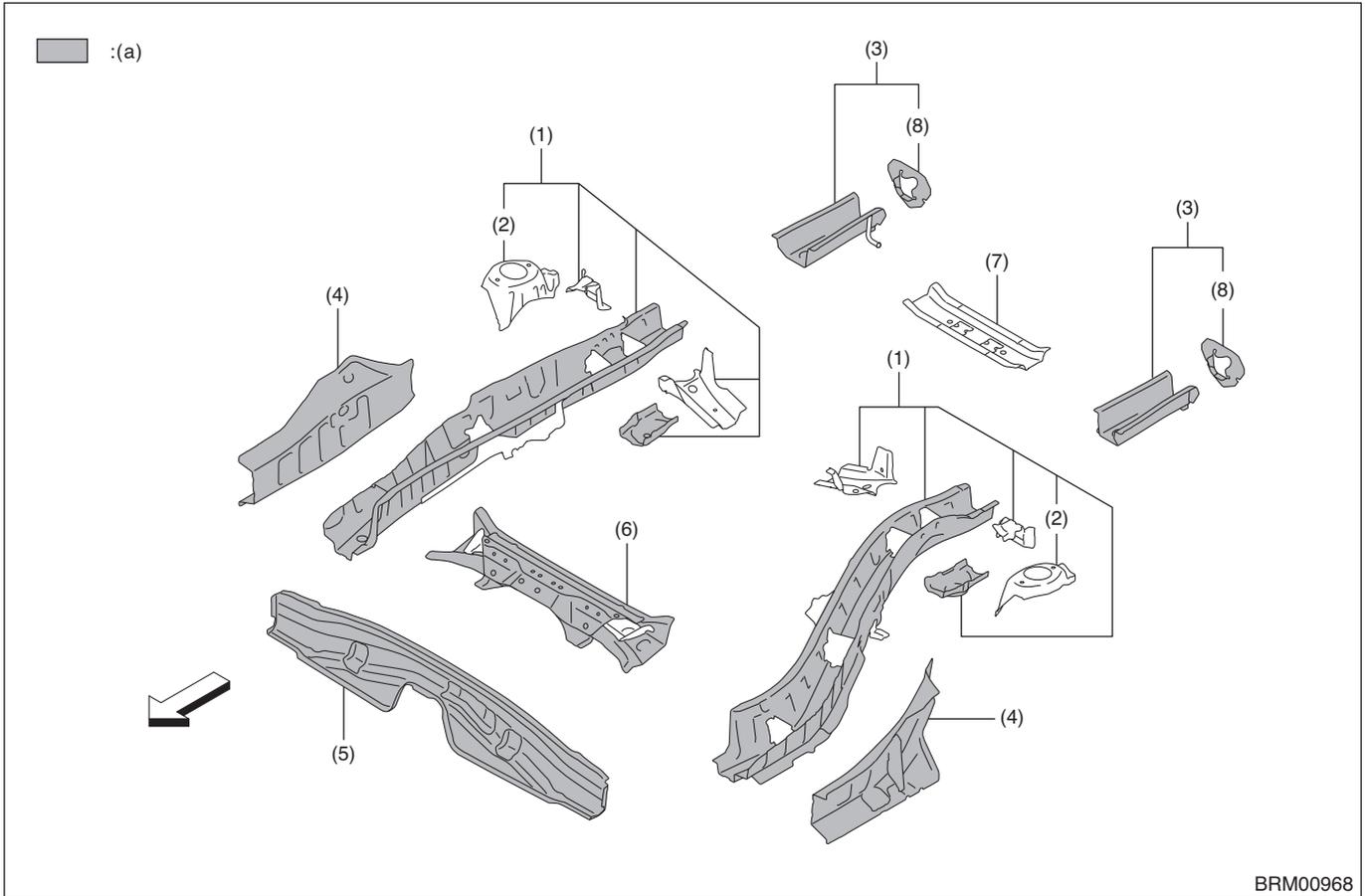
BS-08547

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

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

# Panel Components

## • 5 Door (Hybrid model)



BRM00968

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

(1) Floor side frame rear

(2) Rear suspension bracket

(3) Floor side frame rear lower rear

(4) Side sill inner rear

(5) Rear floor crossmember A rear

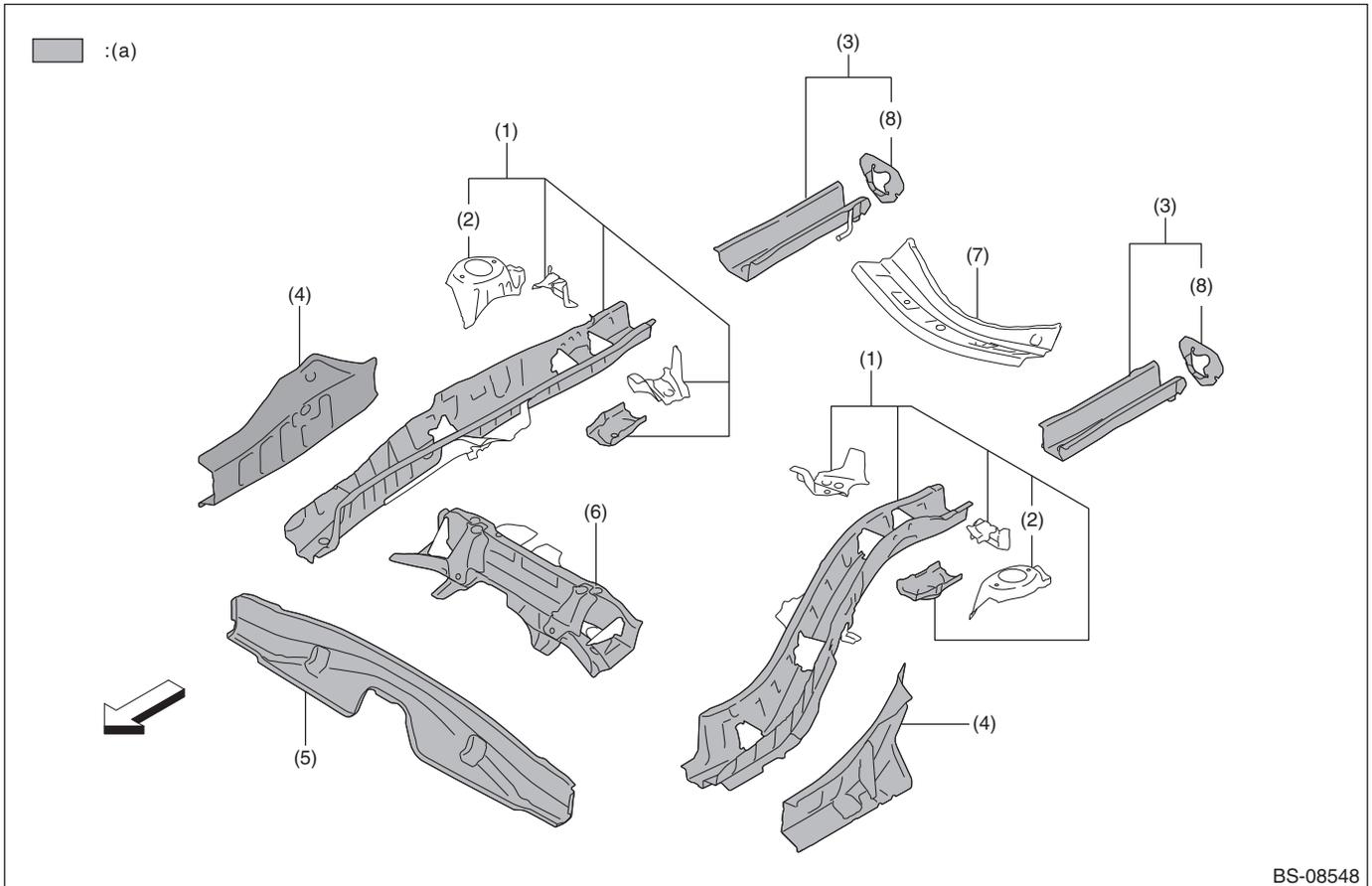
(6) Rear floor crossmember B

(7) Rear floor crossmember C

(8) Rear bumper bracket

# Panel Components

## • 4 Door



BS-08548

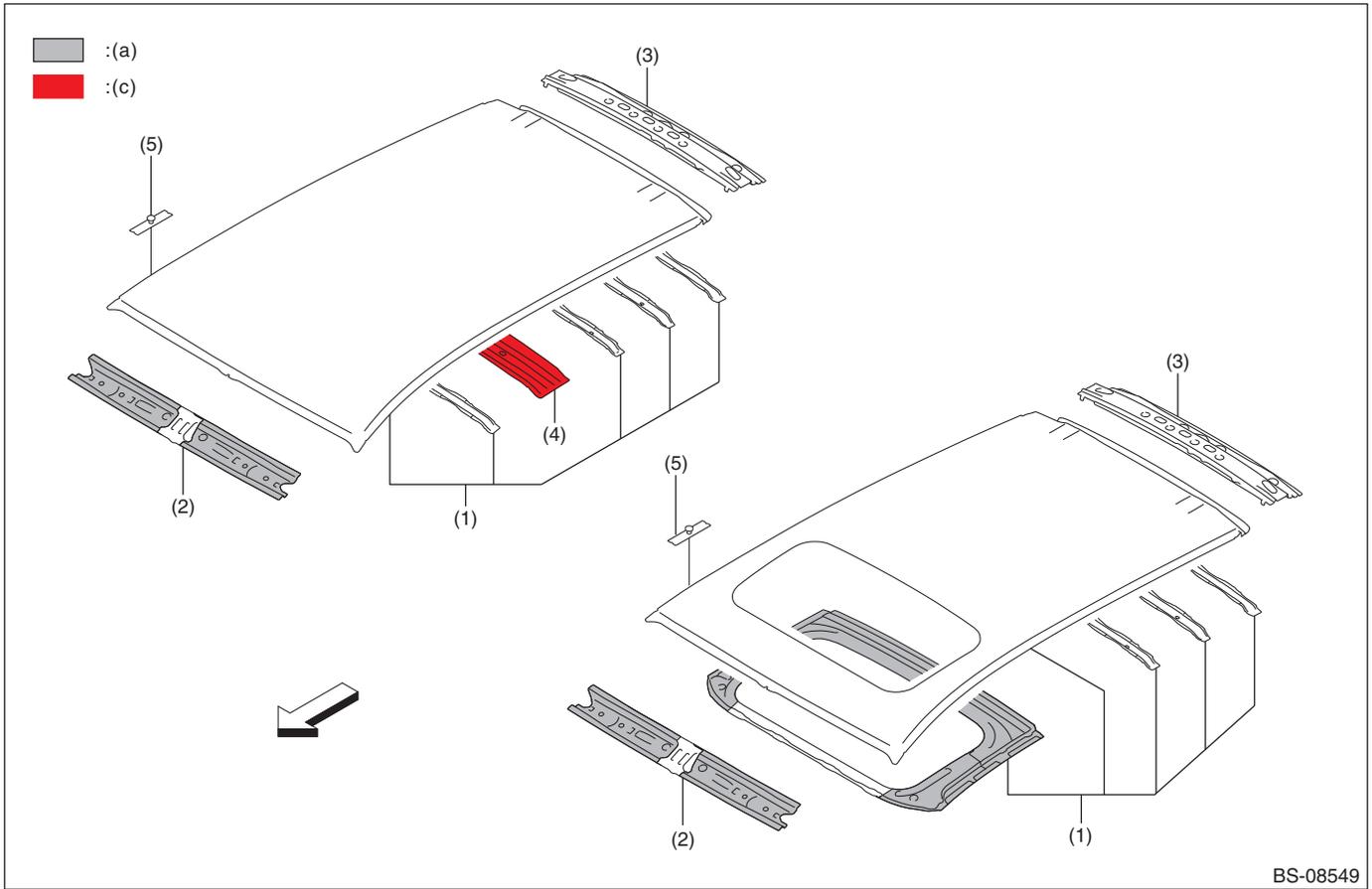
(a) High-strength tensile steel  
(440 — 590 MPa class)

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

# Panel Components

## 8. ROOF

### • 5 Door



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

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

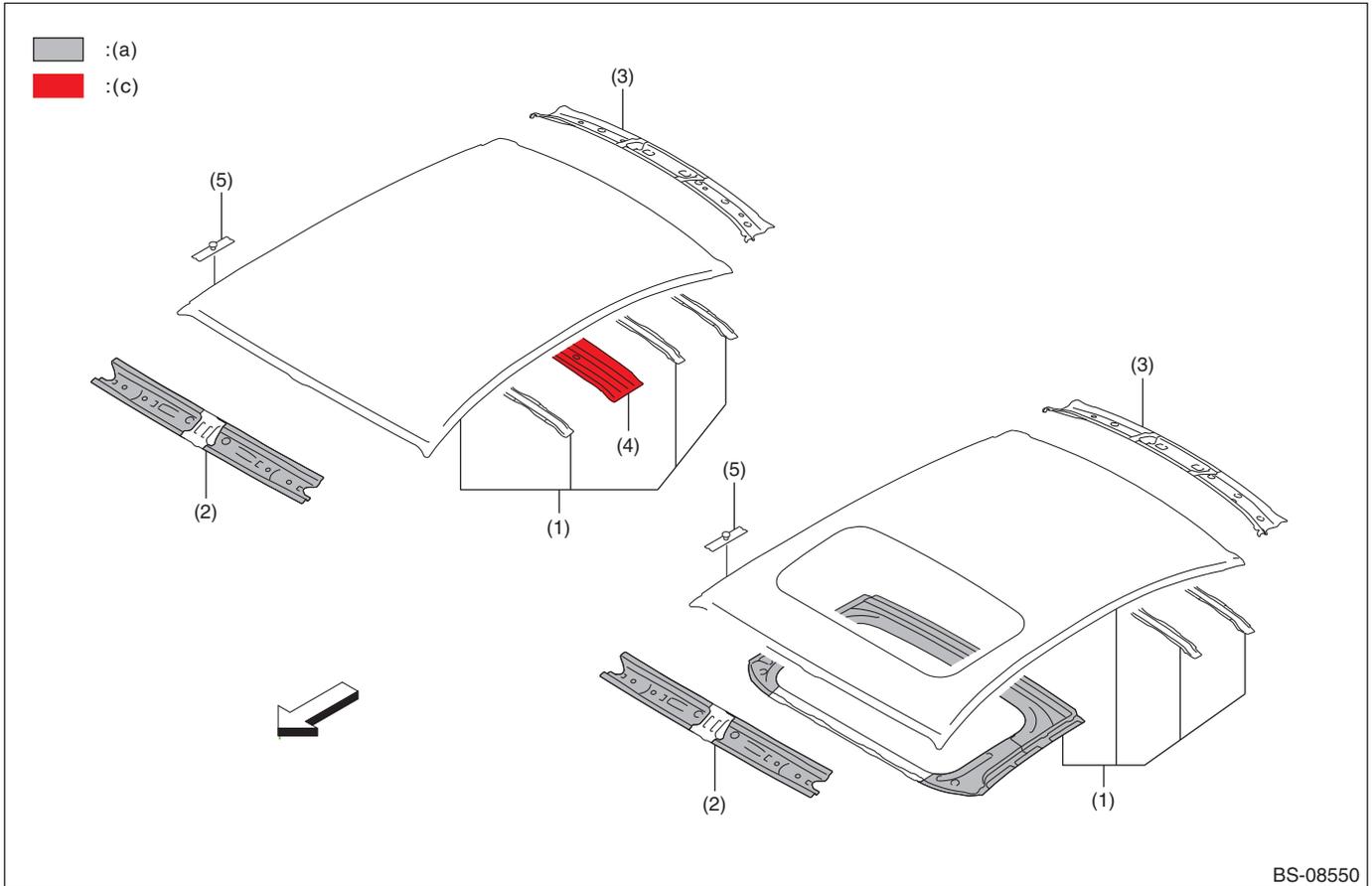
(1) Roof panel  
(2) Front roof rail

(3) Rear roof rail  
(4) Roof center brace

(5) T stud plate

# Panel Components

## • 4 Door



BS-08550

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

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

(1) Roof panel

(3) Rear roof rail

(5) T stud plate

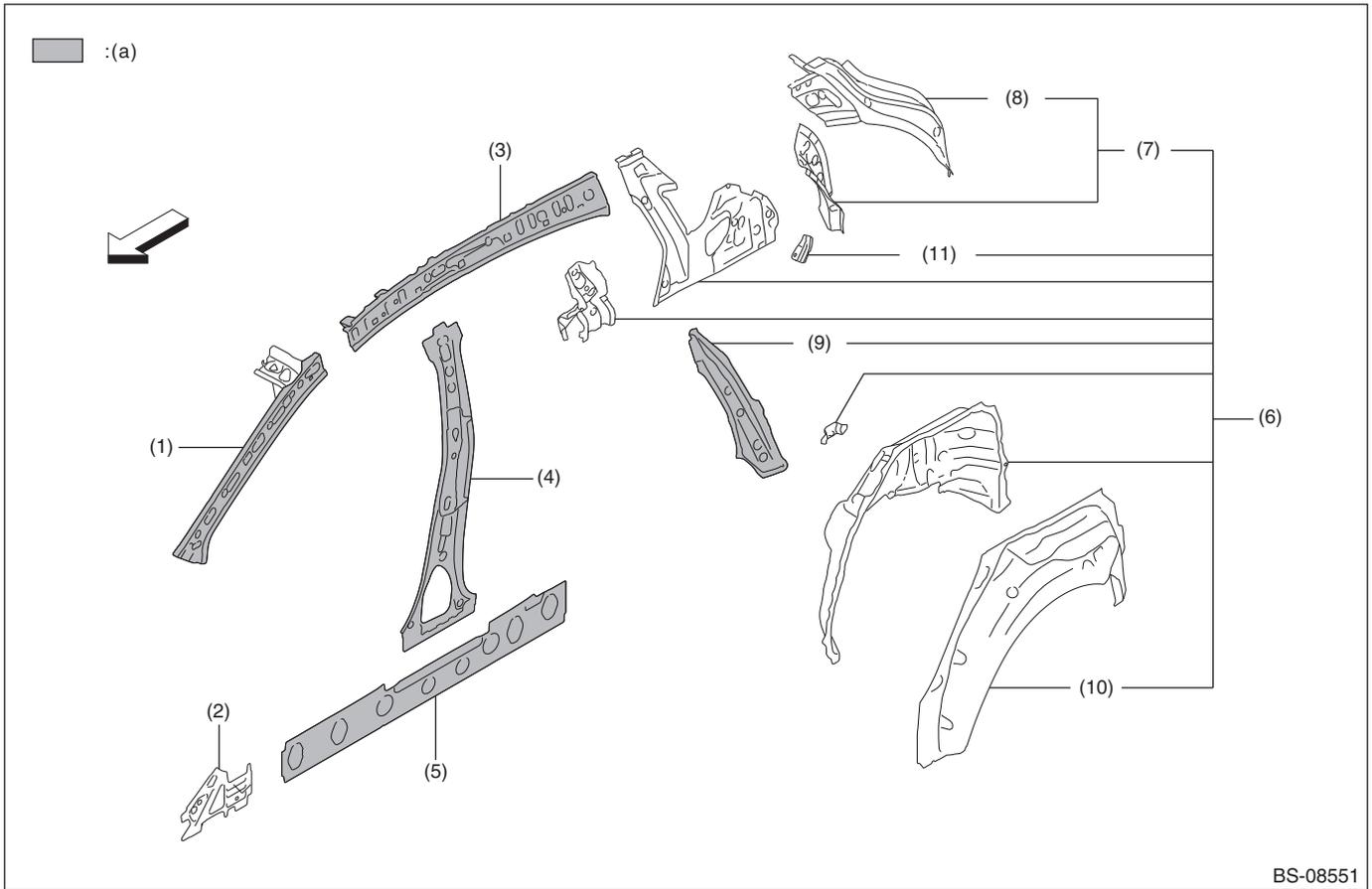
(2) Front roof rail

(4) Roof center brace

# Panel Components

## 9. SIDE PANEL INNER

### • 5 Door (Gasoline model)

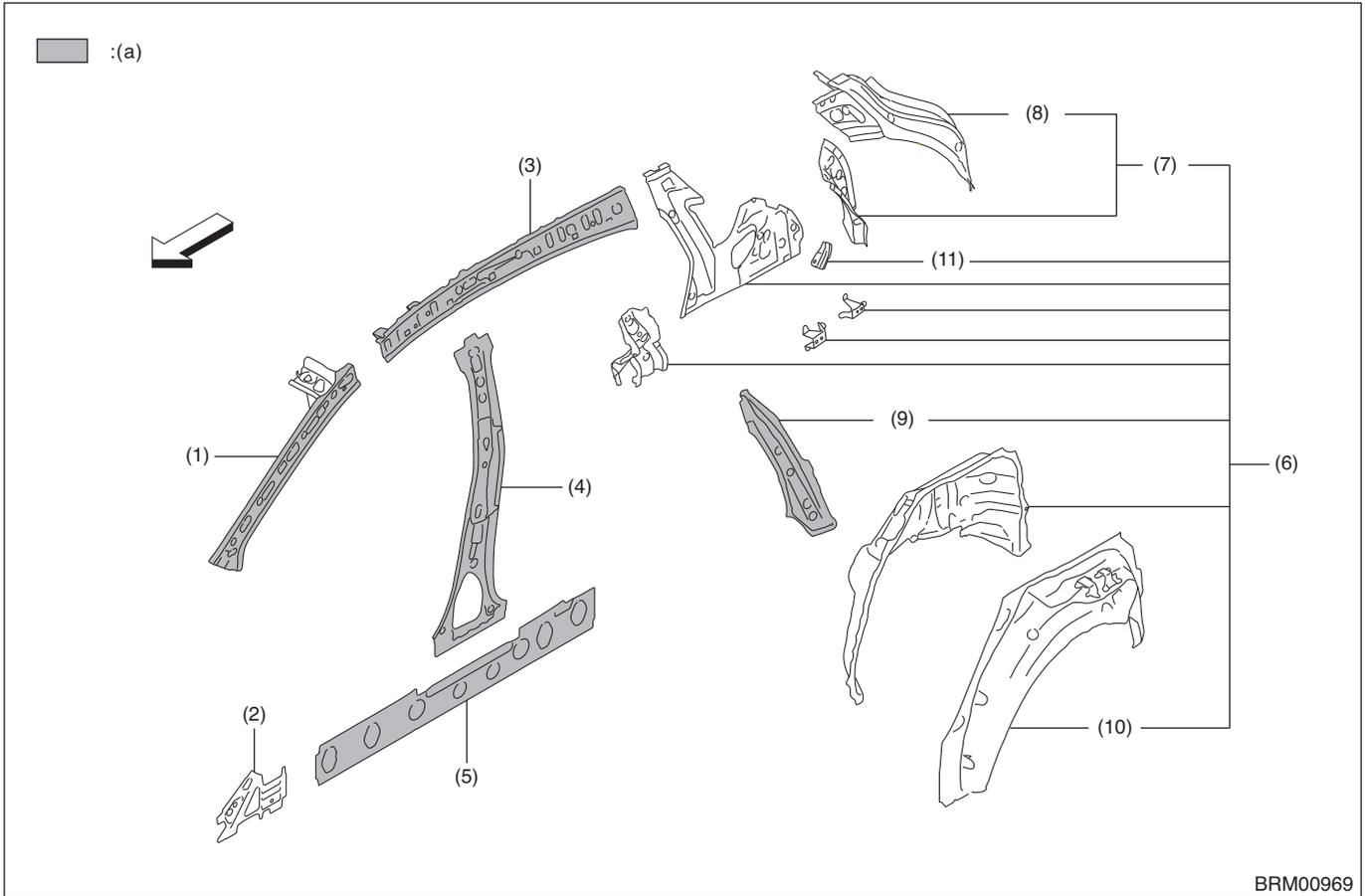


(a) High-strength tensile steel  
(440 — 590 MPa class)

- |                                   |                                  |                                  |
|-----------------------------------|----------------------------------|----------------------------------|
| (1) Pillar front inner upper      | (5) Reinforcement sill side rear | (9) Reinforcement C pillar outer |
| (2) Reinforcement sill side front | (6) Rear quarter inner           | (10) Arch rear inner             |
| (3) Rail side inner               | (7) Reinforcement COMPL D pillar | (11) Bracket retractor           |
| (4) Pillar center inner           | (8) Reinforcement D pillar       |                                  |

# Panel Components

## • 5 Door (Hybrid model)



BRM00969

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

(1) Pillar front inner upper

(2) Reinforcement sill side front

(3) Rail side inner

(4) Pillar center inner

(5) Reinforcement sill side rear

(6) Rear quarter inner

(7) Reinforcement COMPL D pillar

(8) Reinforcement D pillar

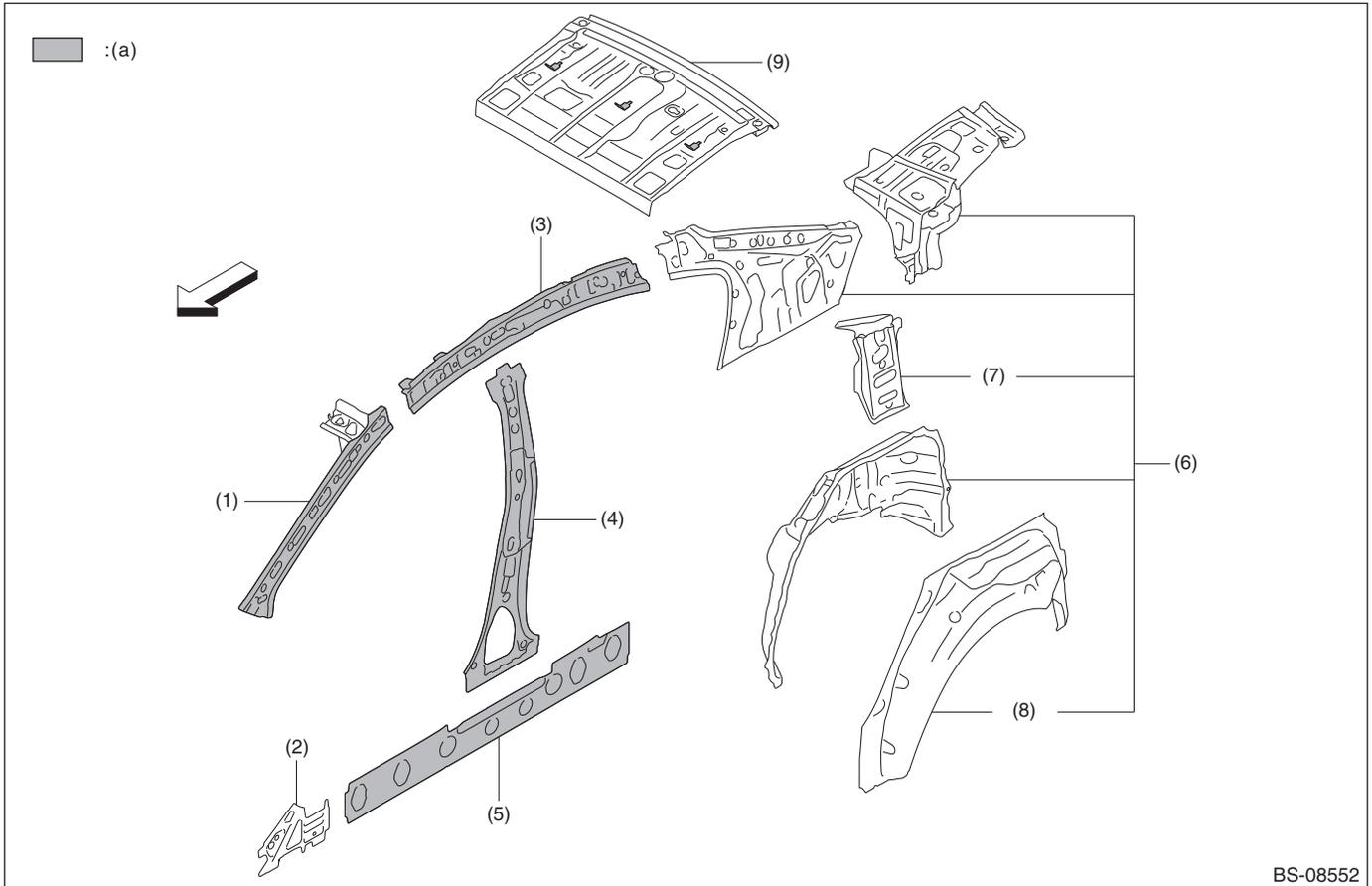
(9) Reinforcement C pillar outer

(10) Arch rear inner

(11) Bracket retractor

# Panel Components

## • 4 Door



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

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

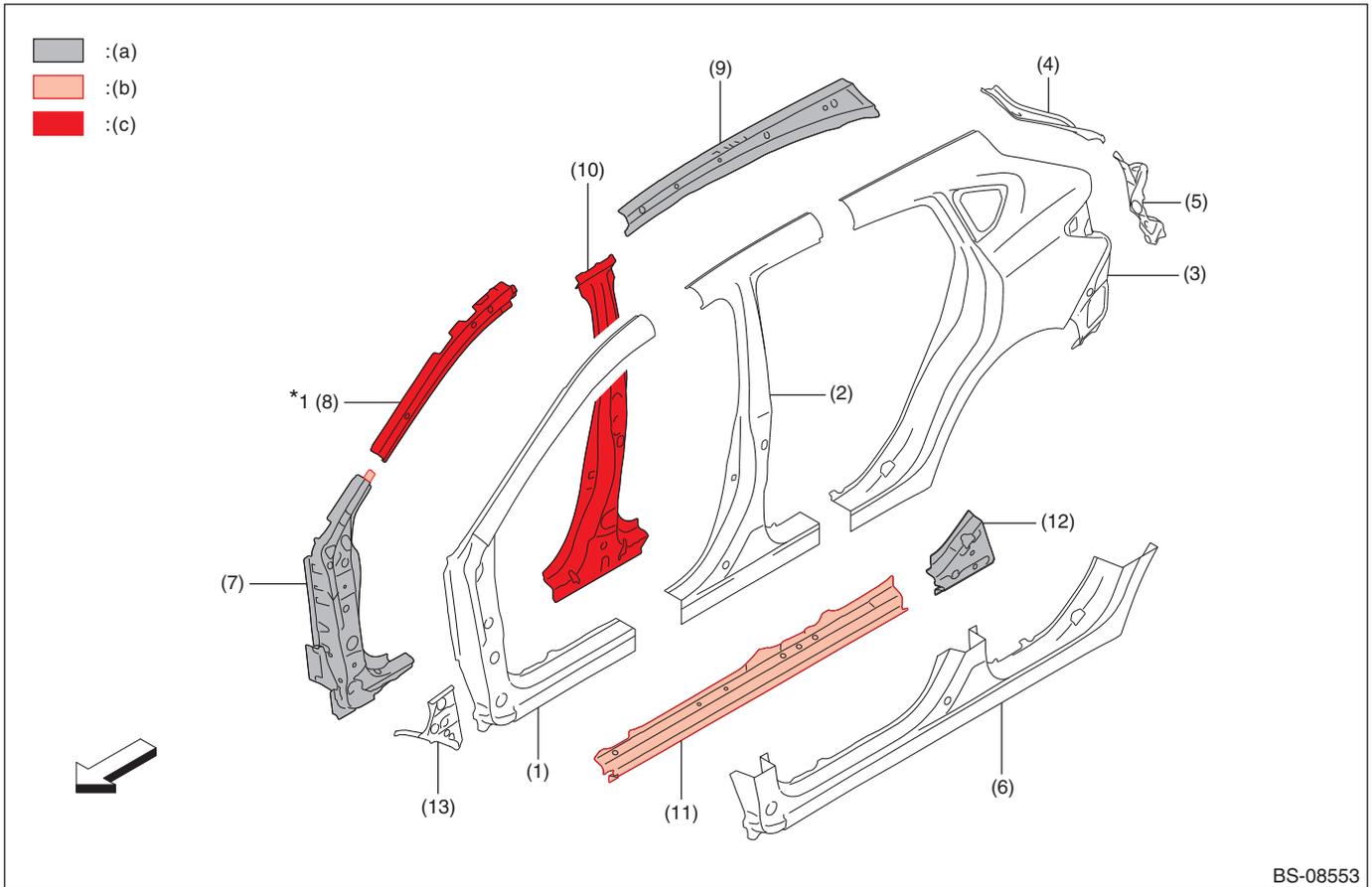
- (4) Pillar center inner
- (5) Reinforcement sill side rear
- (6) Rear quarter inner

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

# Panel Components

## 10. SIDE PANEL OUTER

• 5 Door (Gasoline model)



BS-08553

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

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

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

\*1: High-strength tensile steel RH side  
(440 — 590 MPa class)

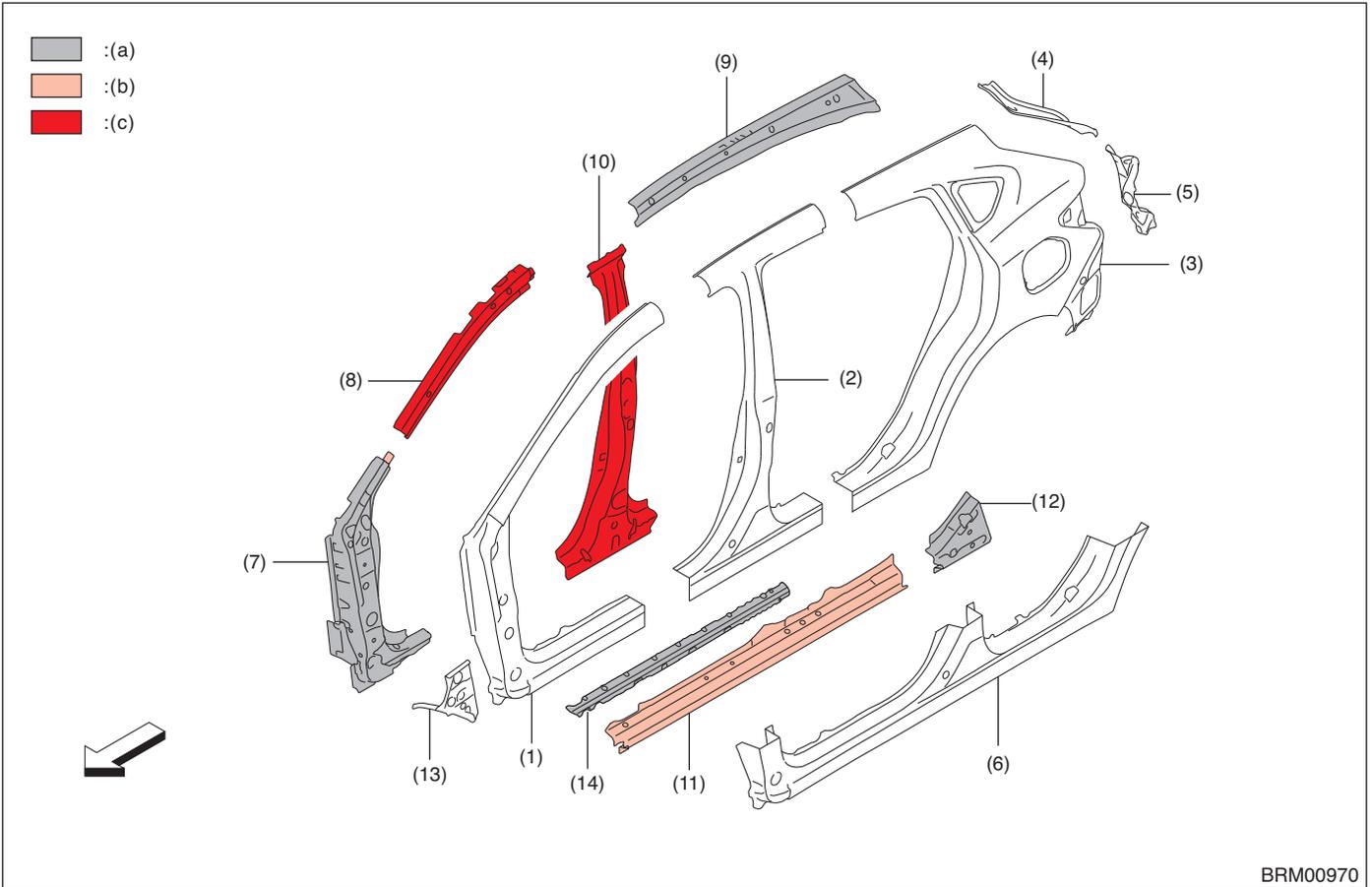
- (1) Front pillar outer
- (2) Center pillar outer
- (3) Rear quarter outer
- (4) Extension D pillar
- (5) Rear quarter end

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

- (11) Reinforcement sill side outer front
- (12) Reinforcement sill side outer rear
- (13) Gusset frame side upper

# Panel Components

## • 5 Door (Hybrid model)



BRM00970

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

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

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

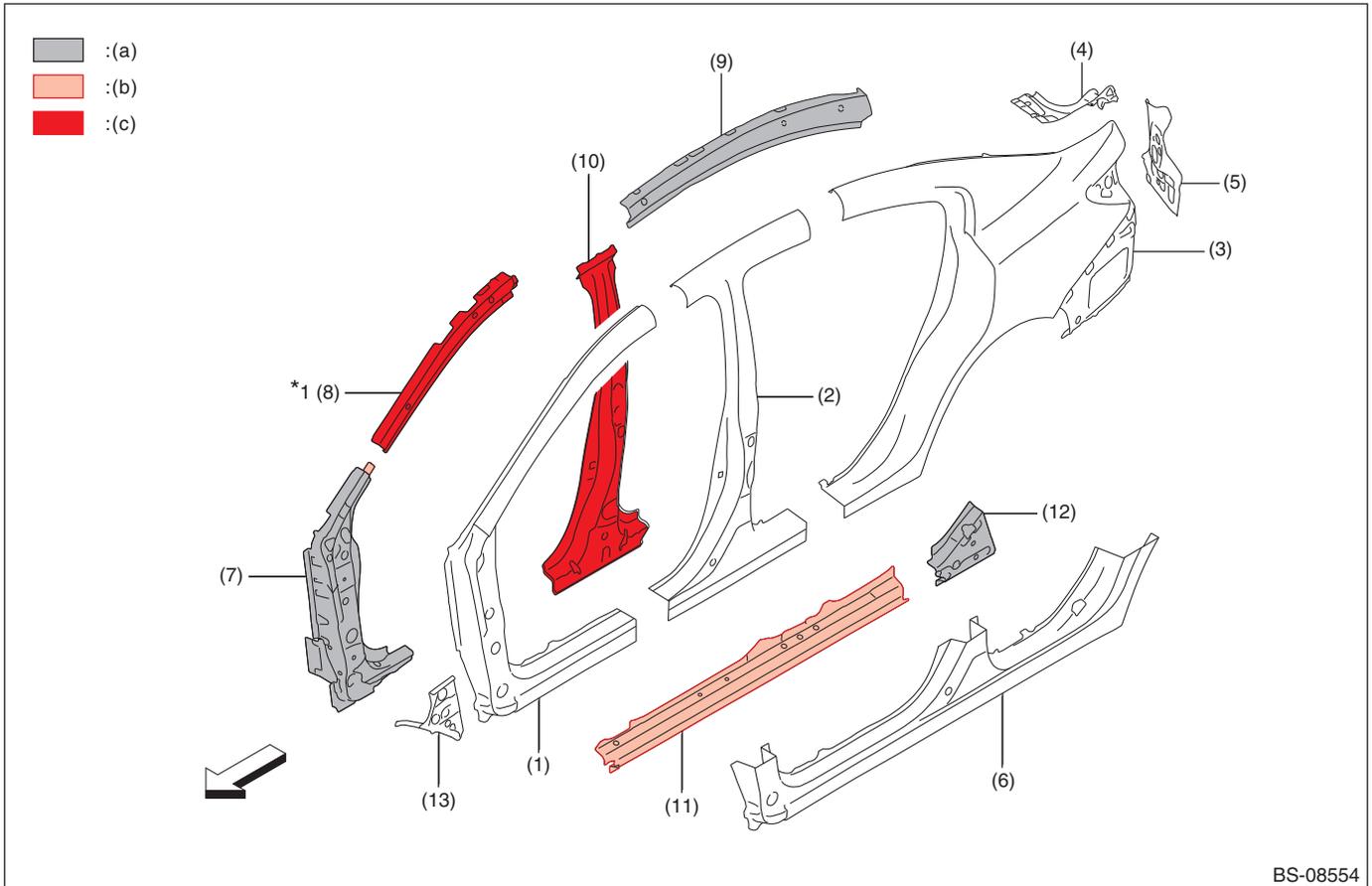
- (1) Front pillar outer
- (2) Center pillar outer
- (3) Rear quarter outer
- (4) Extension D pillar
- (5) Rear quarter end

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

- (11) Reinforcement sill side outer front
- (12) Reinforcement sill side outer rear
- (13) Gusset frame side upper
- (14) Reinforcement sill side outer A

# Panel Components

## • 4 Door



BS-08554

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

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

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

\*1: High-strength tensile steel RH side  
(440 — 590 MPa class)

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

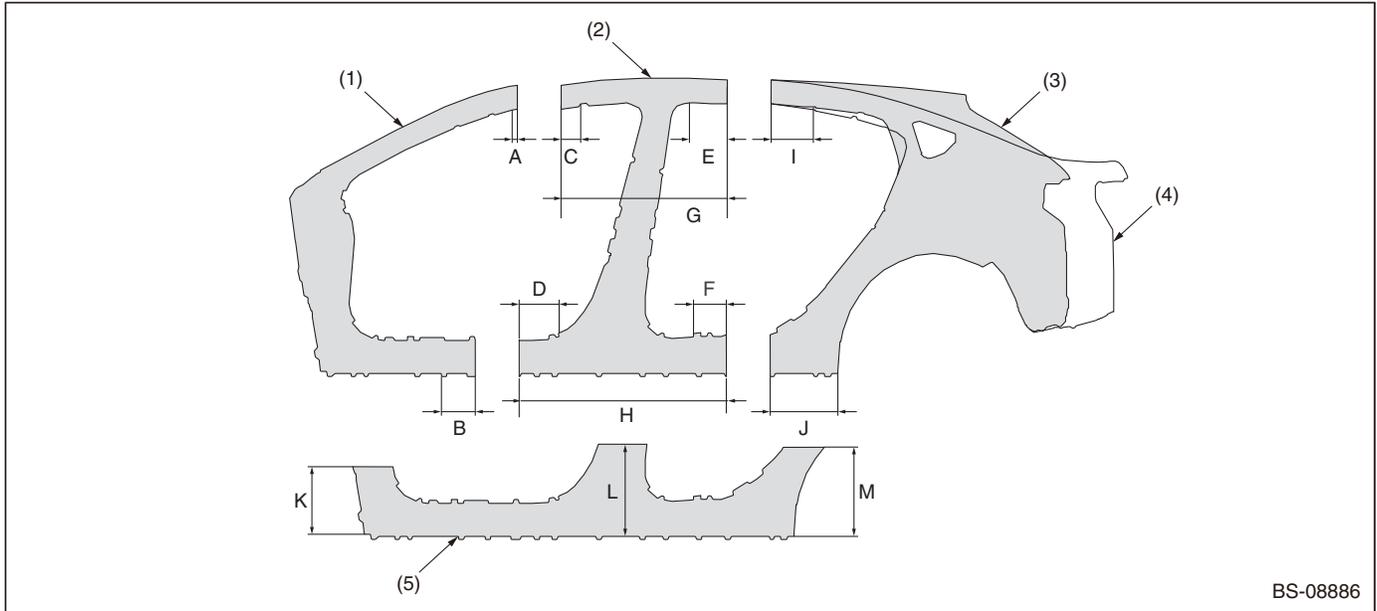
(6) Side sill outer  
(7) Reinforcement pillar front outer  
(8) Reinforcement rail side outer front  
(9) Reinforcement rail side outer rear  
(10) Reinforcement pillar center outer

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

# Panel Components

## B: Repair part size

### 1. SIDE PANEL OUTER



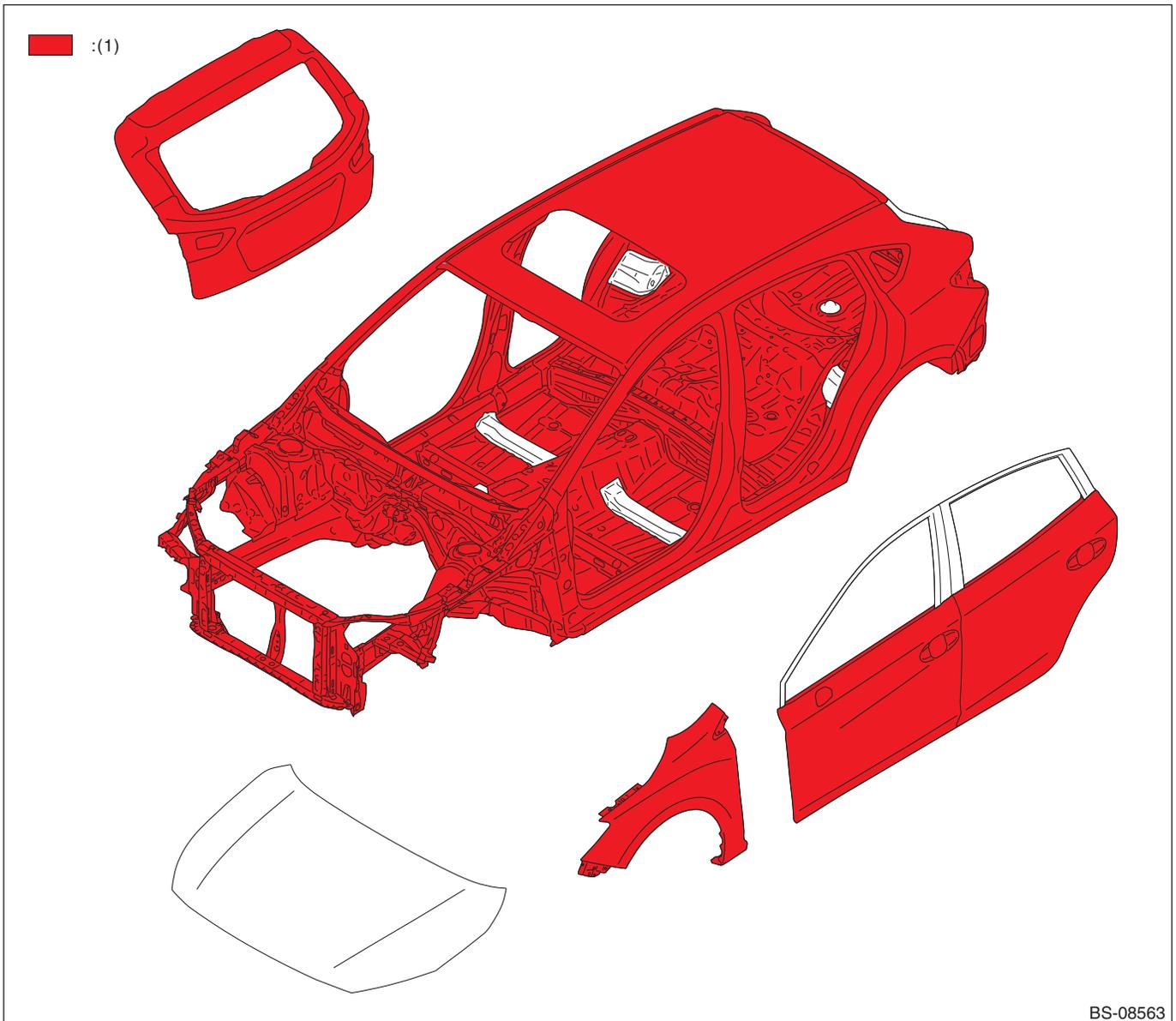
BS-08886

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

## 4. Galvanized Sheet Metal

### A: SPECIFICATIONS

- COMMON PARTS FOR 5 DOOR (Gasoline model) AND 4 DOOR

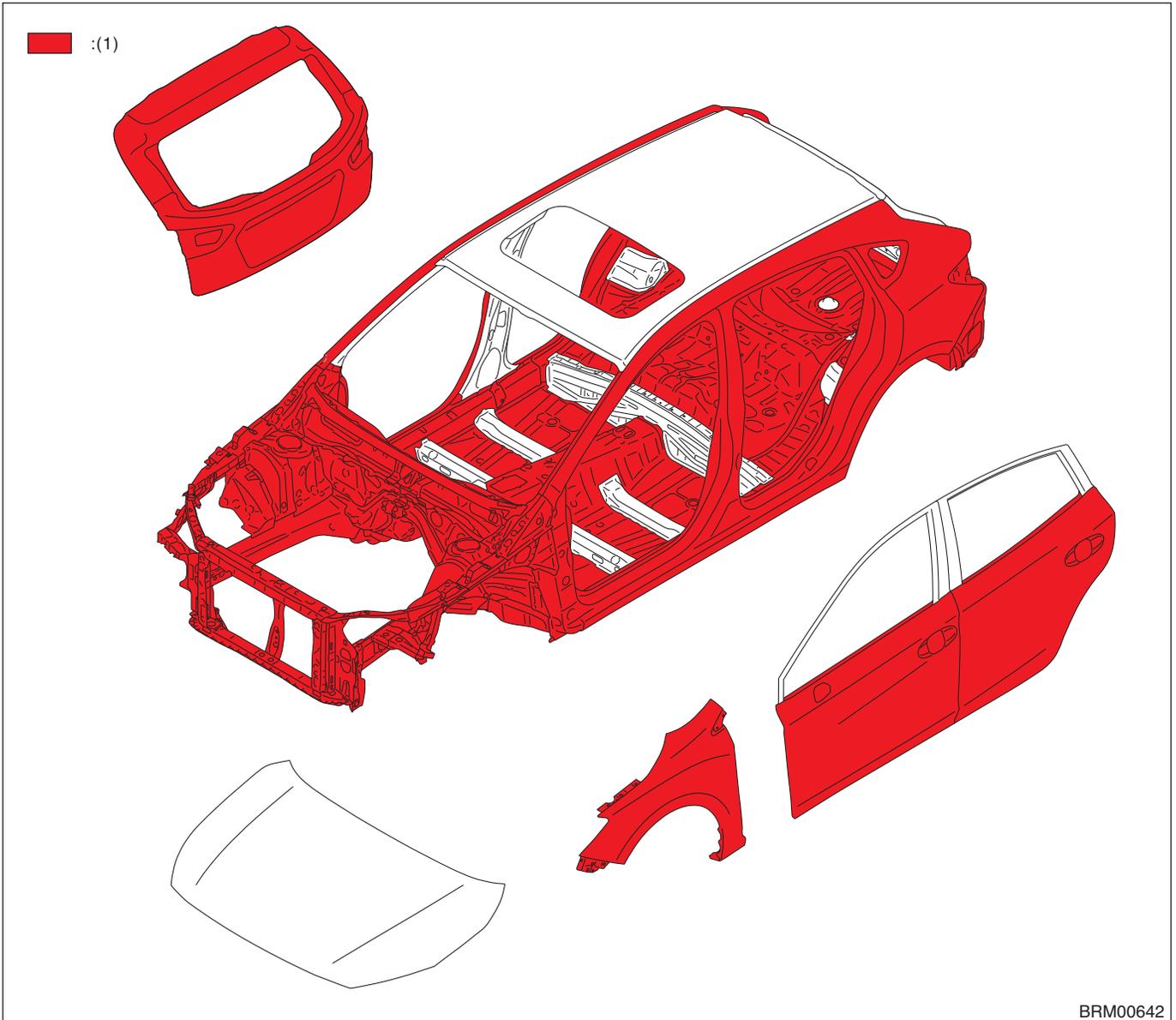


- (1) Galvanized sheet metal  
(both sides)

The fuel flap is made of Galvanized Sheet Metal

# Galvanized Sheet Metal

- XV model

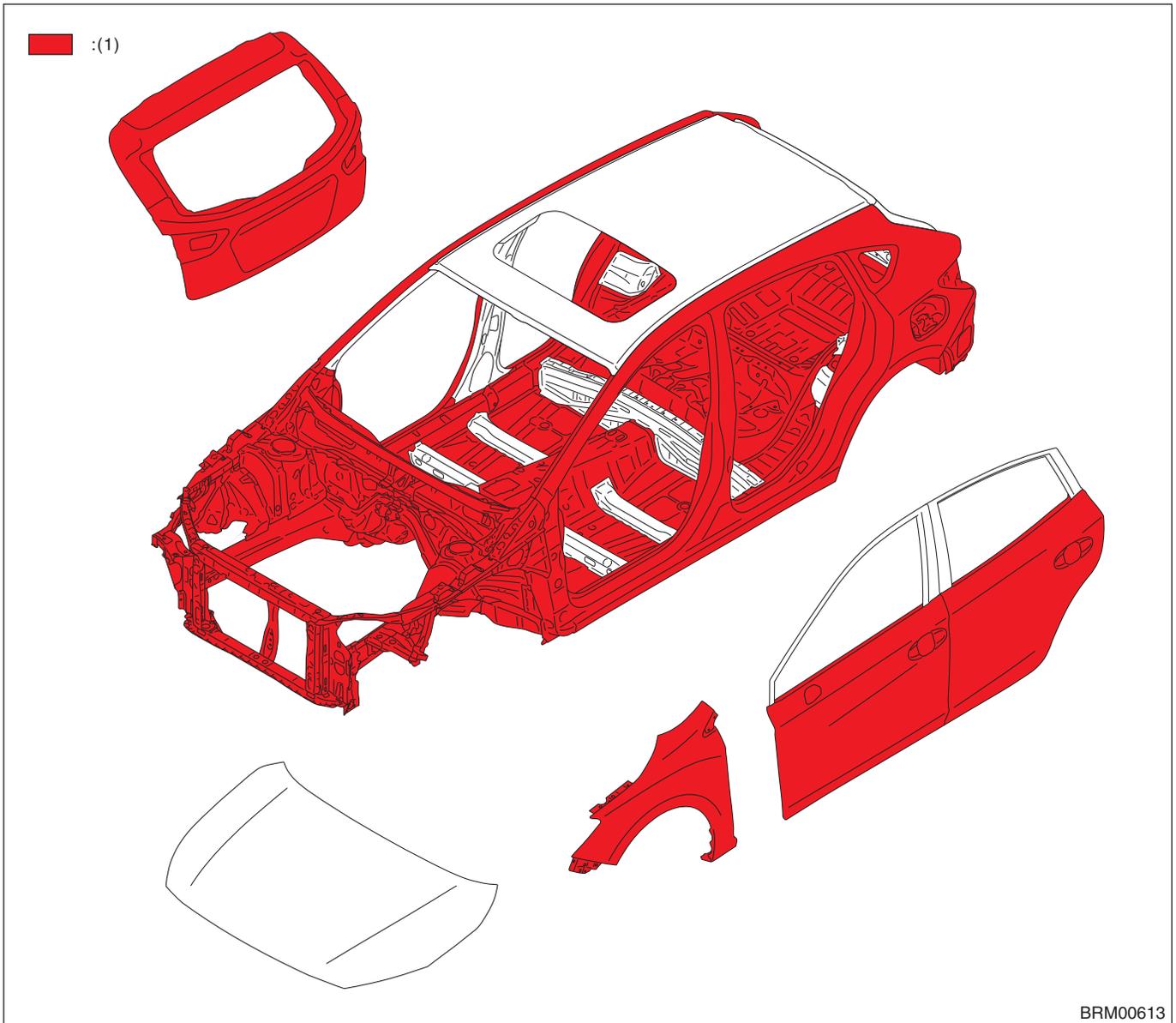


- (1) Galvanized sheet metal  
(both sides)

The fuel flap is made of Galvanized Sheet Metal

# Galvanized Sheet Metal

- Hybrid model



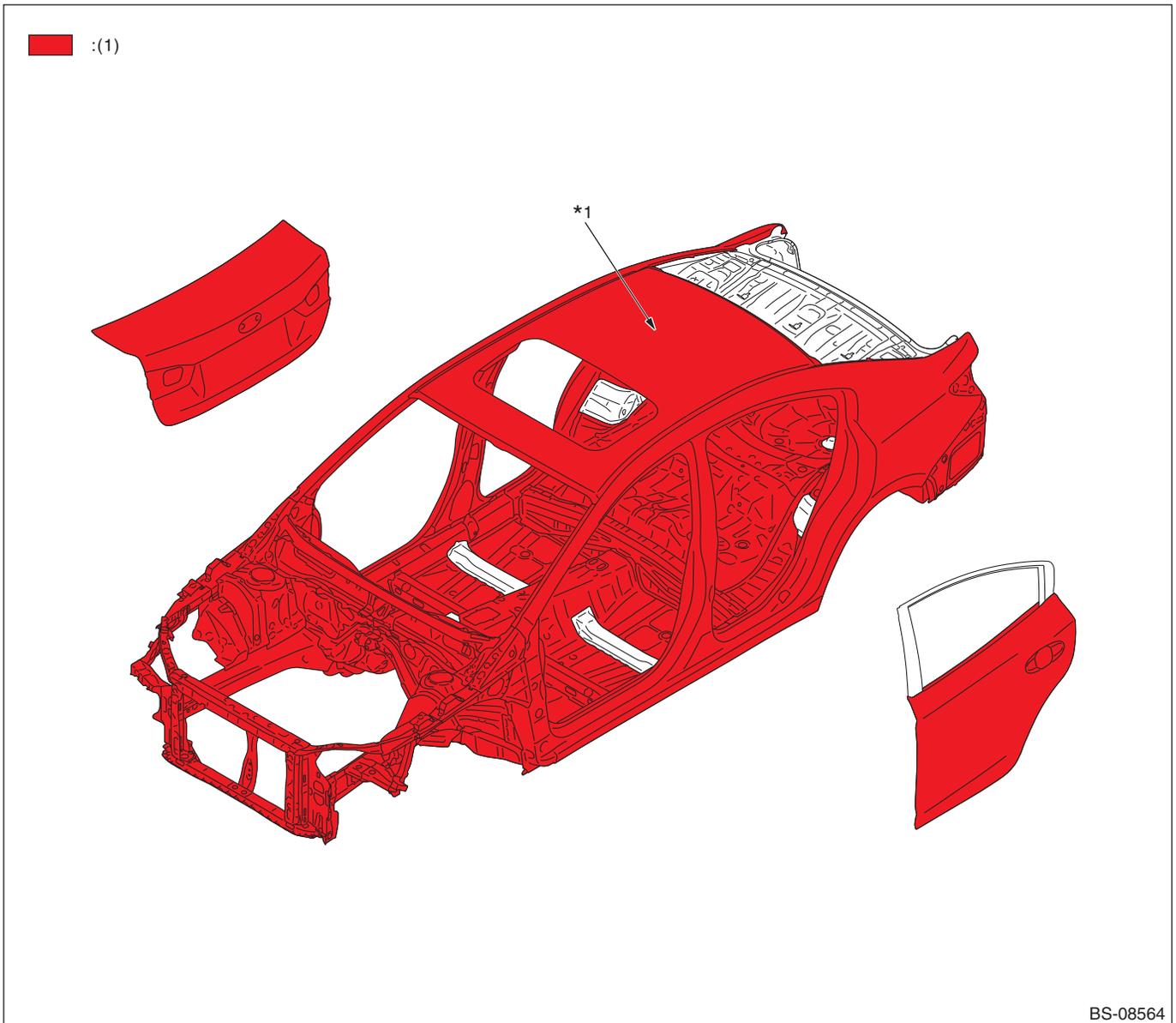
BRM00613

- (1) Galvanized sheet metal  
(both sides)

The fuel flap is made of Galvanized Sheet Metal

# Galvanized Sheet Metal

## • SPECIAL PARTS FOR 4 DOOR



- (1) Galvanized sheet metal  
(both sides)

The fuel flap is made of Galvanized Sheet Metal

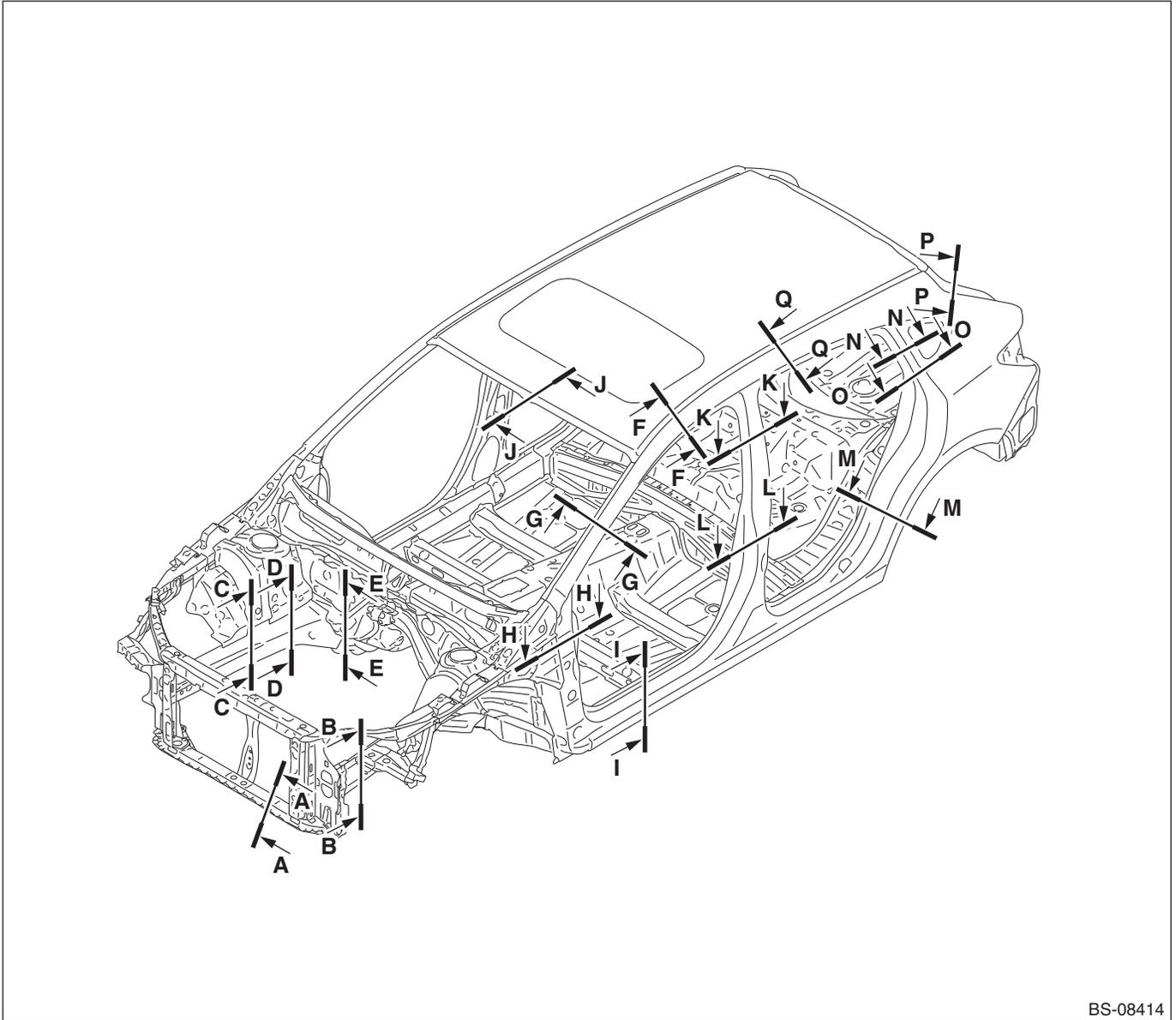
\*1: For models without a sunroof, the roof panel should not be galvanized.

# Body Construction

## 5. Body Construction

### A: SPECIFICATIONS

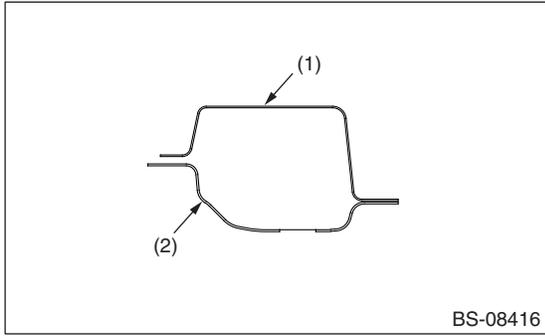
• COMMON PARTS FOR 5 DOOR AND 4 DOOR



BS-08414

# Body Construction

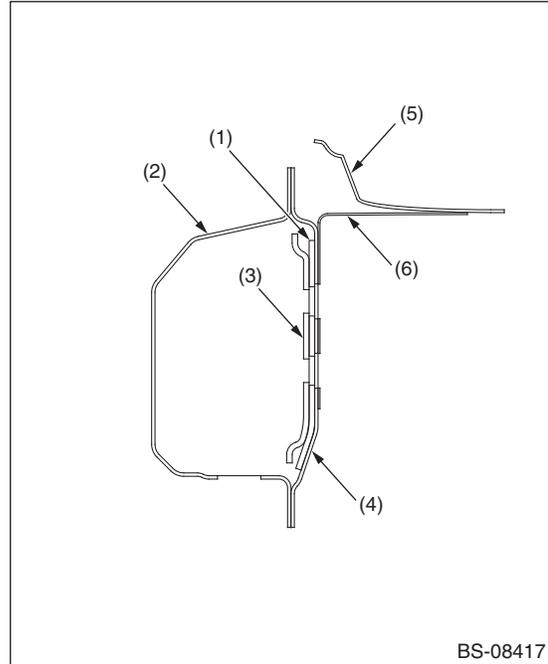
**Cross section A — A**



BS-08416

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

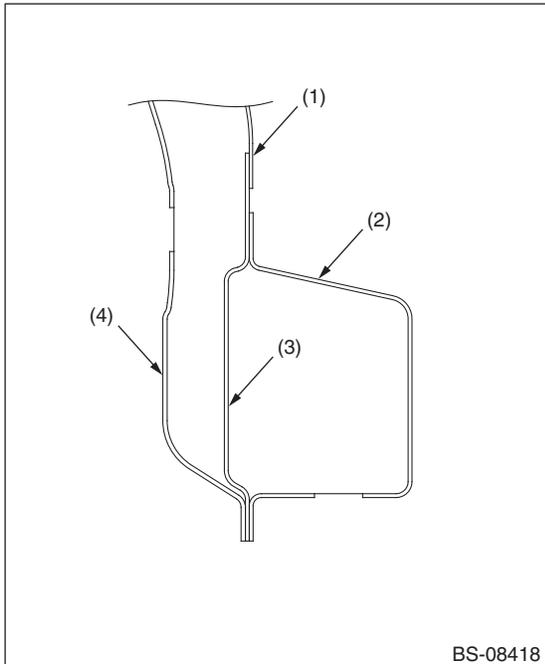
**Cross section B — B**



BS-08417

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

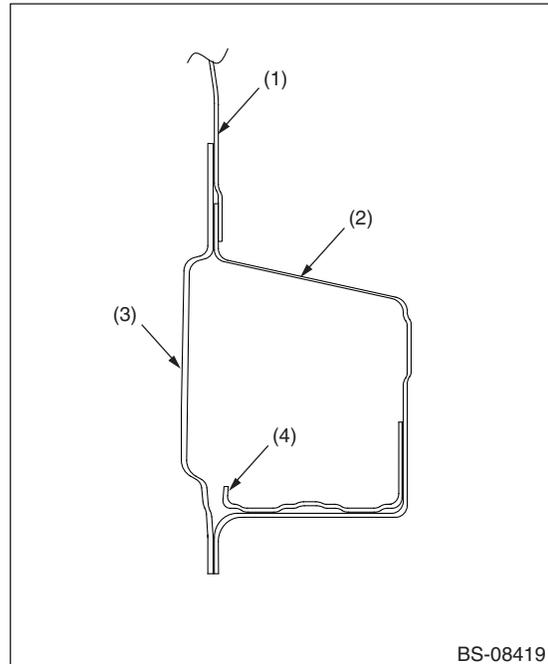
**Cross section C — C**



BS-08418

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

**Cross section D — D**

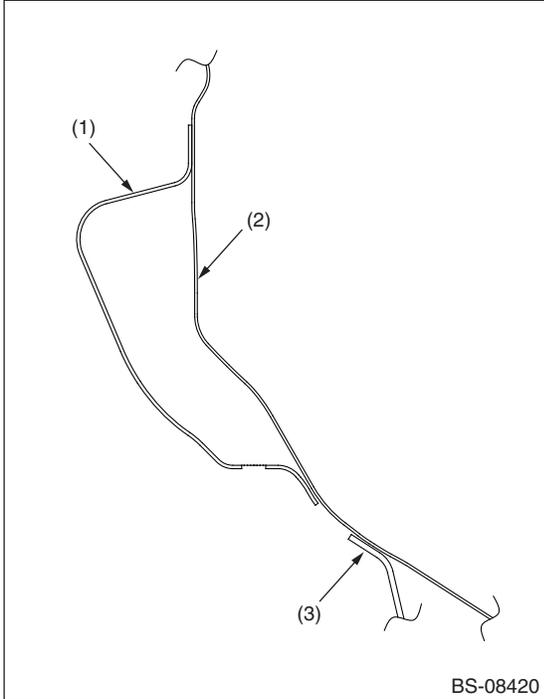


BS-08419

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

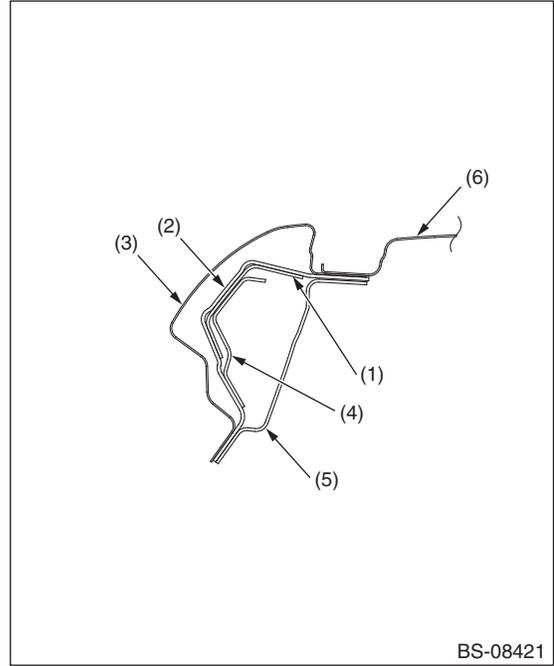
# Body Construction

Cross section E — E



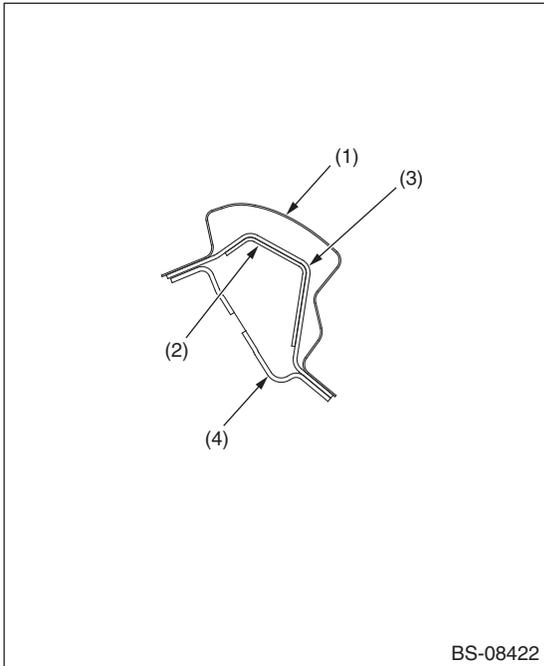
- (1) Crossmember toe board center
- (2) Toe board
- (3) Frame tunnel front

Cross section F — F



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

Cross section G — G

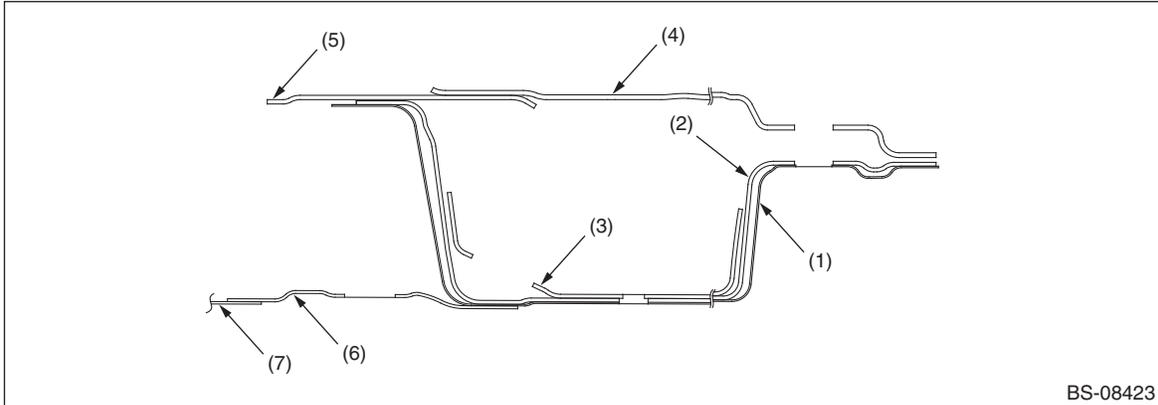


- (1) Panel side outer
- (2) Reinforcement rail side outer front A
- (3) Reinforcement rail side outer front
- (4) Pillar front inner upper

**SUBARU.**

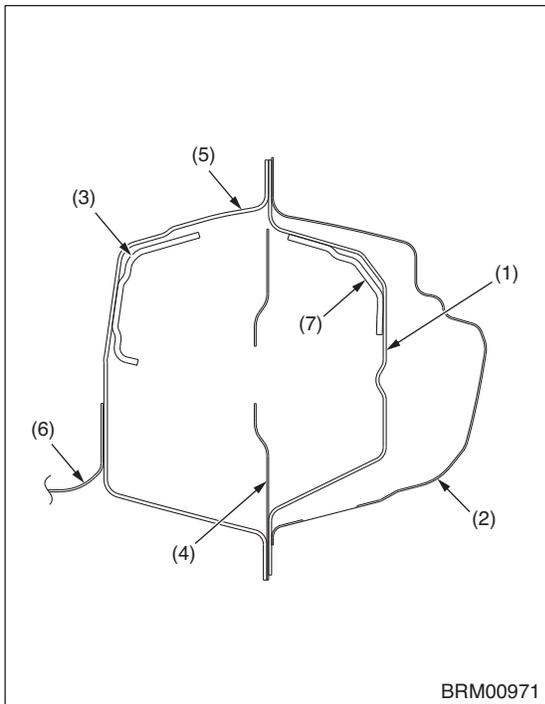
# Body Construction

**Cross section H — H**



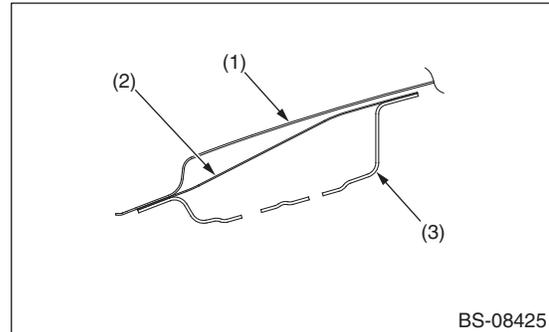
- (1) Panel side outer
- (2) Reinforcement pillar front outer
- (3) Reinforcement pillar front center
- (4) Pillar front inner lower
- (5) Pillar front inner center
- (6) Gusset frame side
- (7) Frame side upper

**Cross section I — I**



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

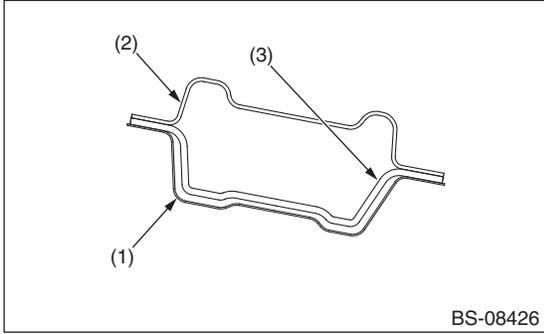
**Cross section J — J**



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

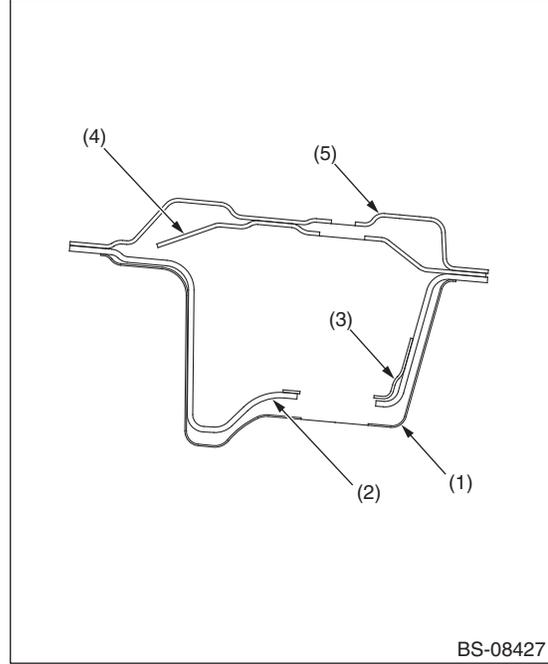
# Body Construction

**Cross section K—K**



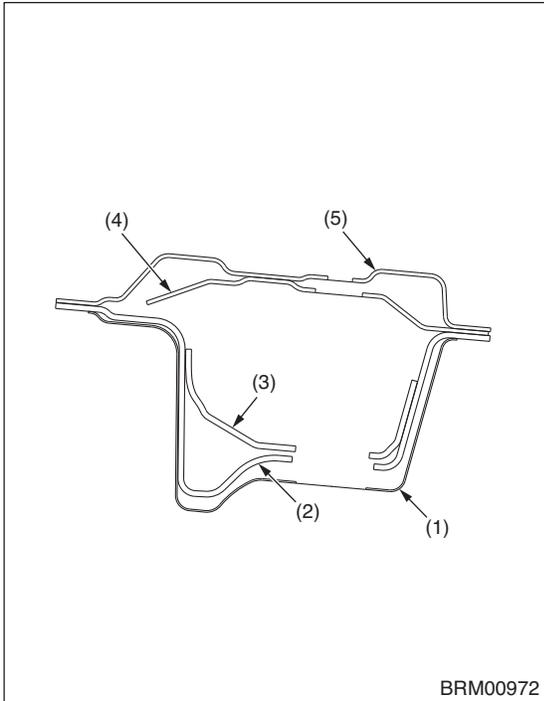
- (1) Panel side outer
- (2) Pillar center inner
- (3) Reinforcement pillar center outer

**Cross section L — L (Gasoline model)**



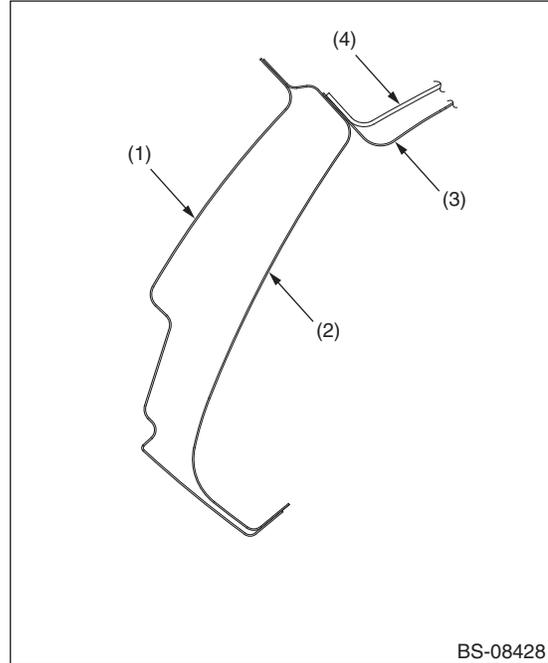
- (1) Panel side outer
- (2) Reinforcement pillar center outer
- (3) Reinforcement pillar center outer upper
- (4) Doubler pillar center
- (5) Pillar center inner

**Cross section L — L (Hybrid model)**



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

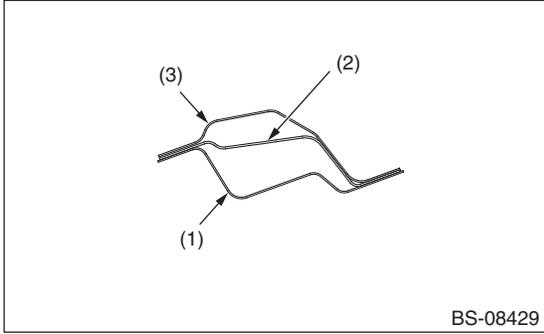
**Cross section M —M**



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

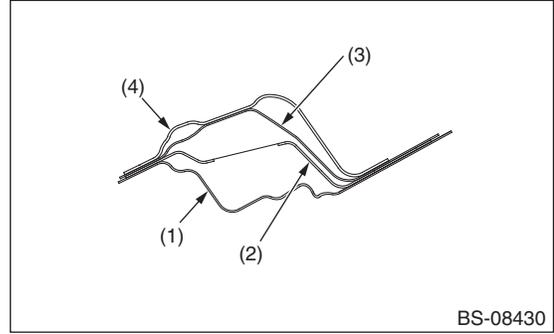
# Body Construction

**Cross section N — N**



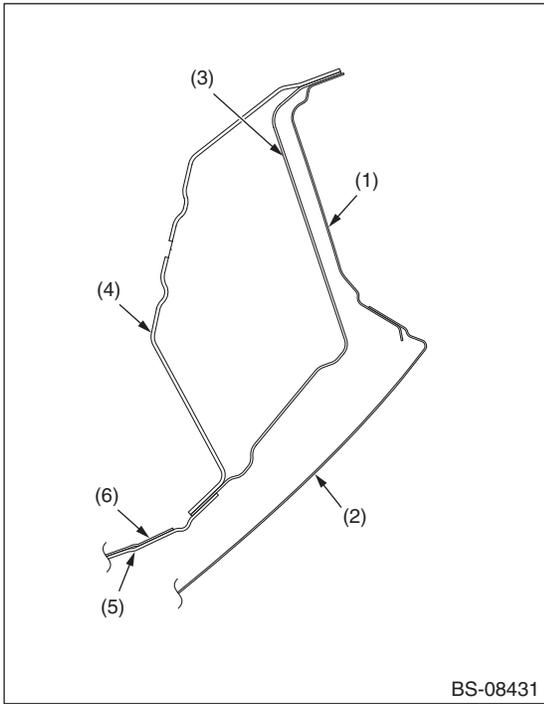
- (1) Panel side outer
- (2) Reinforcement C pillar outer
- (3) Quarter panel rear inner

**Cross section O — O**



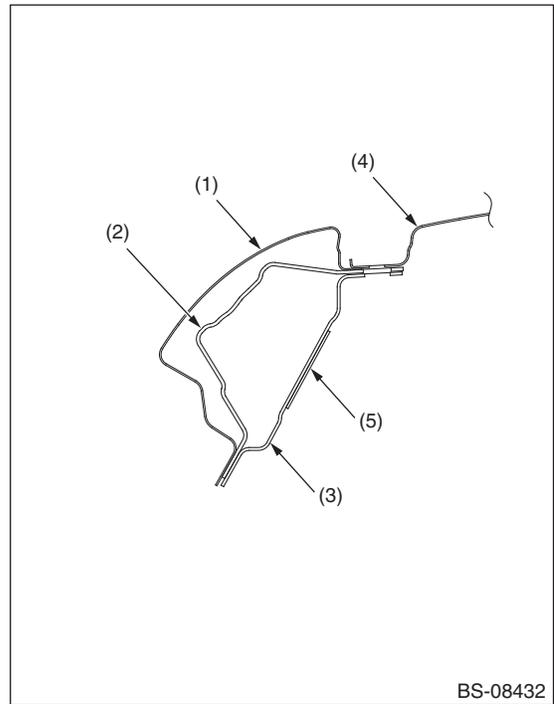
- (1) Panel side outer
- (2) Reinforcement C pillar outer
- (3) Quarter panel rear inner
- (4) Reinforcement rear apron

**Cross section P — P**



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

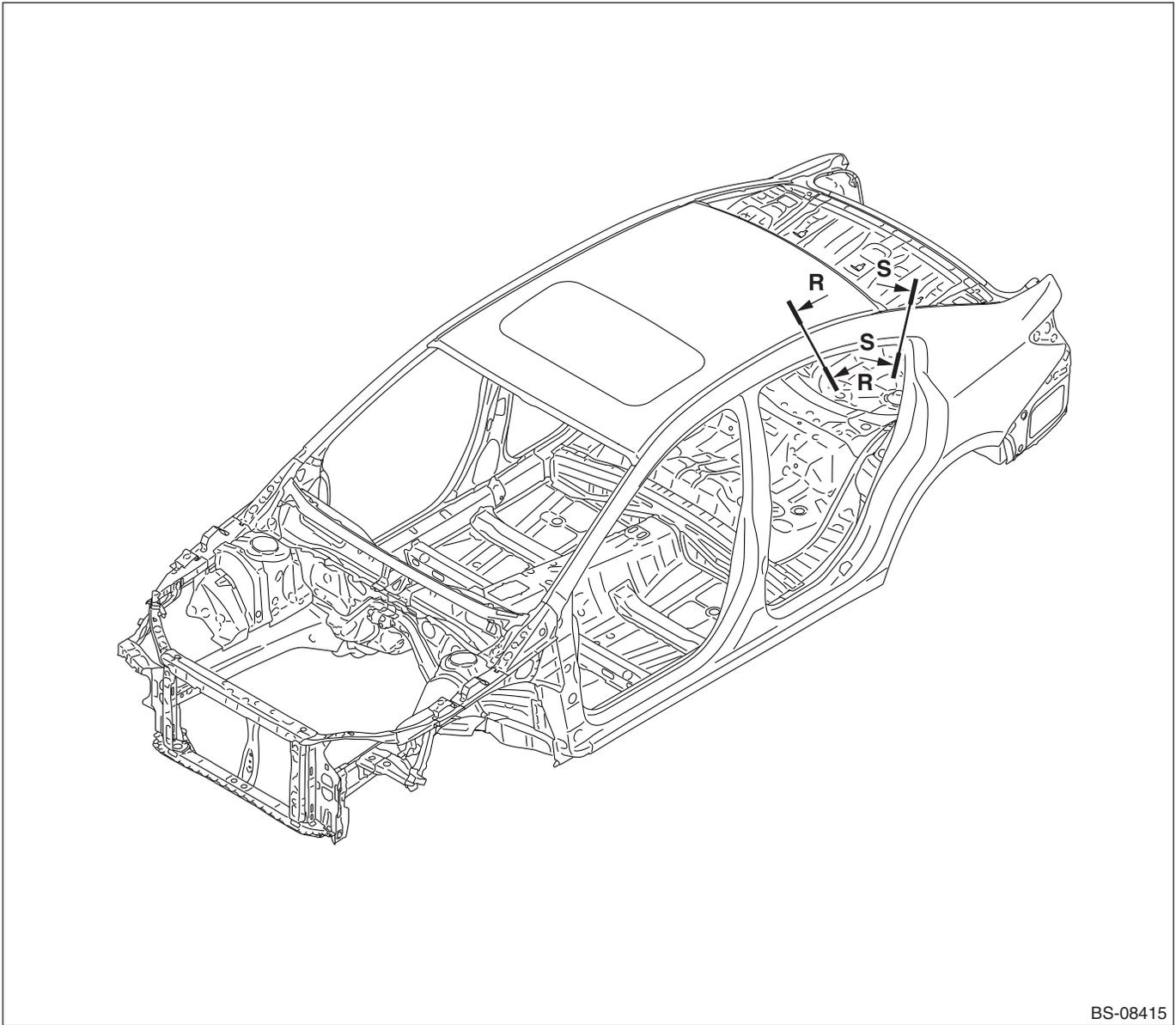
**Cross section Q — Q**



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

# Body Construction

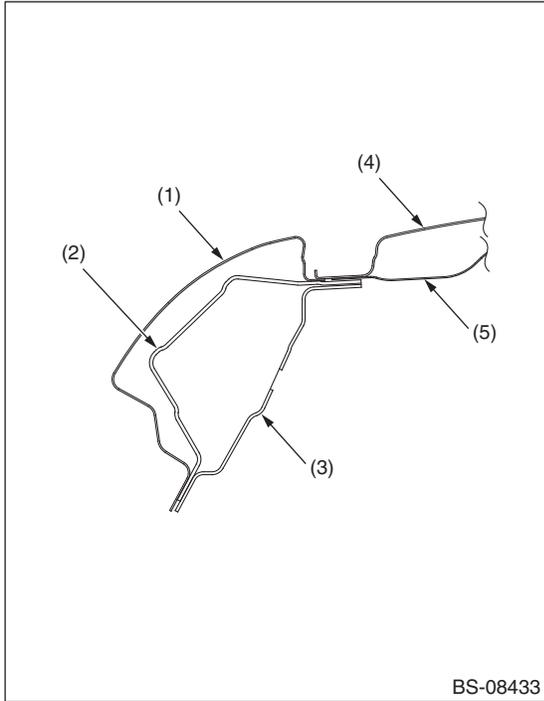
- SPECIAL 4 DOOR PARTS



BS-08415

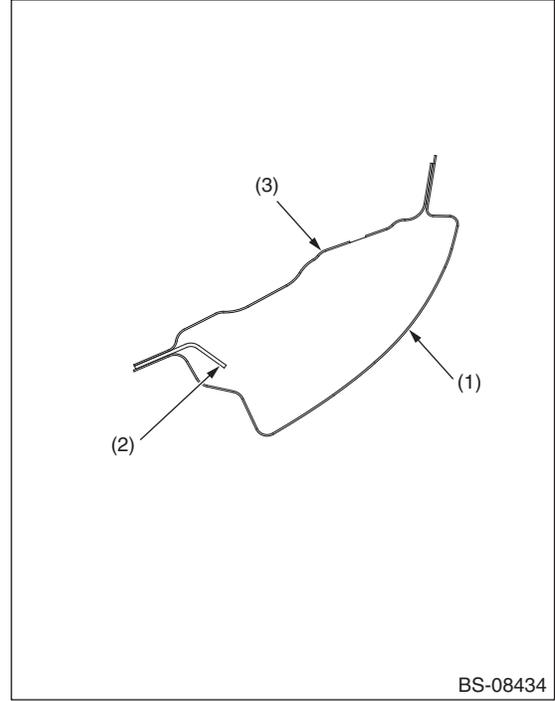
# Body Construction

Cross section R — R



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

Cross section S — S



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

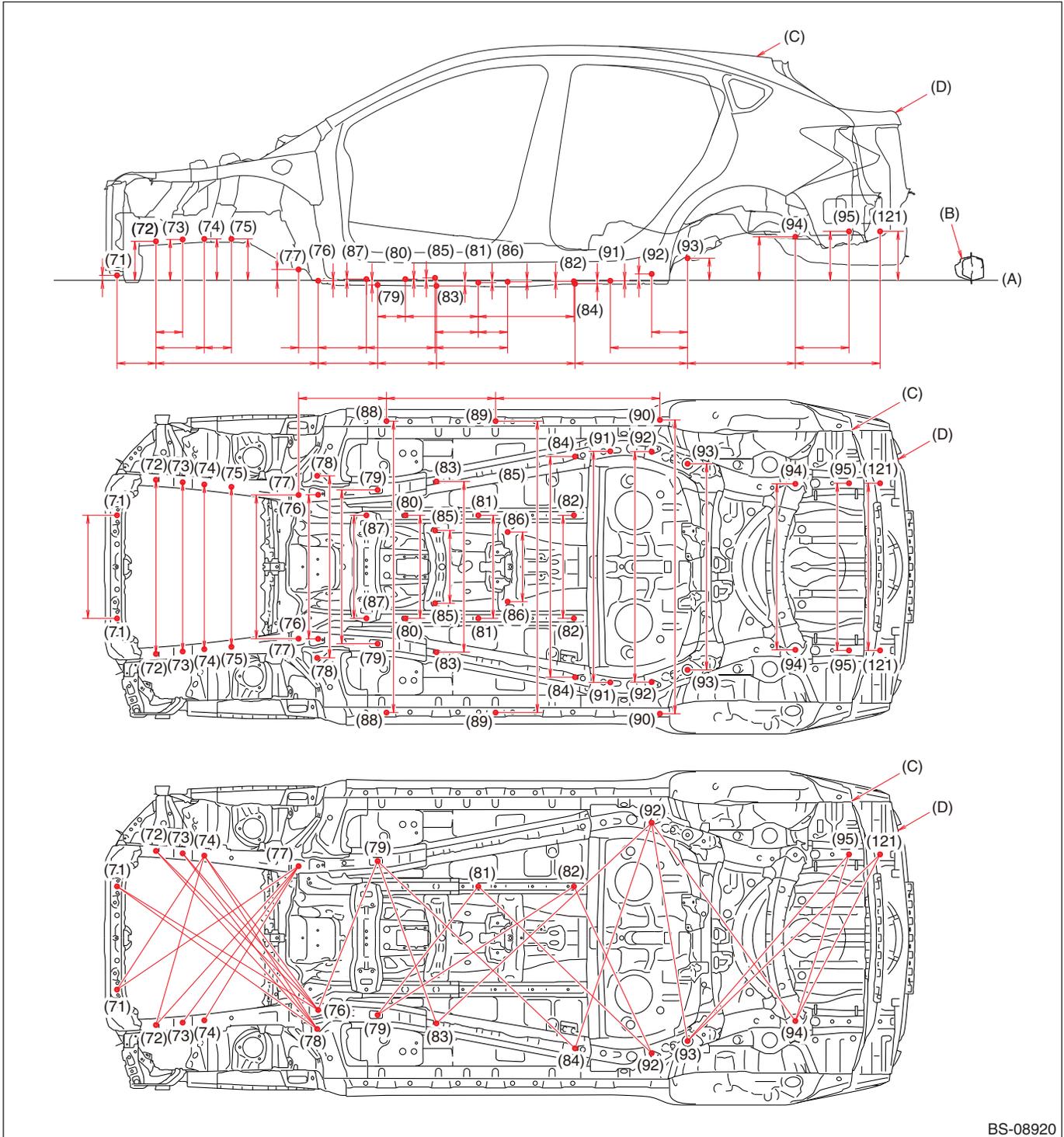
# Body Reference Points

## 6. Body Reference Points

### A: DIMENSIONS

#### 1. LOWER SURFACE

- Gasoline model

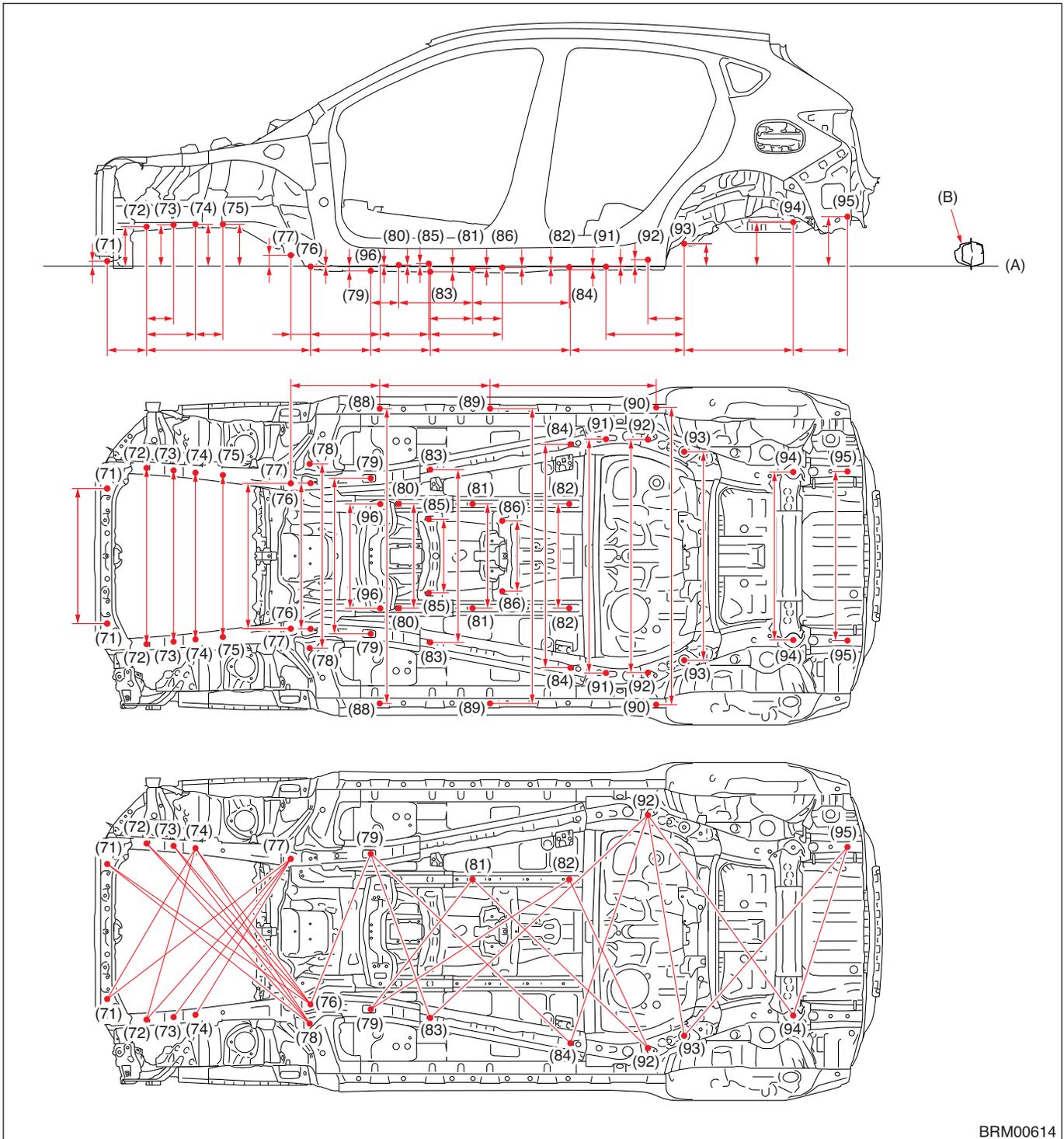


BS-08920

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

# Body Reference Points

## • Hybrid model



BRM00614

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

# Body Reference Points

- |   |   |   |
|---|---|---|
| (A) Standard line   | (C) 5 Door  | (D) 4 Door  |
| (B) Side sill outer panel   |   |   |
| (71) Under cover front mounting hole (symmetrical)                  | (80) Under cover rear mounting hole (symmetrical)                 | (89) Side spoiler mounting hole (symmetrical)                       |
| (72) Gauge hole (symmetrical)                                       | (81) Under cover rear fixing hole (symmetrical)                   | (90) Side spoiler mounting hole (symmetrical)                       |
| (73) Radio ground mounting hole (symmetrical)                       | (82) Protector tank mounting hole (symmetrical)                   | (91) Harness bracket mounting holes (symmetrical)                   |
| (74) Front crossmember mounting hole (symmetrical), front           | (83) Under cover rear fixing hole (symmetrical)                   | (92) Rear suspension support sub frame mounting hole (symmetrical)  |
| (75) Front crossmember mounting hole (symmetrical), rear            | (84) Protector tank mounting hole (symmetrical)                   | (93) Rear suspension crossmember mounting hole (symmetrical), front |
| (76) Front suspension plate mounting hole (symmetrical), inner side | (85) Exhaust cover mounting holeole (symmetrical)                 | (94) Rear suspension crossmember mounting hole (symmetrical), rear  |
| (77) Front suspension arm plate mounting hole (symmetrical)         | (86) Exhaust cover mounting holeole (symmetrical)                 | (95) Gauge hole (symmetrical)                                       |
| (78) Front suspension plate mounting hole (symmetrical), outside    | (87) * <sup>1</sup> Crossmember upper mounting hole (symmetrical) | (96) * <sup>2</sup> Crossmember upper mounting hole (symmetrical)   |
| (79) Under cover rear mounting hole (symmetrical)                   | (88) Side spoiler mounting hole (symmetrical)                     | (121) Gauge hole (symmetrical)                                      |

Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
Datum line — (71)	24 (0.94)	—
Datum line — (72)	207 (8.15)	—
Datum line — (73)	217 (8.54)	—
Datum line — (74)	220 (8.66)	—
Datum line — (75)	220 (8.66)	—
Datum line — (76)	-2 (-0.08)	—
Datum line — (77)	58 (2.28)	—
Datum line — (79)	-25 (-0.98)	—
Datum line — (80)	6 (0.24)	—
Datum line — (81)	-12 (-0.47)	—
Datum line — (82)	-5 (-0.2)	—
Datum line — (83)	-30 (-1.18)	—
Datum line — (84)	-19 (-0.75)	—
Datum line — (85)	13 (0.51)	—
Datum line — (86)	-8 (-0.31)	—
* <sup>1</sup> Datum line — (87)	6 (0.24)	—
Datum line — (91)	-3 (-0.12)	—
Datum line — (92)	34 (1.34)	—
Datum line — (93)	118 (4.65)	—
Datum line — (94)	231 (9.09)	—
Datum line — (95)	260 (10.24)	—
* <sup>2</sup> Datum line — (96)	6 (0.24)	—
Datum line — (121)	260 (10.24)	—
(71) — (72)	209 (8.23)	—

Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
(72) — (73)	142 (5.59)	—
(72) — (74)	257 (10.12)	—
(72) — (76)	862 (33.94)	—
(74) — (75)	144 (5.67)	—
(76) — (77)	104 (4.09)	—
(76) — (79)	316 (12.44)	—
* <sup>1</sup> (76) — (87)	257 (10.12)	—
* <sup>2</sup> (76) — (96)	367 (14.45)	—
(79) — (80)	147 (5.79)	—
(79) — (83)	313 (12.32)	—
(80) — (81)	388 (15.28)	—
(81) — (82)	508 (20.00)	—
(81) — (85)	230 (9.06)	—
(81) — (86)	156 (6.14)	—
(83) — (84)	737 (29.02)	—
(84) — (93)	598 (23.54)	—
(85) — (86)	386 (15.20)	—
* <sup>1</sup> (85) — (87)	365 (14.37)	—
* <sup>2</sup> (85) — (96)	255 (10.34)	—
(91) — (93)	411 (16.18)	—
(92) — (93)	190 (7.48)	—
(93) — (94)	573 (22.56)	—
(94) — (95)	285 (11.22)	—
(94) — (121)	450 (17.72)	—

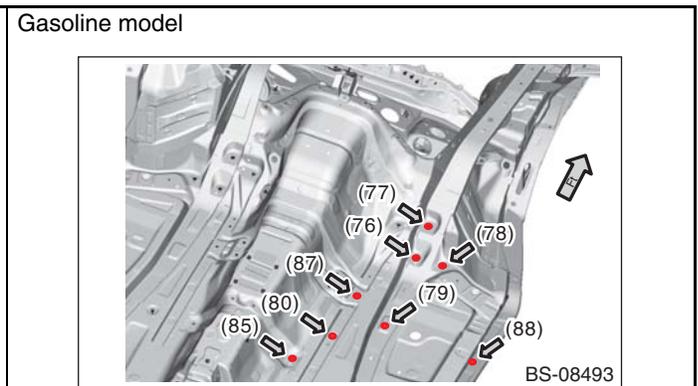
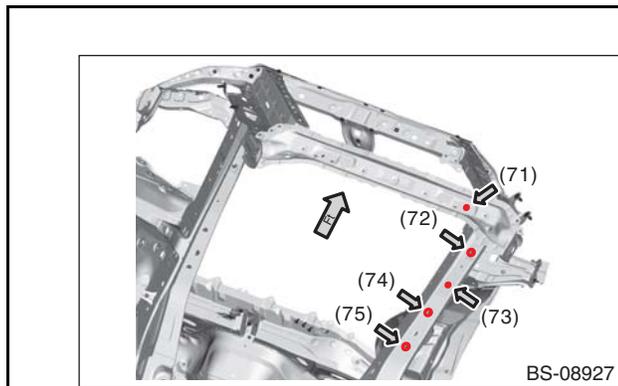
## Body Reference Points

Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
(77) — (88)	467 (18.39)	—
(88) — (89)	580 (22.83)	—
(89) — (90)	873 (34.37)	—
(71)R — (71)L	560 (22.05)	—
(72)R — (72)L	926 (36.46)	—
(73)R — (73)L	900 (35.43)	—
(74)R — (74)L	876 (34.49)	—
(75)R — (75)L	851 (33.50)	—
(76)R — (76)L	766 (30.16)	—
(77)R — (77)L	764 (30.08)	—
(78)R — (78)L	968 (38.11)	—
(79)R — (79)L	818 (32.20)	—
(80)R — (80)L	548 (21.57)	—
(81)R — (81)L	548 (21.57)	—
(82)R — (82)L	548 (21.57)	—
(83)R — (83)L	908 (35.75)	—
(84)R — (84)L	1,174 (46.22)	—
(85)R — (85)L	387 (15.24)	—
(86)R — (86)L	370 (14.57)	—
* <sup>1</sup> (87)R — (87)L	548 (21.57)	—
(88)R — (88)L	1,550 (61.02)	—
(89)R — (89)L	1,550 (61.02)	—
(90)R — (90)L	1,562 (61.50)	—
(91)R — (91)L	1,229 (48.39)	—
(92)R — (92)L	1,225 (48.23)	—
(93)R — (93)L	1,096 (43.15)	—
(94)R — (94)L	883 (34.76)	—
(95)R — (95)L	889 (35.00)	—
* <sup>2</sup> (96)R — (96)L	548 (21.57)	—
(121)R — (121)L	889 (35.00)	—

Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
(71)R — (74)L	878 (34.57)	856 (33.70)
(71)L — (76)R	1,260 (49.61)	1,260 (49.61)
(71)R — (77)L	1,172 (46.14)	1,172 (46.14)
(71)L — (78)R	1,312 (51.65)	1,312 (51.65)
(72)R — (74)L	937 (36.89)	937 (36.89)
(72)L — (76)R	1,226 (48.27)	1,208 (47.56)
(72)R — (77)L	1,145 (45.08)	1,135 (44.68)
(72)L — (78)R	1,294 (50.94)	1,277 (50.28)
(73)L — (76)R	1,123 (44.21)	1,101 (43.35)
(73)R — (77)L	1,047 (41.22)	1,035 (40.75)
(73)L — (78)R	1,197 (47.13)	1,176 (46.3)
(74)L — (76)R	1,044 (41.10)	1,020 (40.16)
(74)R — (77)L	975 (38.39)	961 (37.83)
(74)L — (78)R	1,122 (44.17)	1,100 (43.31)
(76)R — (79)L	853 (33.58)	853 (33.58)
(79)R — (81)L	868 (34.17)	868 (34.17)
(79)R — (82)L	1,247 (49.09)	1,247 (49.09)
(79)L — (83)R	918 (36.14)	918 (36.14)
(79)L — (84)R	1,447 (56.97)	1,447 (56.97)
(81)L — (92)R	1,280 (50.39)	1,279 (50.35)
(82)L — (92)R	979 (38.54)	978 (38.5)
(83)R — (92)L	1,565 (61.61)	1,564 (61.57)
(84)R — (92)L	1,268 (49.92)	1,267 (49.88)
(92)L — (93)R	1,179 (46.42)	1,176 (46.3)
(92)L — (94)R	1,316 (51.81)	1,302 (51.26)
(93)R — (95)L	1,320 (51.97)	1,312 (51.65)
(93)R — (121)L	1,432 (56.38)	1,425 (56.1)
(94)R — (95)L	931 (36.65)	931 (36.65)
(94)R — (121)L	994 (39.13)	994 (39.13)

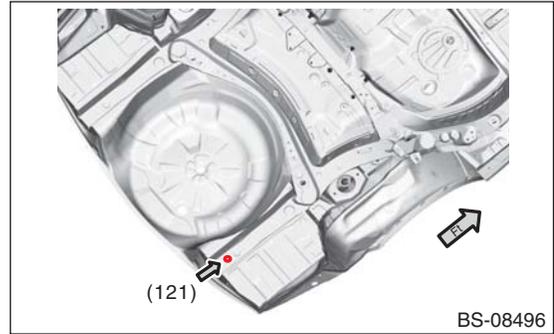
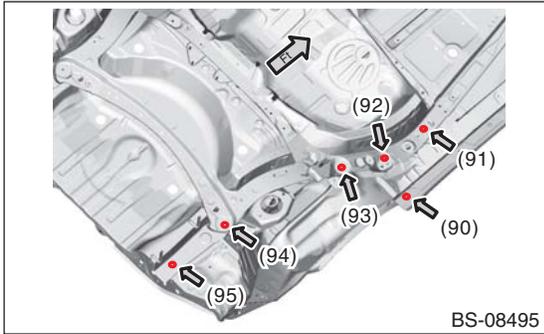
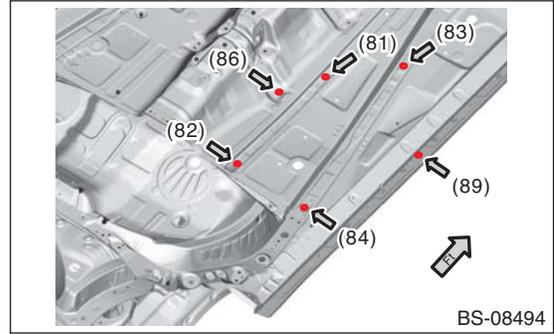
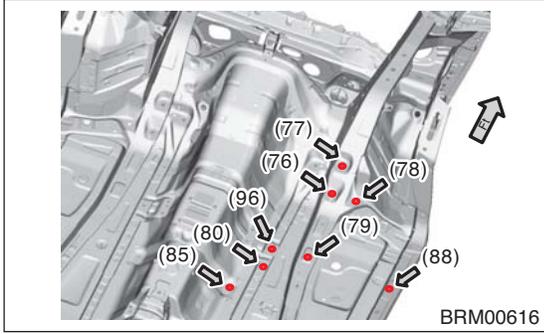
\*<sup>1</sup>: Gasoline model

\*<sup>2</sup>: Hybrid model



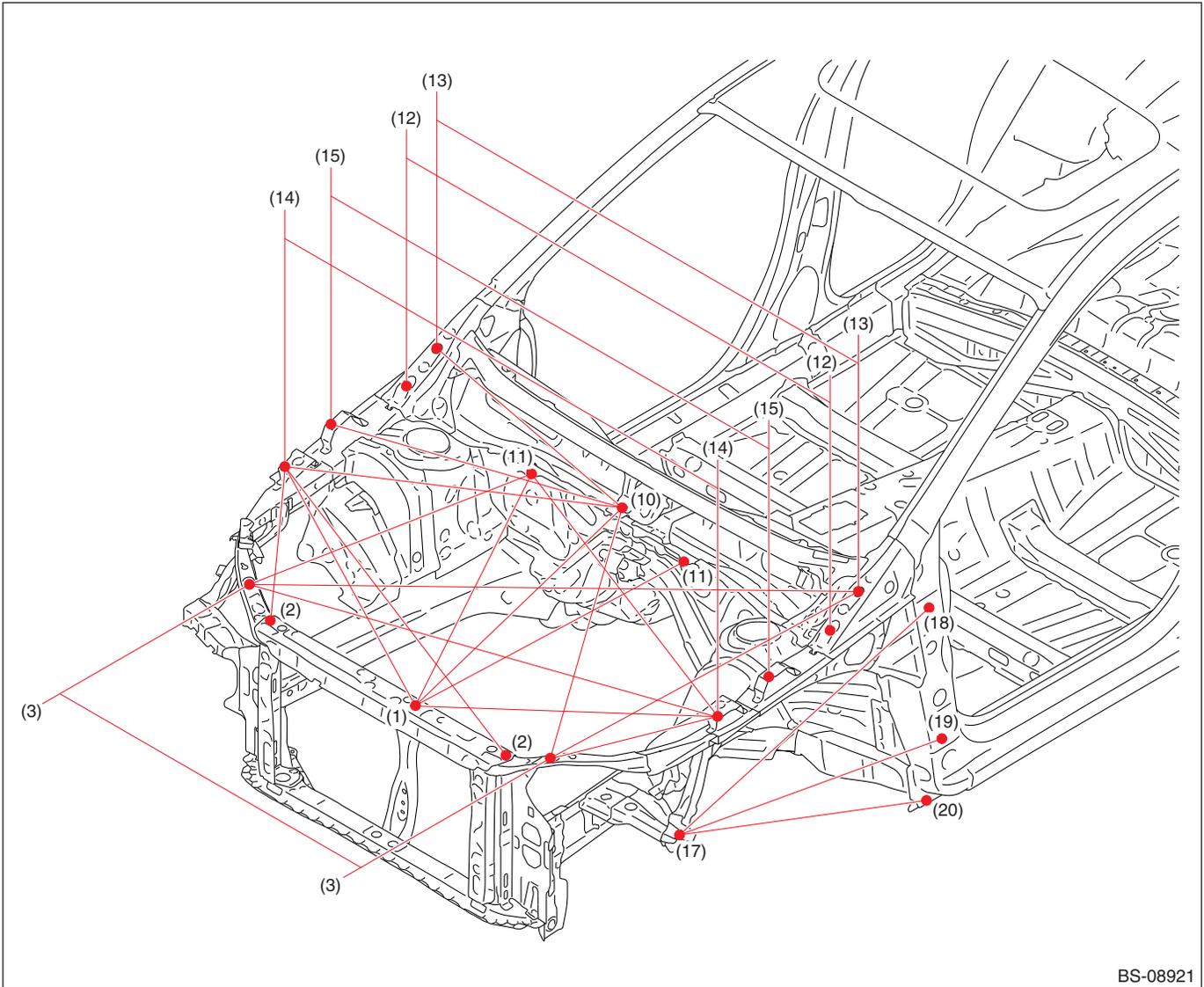
# Body Reference Points

Hybrid model



# Body Reference Points

## 2. FRONT 1



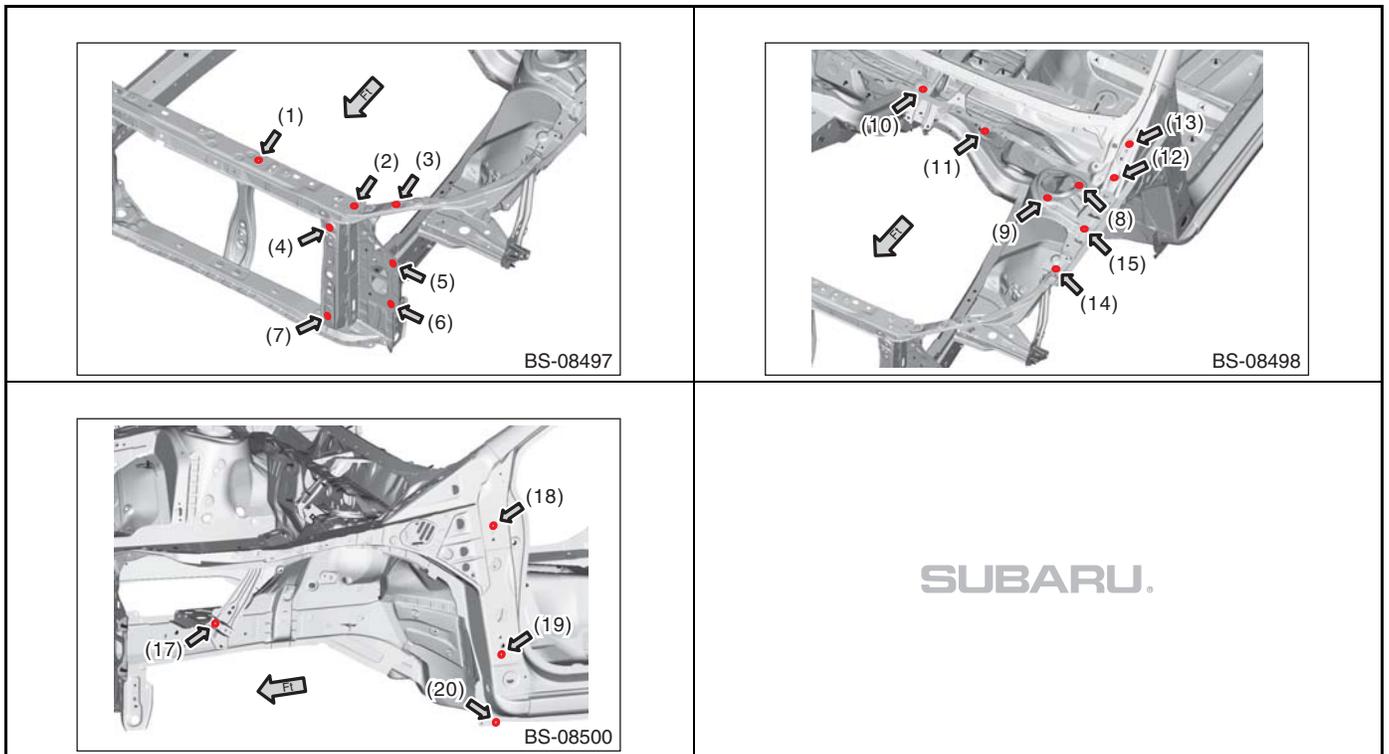
- |  |  |   |
|--|--|---|
| (1) Cover upper mounting hole (left side)            | (12) Gauge hole (symmetrical)                    | (18) Front door hinge upper mounting hole (symmetrical), upper side |
| (2) Radiator upper frame mounting hole (symmetrical) | (13) Hood hinge rear mounting hole (symmetrical)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

# Body Reference Points

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

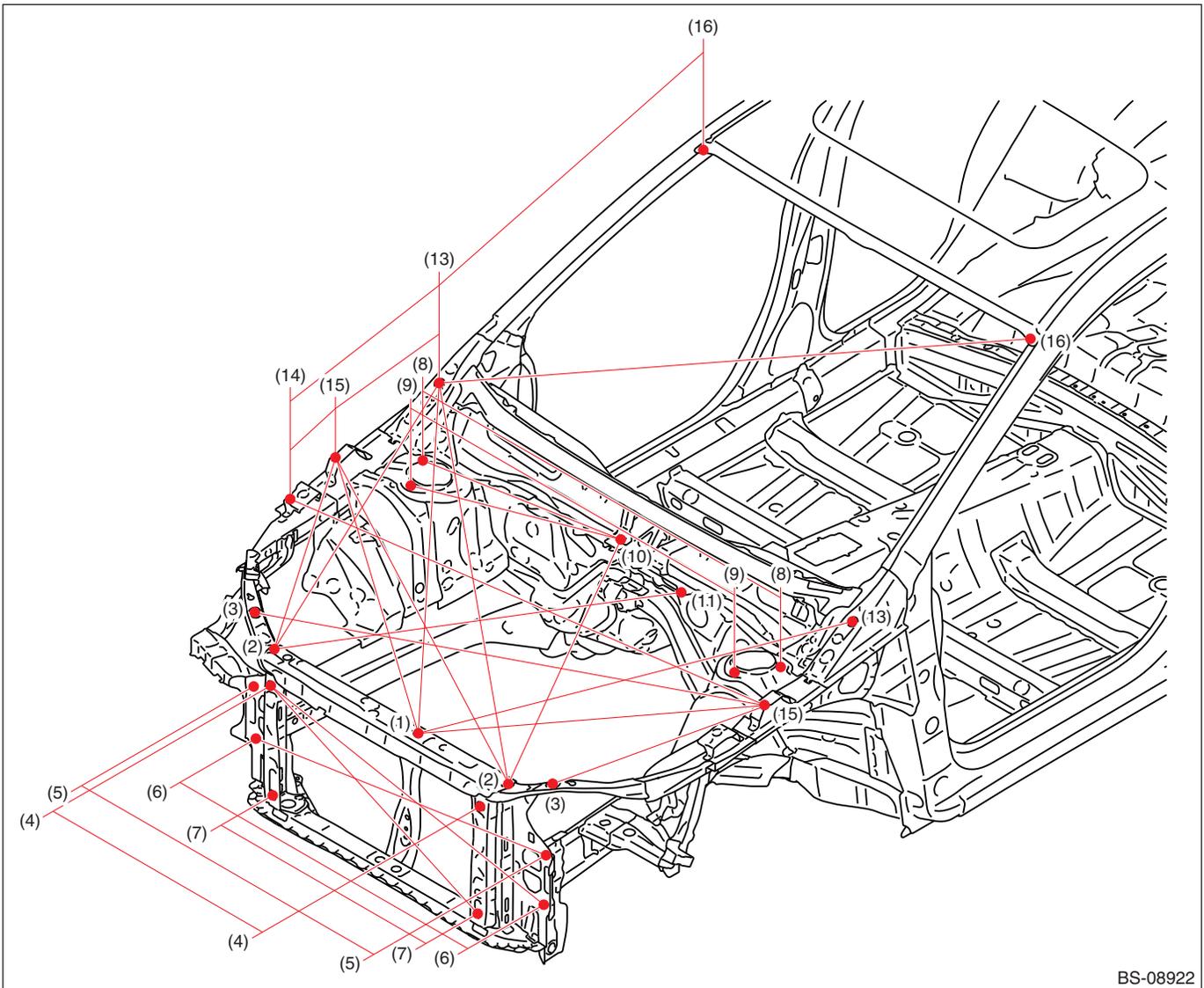
Measuring point	Datum dimension mm (in)
(3)L — (14)L	431 (16.97)
(10) — (13)R	751 (29.57)
(10) — (14)R	874 (34.41)
(10) — (15)R	811 (31.93)
(11)R — (14)L	1,097 (43.19)
(12)R — (12)L	1,491 (58.70)
(13)R — (13)L	1,484 (58.43)
(14)R — (14)L	1,524 (60.00)
(15)R — (15)L	1,541 (60.67)
(17)L — (18)L	929 (36.57)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

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



# Body Reference Points

## 3. FRONT 2



BS-08922

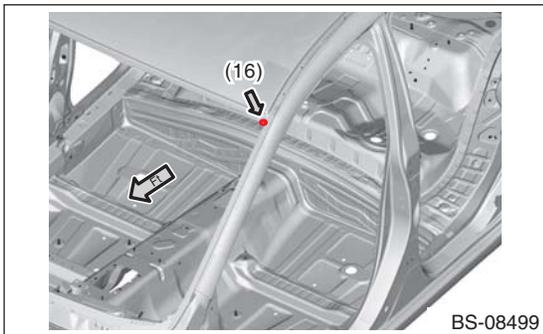
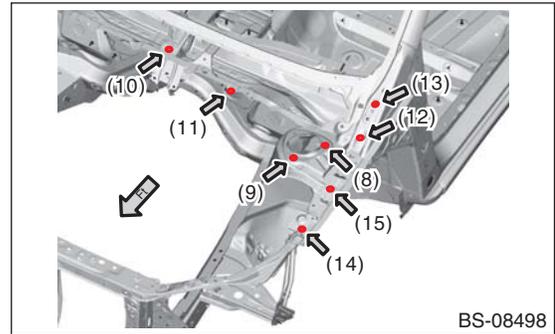
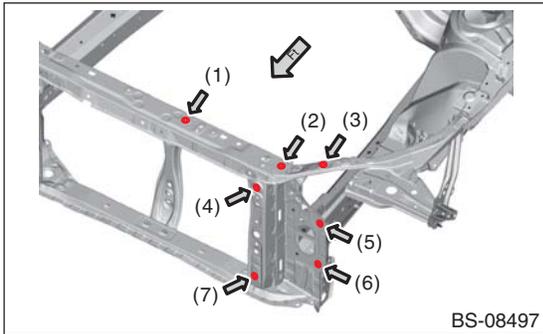
- |   |  |  |
|---|--|--|
| (1) Cover upper mounting hole (left side)               | (6) Bumper beam mounting hole (symmetrical), lower side        | (11) Cowl panel mounting hole (symmetrical)                |
| (2) Radiator upper frame mounting hole (symmetrical)    | (7) Gauge hole (symmetrical)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

# Body Reference Points

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

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

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

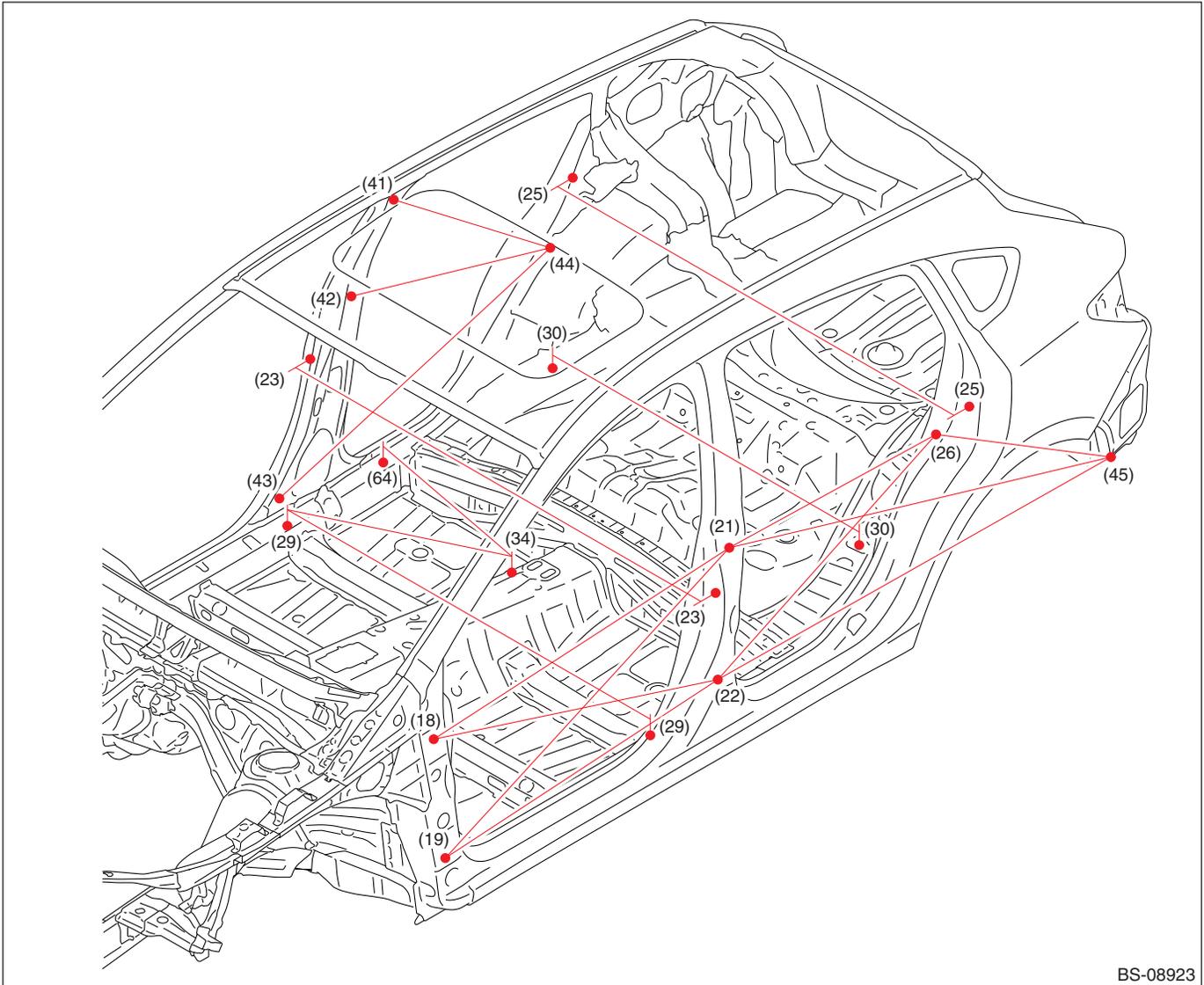


SUBARU.

# Body Reference Points

## 4. INSIDE 1

• Common for 5 Door and 4 Door



BS-08923

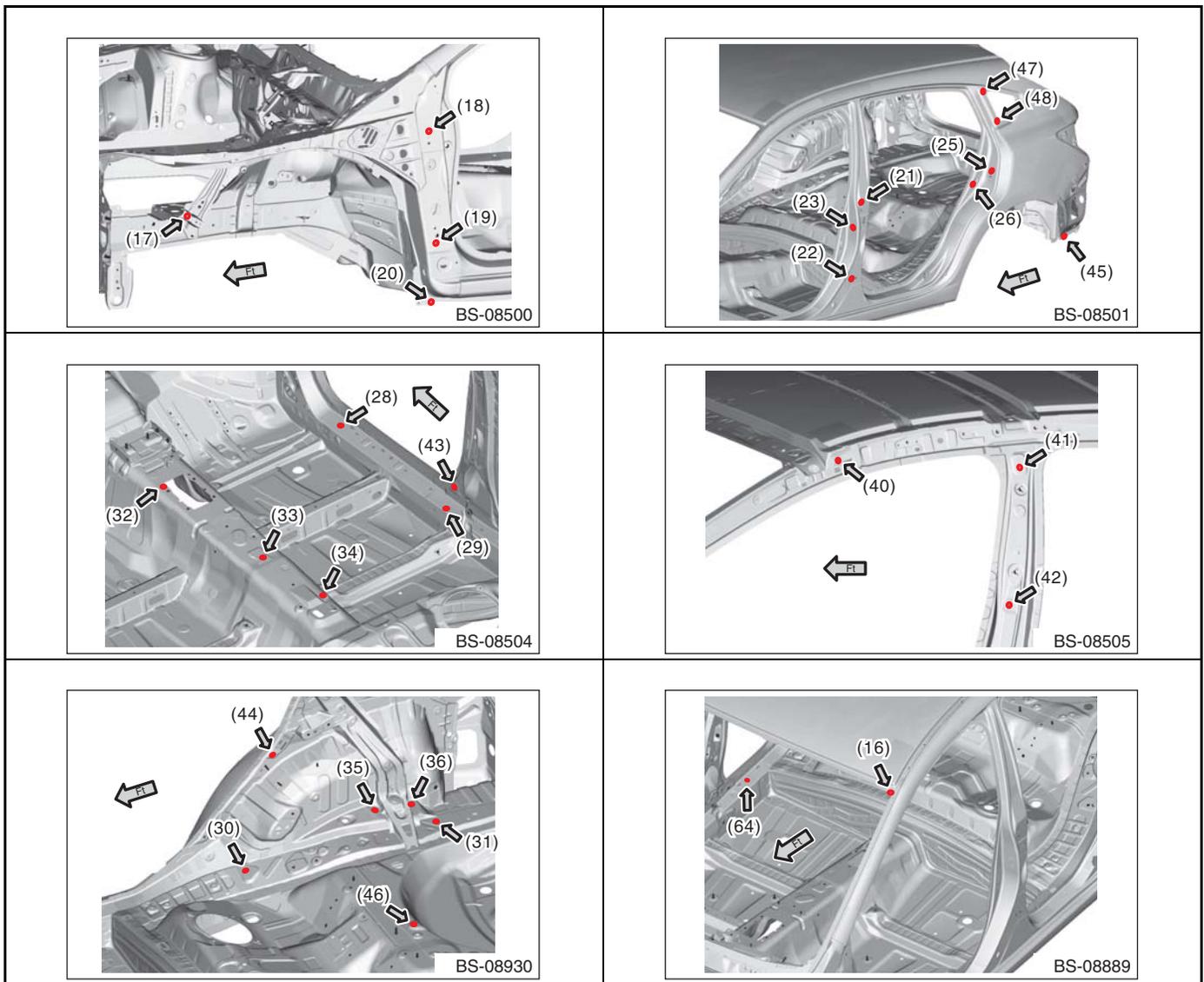
- |   |   |   |
|---|---|---|
| (18) Front door hinge upper mounting hole (symmetrical), upper side | (26) Rear door switch mounting hole (symmetrical) | (43) Trim mounting hole (symmetrical)             |
| (19) Front door hinge lower mounting hole (symmetrical), lower side | (29) Harness clip mounting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

# Body Reference Points

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

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

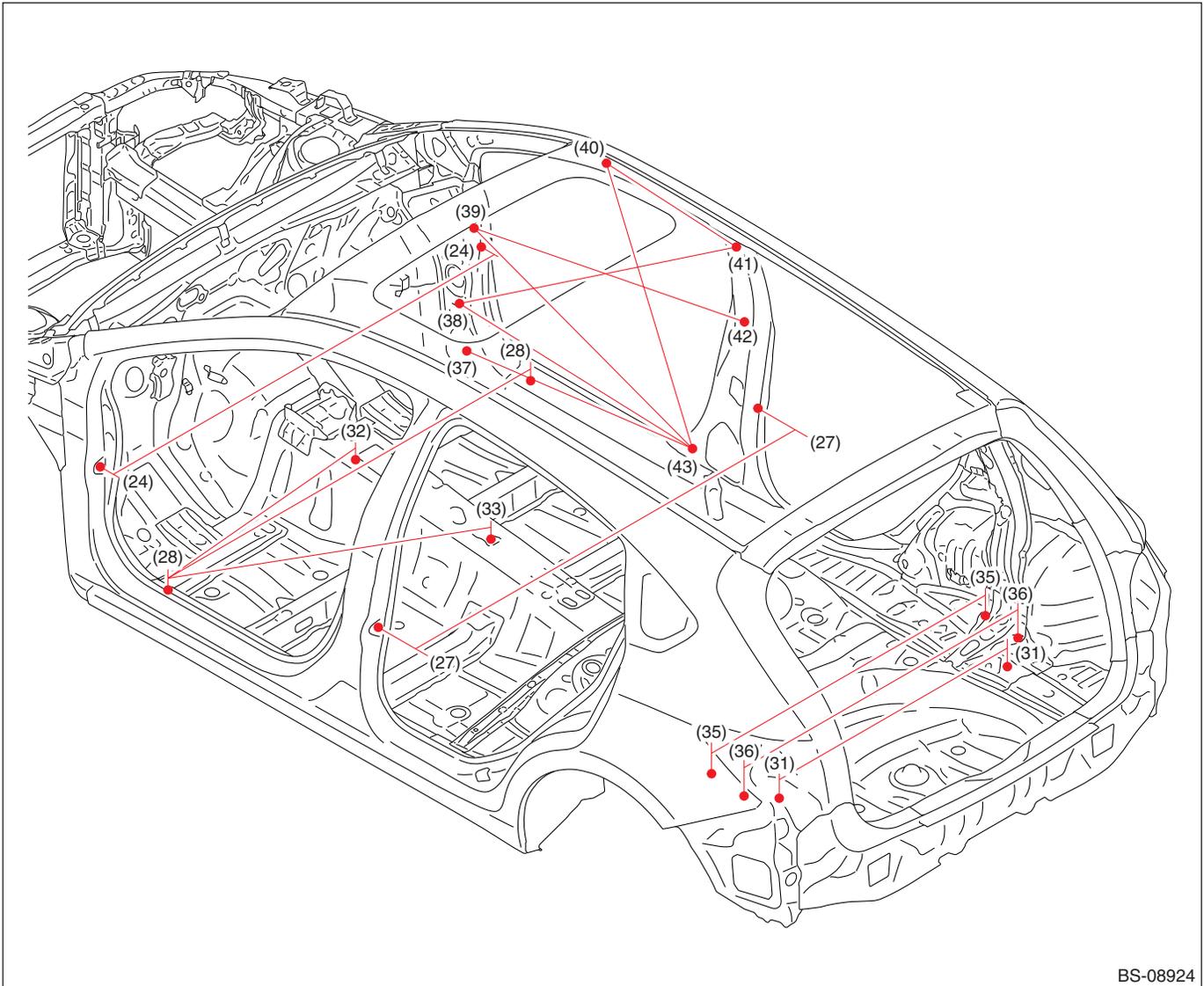
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



# Body Reference Points

## 5. INSIDE 2

• Common for 5 Door and 4 Door



BS-08924

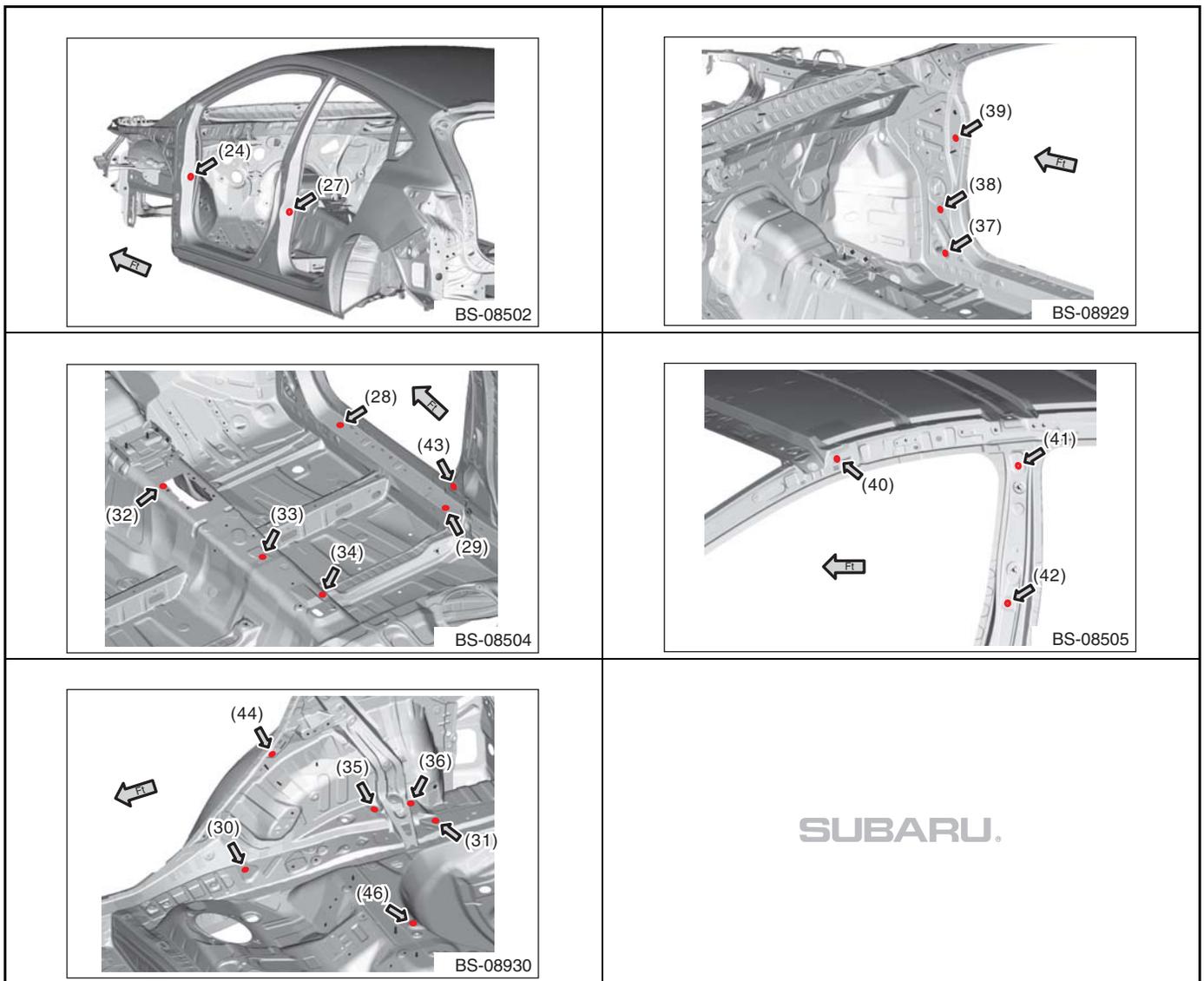
- |   |   |  |
|---|---|--|
| (24) Front door checker mounting hole (symmetrical) | (33) Hand brake mounting hole (body center)             | (39) Steering beam mounting hole (symmetrical), lower side |
| (27) Rear door checker mounting hole (symmetrical)  | (35) Rear suspension mounting hole (symmetrical),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

# Body Reference Points

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

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

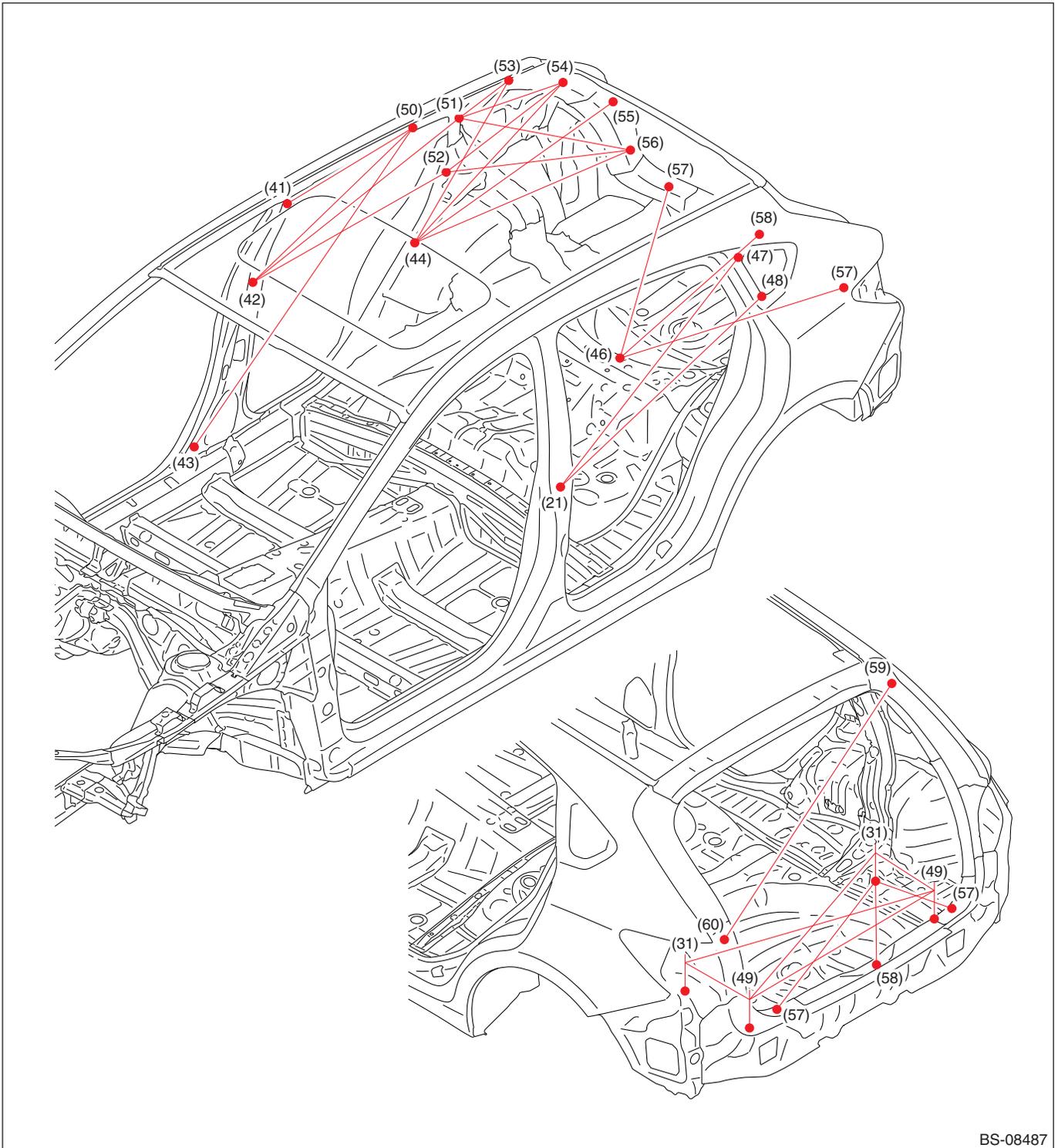
- Reference point (33) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



# Body Reference Points

## 6. INSIDE & REAR 1

- SPECIAL PARTS FOR 5 DOOR (Gasoline model)



BS-08487



# Body Reference Points

(21) Rear door hinge upper mounting hole (symmetrical), upper side	(49)L *1Gauge hole (left side)	(59) Rear gate stay mounting hole (symmetrical), upper side
(31) Gauge hole (symmetrical)	(50) Gauge hole (symmetrical)	(60) Rear combination light mounting hole (symmetrical), upper side
(41) Trim mounting hole (symmetrical)	(51) Trim D-pillar mounting hole (symmetrical)	(66) *2R seat center hinge mounting hole (left side)
(42) Trim mounting hole (symmetrical)	(52) Apron trim mounting hole (symmetrical)	(67) *2Frame battery front mounting hole (symmetrical)
(43) Trim mounting hole (symmetrical)	(53) Gauge hole (symmetrical)	(68) *2Bracket bar rear front mounting hole (symmetrical)
(44) Apron trim mounting hole (symmetrical)	(54) Trim clip mounting hole (symmetrical)	(69) *2Bracket battery mounting hole (symmetrical)
(46) *1Spacer front mounting hole	(55) Trim clip mounting hole (symmetrical)	(70)R *2Gauge hole (right side)
(47) Rear quarter glass mounting hole (symmetrical), front upper side	(56) Gauge hole (symmetrical)	(70)L *2Gauge hole (left side)
(48) Rear quarter glass mounting hole (symmetrical), front lower side	(57) Trim mounting hole (symmetrical)	
(49)R *1Gauge hole (right side)	(58) Striker mounting hole (symmetrical)	

Measuring point	Datum dimension mm (in)
(21)L — (47)L	1,064 (41.89)
(21)L — (48)L	1,060 (41.73)
*1(31)R — (49)R	288 (11.34)
*1(31)L — (49)R	943 (37.13)
*1(31)R — (49)L	946 (37.24)
*1(31)L — (49)L	298 (11.73)
(31)R — (57)R	415 (16.34)
(31)R — (57)L	963 (37.91)
(31)R — (58)R	620 (24.41)
(41)R — (50)R	555 (21.85)
(42)R — (50)R	750 (29.53)
(42)R — (51)R	945 (37.20)
(42)R — (52)R	914 (35.98)
(43)R — (50)R	1,313 (51.69)
(44)R — (53)R	647 (25.47)
(44)R — (54)R	675 (26.57)
(44)R — (55)R	784 (30.87)
(44)R — (56)R	828 (32.60)
*1(46)L — (57)R	877 (34.53)
*1(46)L — (57)L	805 (31.69)
*1(46)L — (58)R	768 (30.24)

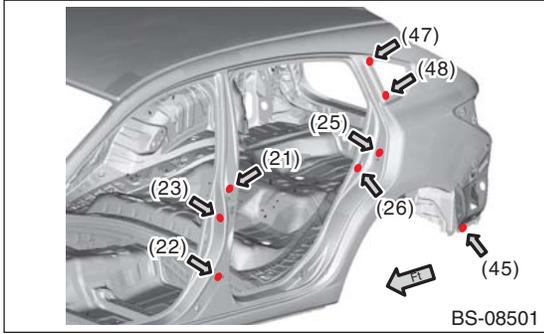
Measuring point	Datum dimension mm (in)
*1(49)R — (49)L	889 (35.00)
(51)R — (53)R	218 (8.58)
(51)R — (54)R	410 (16.14)
(51)R — (56)R	862 (33.94)
(52)R — (54)R	496 (19.53)
(52)R — (56)R	760 (29.92)
(59)R — (60)L	1,244 (48.98)
*2(31)R — (70)R	330 (12.99)
*2(31)R — (70)L	960 (37.80)
*2(31)L — (70)R	956 (37.64)
*2(31)L — (70)L	340 (13.39)
*2(67)R — (67)L	976 (38.43)
*2(67)R — (69)R	626 (24.65)
*2(67)L — (69)R	1,134 (44.65)
*2(69)R — (69)L	916 (36.06)
*2(70)R — (70)L	889 (35.00)
*2(57)R — (66)L	1,006 (39.61)
*2(57)L — (66)L	983 (38.70)
*2(58)R — (66)L	937 (36.89)
*2(68)R — (68)L	1,100 (43.31)

\*1: Gasoline model

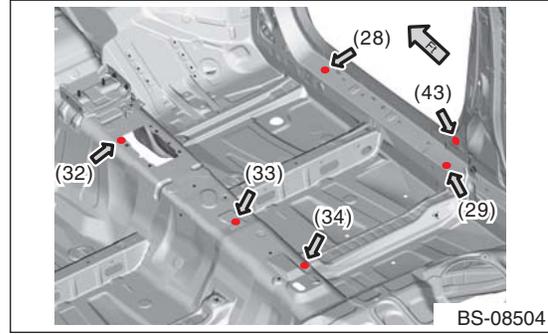
\*2: Hybrid model

- Reference point (46) indicates a left side part. The reference points (49) and (70) are left-right asymmetry. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.

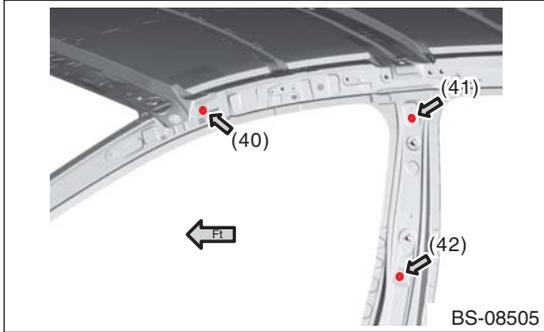
# Body Reference Points



BS-08501

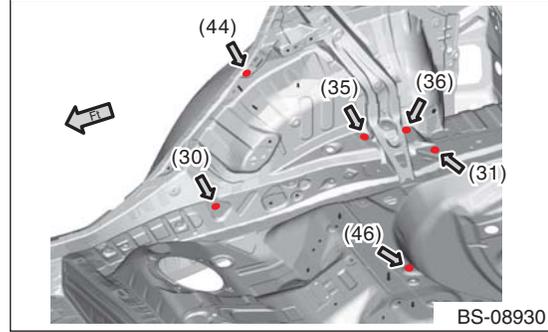


BS-08504



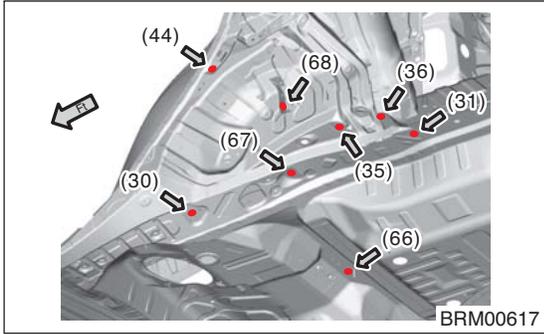
BS-08505

Gasoline model

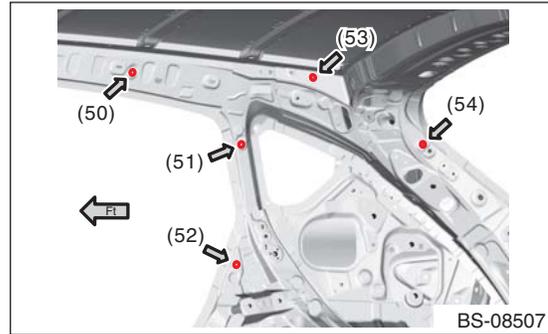


BS-08930

Hybrid model

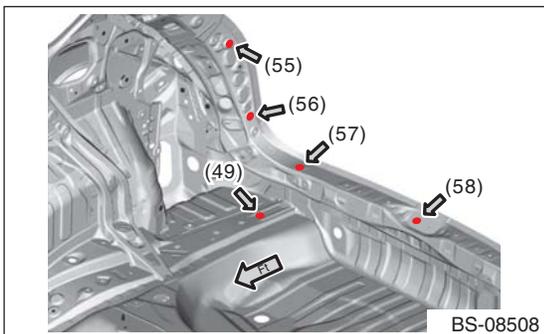


BRM00617



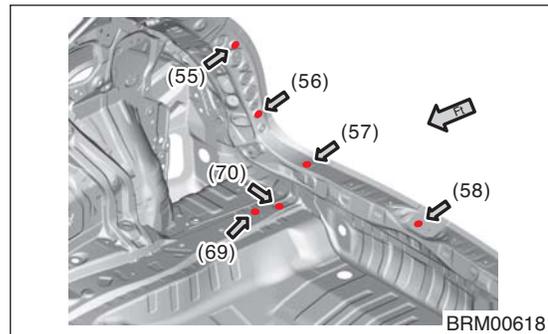
BS-08507

Gasoline model



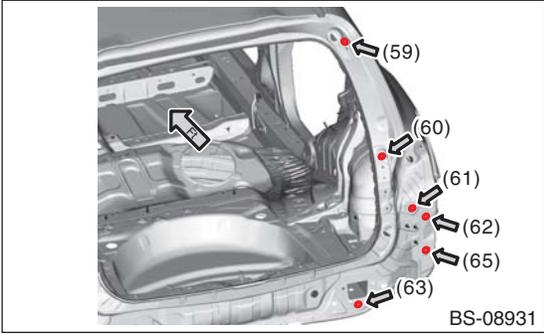
BS-08508

Hybrid model



BRM00618

# Body Reference Points

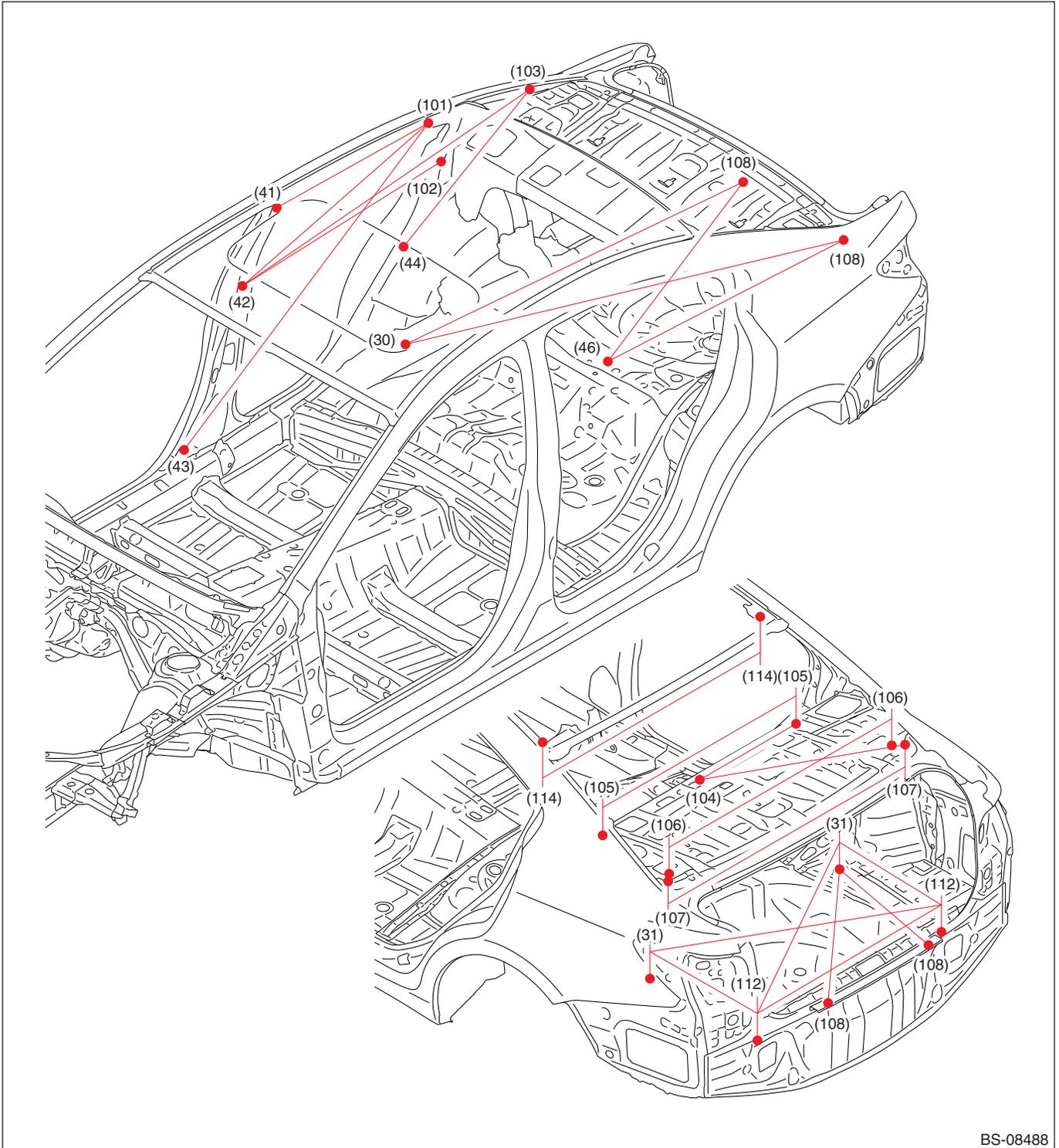


SUBARU.

# Body Reference Points

## 7. INSIDE & REAR 2

### • SPECIAL PARTS FOR 4 DOOR



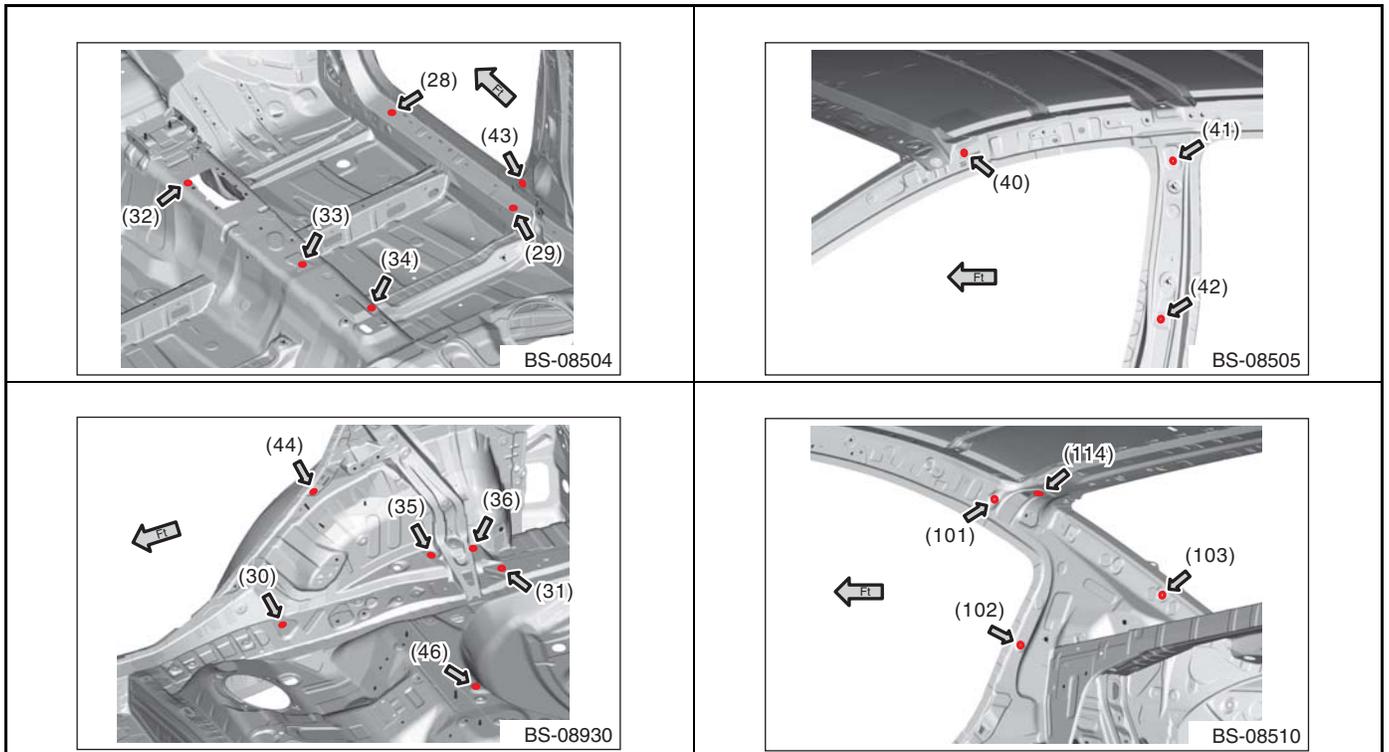
# Body Reference Points

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

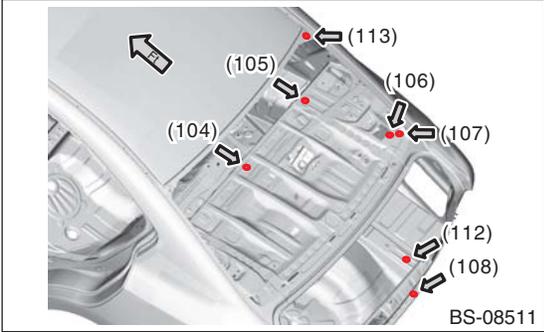
Measuring point	Datum dimension mm (in)
(30)R — (108)R	1,327 (52.24)
(30)R — (108)L	1,527 (60.12)
(31)R — (108)R	682 (26.85)
(31)R — (108)L	949 (37.36)
(31)R — (112)R	495 (19.49)
(31)L — (112)R	1,025 (40.35)
(31)R — (112)L	1,030 (40.55)
(31)L — (112)L	505 (19.88)
(41)R — (101)R	698 (27.48)
(42)R — (101)R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

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

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



# Body Reference Points

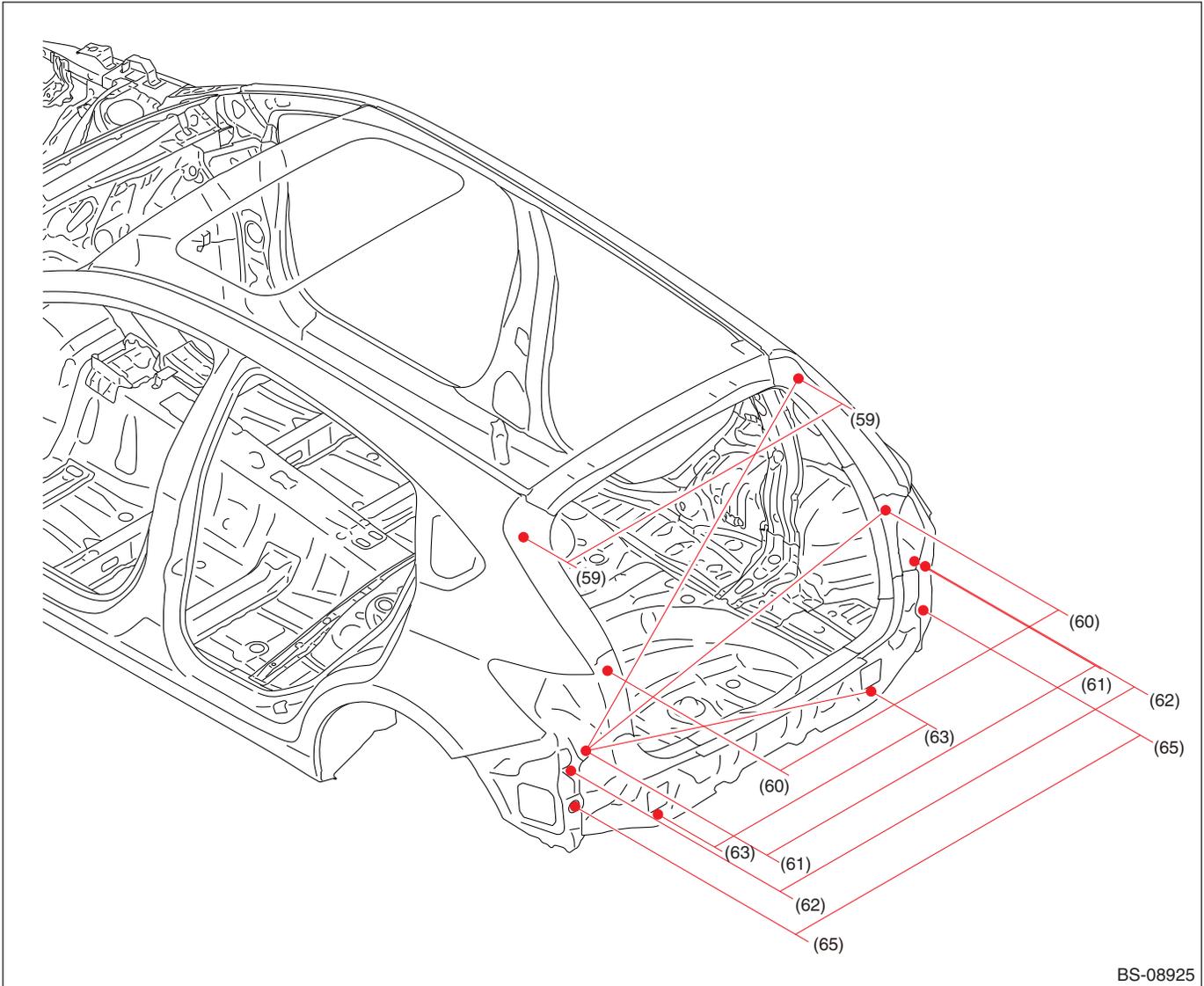


SUBARU.

# Body Reference Points

## 8. REAR 1

### • SPECIAL PARTS FOR 5 DOOR



BS-08925

- |   |  |  |
|---|--|--|
| (59) Rear gate stay mounting hole (symmetrical), upper side         | (61) Rear bumper bracket mounting hole (symmetrical) | (63) Bumper beam mounting hole (symmetrical)     |
| (60) Rear combination light mounting hole (symmetrical), upper side | (62) Gauge hole (symmetrical)                        | (65) Harness grommet mounting hole (symmetrical) |

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

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

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

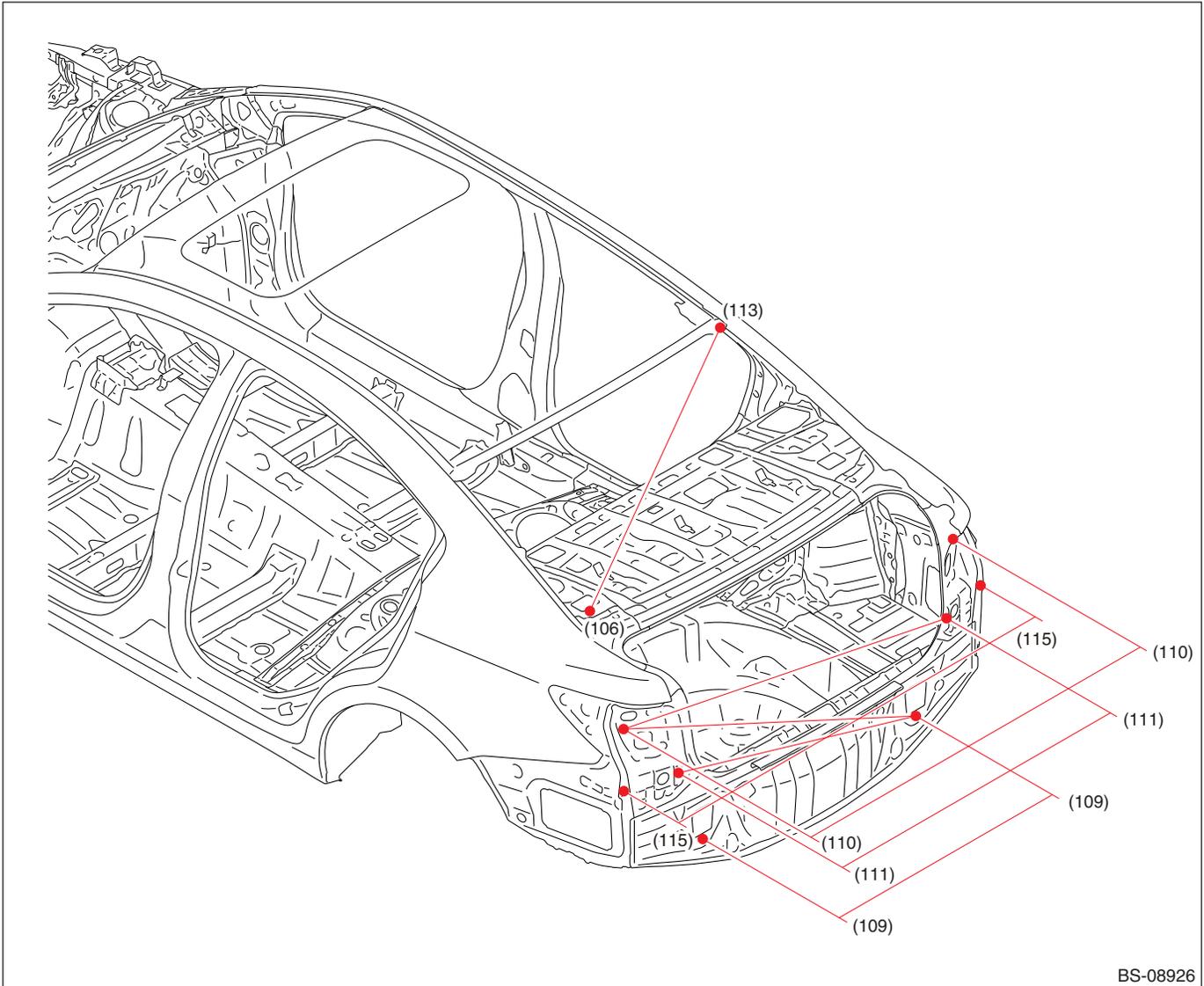
# Body Reference Points



# Body Reference Points

## 9. REAR 2

### • SPECIAL PARTS FOR 4 DOOR



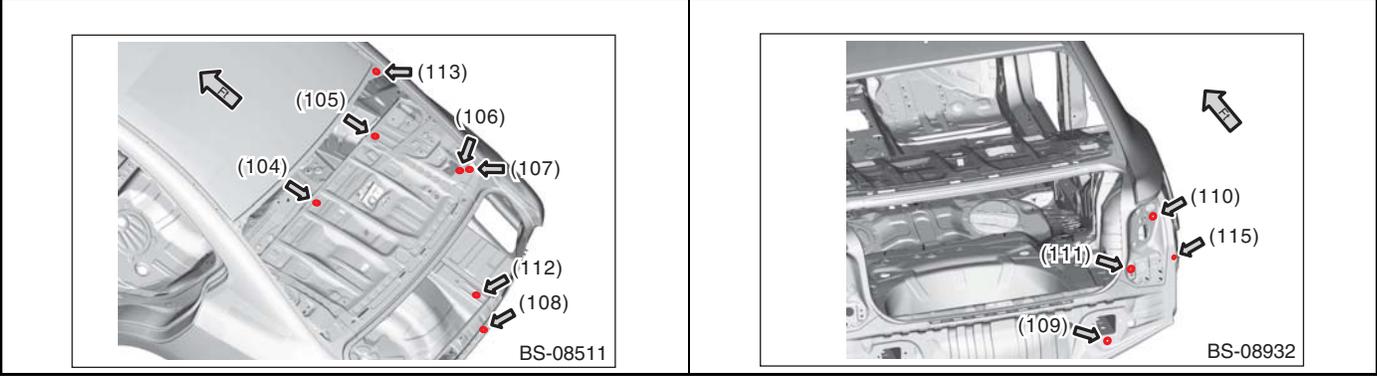
- |   |   |  |
|---|---|--|
| (106) Trunk hinge mounting hole (symmetrical) | (110) Rear combination light mounting hole (symmetrical), outside | (113) Rear glass installation reference hole (symmetrical) |
| (109) Bumper beam mounting hole (symmetrical) | (111) Bracket corner rear mounting hole (symmetrical)             | (115) Gauge hole (symmetrical)                             |

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

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

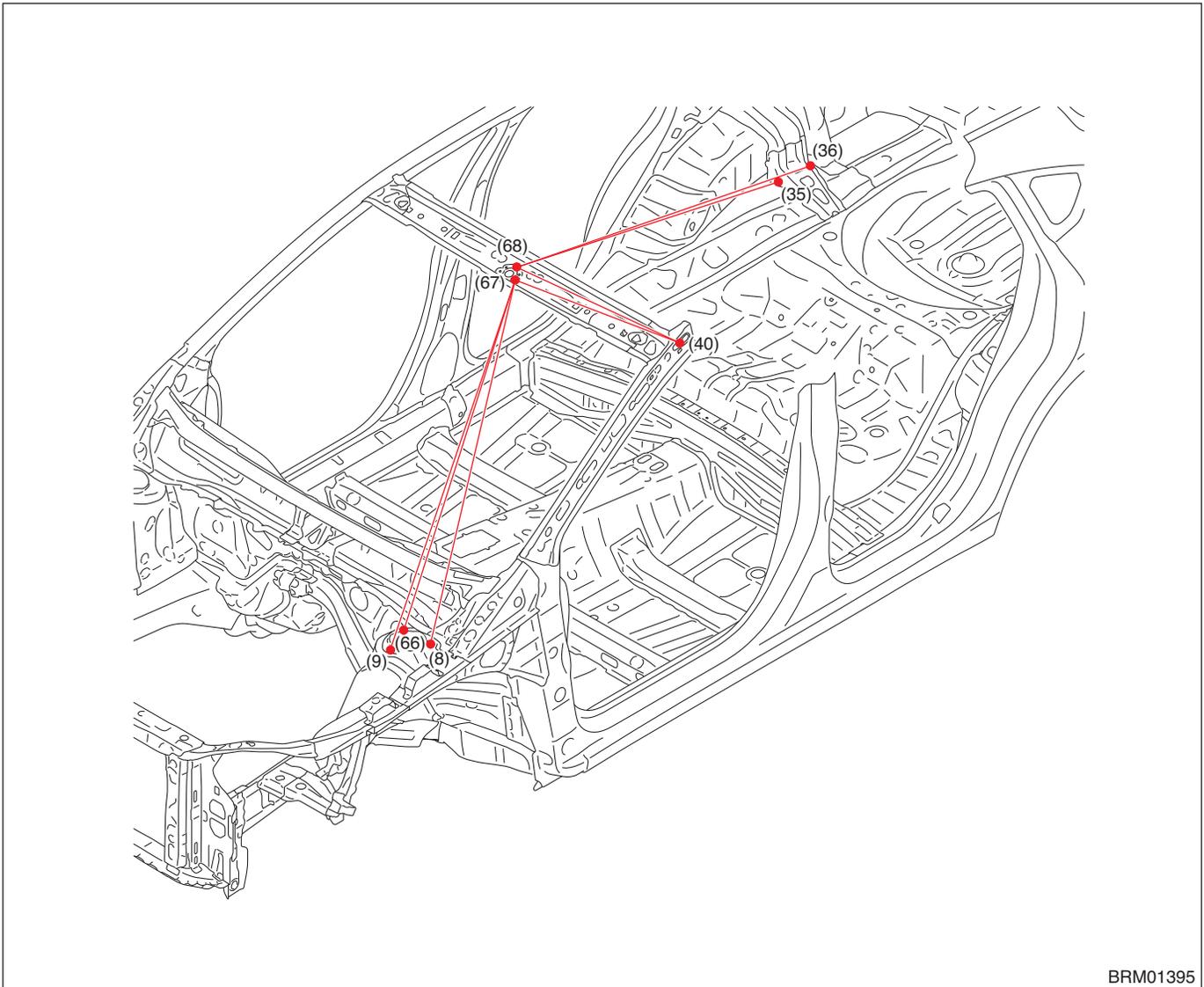
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

# Body Reference Points



# Body Reference Points

## 10.FRONT ROOF RAIL (CAMERA PLATE)



BRM01395

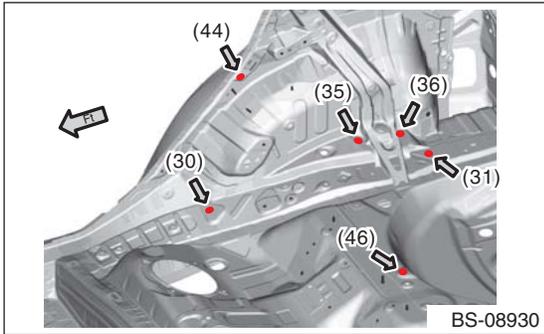
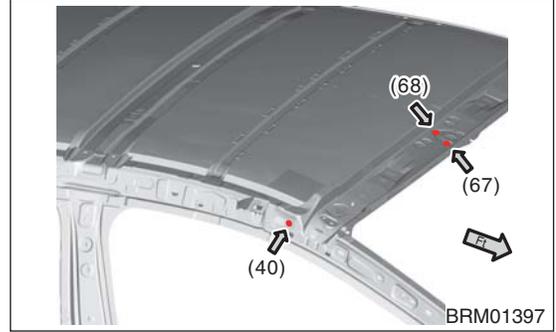
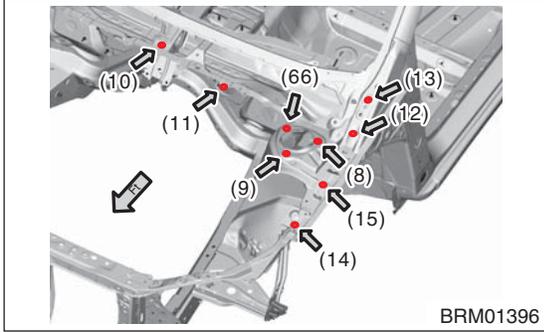
- |  |  |   |
|--|--|---|
| (8) Front suspension mounting hole (symmetrical), rear outside | (36) Rear suspension mounting hole (symmetrical), rear         | (67) Stereo camera (camera plate) mounting hole (symmetrical), front side |
| (9) Front suspension mounting hole (symmetrical), front        | (40) Pad A pillar mounting hole (symmetrical)                  | (68) Stereo camera (camera plate) mounting hole (body center), rear side  |
| (35) Rear suspension mounting hole (symmetrical), front        | (66) Front suspension mounting hole (symmetrical), rear inside |   |

Measuring point	Datum dimension mm (in)
(8)L — (67)L	1,263 (49.72)
(9)L — (67)L	1,316 (51.81)
(35)R — (68)	1,898 (74.72)
(36)R — (68)	2,015 (79.33)

Measuring point	Datum dimension mm (in)
(40)L — (67)L	574 (22.60)
(40)L — (68)	598 (23.54)
(66)L — (67)L	1,215 (47.83)

- Reference point (68) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.

# Body Reference Points



SUBARU.

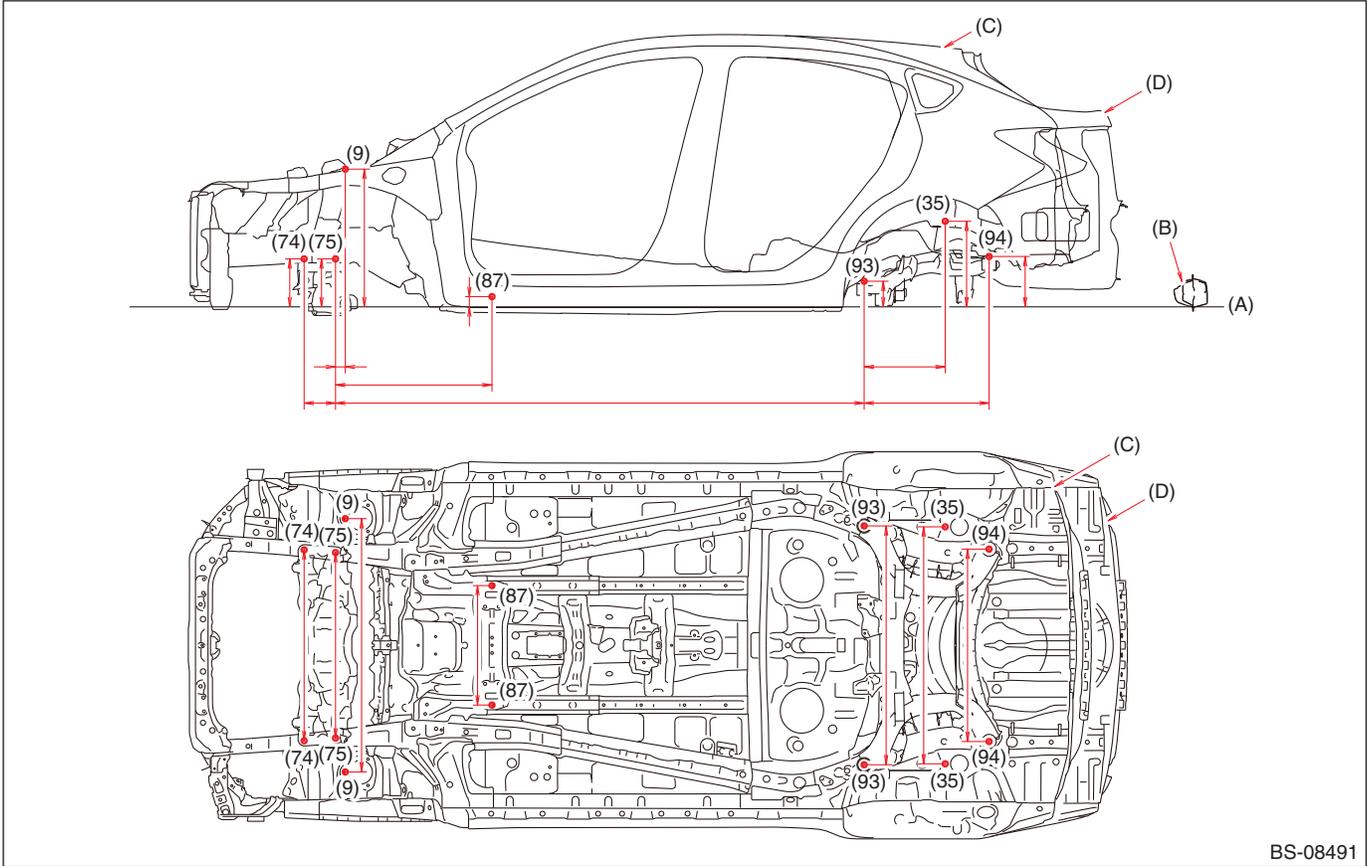
# Measurement for Combined Parts

## 7. Measurement for Combined Parts

### A: DIMENSIONS

#### 1. SUSPENSION MOUNT & ENGINE MOUNT

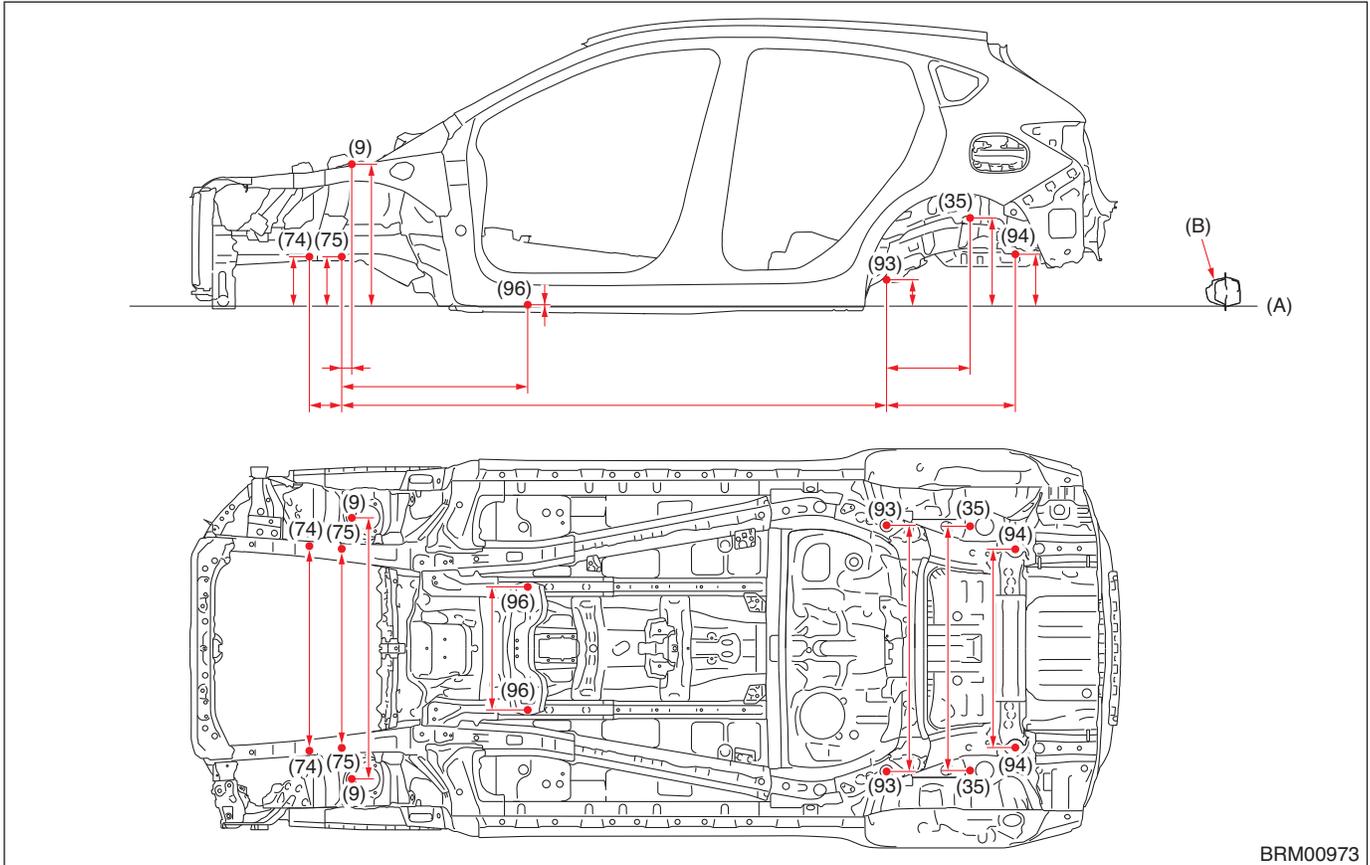
- Gasoline model



BS-08491

## Measurement for Combined Parts

- Hybrid model



BRM00973

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

(A) Standard line

(C) 5 Door

(D) 4 Door

(B) Side sill outer panel

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

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

(94) Rear suspension crossmember mounting hole (symmetrical), rear

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

(87) \*1Crossmember upper mounting hole (symmetrical)

(96) \*2Crossmember upper mounting hole (symmetrical)

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

(93) Rear suspension crossmember mounting hole (symmetrical), front

## Measurement for Combined Parts

Measuring point	Datum dimension mm (in)
Datum line — (9)	632 (24.88)
Datum line — (35)	393 (15.47)
Datum line — (74)	220 (8.66)
Datum line — (75)	220 (8.66)
* <sup>1</sup> Datum line — (87)	6 (0.24)
Datum line — (93)	118 (4.65)
Datum line — (94)	231 (9.09)
* <sup>2</sup> Datum line — (96)	6 (0.24)
(9) — (75)	45 (1.77)
(35) — (93)	372 (14.65)
(74) — (75)	144 (5.67)
* <sup>1</sup> (75) — (87)	718 (28.27)

Measuring point	Datum dimension mm (in)
(75) — (93)	2,424 (95.43)
* <sup>2</sup> (75) — (96)	828 (32.60)
(93) — (94)	573 (22.56)
(9) — (9)	1,163 (45.79)
(35) — (35)	1,087 (42.80)
(74) — (74)	876 (34.49)
(75) — (75)	851 (33.50)
* <sup>1</sup> (87) — (87)	548 (21.57)
(93) — (93)	1,096 (43.15)
(94) — (94)	883 (34.76)
* <sup>2</sup> (96) — (96)	548 (21.57)

\*<sup>1</sup>: Gasoline model

\*<sup>2</sup>: Hybrid model

**CAUTION:**

For the reference points (9), refer to the figure "FRONT 2, DIMENSIONS, Body Reference Points" on page 57.

For the reference points (35), refer to the figure "INSIDE 2, DIMENSIONS, Body Reference Points" on page 61.

Except the reference points (9) and (35), refer to the figure "LOWER SURFACE, DIMENSIONS, Body Reference Points" on page 50.

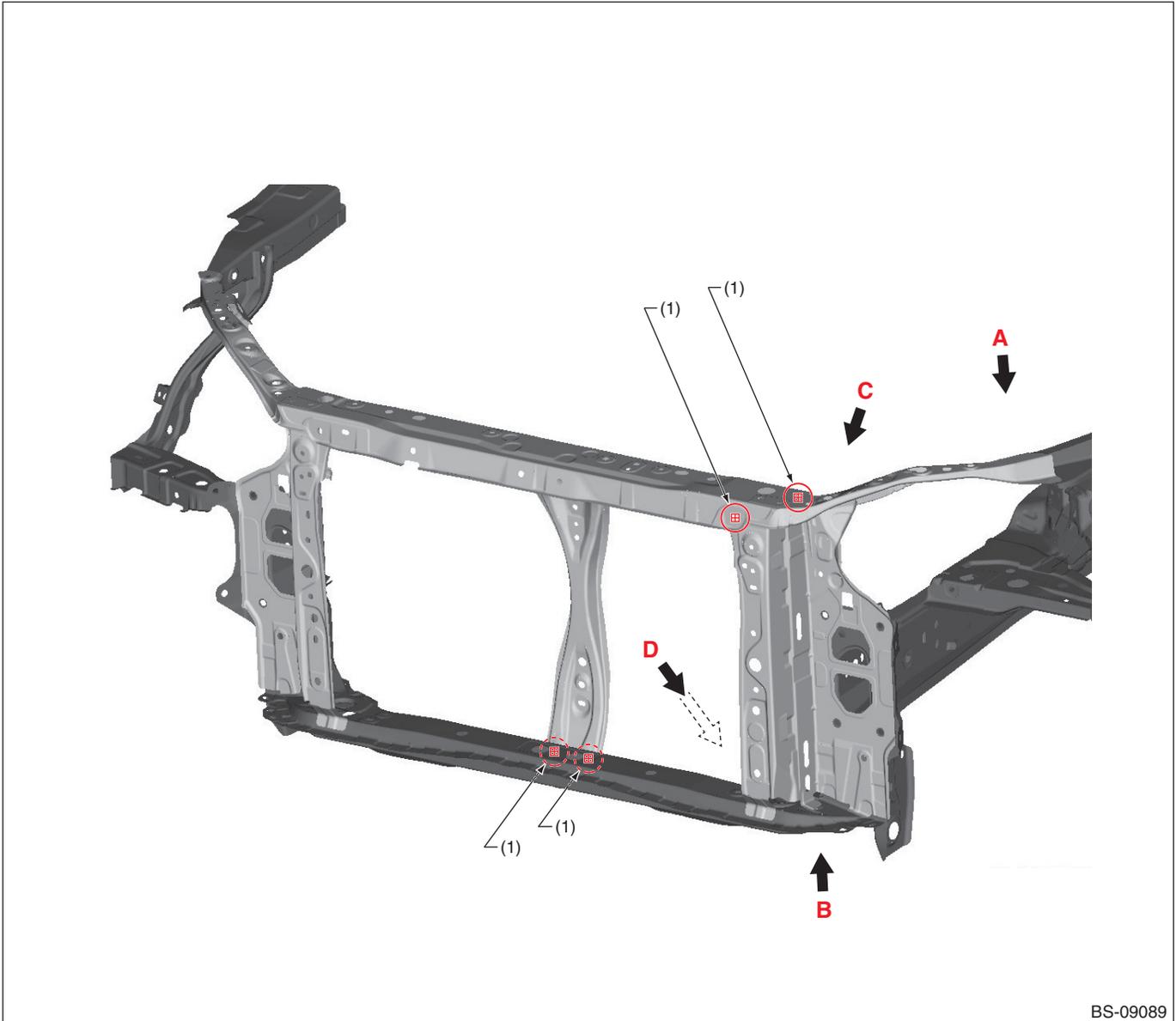
# Panel Replacement

## 8. Panel Replacement

### 8-1. Radiator Panel (total replacement)

#### A: REMOVAL

- Overall view



BS-09089

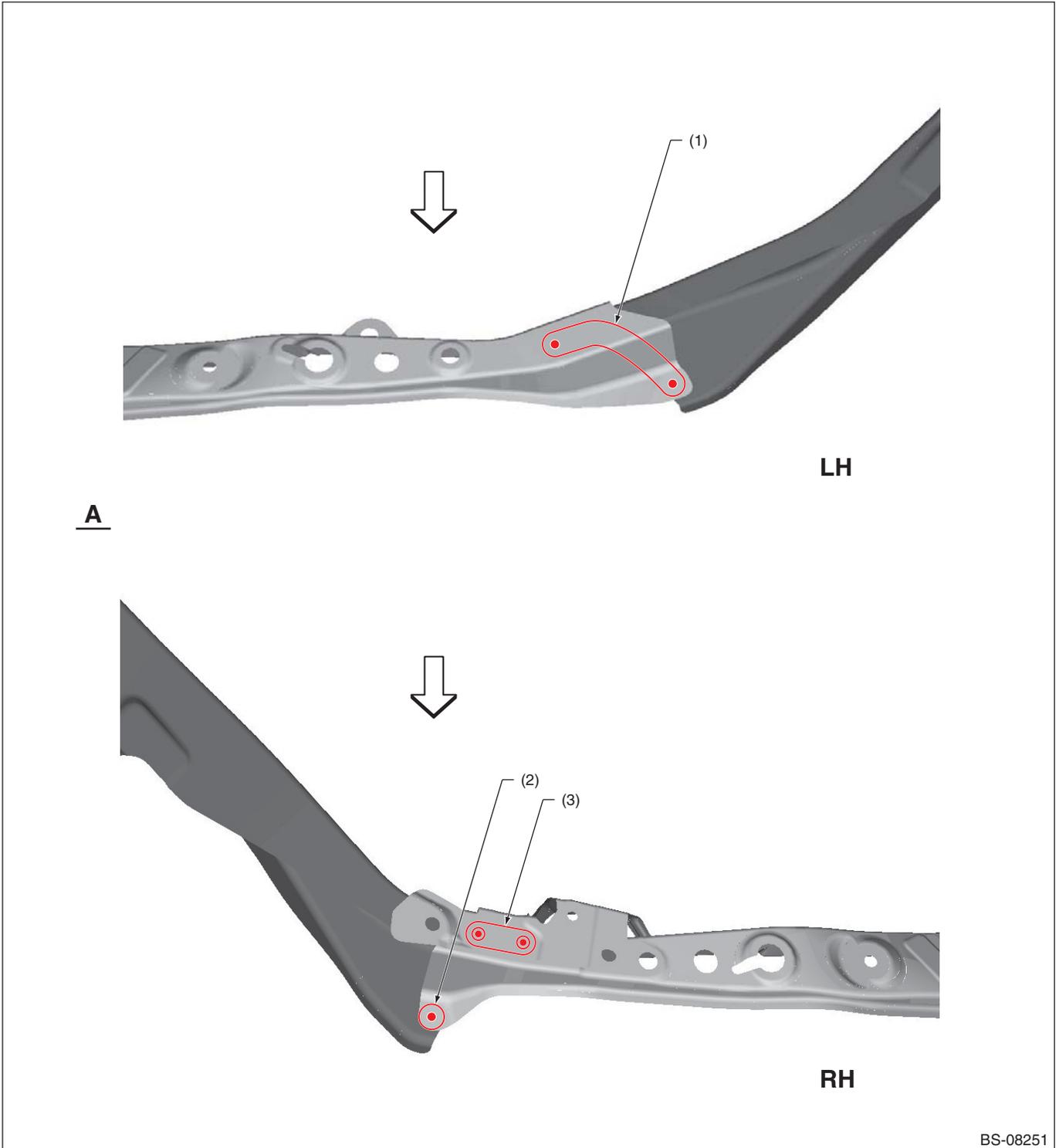
(1) 1 point (bolt)

Note: The illustration shows a gasoline model.

The Hybrid model has a different panel shape from the gasoline model, but the number of welding points and their locations are the same as with the gasoline model.

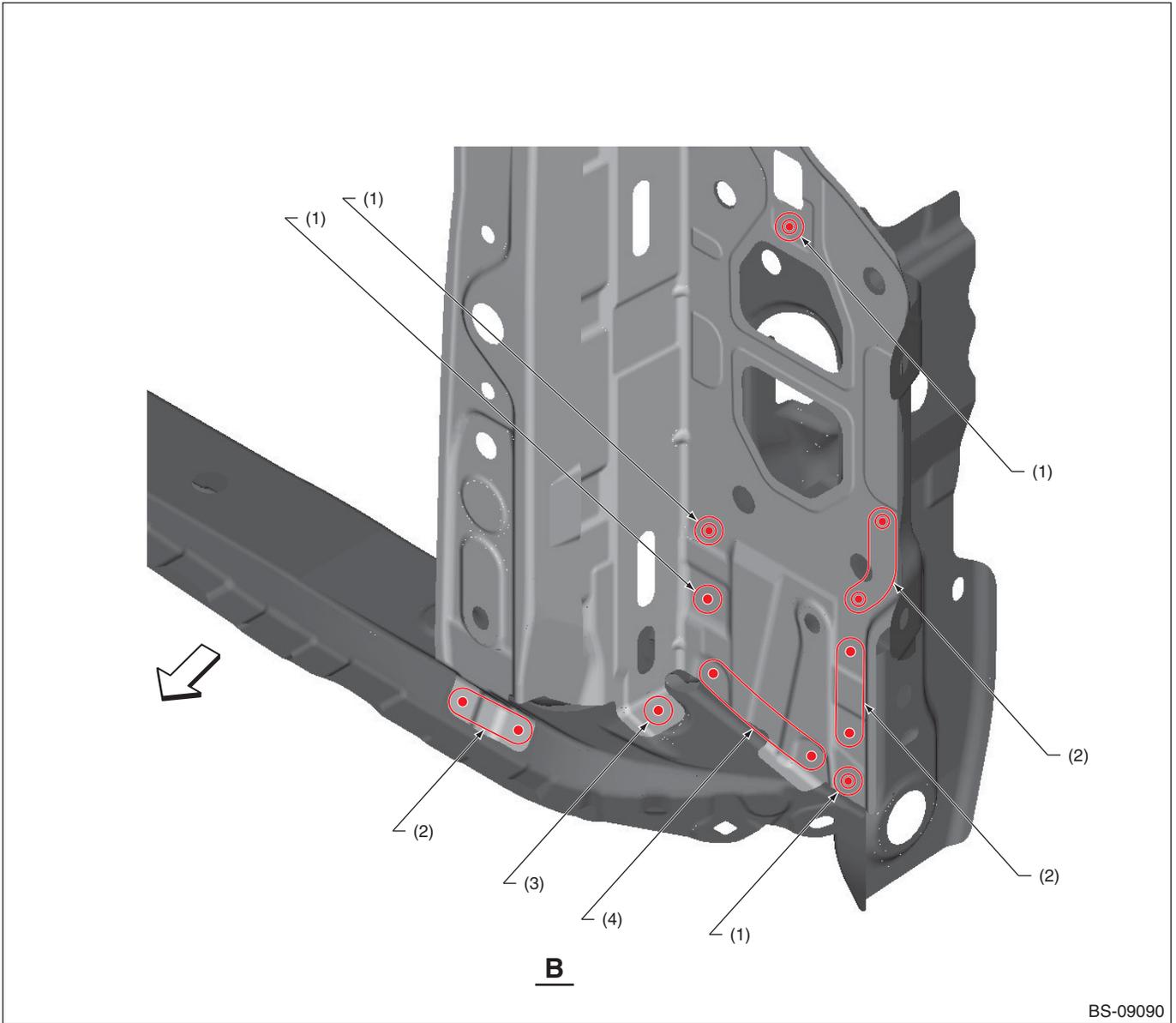
# Panel Replacement

## • Views A



# Panel Replacement

## • Views B



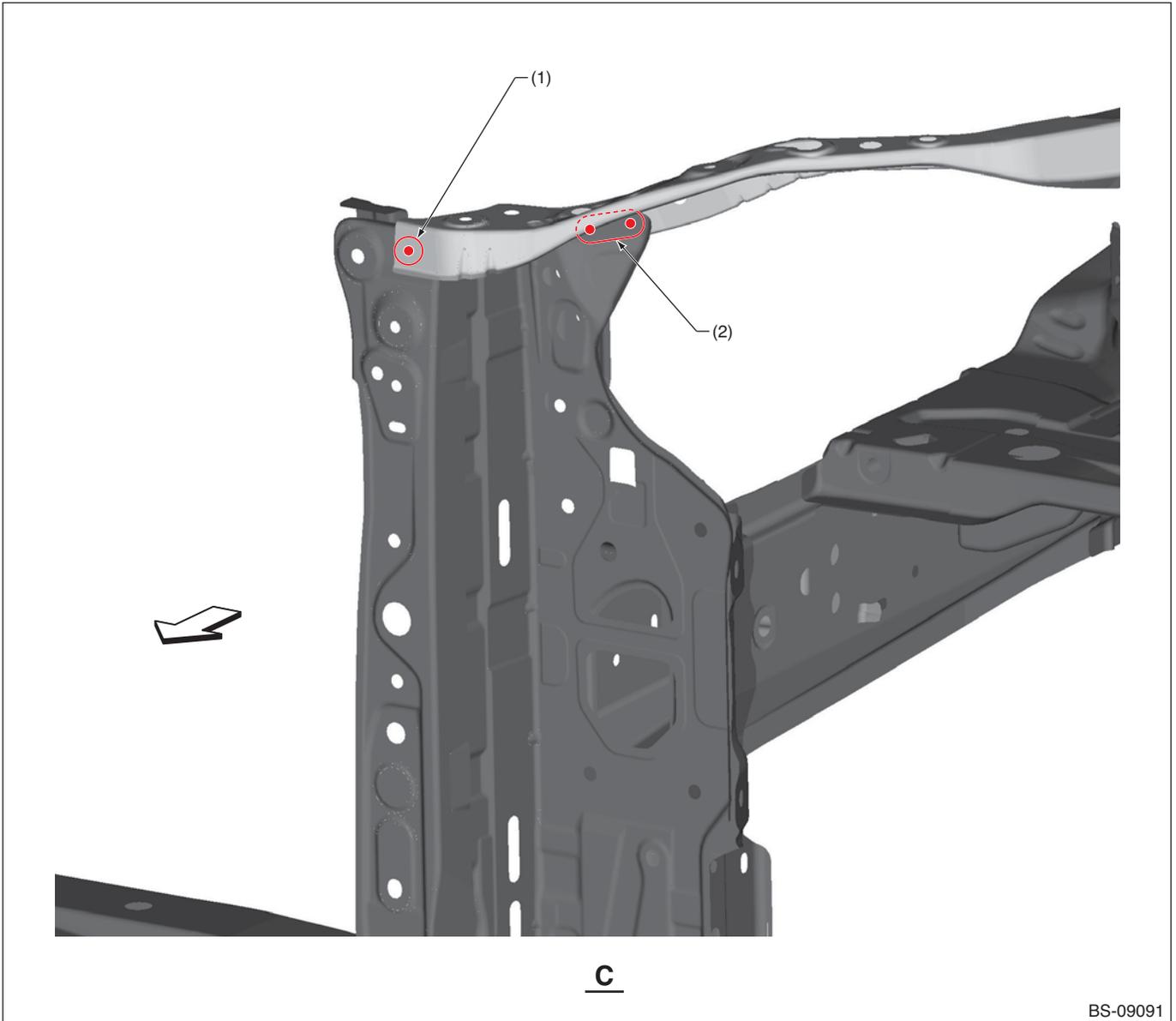
(1) 1 point (outside · 1)  
(2) 2 points (outside · 1)

(3) 1 point (top · 1)

(4) 3 points (outside · 1)

# Panel Replacement

## • Views C



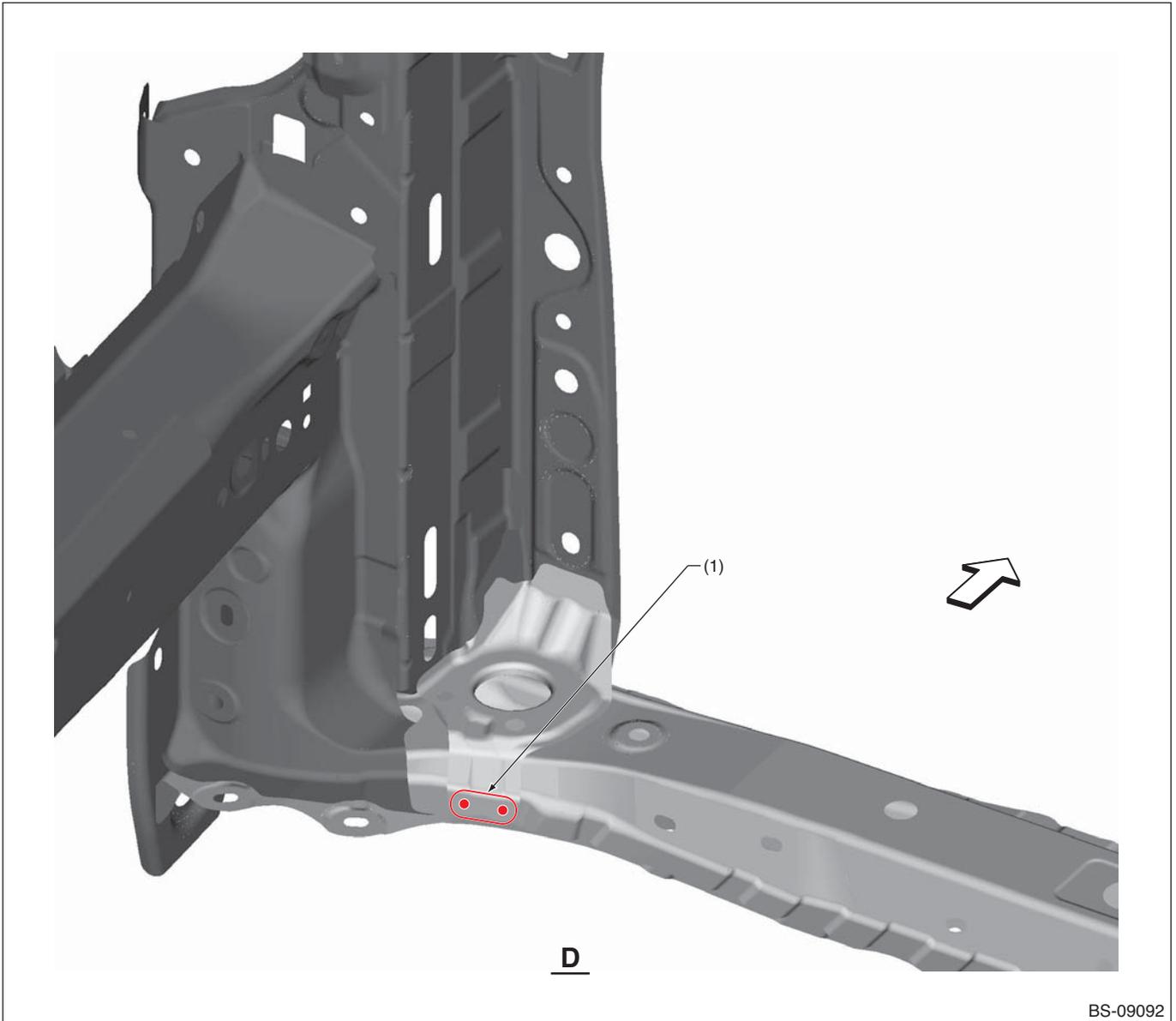
BS-09091

(1) 1 point (outside · 1)

(2) 2 points (inside · 1)

# Panel Replacement

- Views D

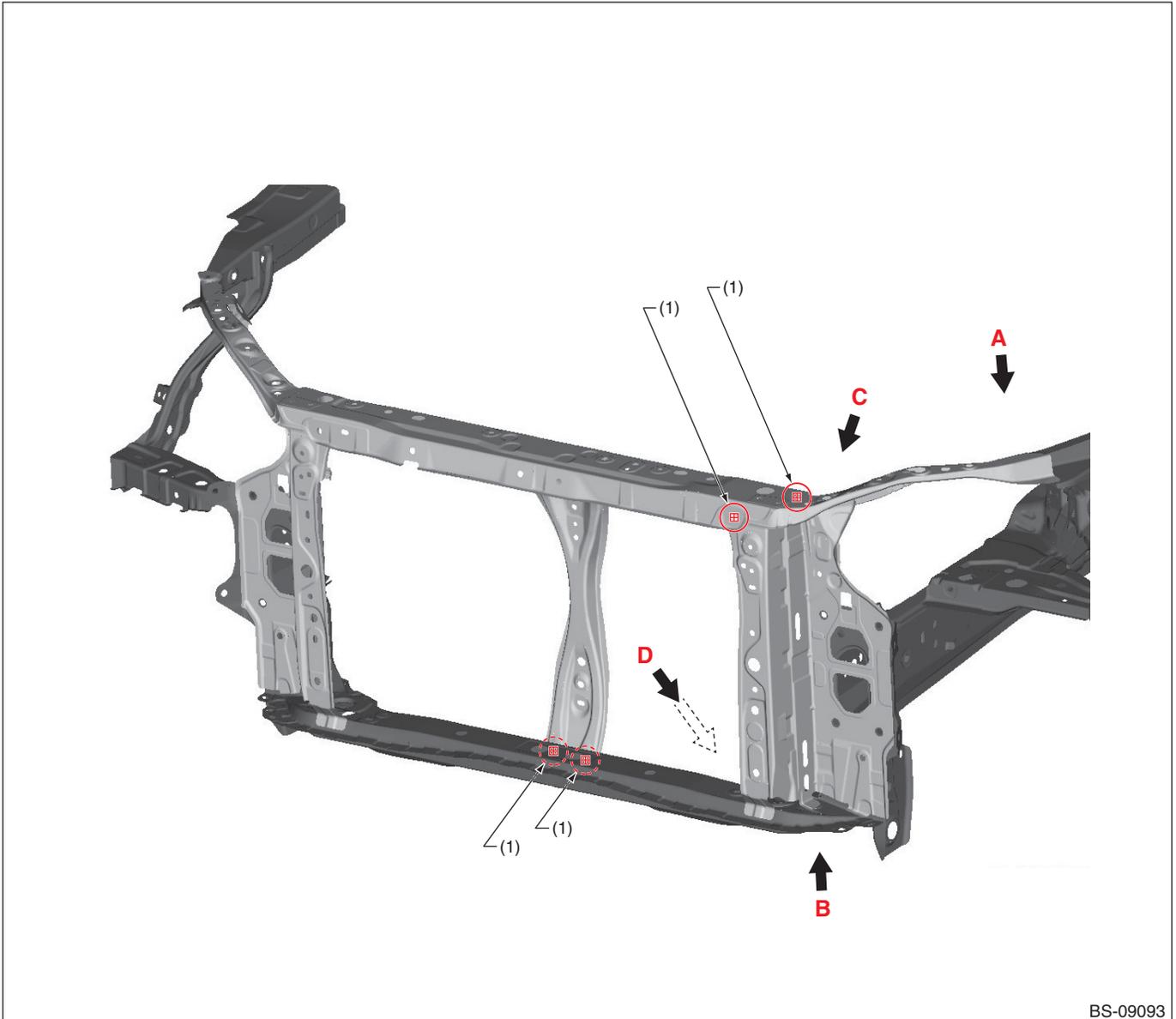


(1) 2 points (top - 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09093

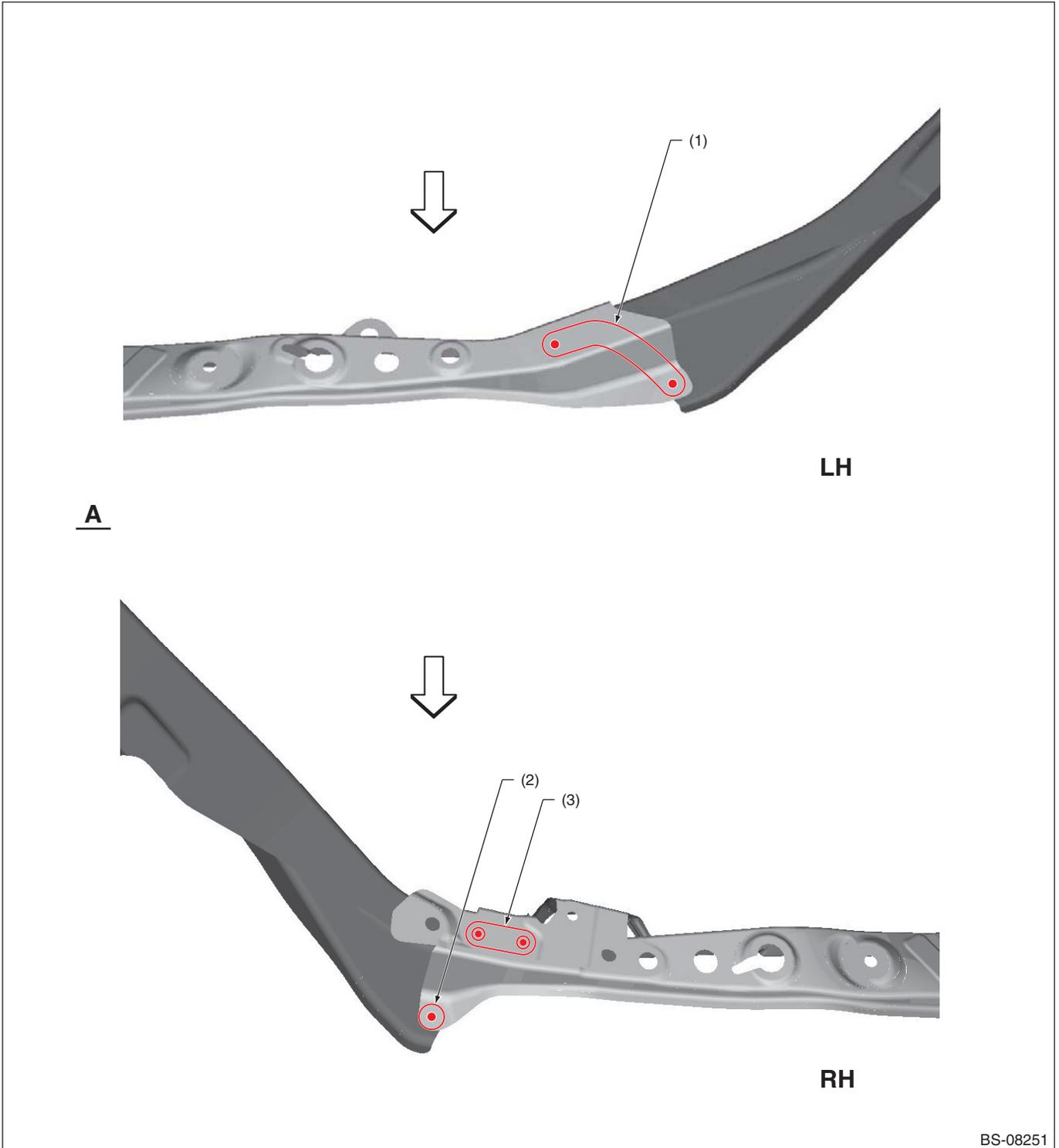
(1) 1 point (bolt)

Note: The illustration shows a gasoline model.

The Hybrid model has a different panel shape from the gasoline model, but the number of welding points and their locations are the same as with the gasoline model.

# Panel Replacement

## • Views A



BS-08251

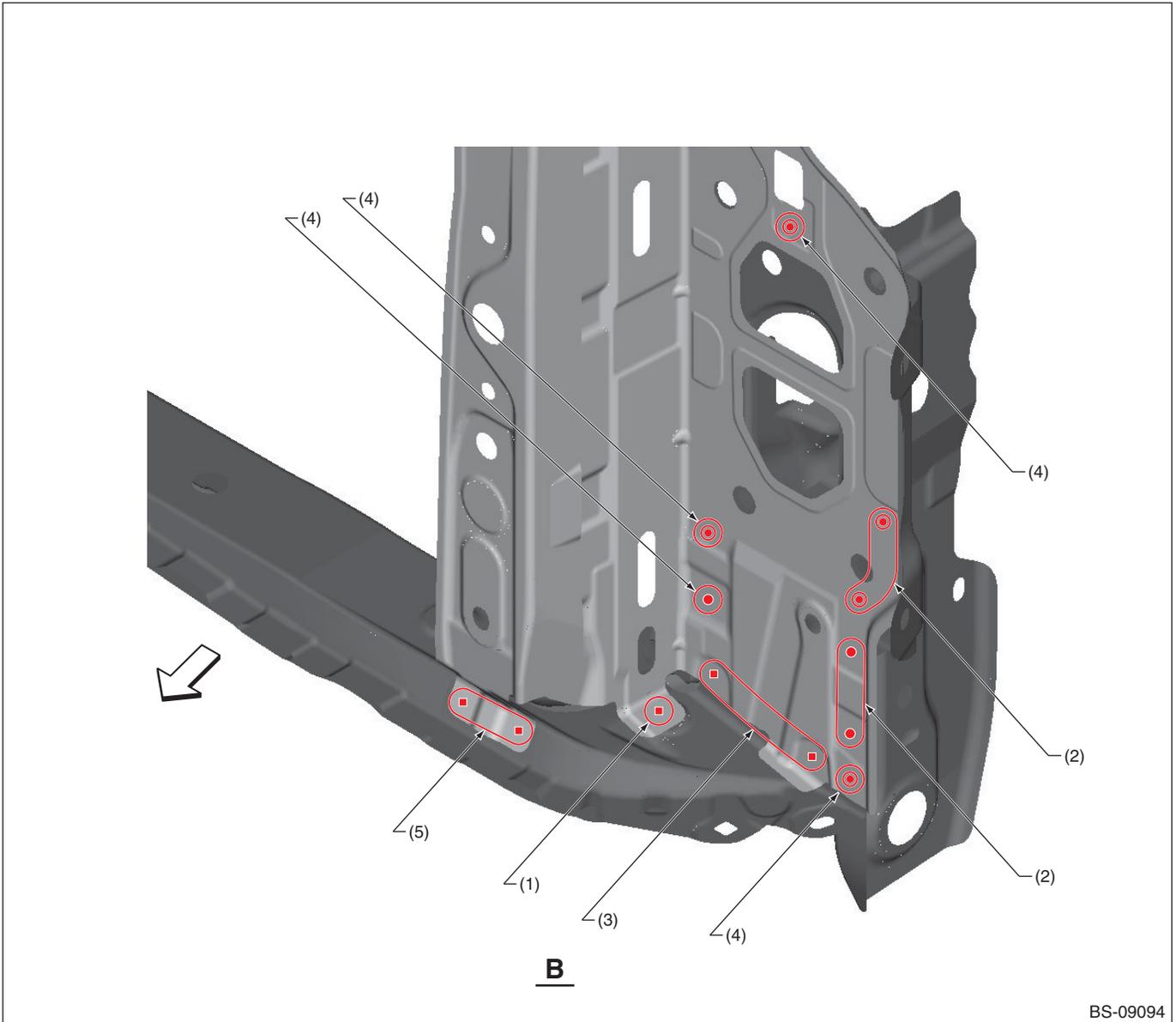
(1) 3 points

(2) 1 point

(3) 2 points

# Panel Replacement

## • Views B



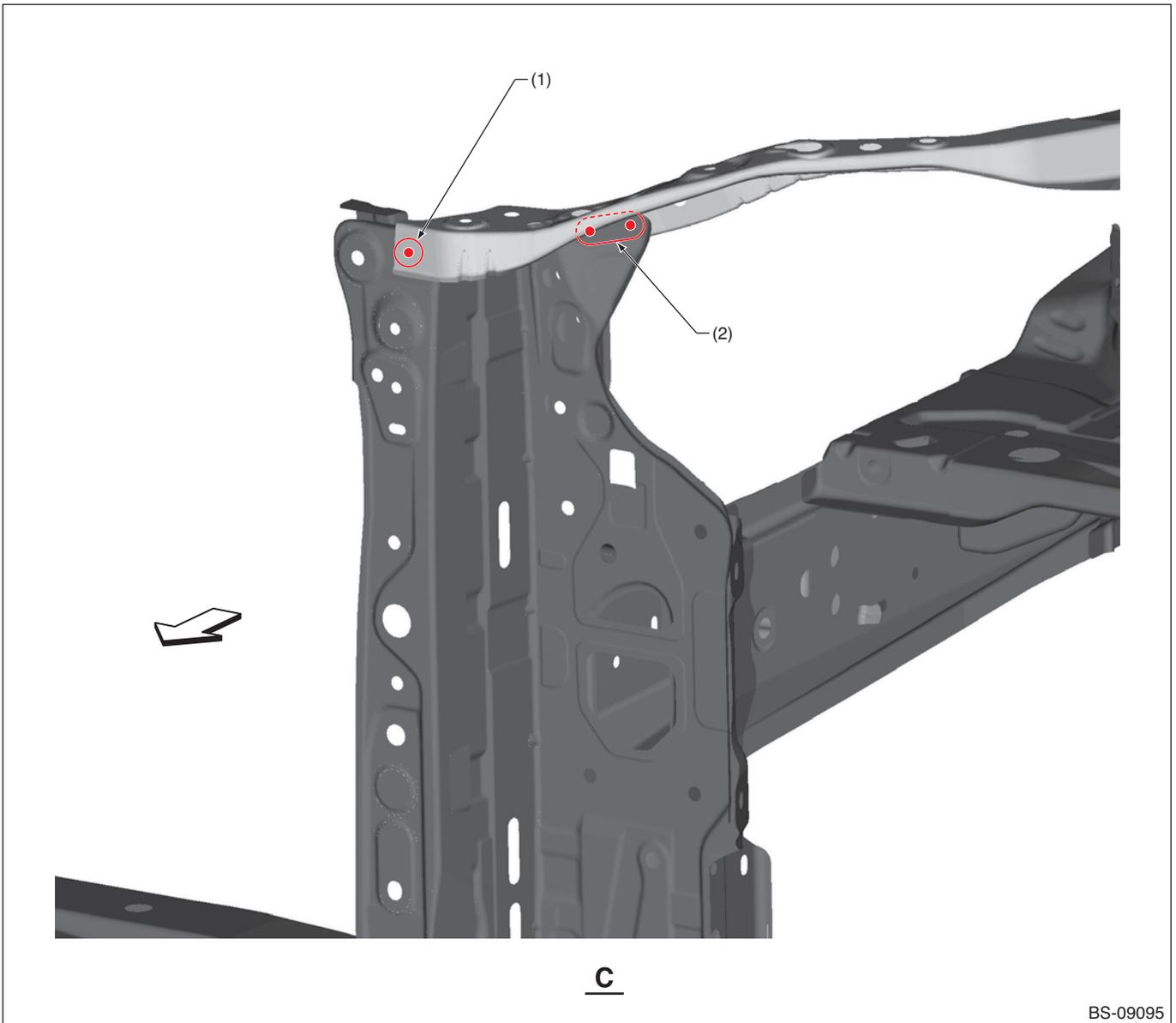
(1) 1 point (service)  
(2) 2 points

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

(5) 2 points (service)

# Panel Replacement

## • Views C

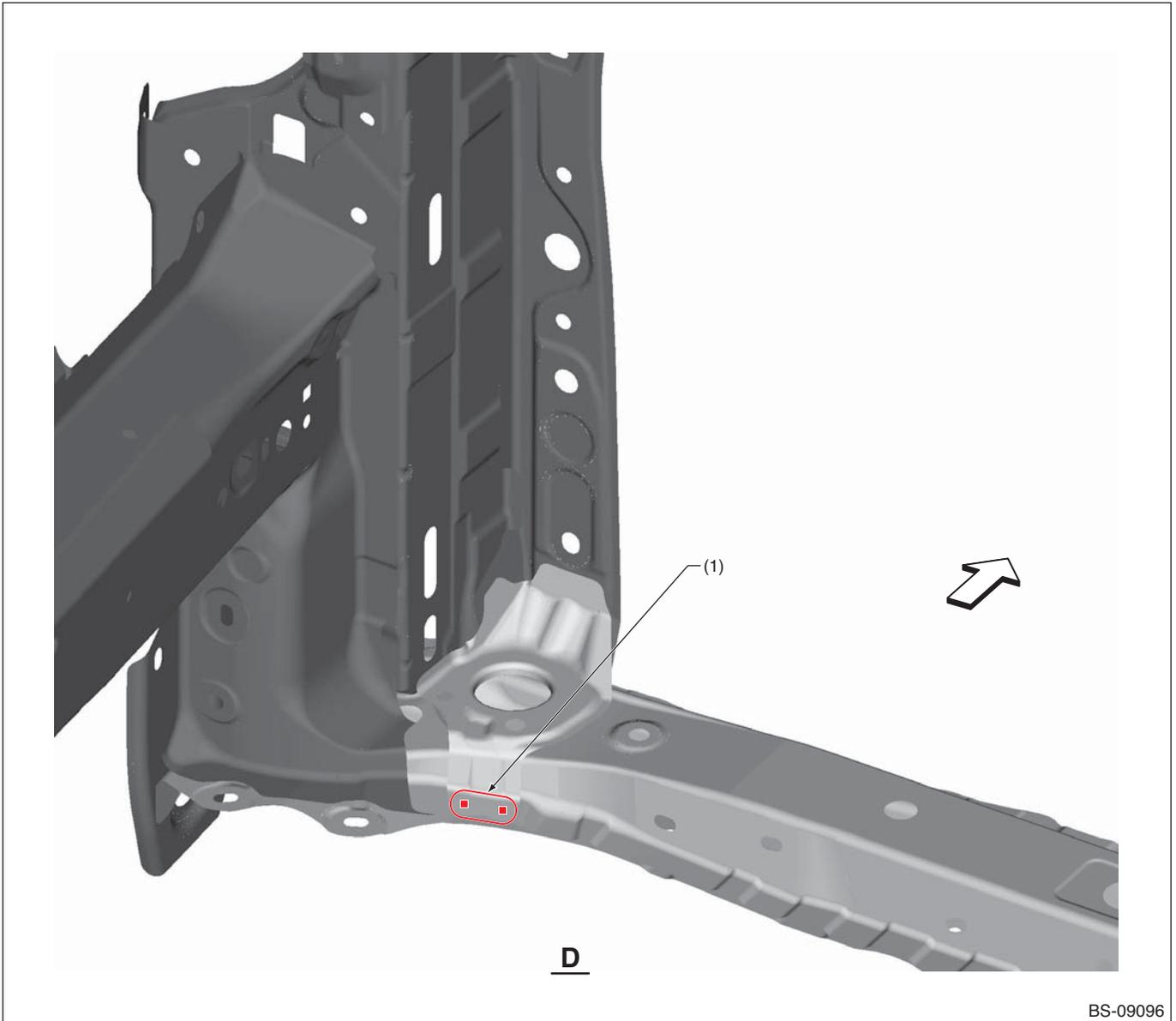


(1) 1 point

(2) 2 points

# Panel Replacement

- Views D



BS-09096

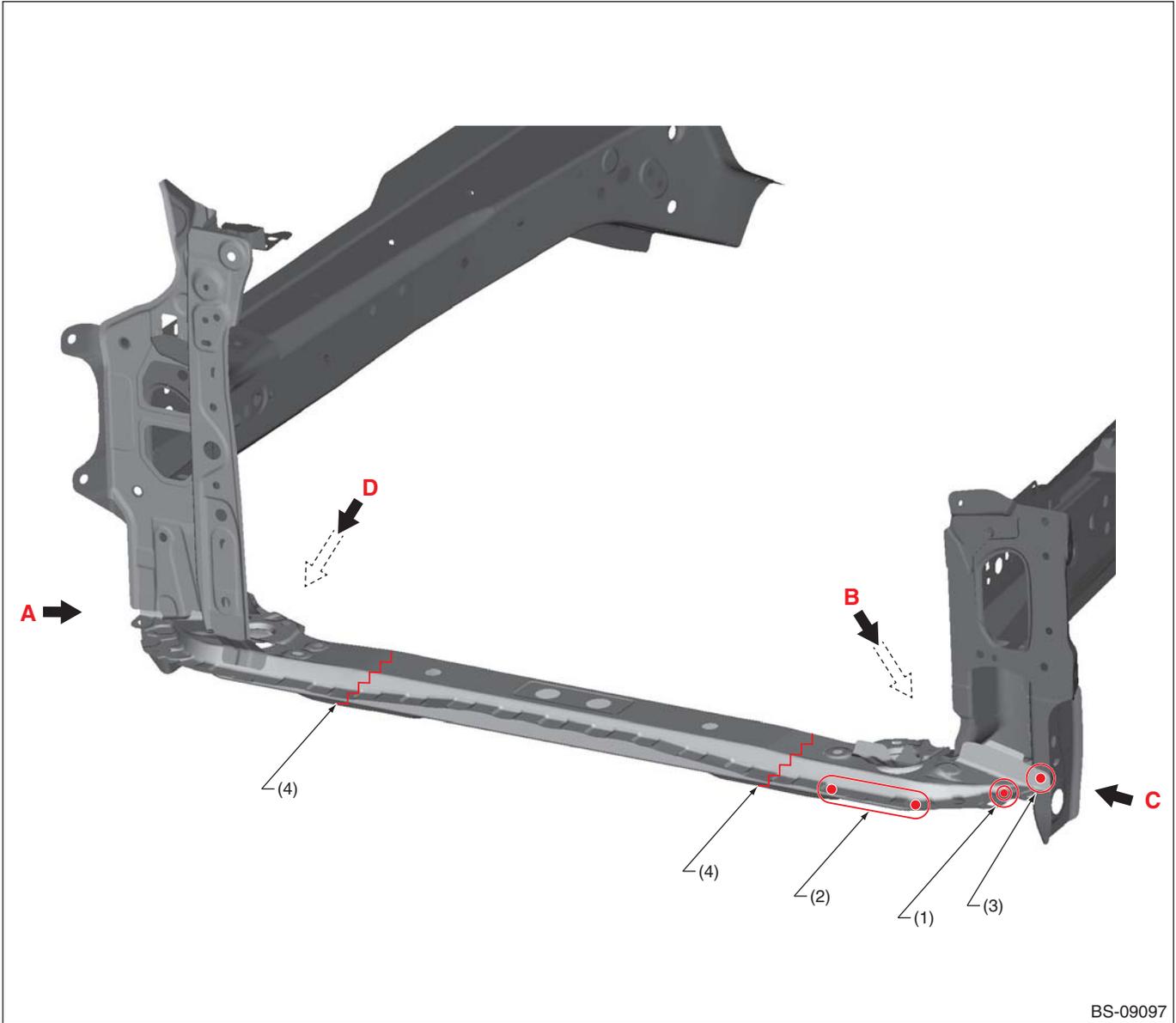
(1) 2 points (service)

# Panel Replacement

## 8-2. Radiator Core Support (total replacement)

### A: REMOVAL

#### • Overall view



BS-09097

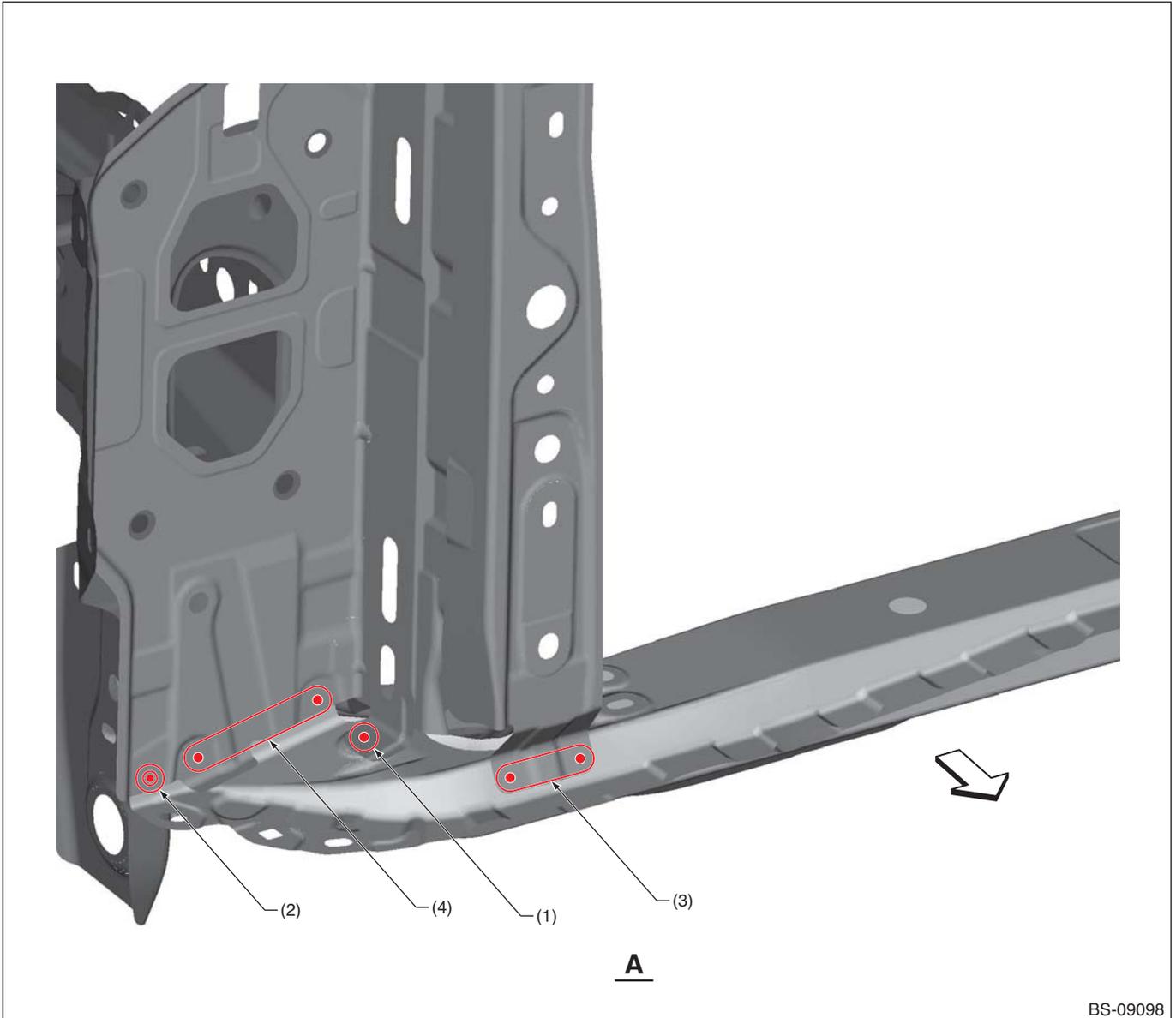
- (1) 1 point (top · 1)
- (2) 3 points (top · 1)

- (3) 1 point (outside · 1)

- (4) Rough cutting

# Panel Replacement

## • Views A



BS-09098

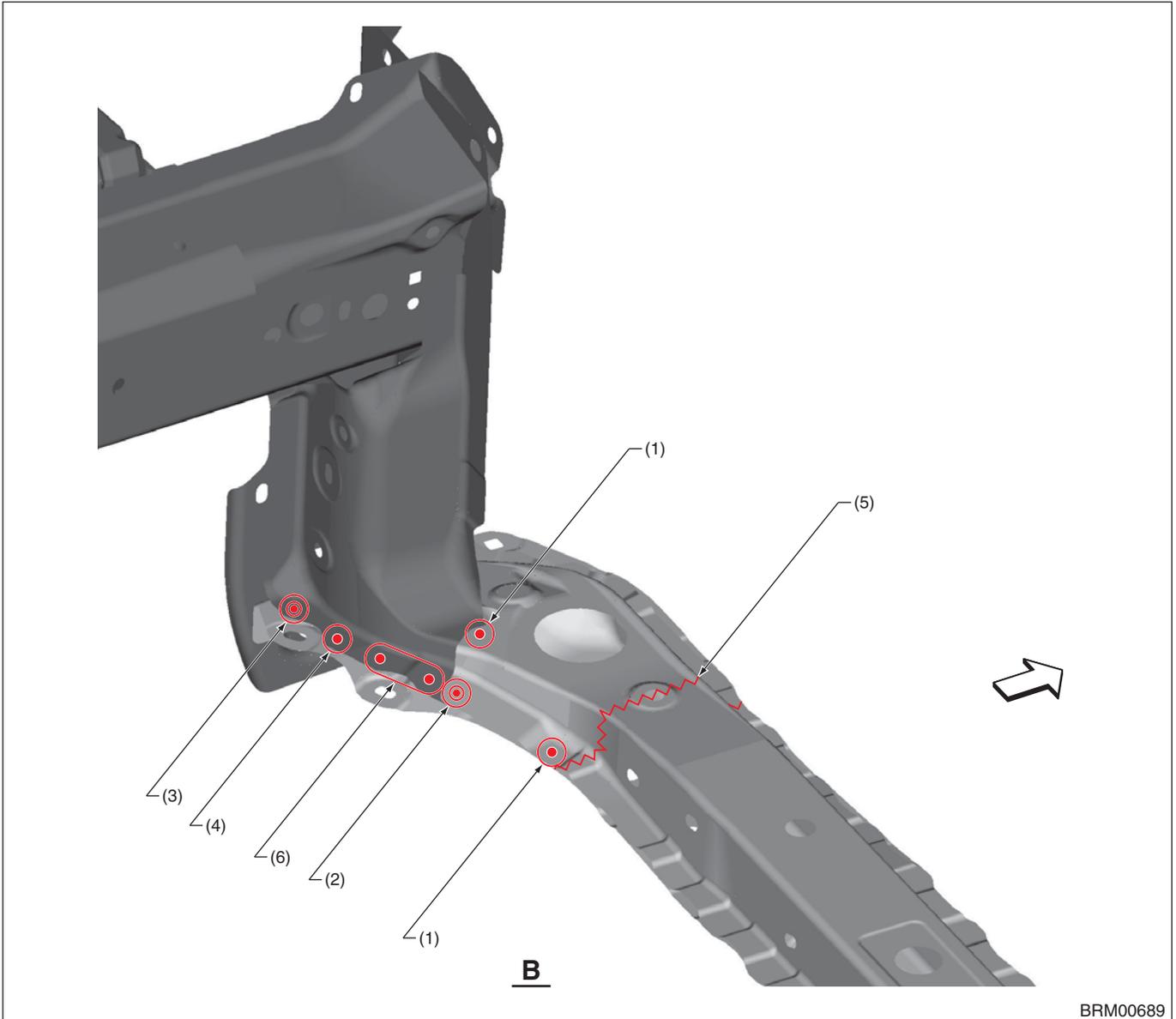
- (1) 1 point (top · 1)
- (2) 1 point (outside · 2)

- (3) 2 points (outside · 1)

- (4) 3 points (outside · 1)

# Panel Replacement

## • Views B



(1) 1 point (top · 1)

(2) 1 point (top · 1, bottom · 1)

(3) 1 point (bottom · 2)

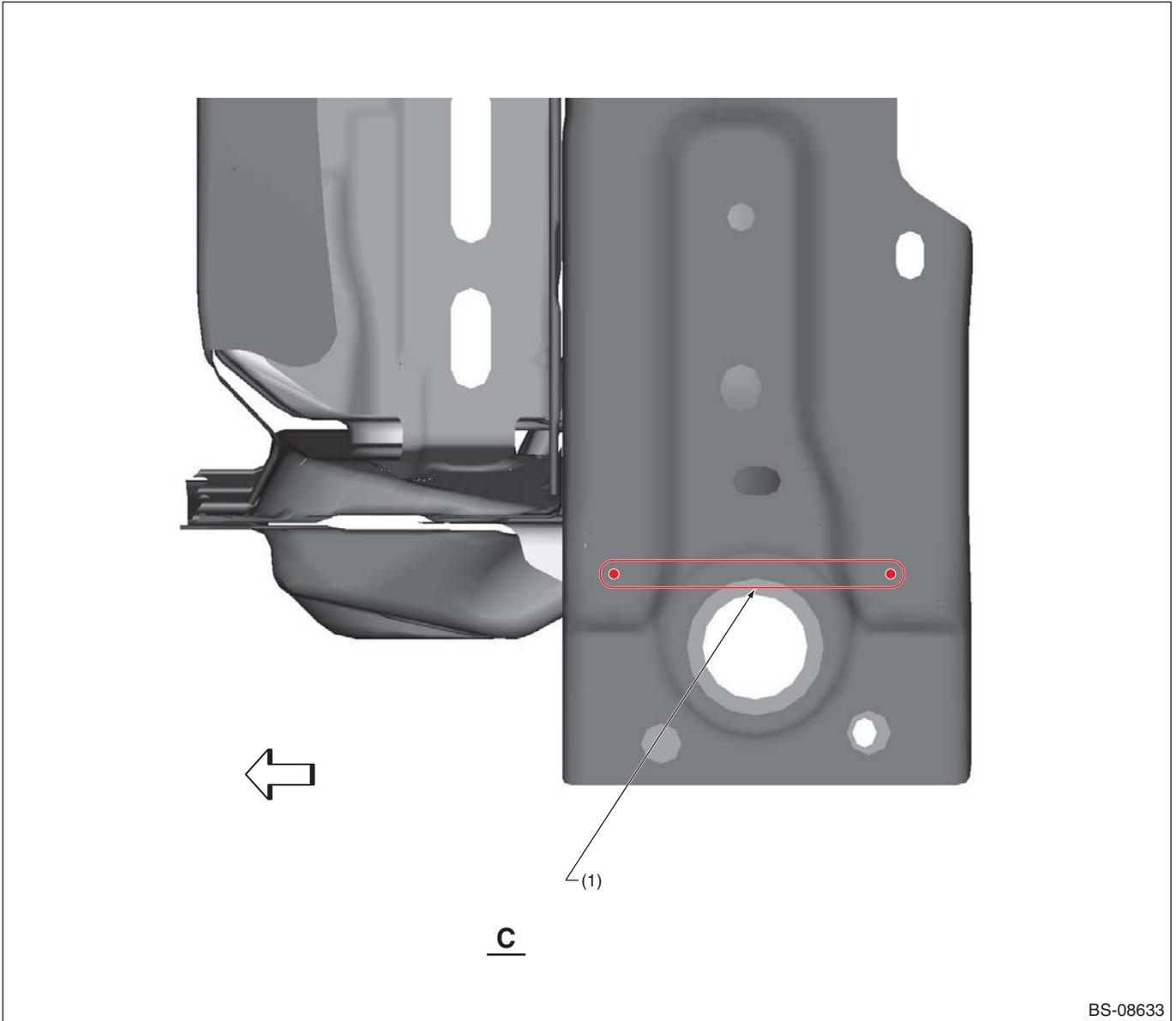
(4) 1 point (top · 1 belt sander)

(5) Rough cutting

(6) 2 points (bottom · 1)

# Panel Replacement

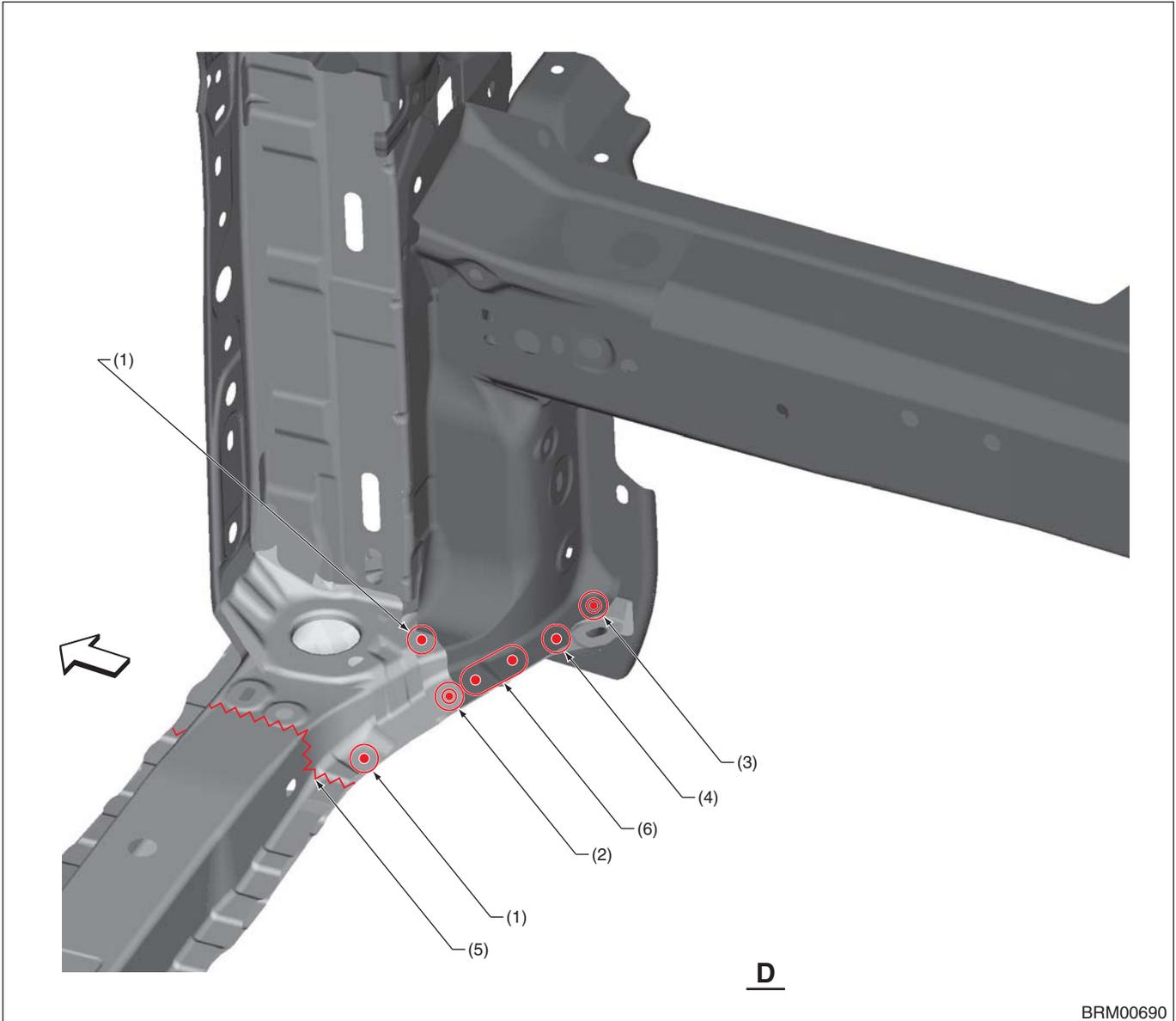
## • Views C



(1) 2 points (outside · 1)

# Panel Replacement

## • Views D



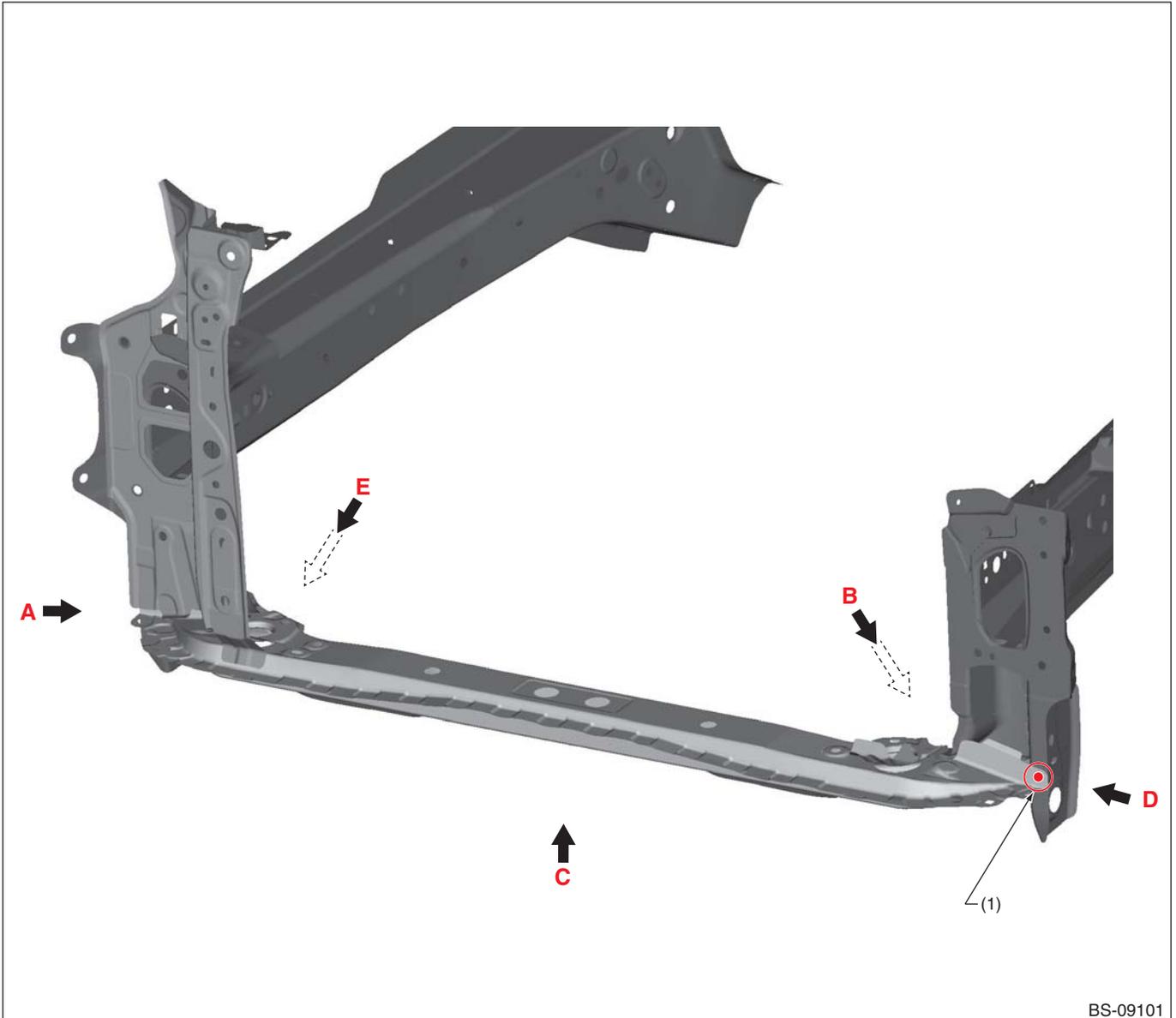
BRM00690

- |     |                               |     |                               |     |                       |
|-----|-------------------------------|-----|-------------------------------|-----|-----------------------|
| (1) | 1 point (top · 1)             | (3) | 1 point (bottom · 2)          | (5) | Rough cutting         |
| (2) | 1 point (top · 1, bottom · 1) | (4) | 1 point (top · 1 belt sander) | (6) | 2 points (bottom · 1) |

# Panel Replacement

## B: INSTALLATION

### • Overall view

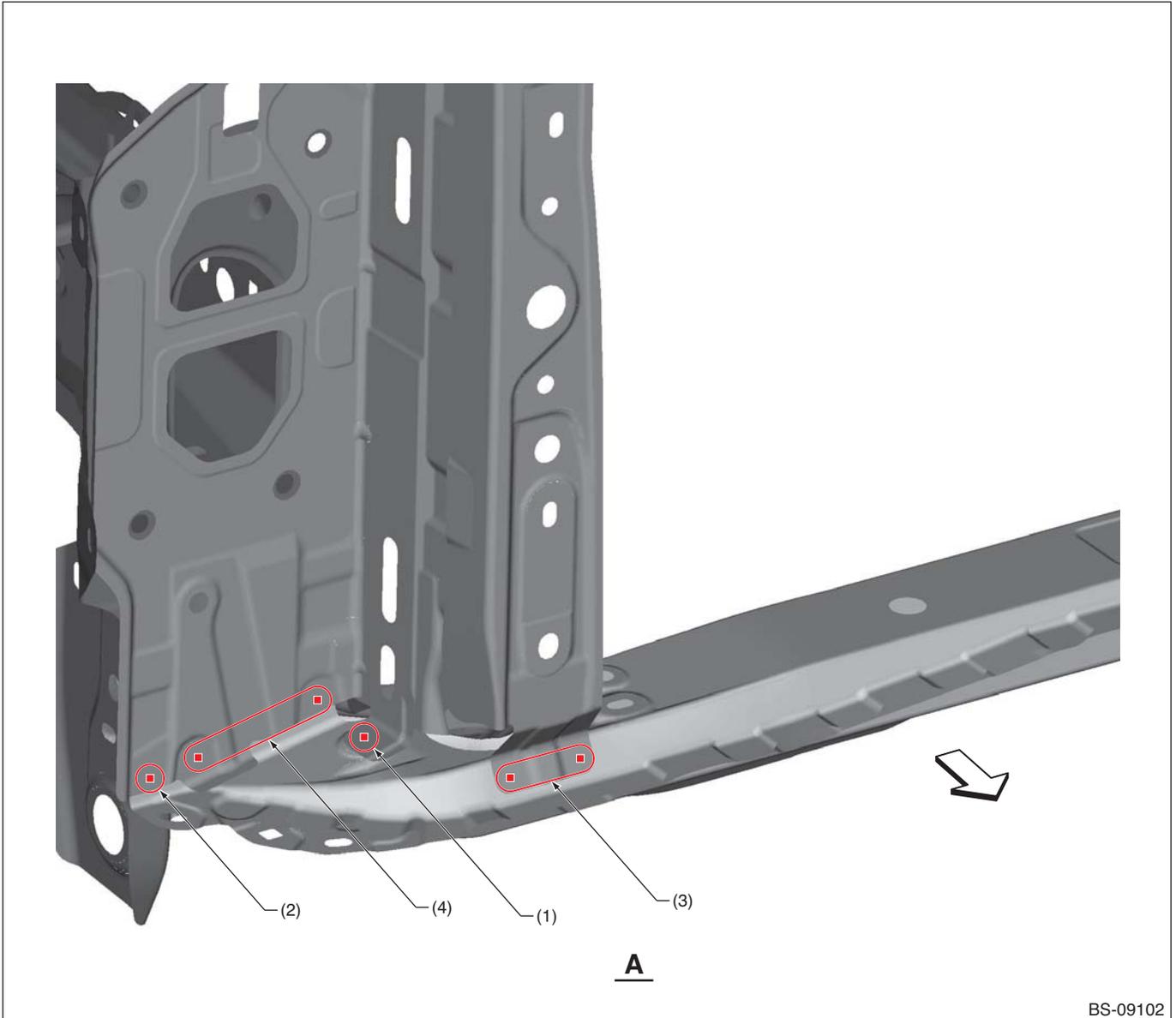


BS-09101

(1) 1 point

# Panel Replacement

## • Views A



(1) 1 point (service)

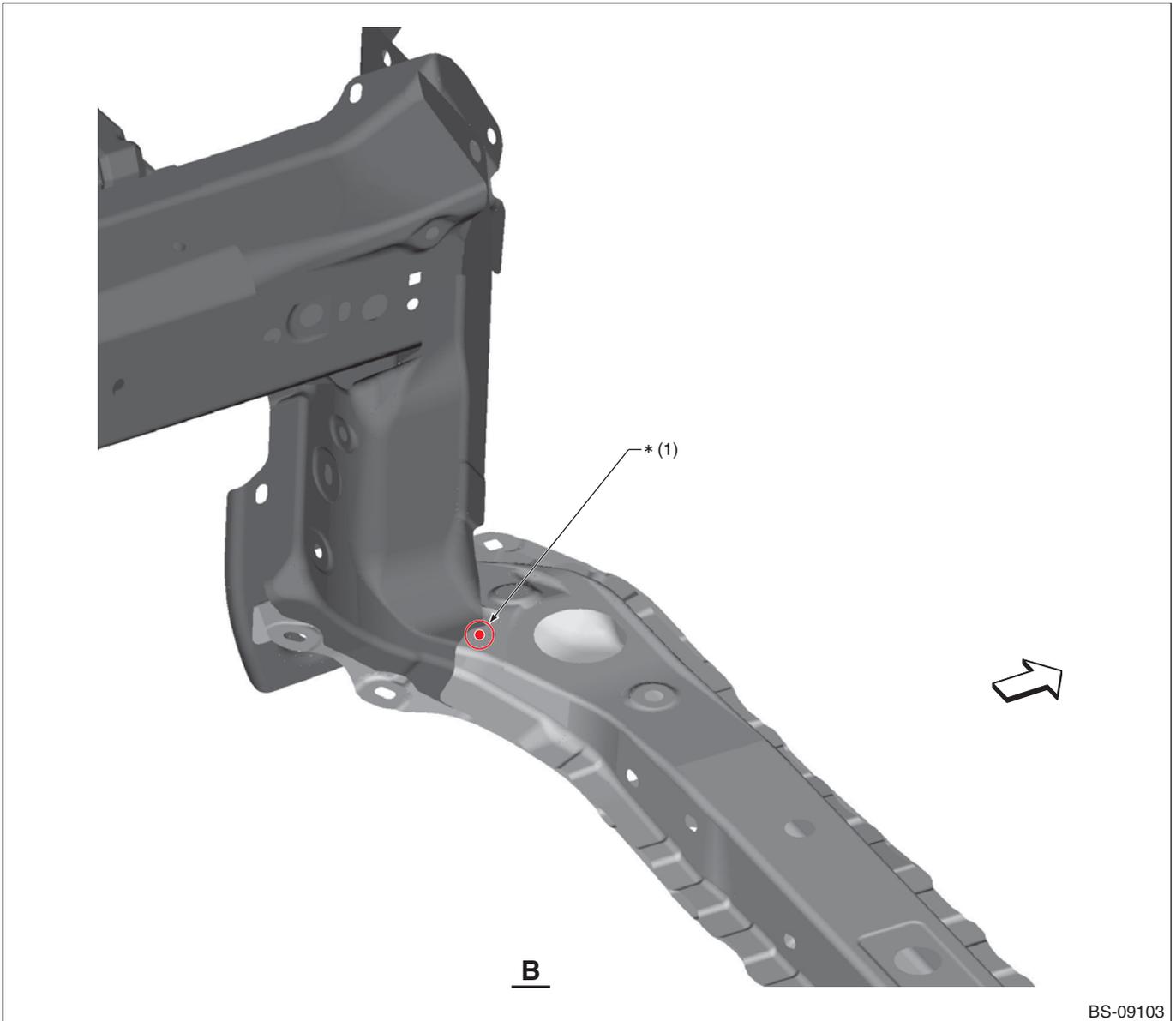
(3) 2 points (service)

(4) 3 points (service)

(2) 1 point (service - matching)

# Panel Replacement

## • Views B

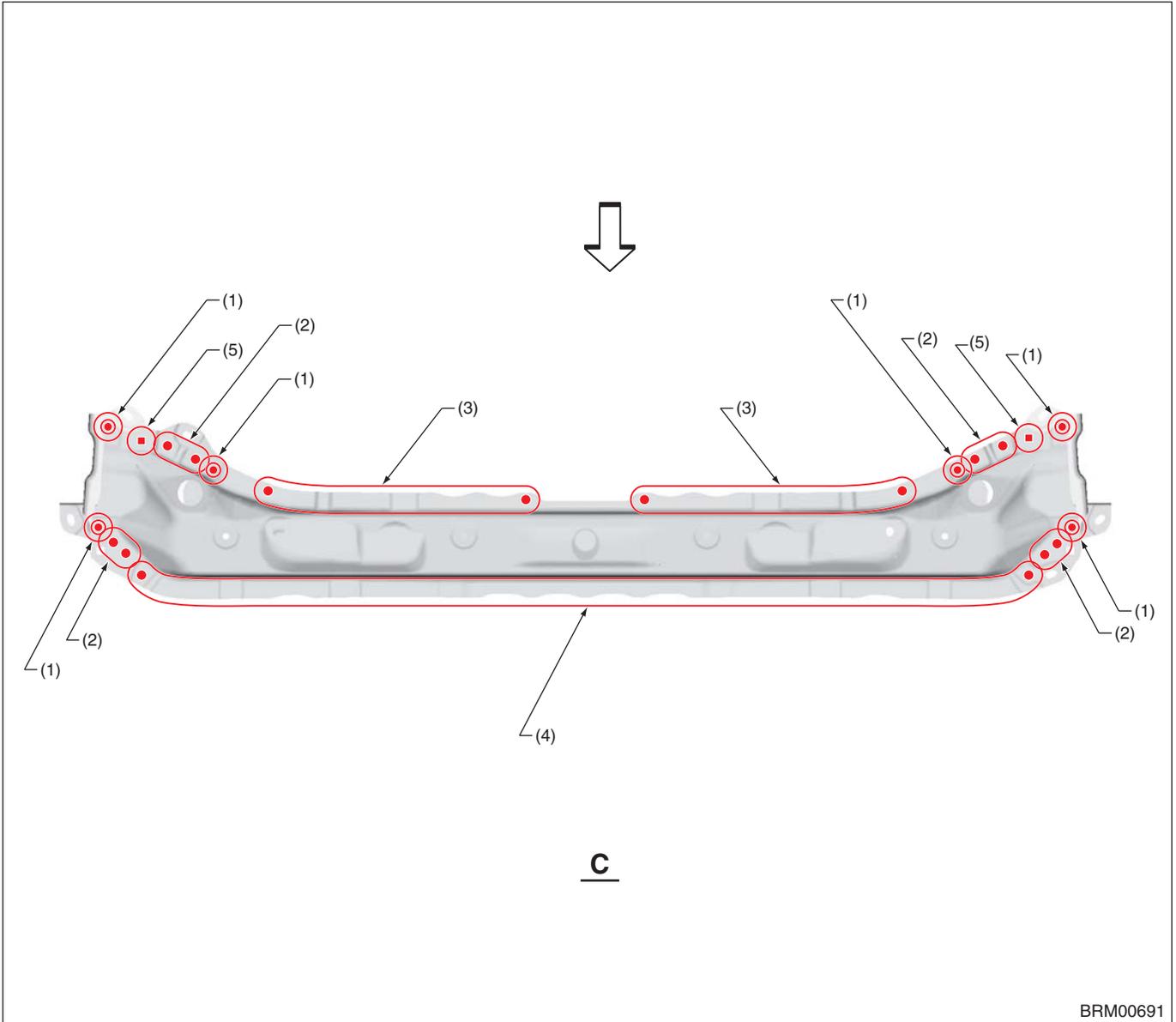


(1) 1 point

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

# Panel Replacement

## • Views C



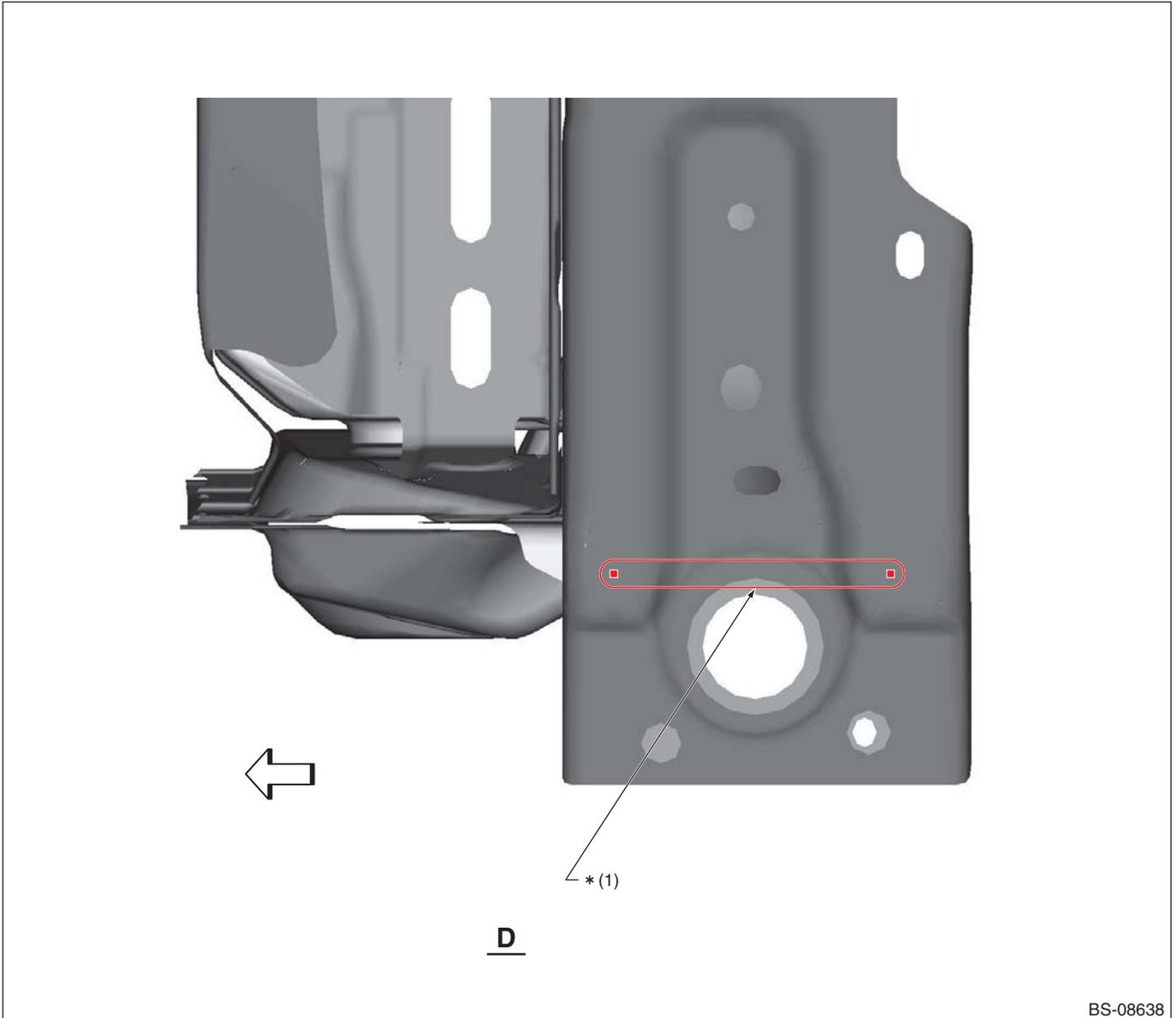
(1) 1 point  
(2) 2 points

(3) 7 points  
(4) 17 points

(5) 1 point (service)

# Panel Replacement

## • Views D



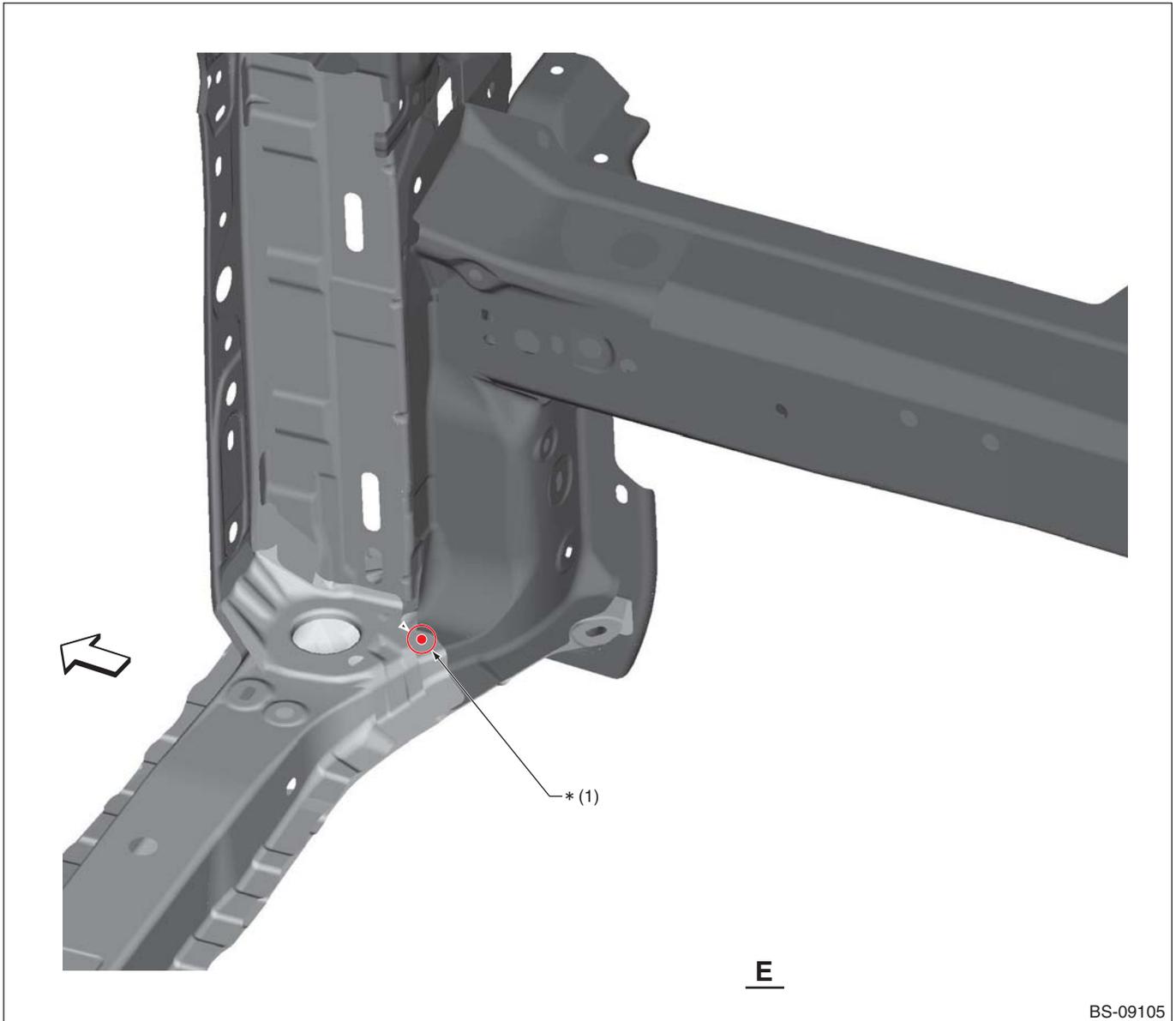
BS-08638

(1) 2 points

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

# Panel Replacement

## • Views E



(1) 1 point

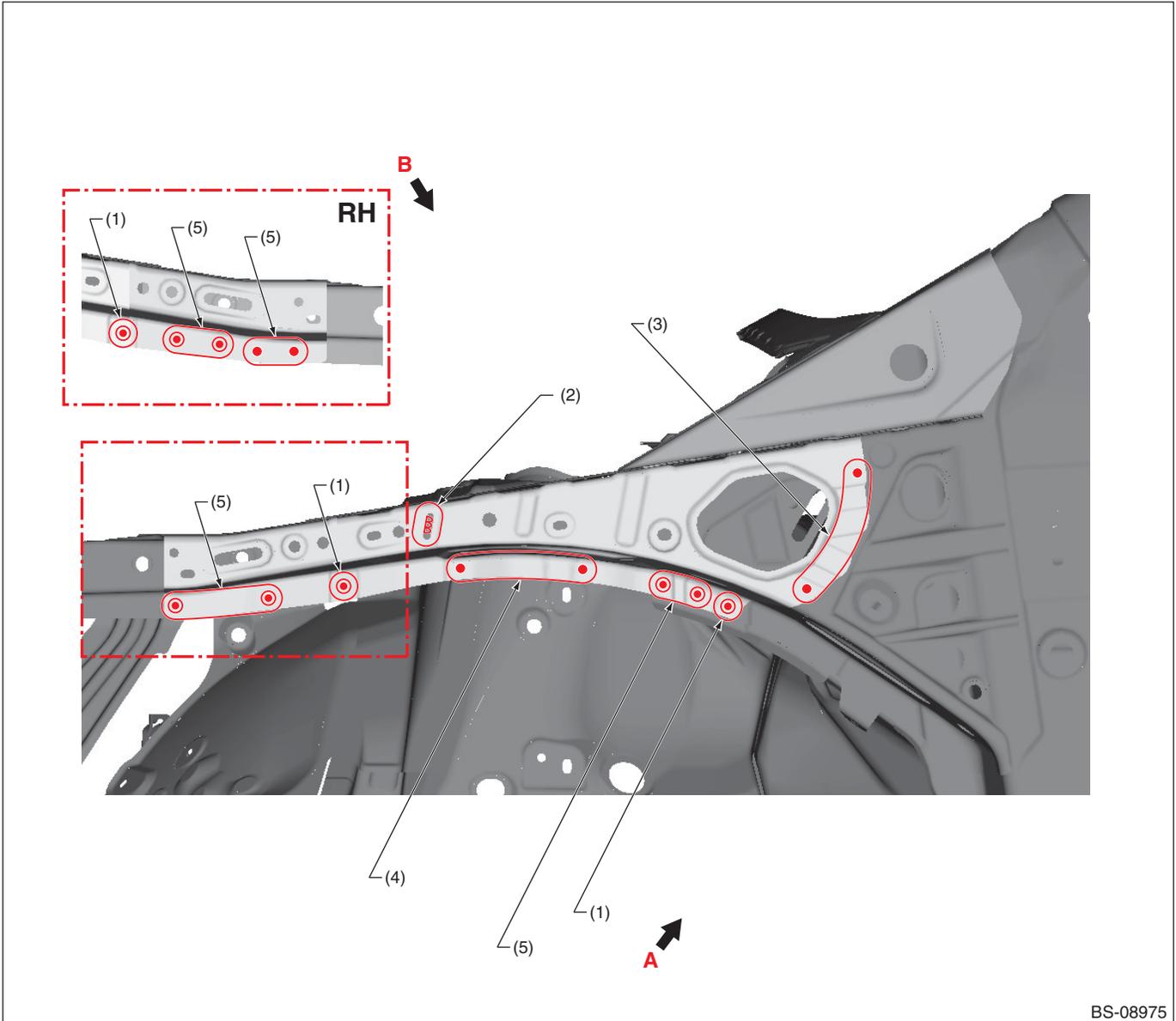
\* : Before radiator B is installed, this point is welded.

# Panel Replacement

## 8-3. Side Upper Frame (total replacement)

### A: REMOVAL

• Overall view



BS-08975

(1) 1 point (outside · 2)

(2) 1 point (outside · 1 belt sander)

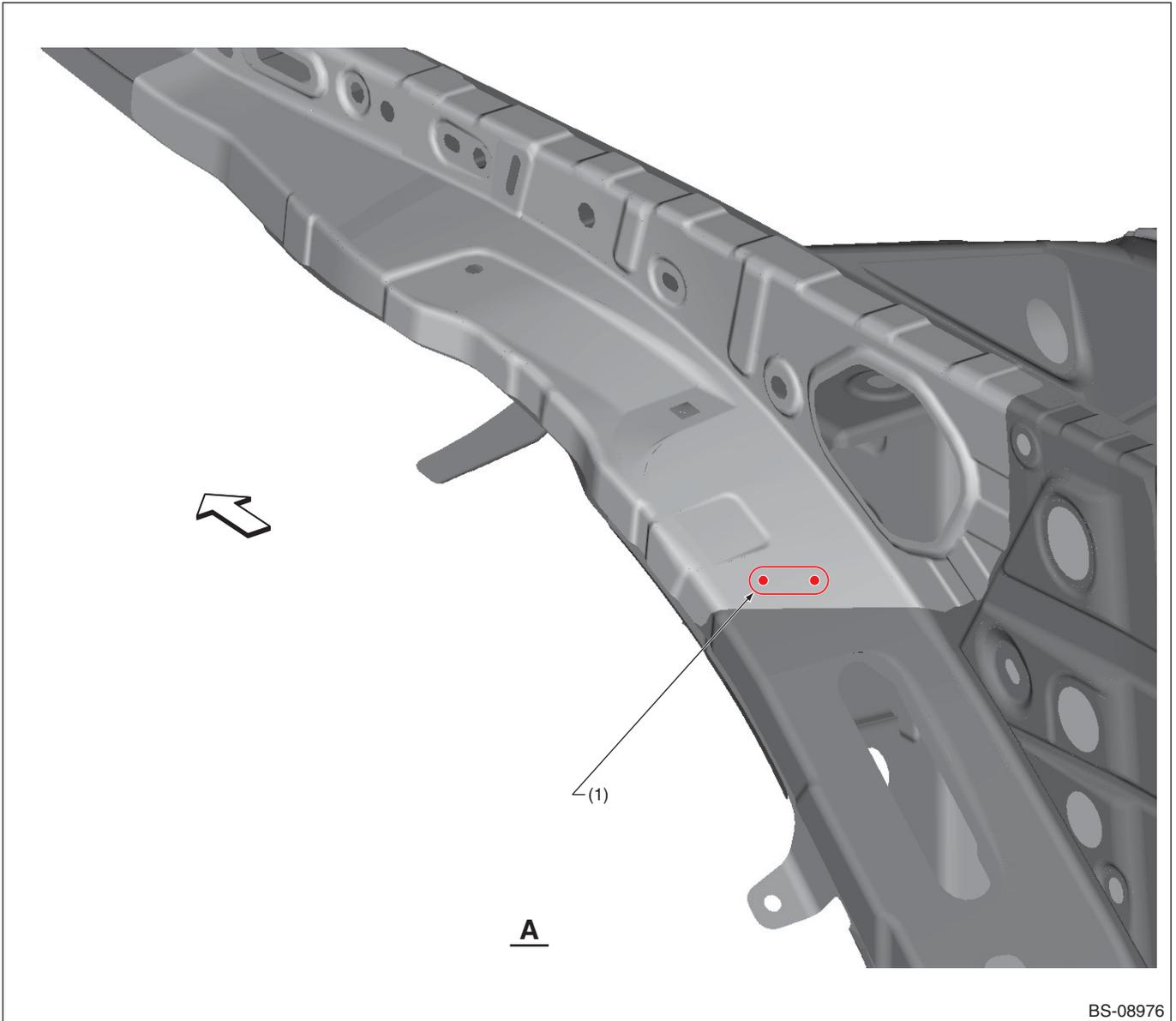
(3) 4 points (outside · 1)

(4) 3 points (outside · 1)

(5) 2 points (outside · 1)

# Panel Replacement

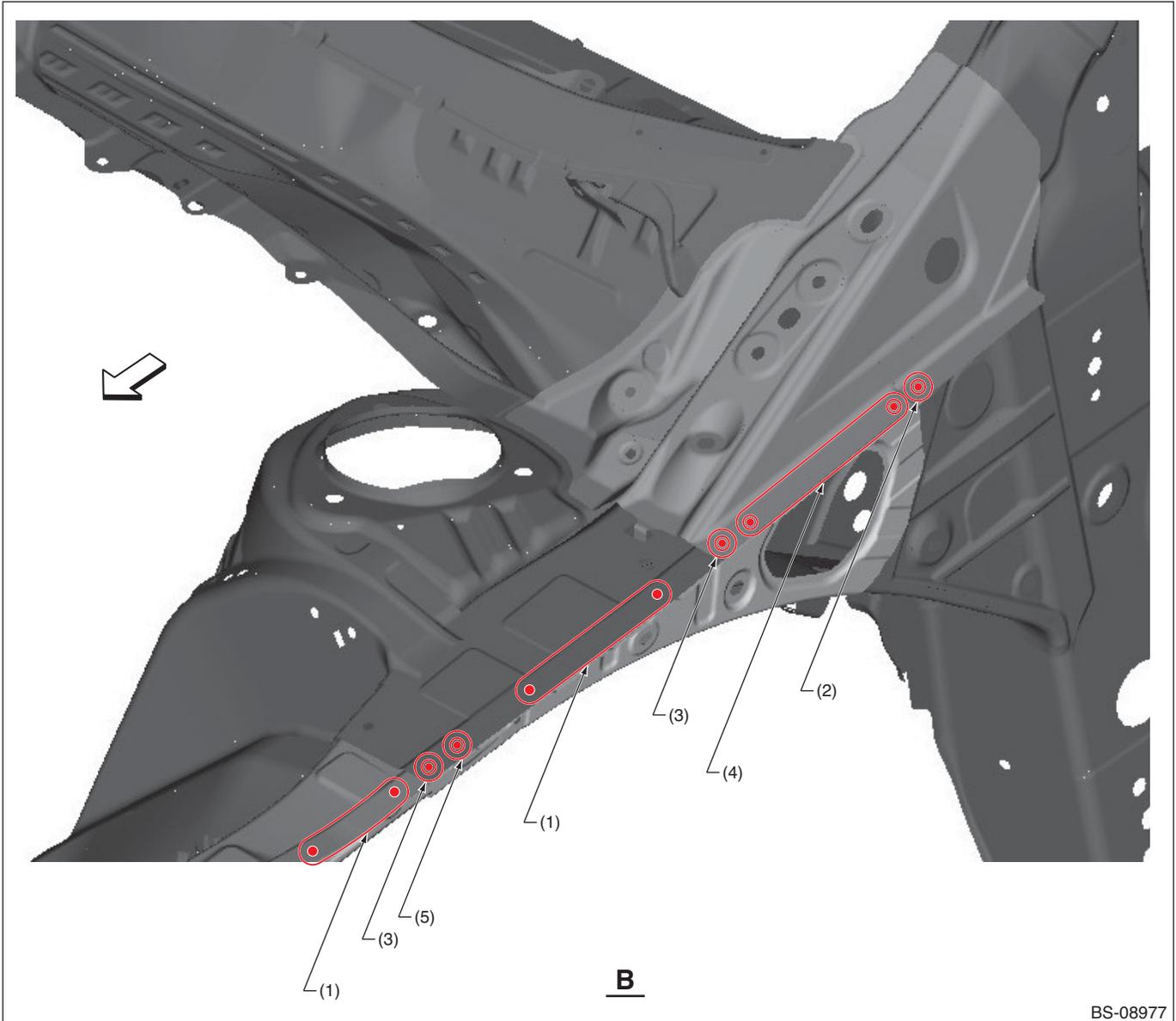
## • Views A



(1) 2 points (outside · 1)

# Panel Replacement

## • Views B



BS-08977

(1) 3 points (bottom · 1)

(3) 1 point (bottom · 1)

(5) 1 point (bottom · 2)

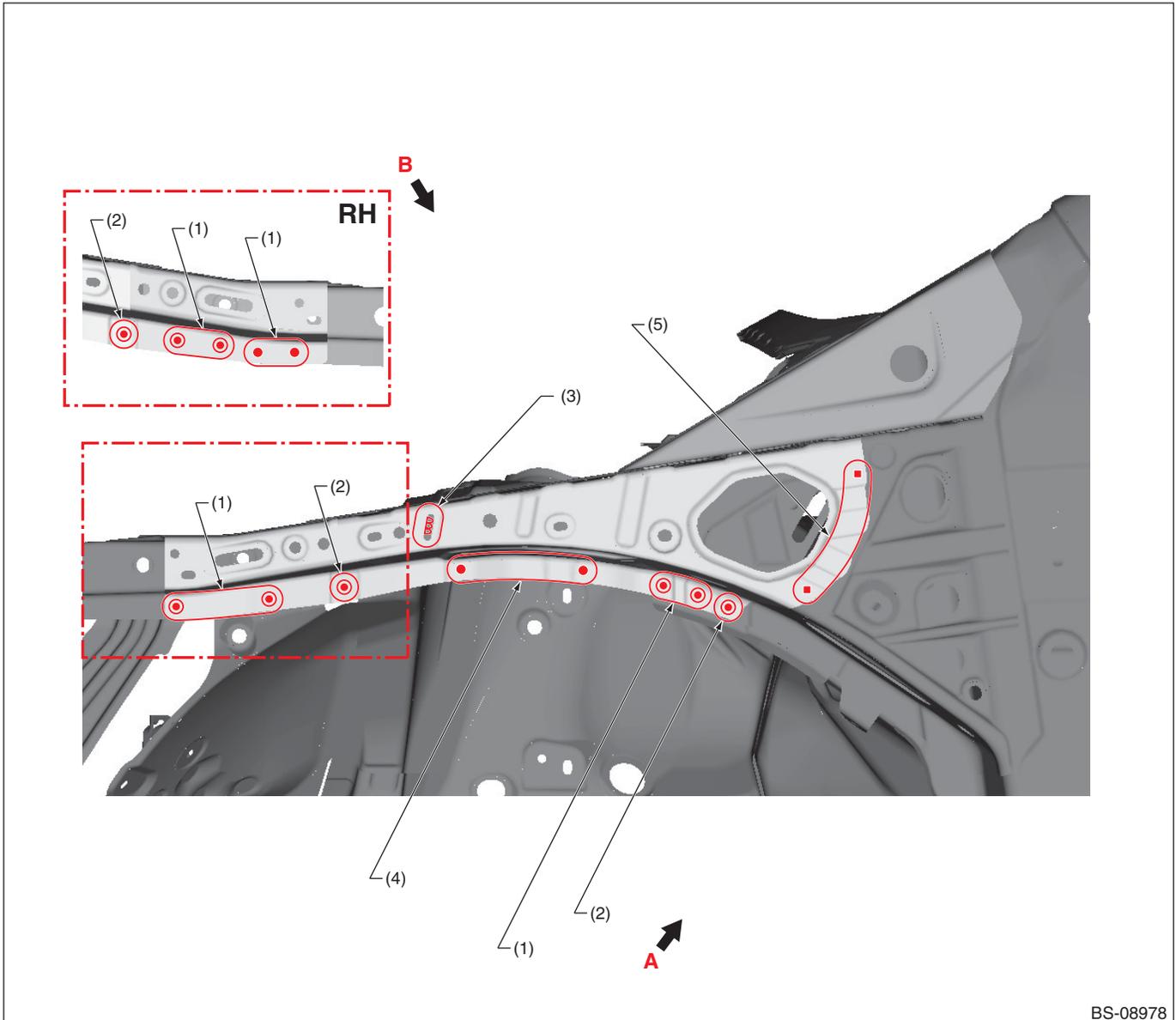
(2) 1 point (bottom · 1 belt sander)

(4) 3 points (bottom · 1 belt sander)

# Panel Replacement

## B: INSTALLATION

### • Overall view



(1) 2 points

(2) 1 point

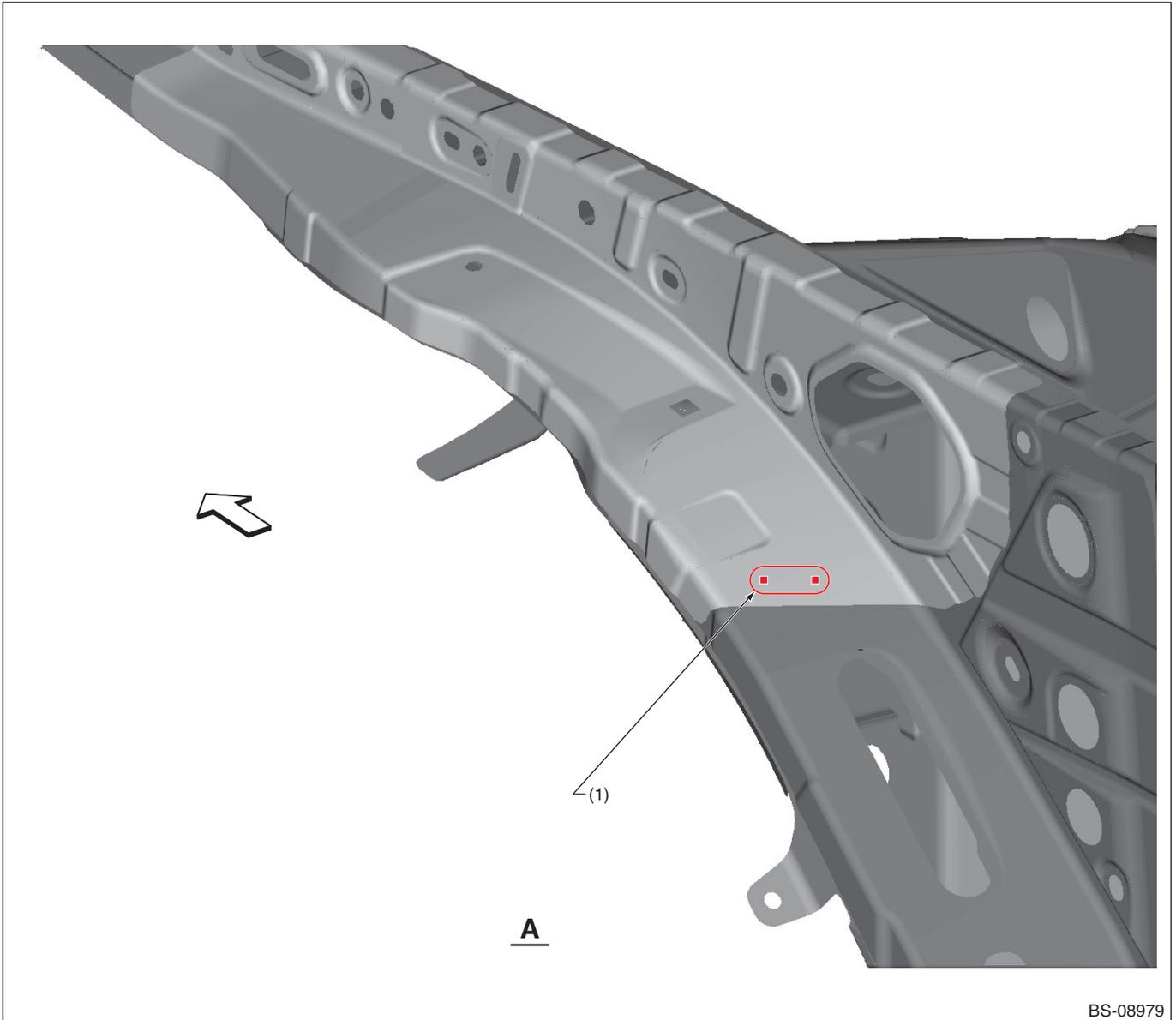
(3) 1 point (Continuous welding)  
[20 mm (0.79 in)]

(4) 3 points

(5) 4 points (service)

# Panel Replacement

## • Views A

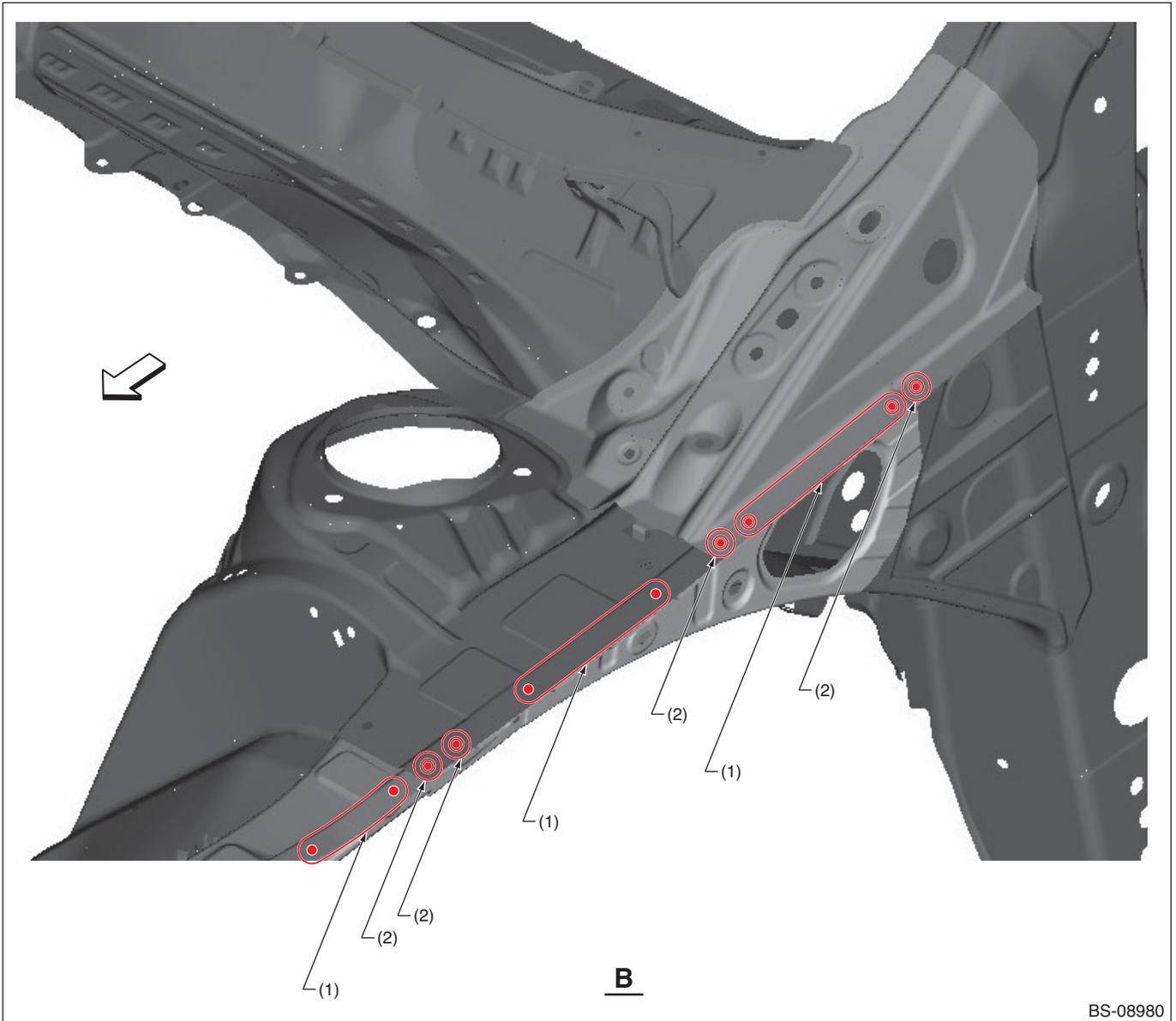


BS-08979

(1) 2 points (service)

# Panel Replacement

## • Views B



(1) 3 points

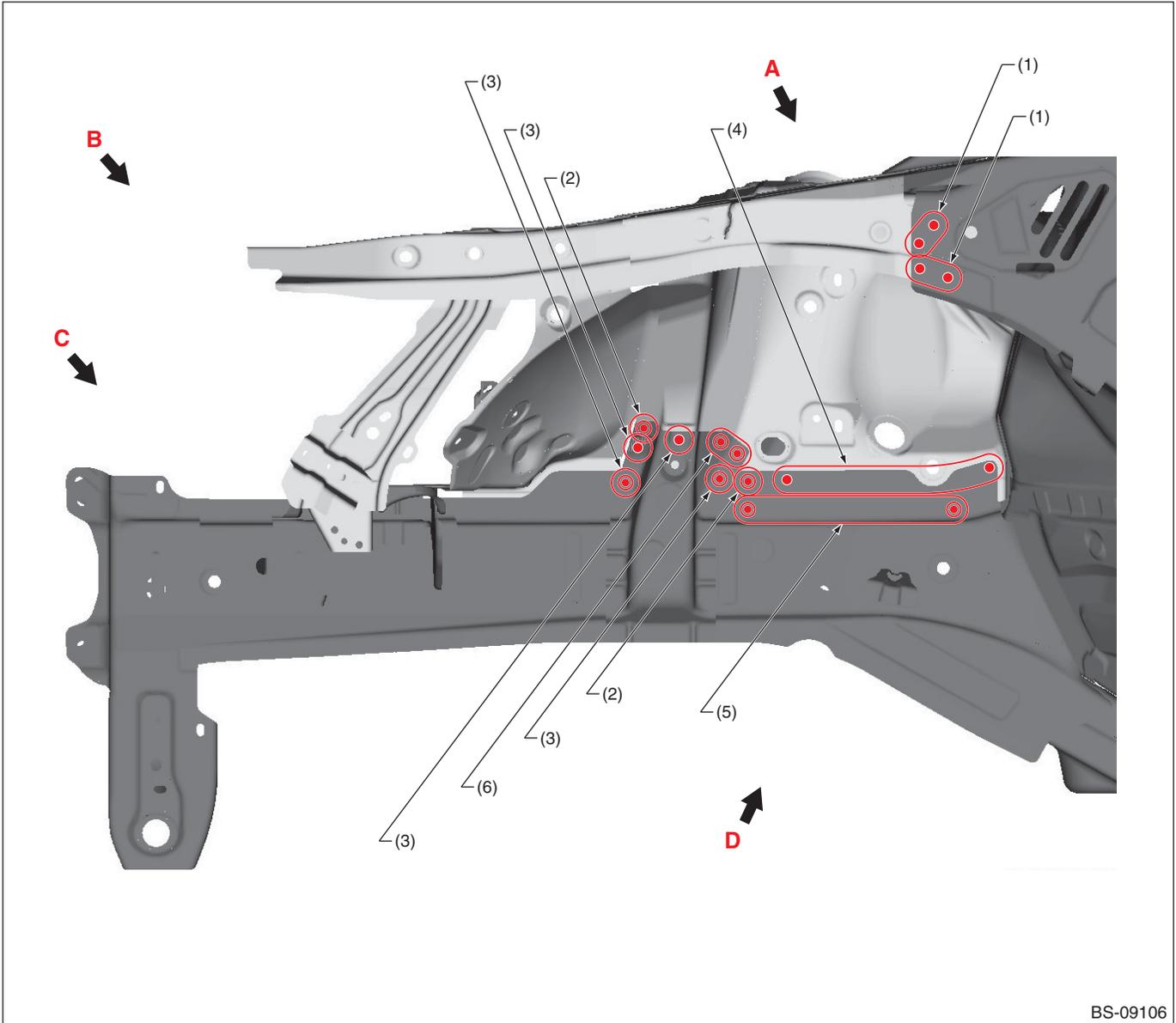
(2) 1 point

# Panel Replacement

## 8-4. Front Wheel Apron (total replacement)

### A: REMOVAL

#### • Overall view



BS-09106

(1) 2 points (outside · 1)

(2) 1 point (inside · 2)

(3) 1 point (inside · 1)

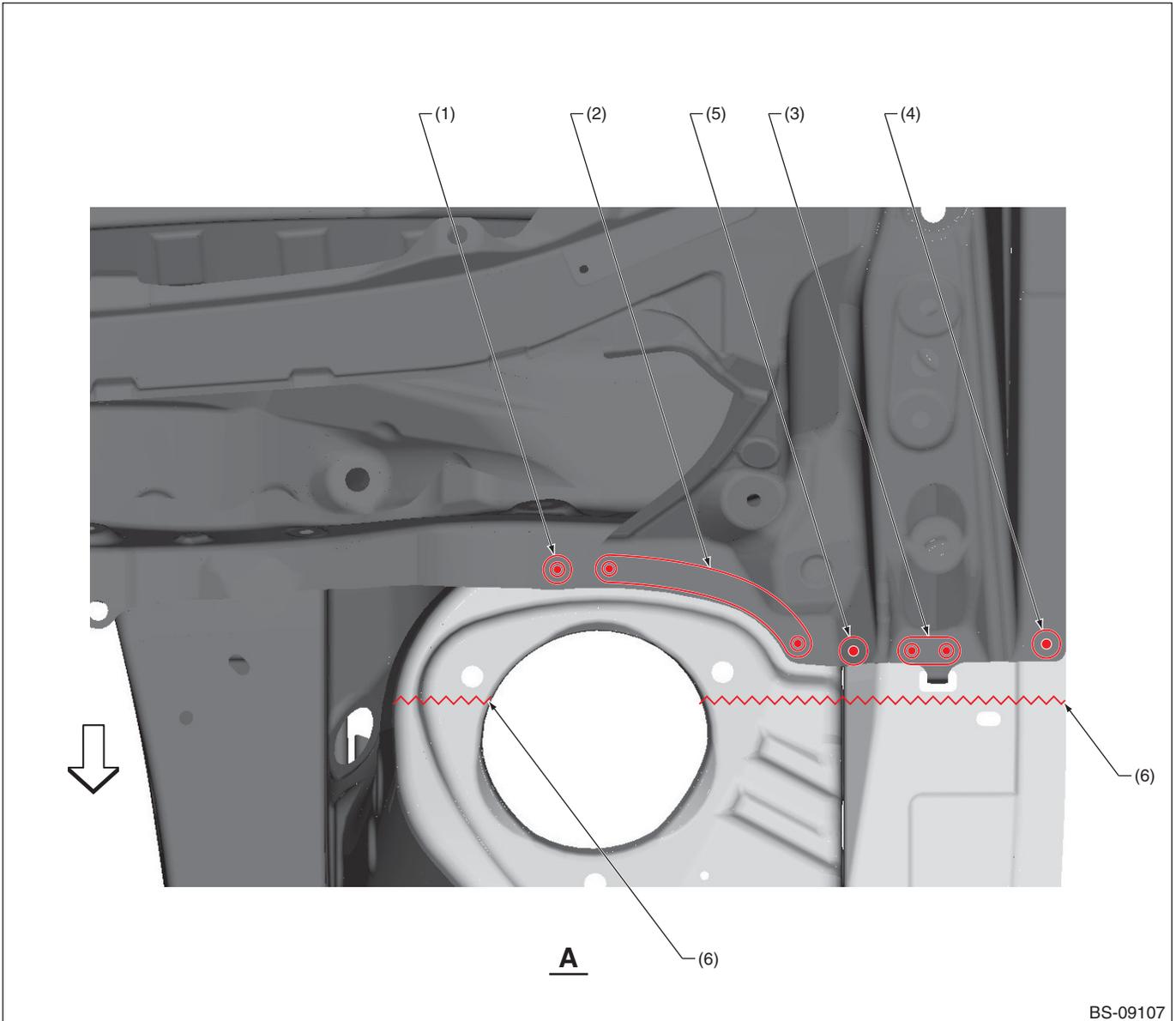
(4) 6 points (inside · 1)

(5) 4 points (inside · 1)

(6) 2 points (inside · 2)

# Panel Replacement

## • Views A



BS-09107

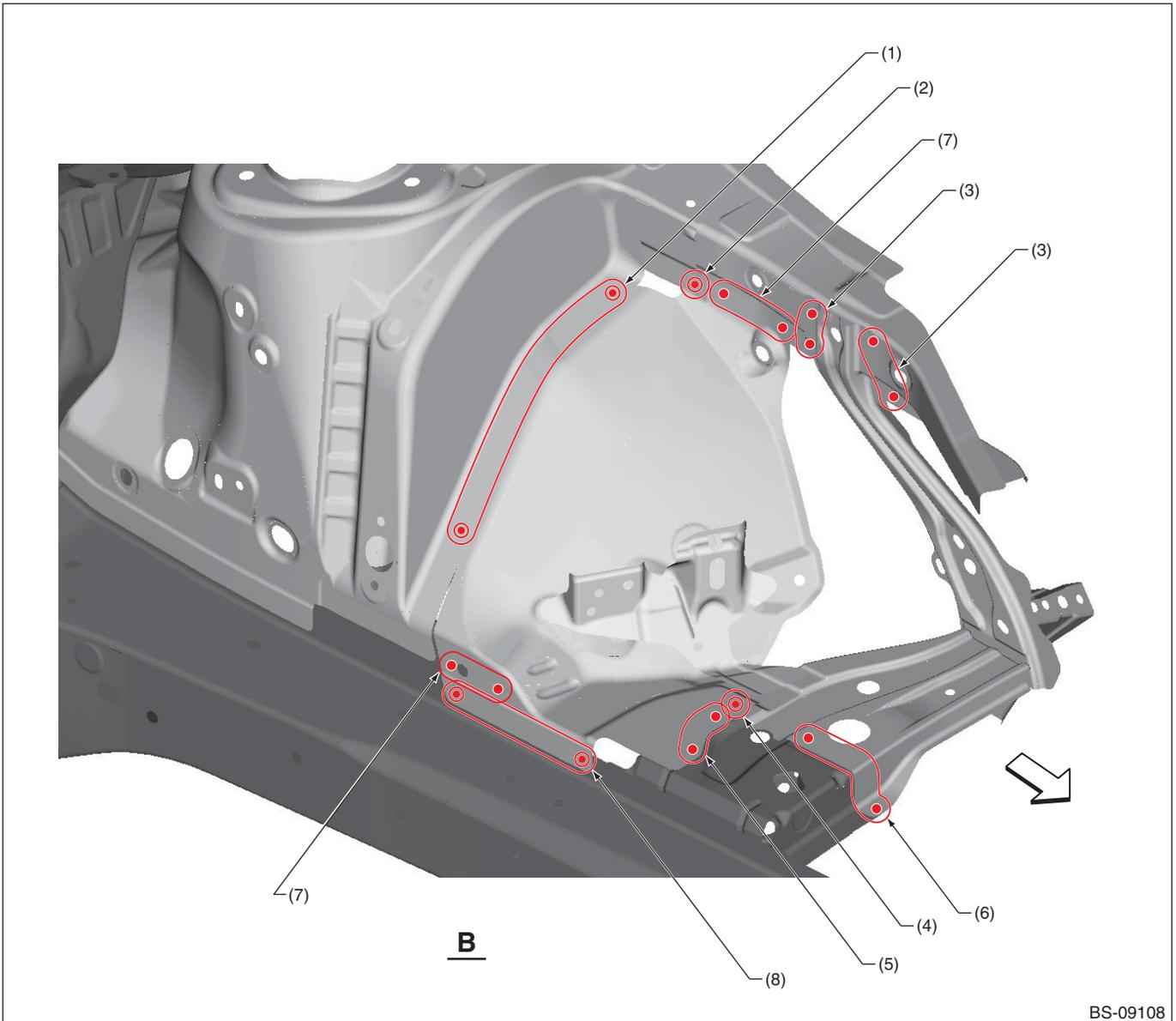
(1) 1 point (top · 2)  
(2) 4 points (top · 2)

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

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

# Panel Replacement

## • Views B (LH)



BS-09108

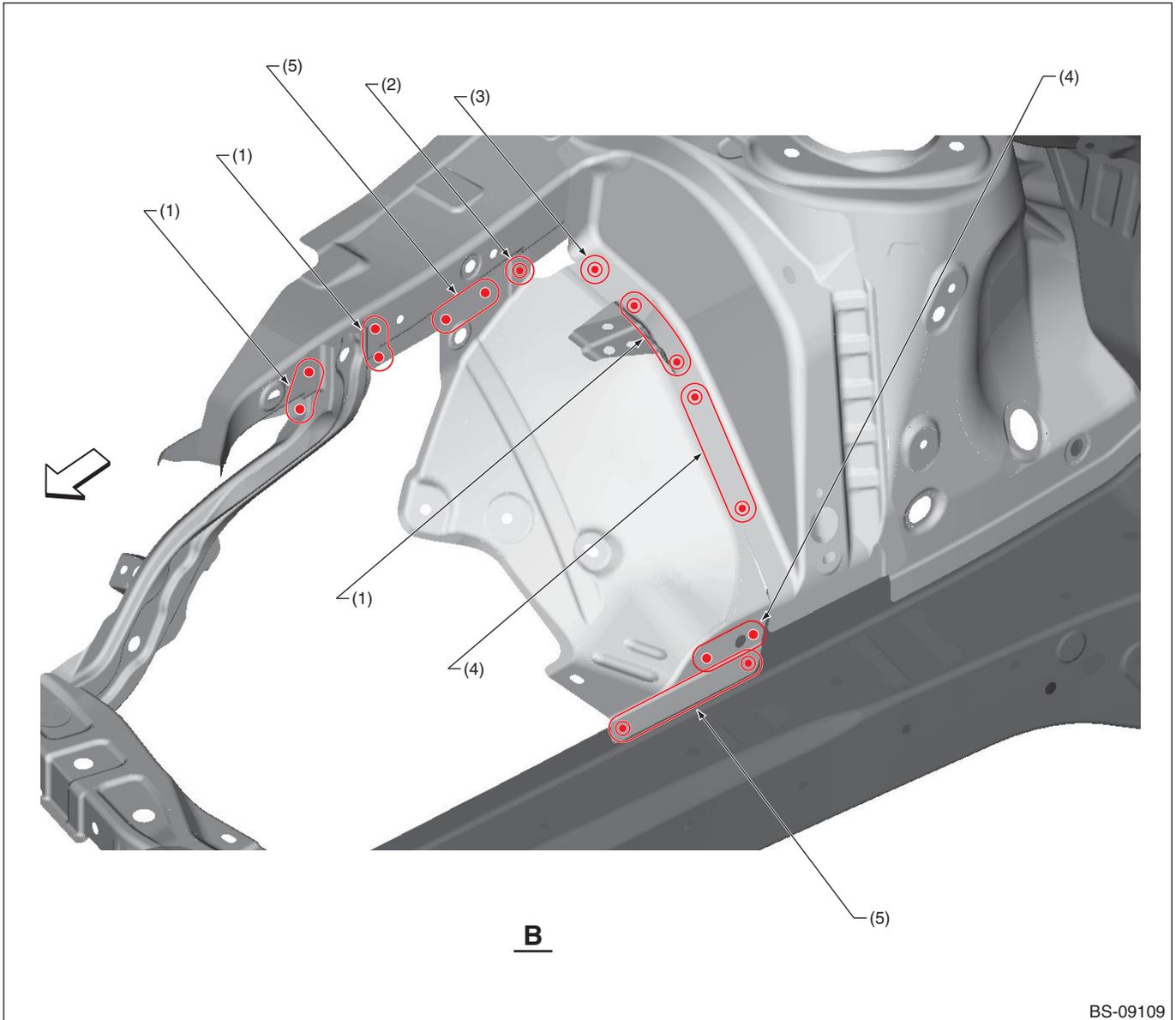
- (1) 5 points (top · 1)
- (2) 1 point (inside · 1)
- (3) 2 points (inside · 1)

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

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

# Panel Replacement

## • Views B (RH)



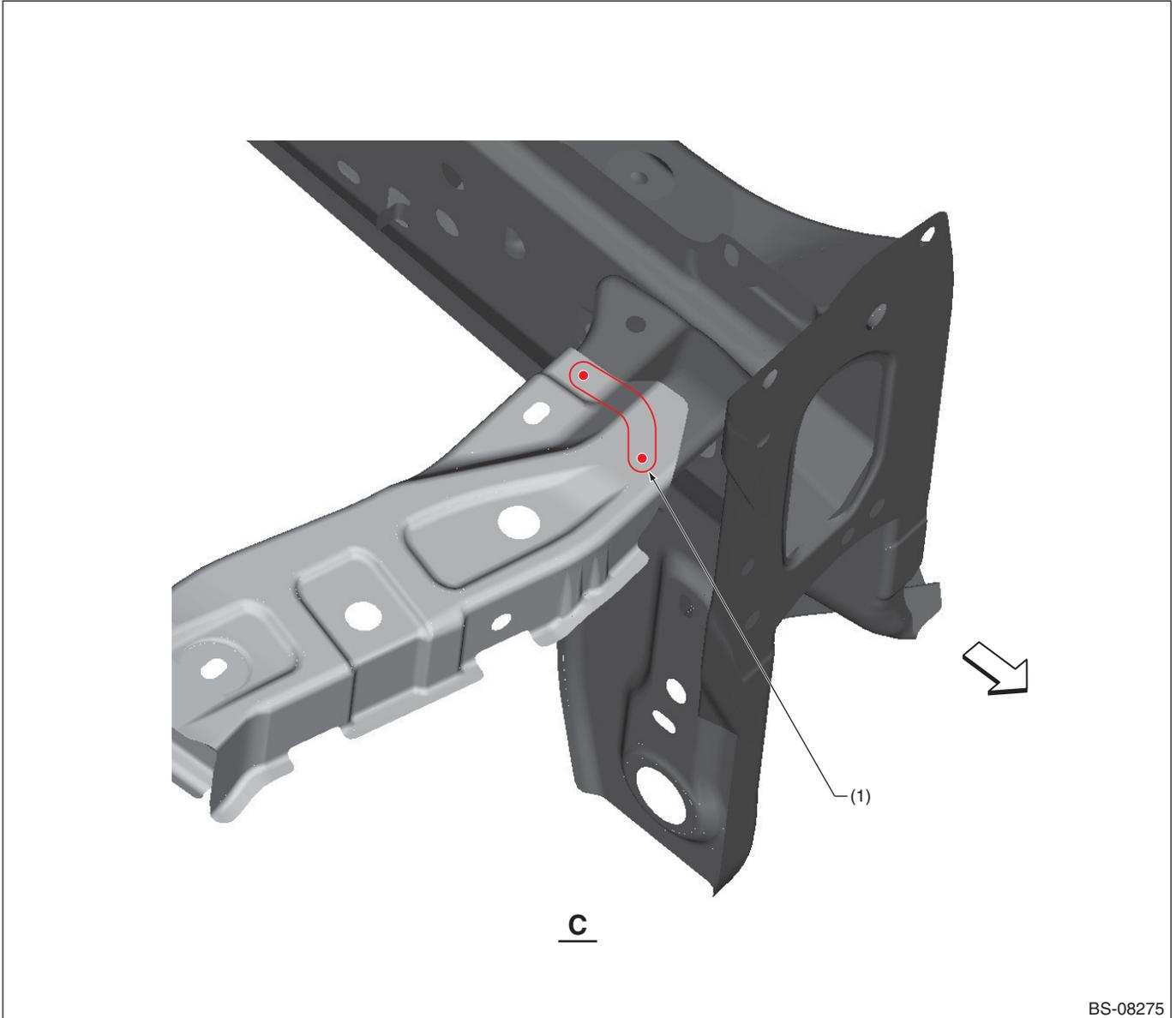
(1) 2 points (inside · 1)  
(2) 1 point (inside · 1)

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

(5) 4 points (inside · 1)

# Panel Replacement

- Views C (RH only)

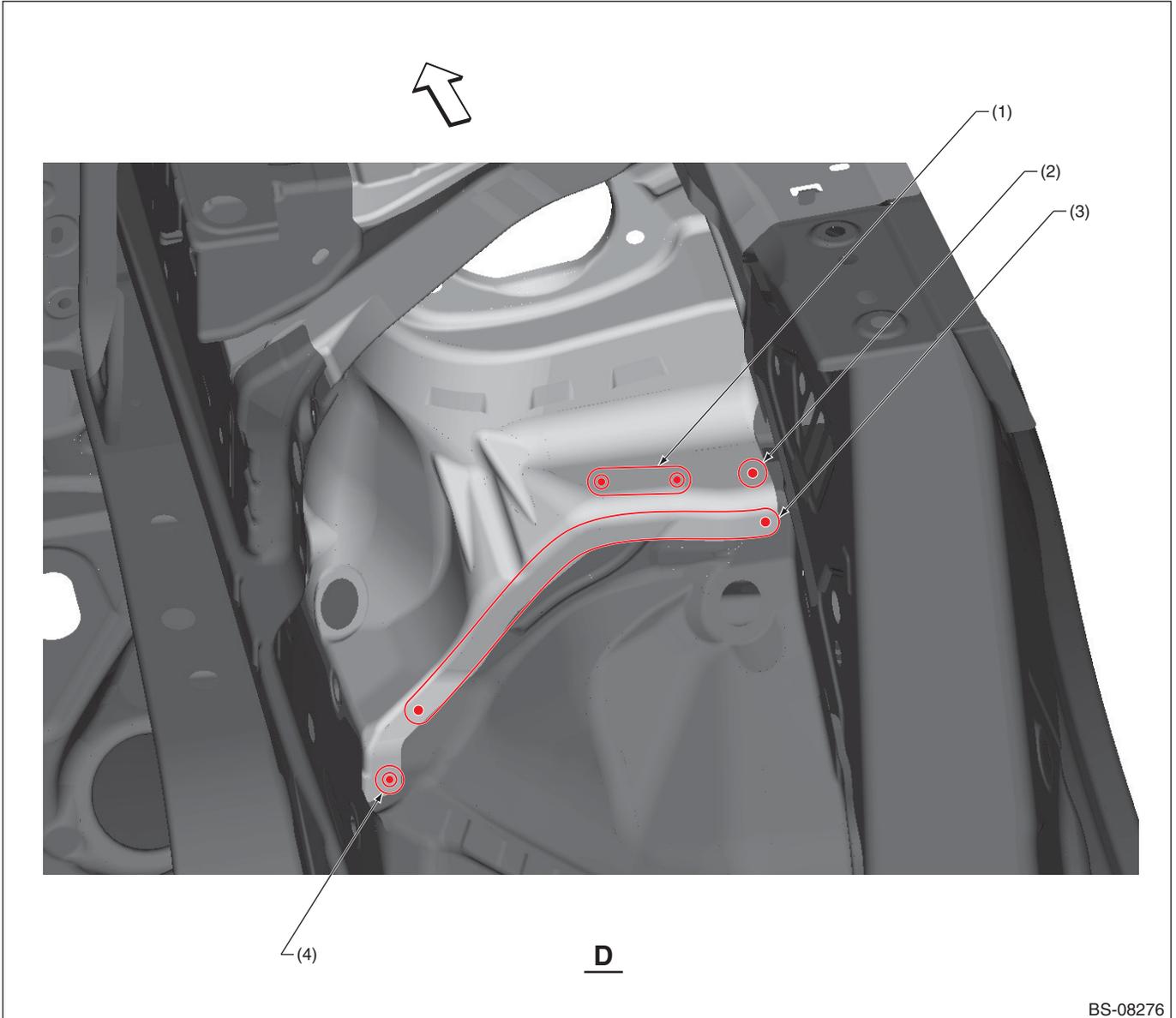


BS-08275

(1) 3 points (top - 1)

# Panel Replacement

## • Views D



BS-08276

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

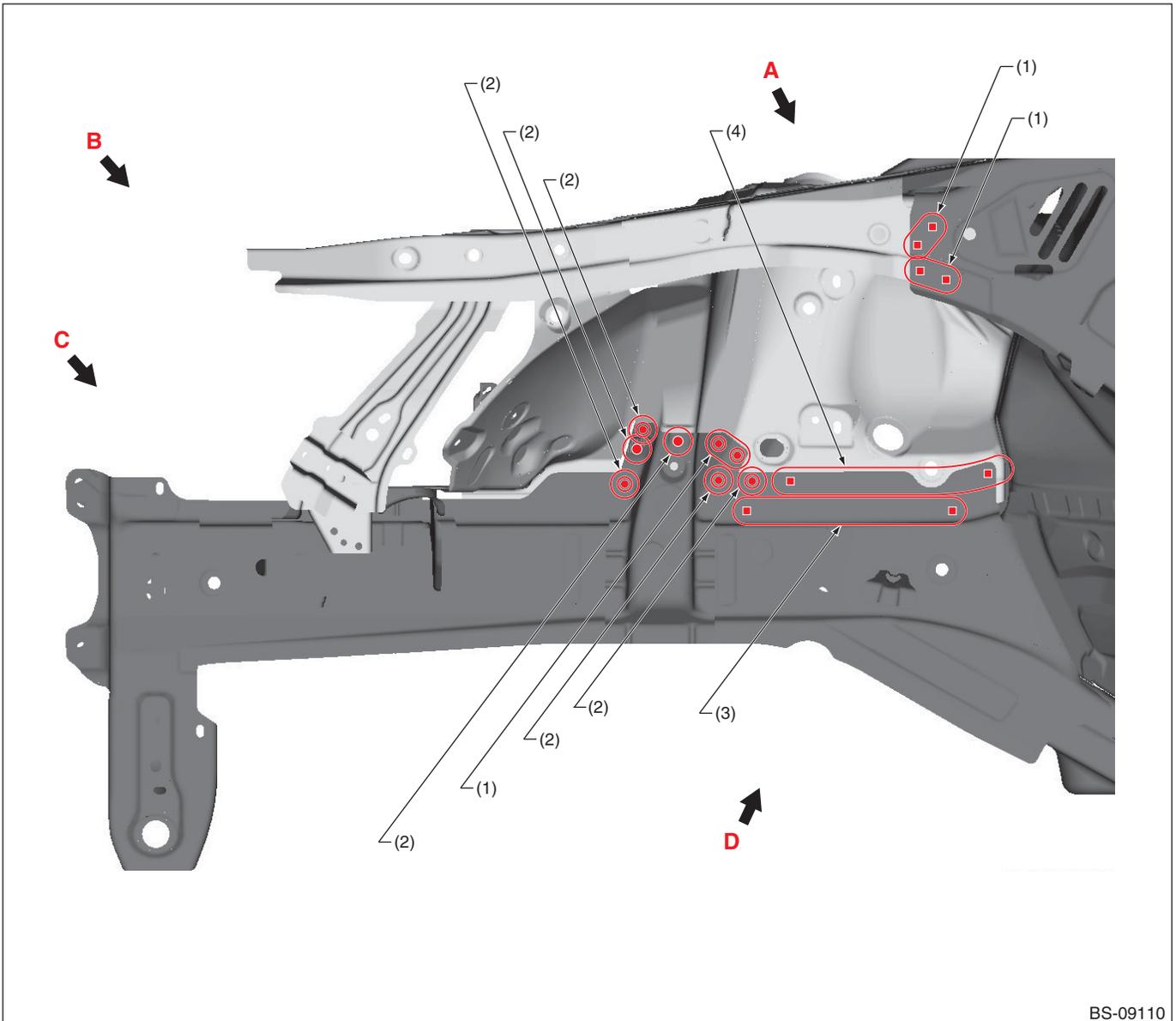
(3) 8 points (outside · 1)

(4) 1 point (outside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



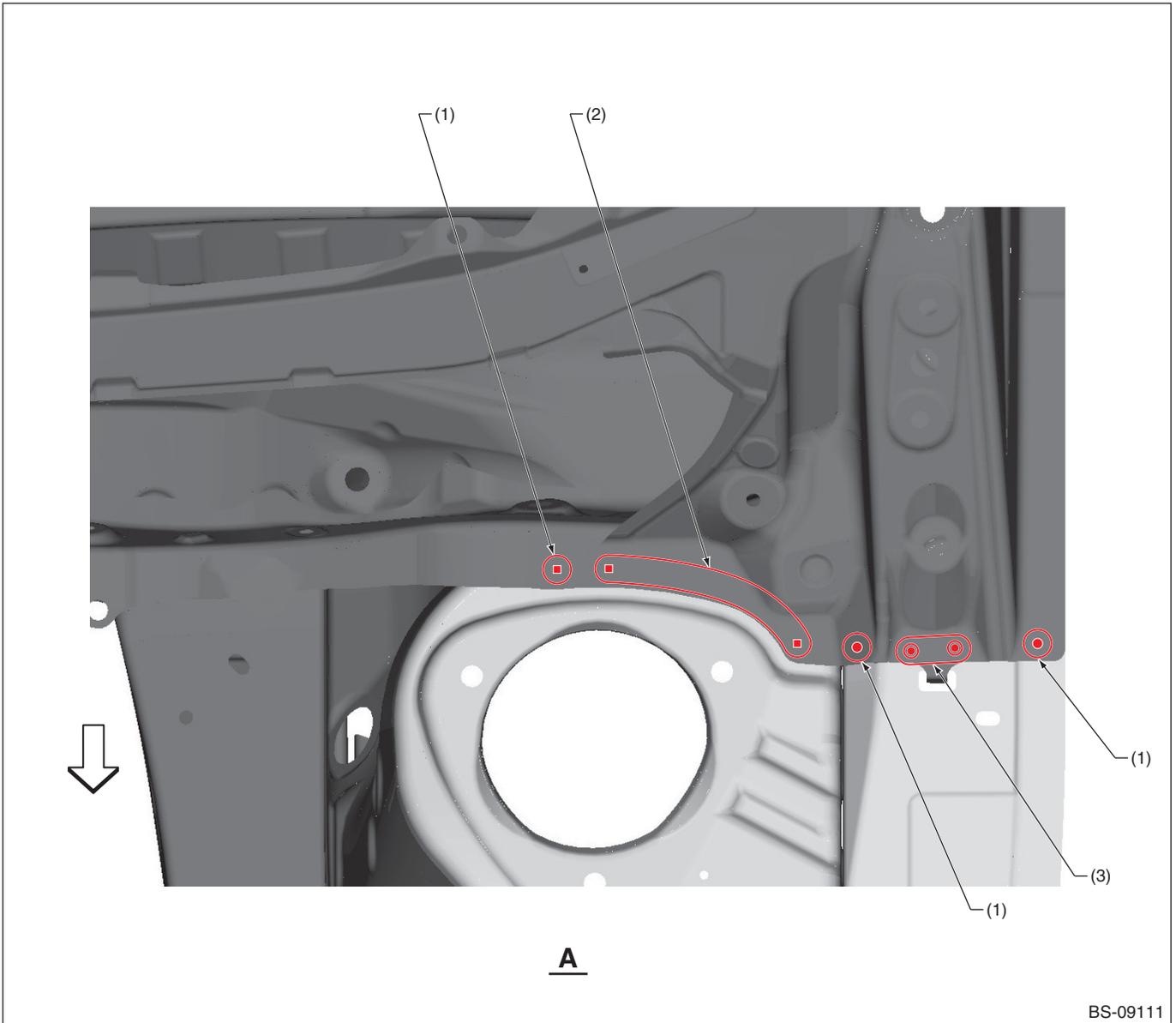
(1) 2 points  
(2) 1 point

(3) 4 points (service)

(4) 6 points (service)

# Panel Replacement

## • Views A



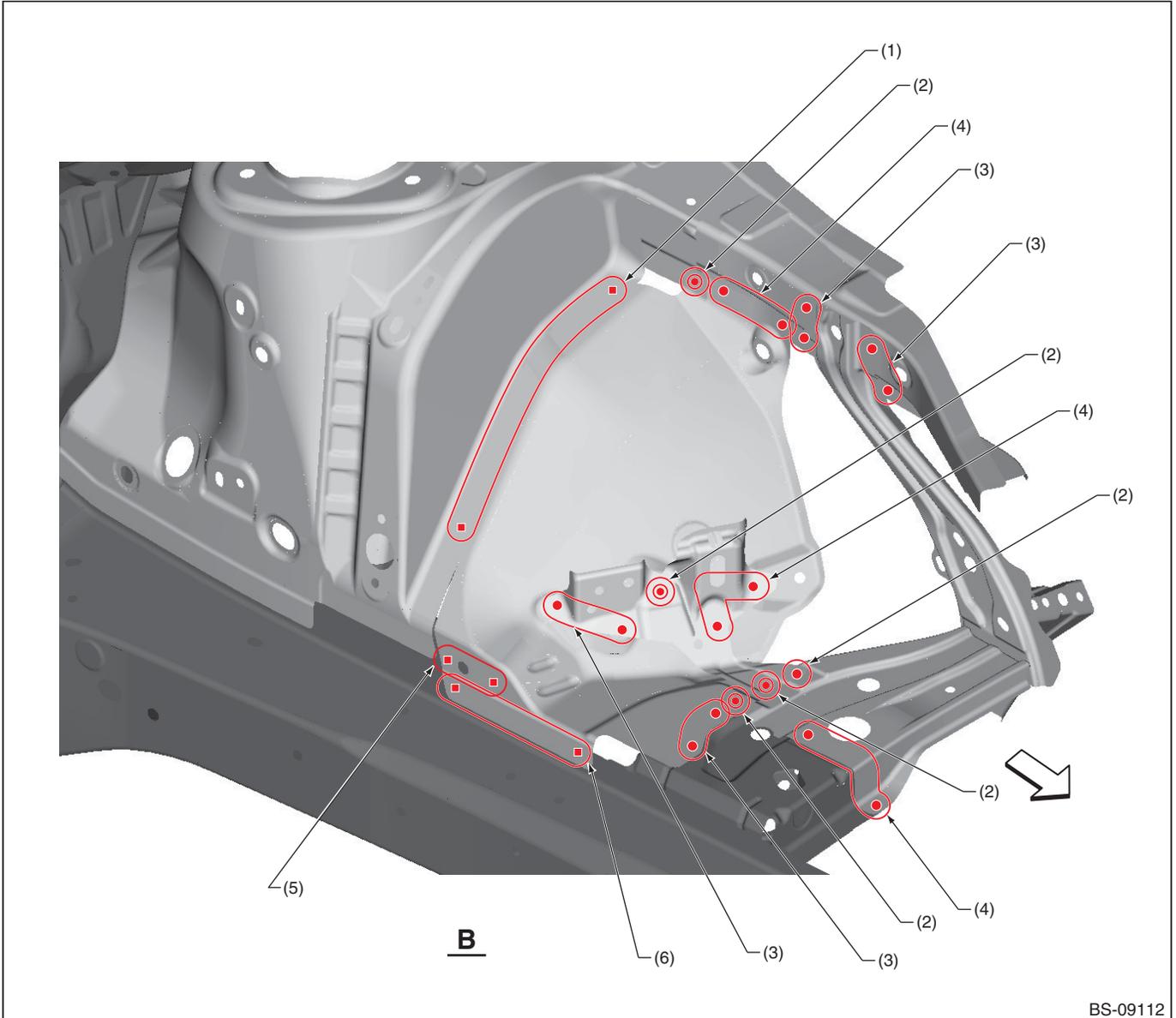
(1) 1 point

(2) 4 points

(3) 2 points

# Panel Replacement

## • Views B (LH)



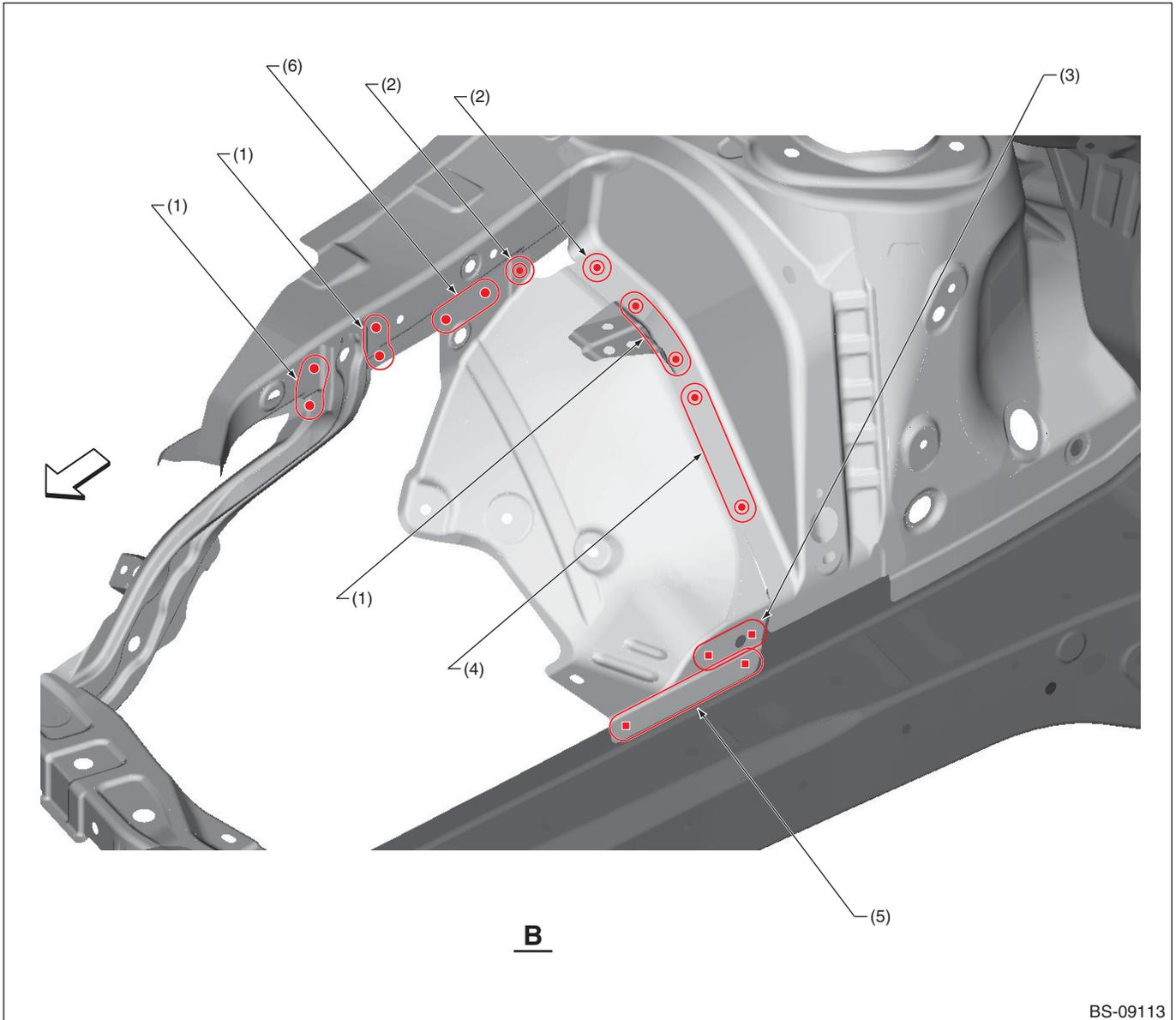
(1) 5 points (service)  
(2) 1 point

(3) 2 points  
(4) 3 points

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

# Panel Replacement

## • Views B (RH)



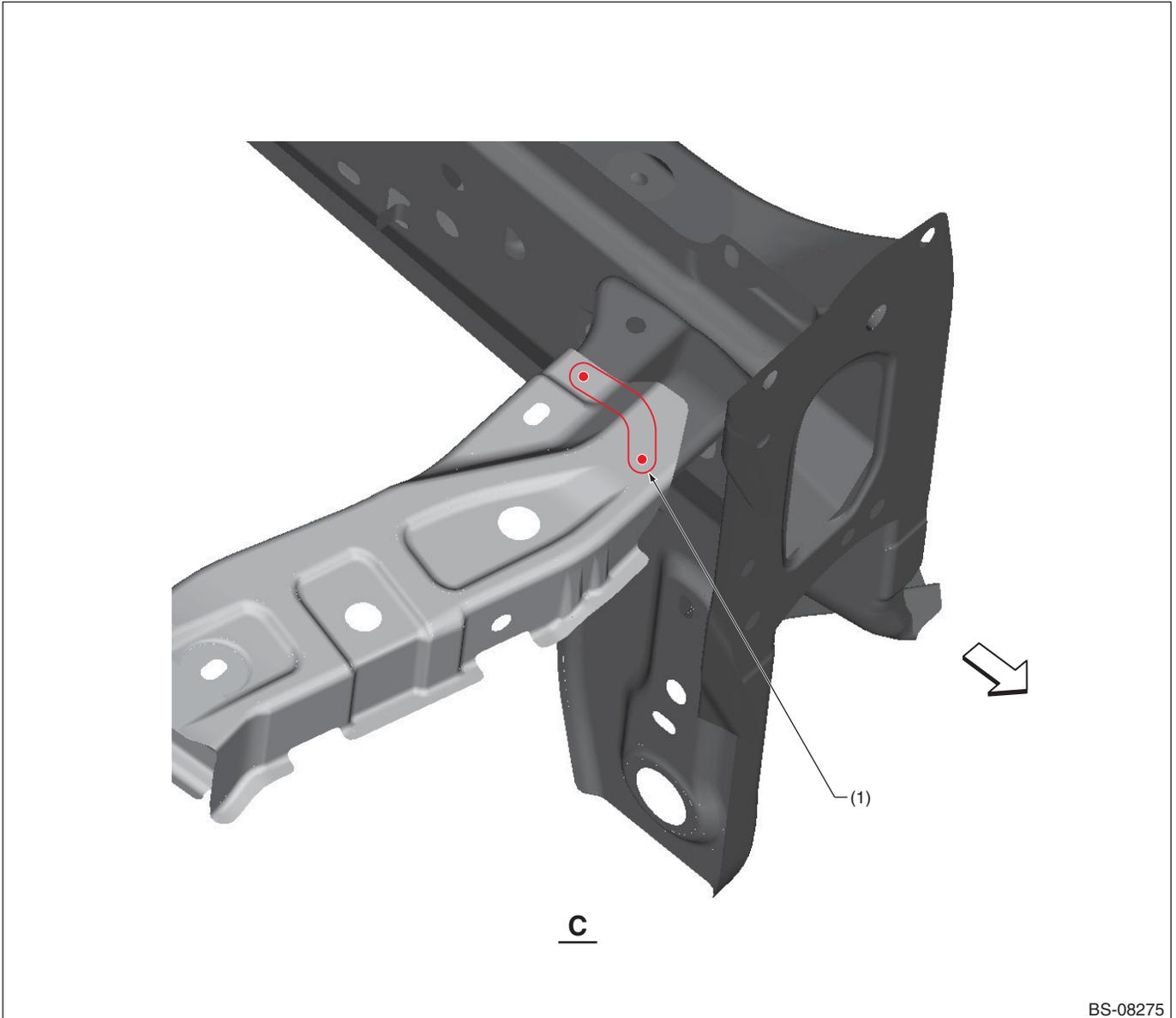
(1) 2 points  
(2) 1 point

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

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

# Panel Replacement

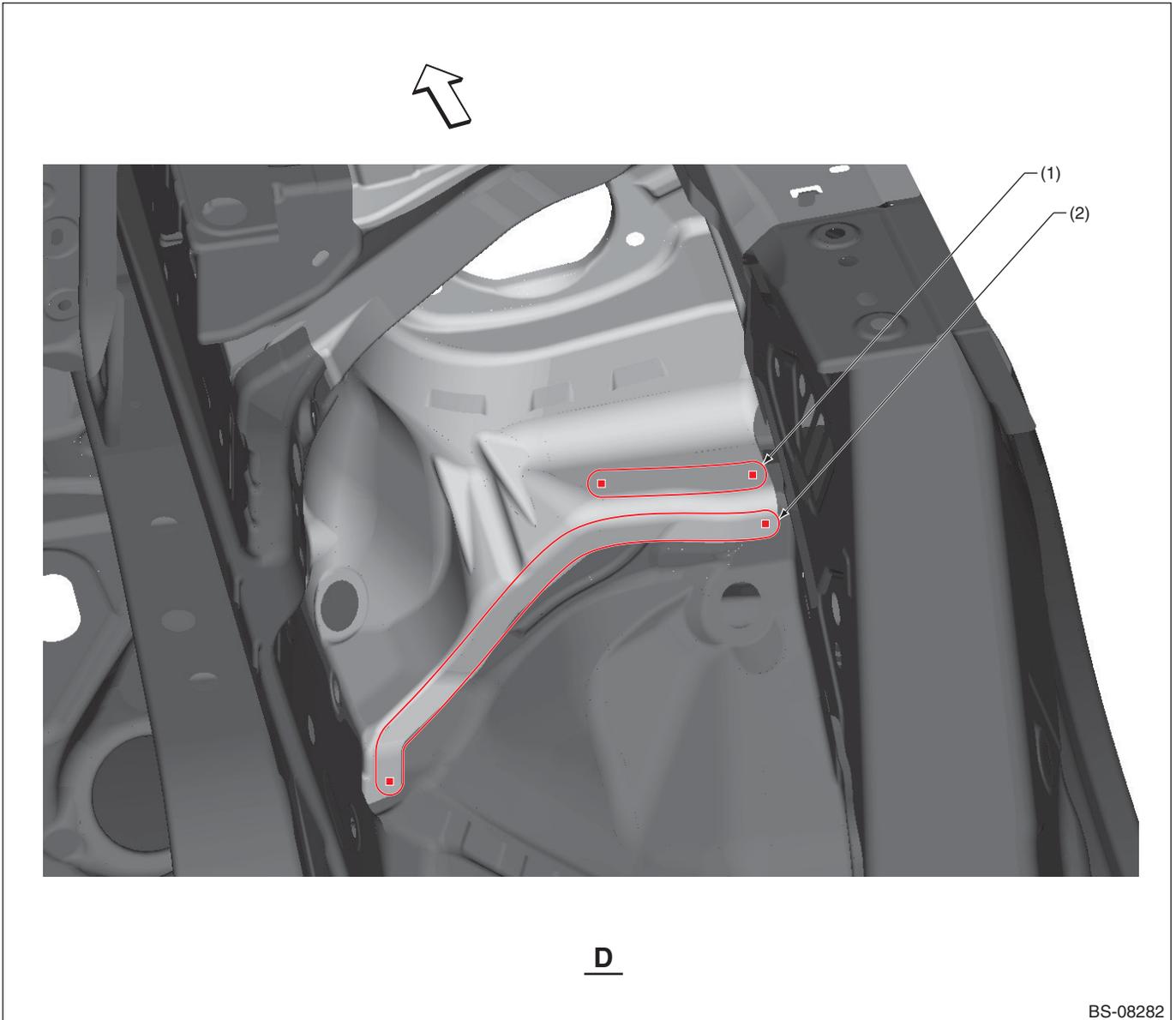
- Views C (RH)



(1) 3 points

# Panel Replacement

## • Views D



(1) 4 points (service)

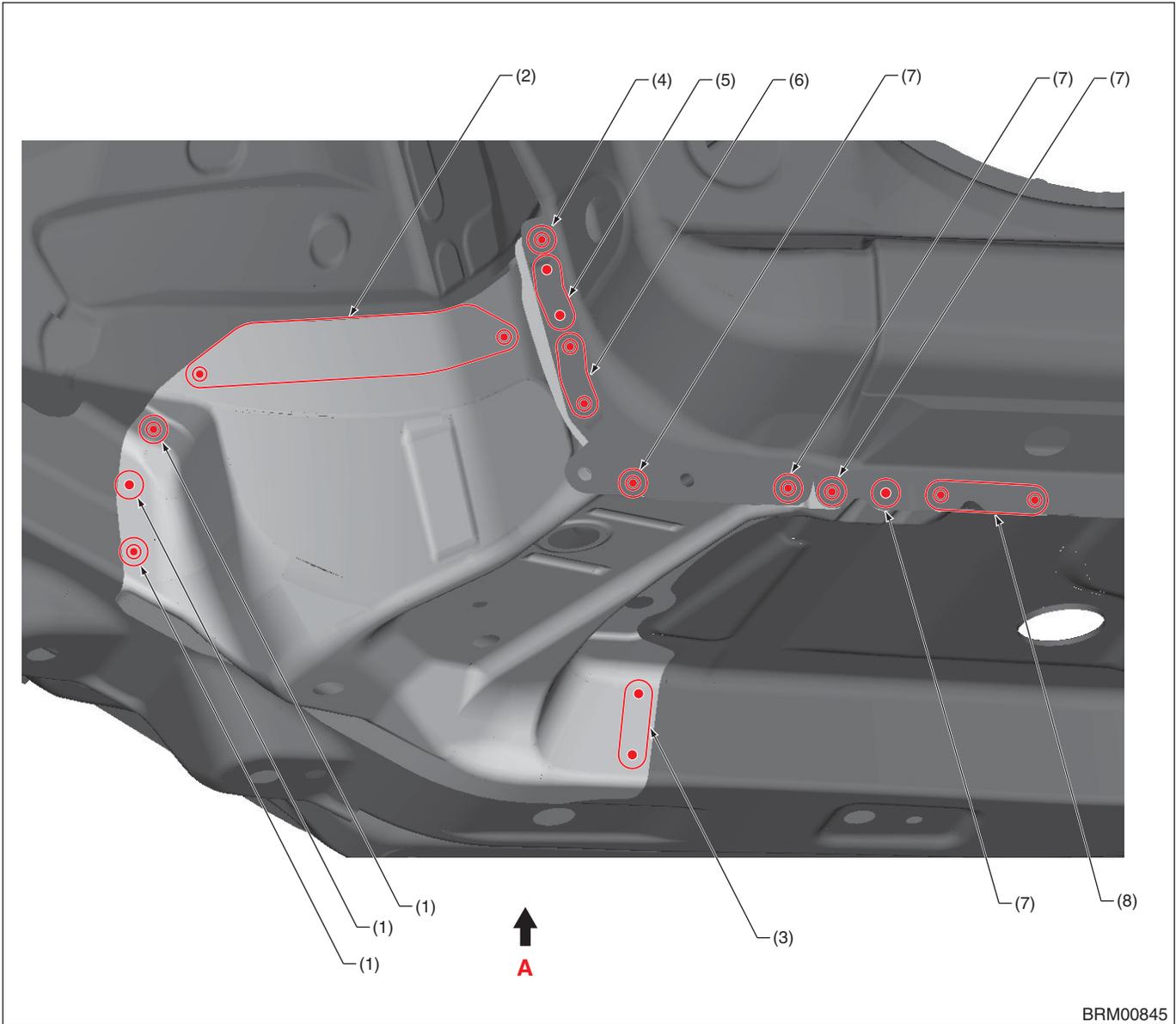
(2) 9 points (service)

# Panel Replacement

## 8-5. Toe Board Reinforcement (total replacement)

### A: REMOVAL

• Overall view (— '18MY)



BRM00845

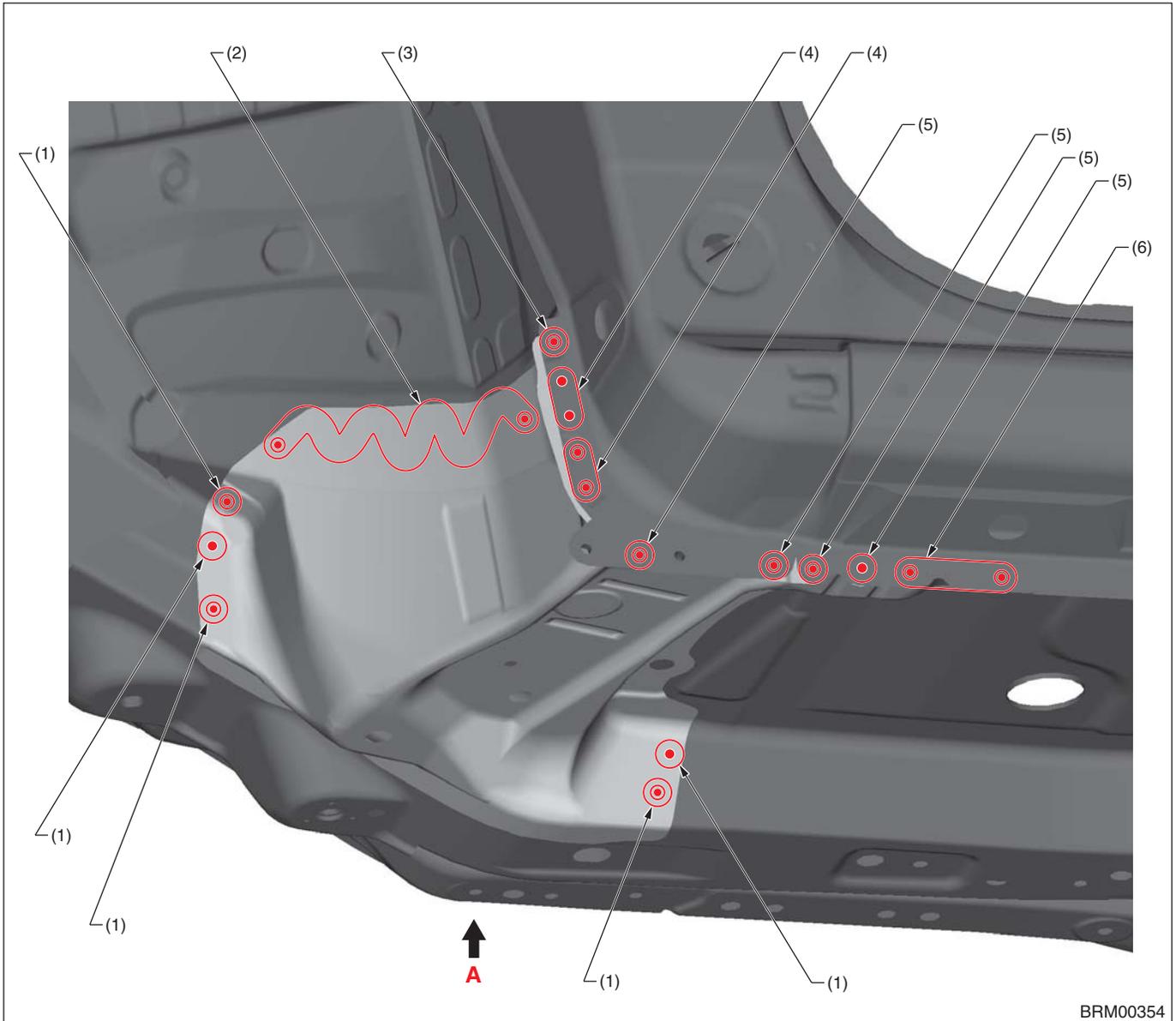
- (1) 1 point (outside · 1)
- (2) 9 points (outside · 1)
- (3) 2 points (outside · 1)

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

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

# Panel Replacement

## • Overall view ('19MY →)



BRM00354

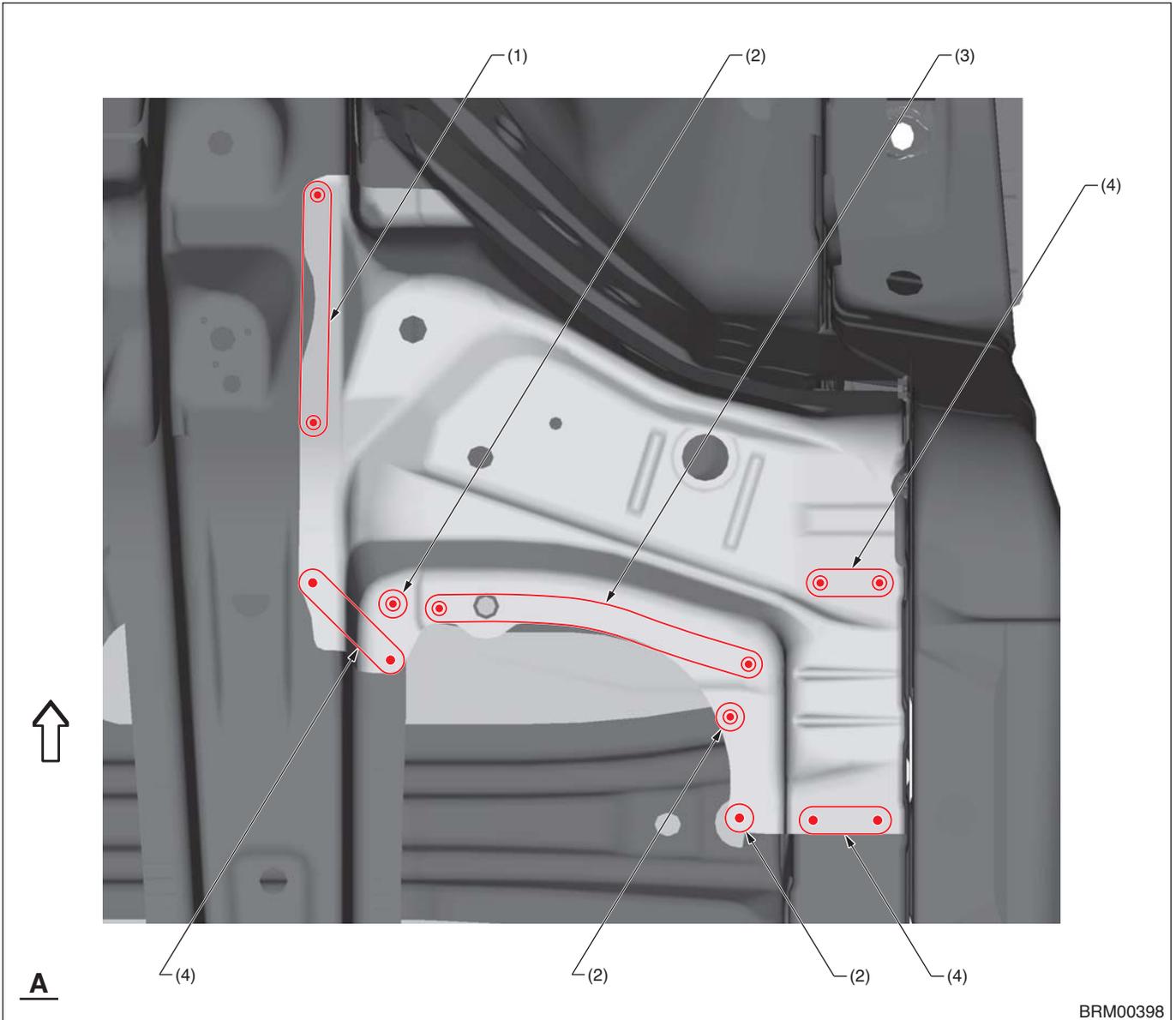
(1) 1 point (outside · 1)  
(2) 9 points (outside · 1)

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

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

# Panel Replacement

## • Views A



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

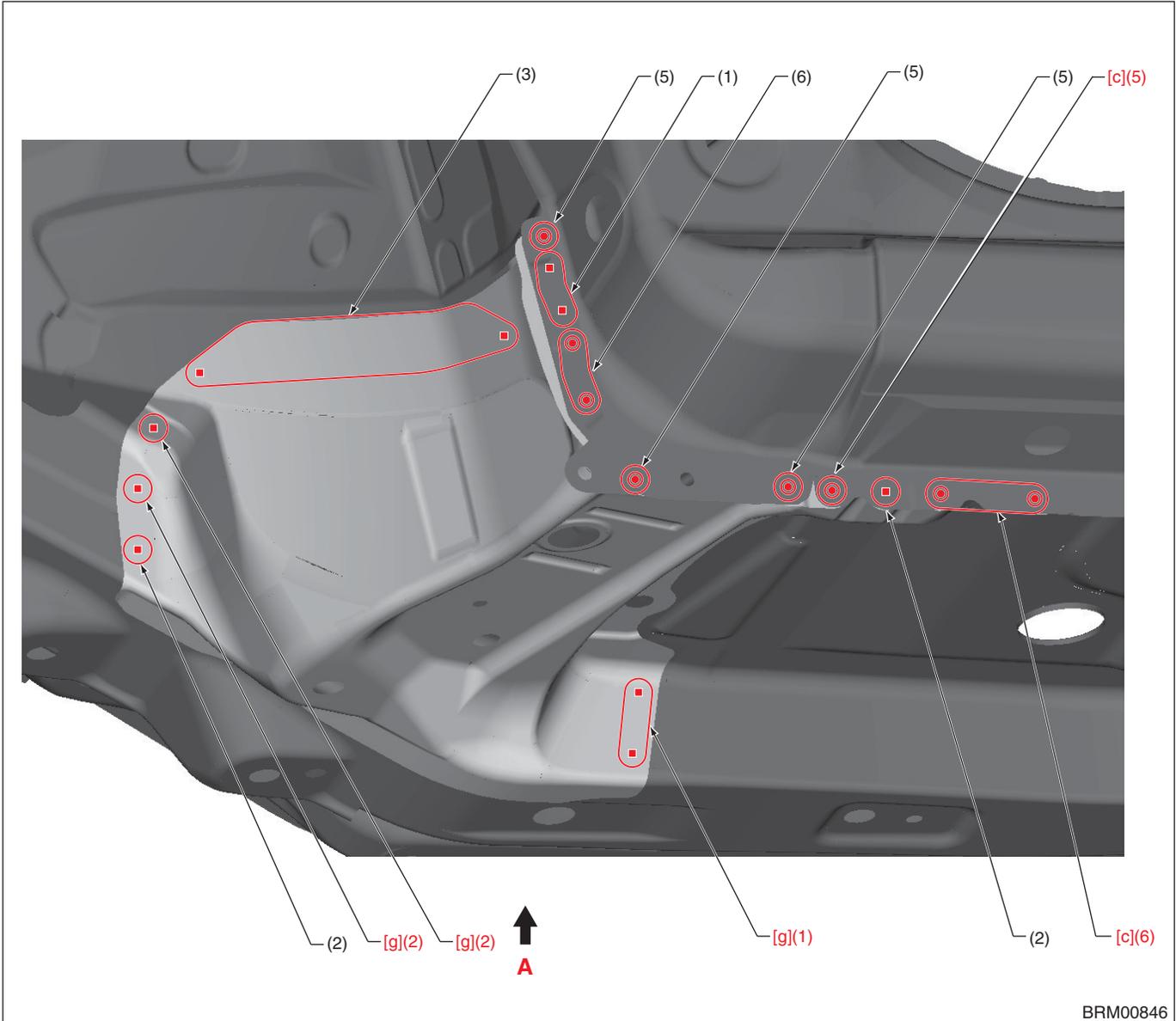
(3) 5 points (bottom · 1)

(4) 2 points (bottom · 1)

# Panel Replacement

## B: INSTALLATION

• Overall view ( — '18MY)



BRM00846

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

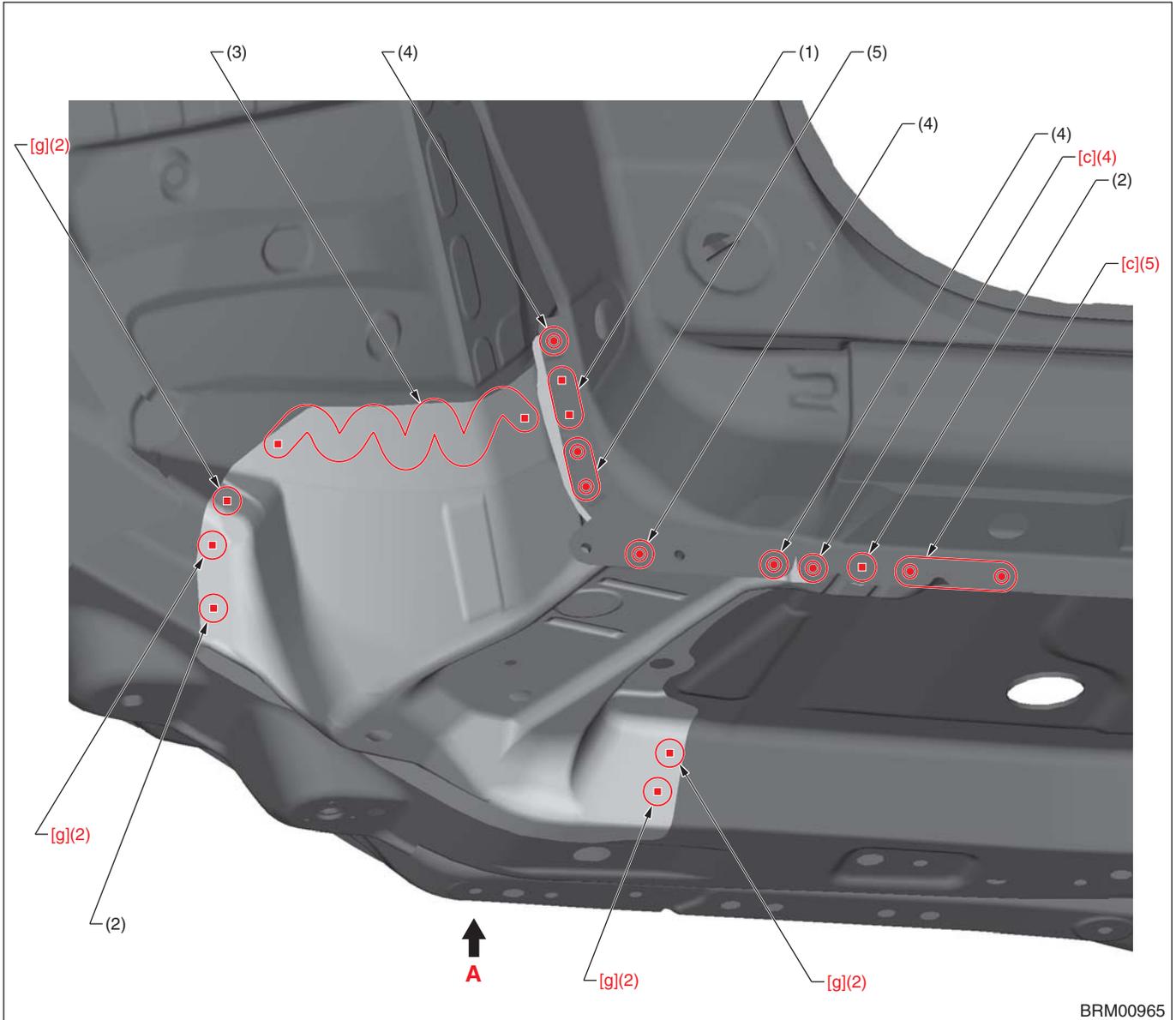
(3) 9 points (service)  
(4) 3 points

(5) 1 point  
(6) 2 points

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

# Panel Replacement

## • Overall view ('19MY — )



BRM00965

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

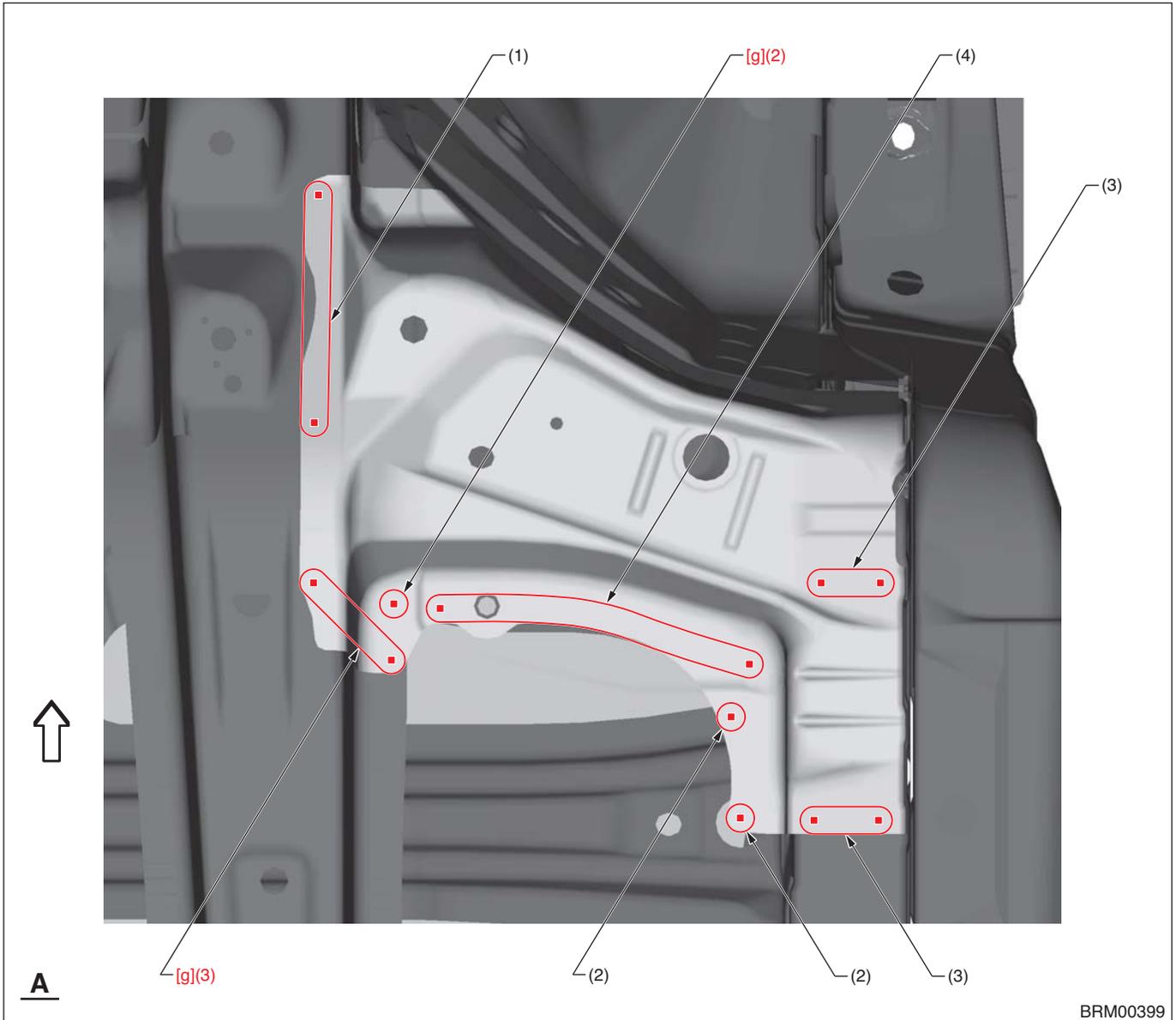
(3) 9 points (service)  
(4) 1 point

(5) 2 points

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

# Panel Replacement

## • Views A



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

(3) 2 points (service)

(4) 5 points (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO<sub>2</sub>

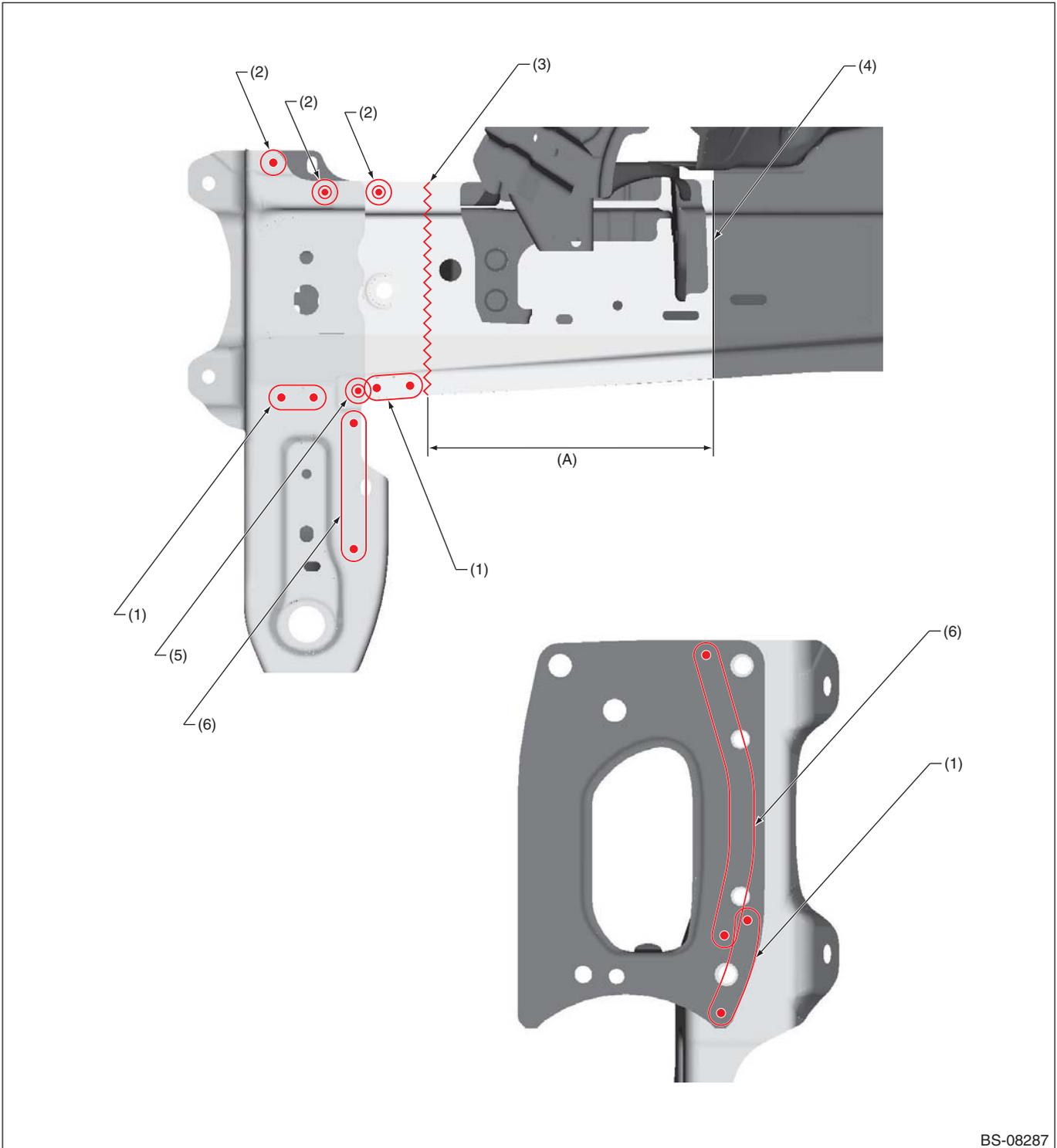
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO<sub>2</sub>: 20 %)

# Panel Replacement

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

### A: REMOVAL

• Overall view (Gasoline model)



BS-08287

(A) 210 mm [8.27 in]

(1) 2 points (outside · 1)

(2) 1 point (outside · 1)

(3) Cut position

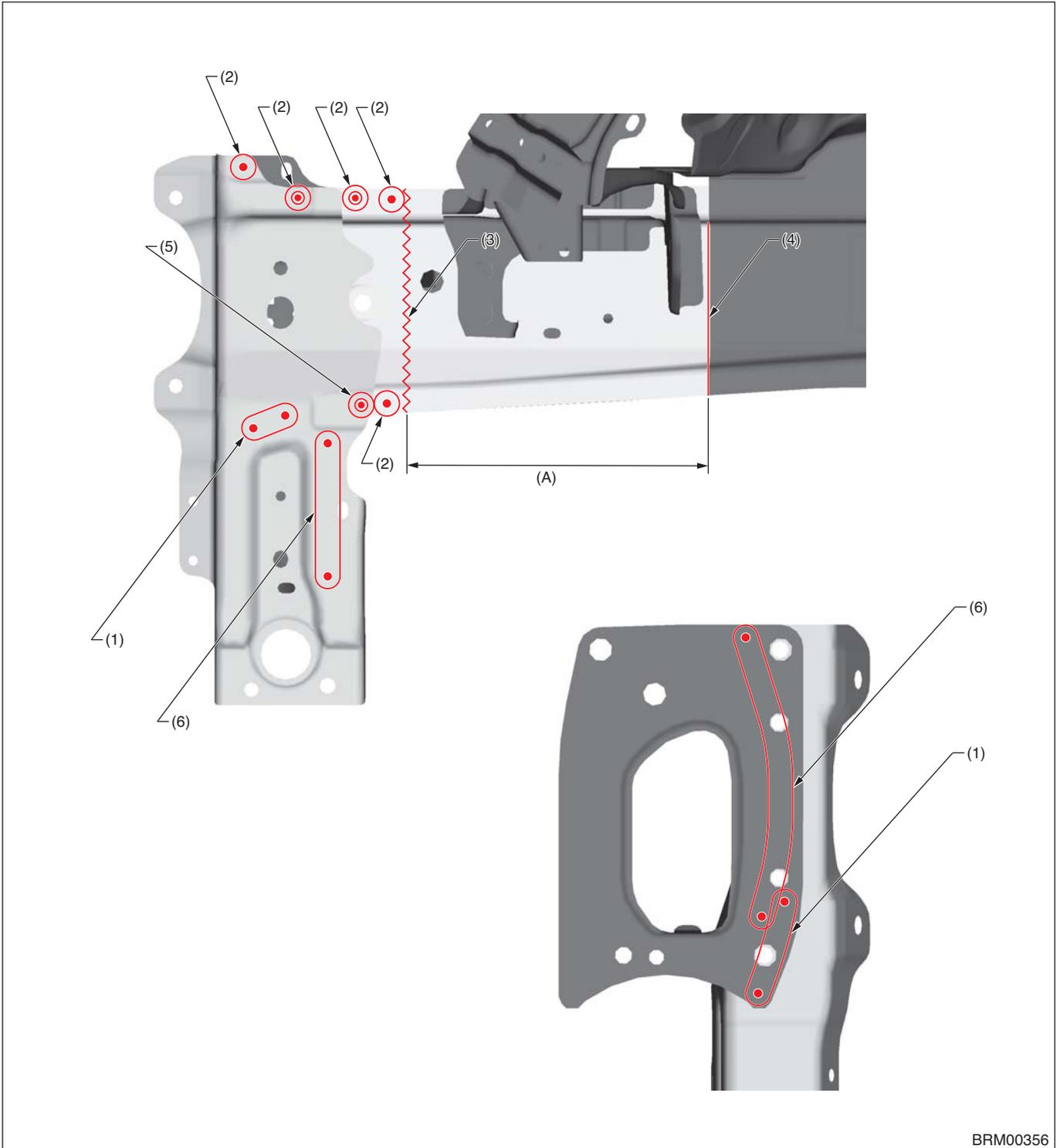
(4) Tailored line

(5) 1 point (outside · 2)

(6) 4 points (outside · 1)

# Panel Replacement

## • Overall view (Hybrid model)



(A) 210 mm [8.27 in]

(1) 2 points (outside · 1)

(2) 1 point (outside · 1)

(3) Cut position

(4) Tailored line

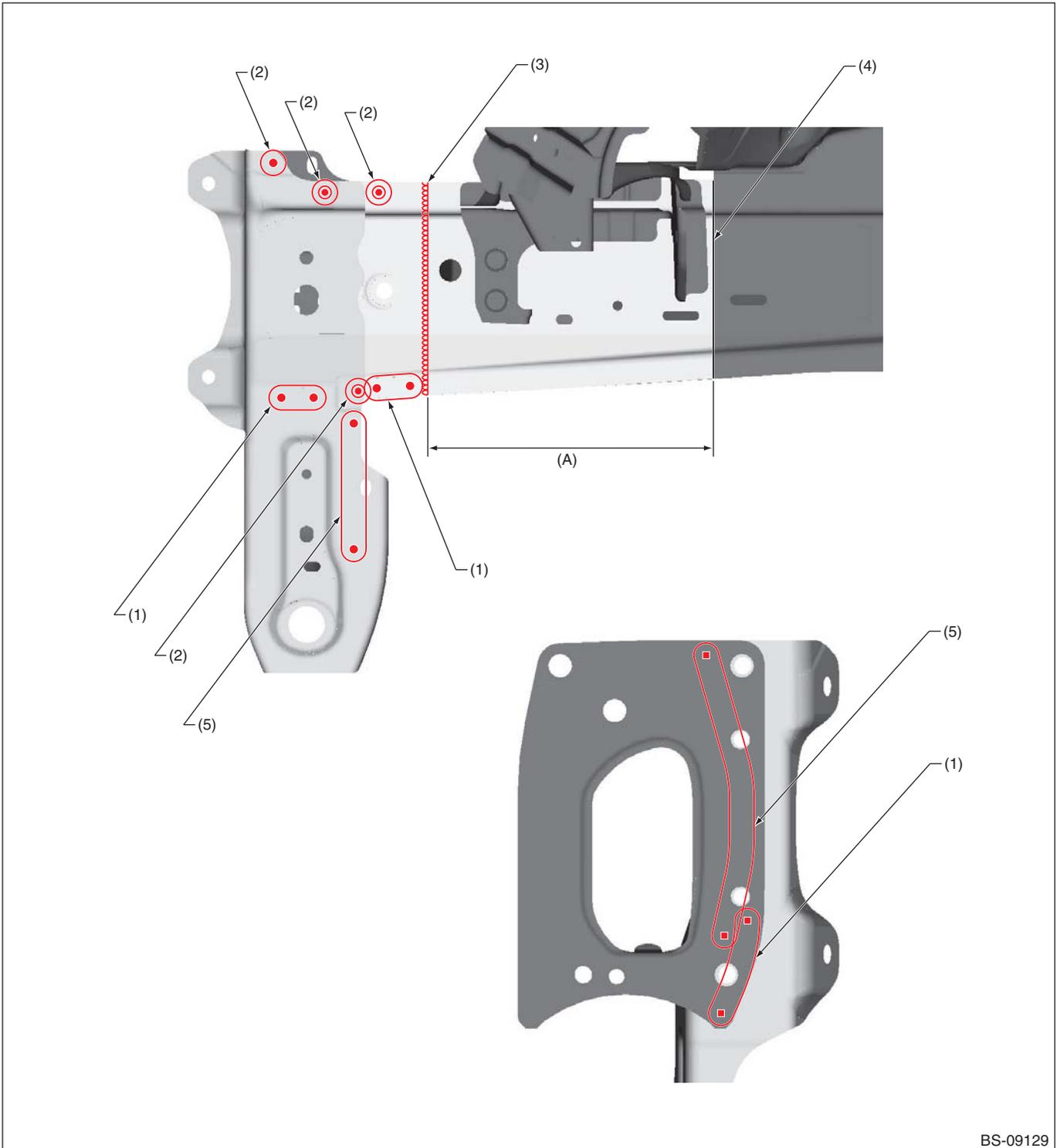
(5) 1 point (outside · 2)

(6) 4 points (outside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view (Gasoline model)



BS-09129

(A) 210 mm [8.27 in]

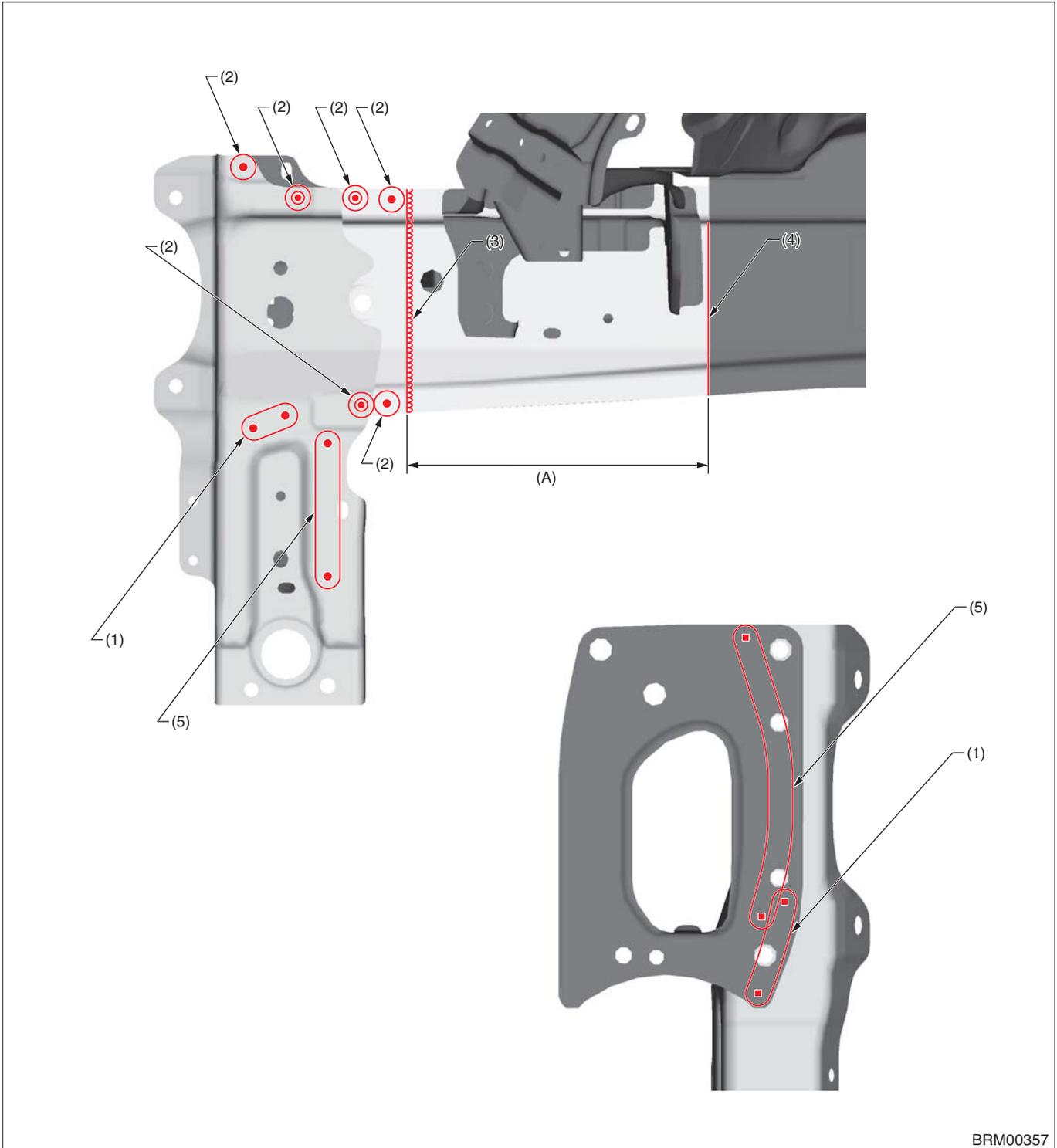
(1) 2 points  
(2) 1 point

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

(5) 4 points

# Panel Replacement

## • Overall view (Hybrid model)



BRM00357

(A) 210 mm [8.27 in]

(1) 2 points  
(2) 1 point

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

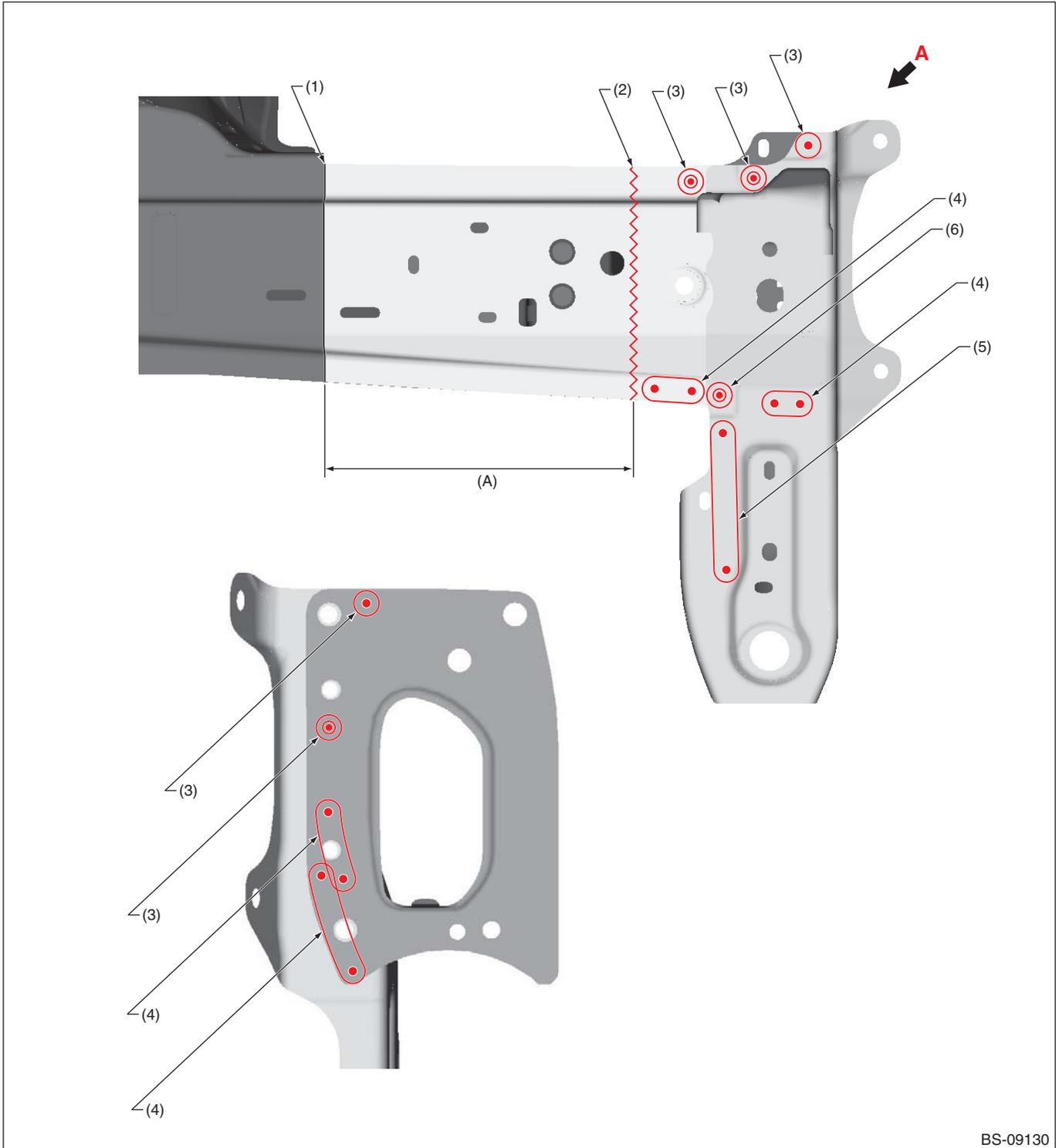
(5) 4 points

# Panel Replacement

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

### A: REMOVAL

• Overall view (Gasoline model)



BS-09130

(A) 210 mm [8.27 in]

(1) Tailored line

(2) Cut position

(3) 1 point (outside · 1)

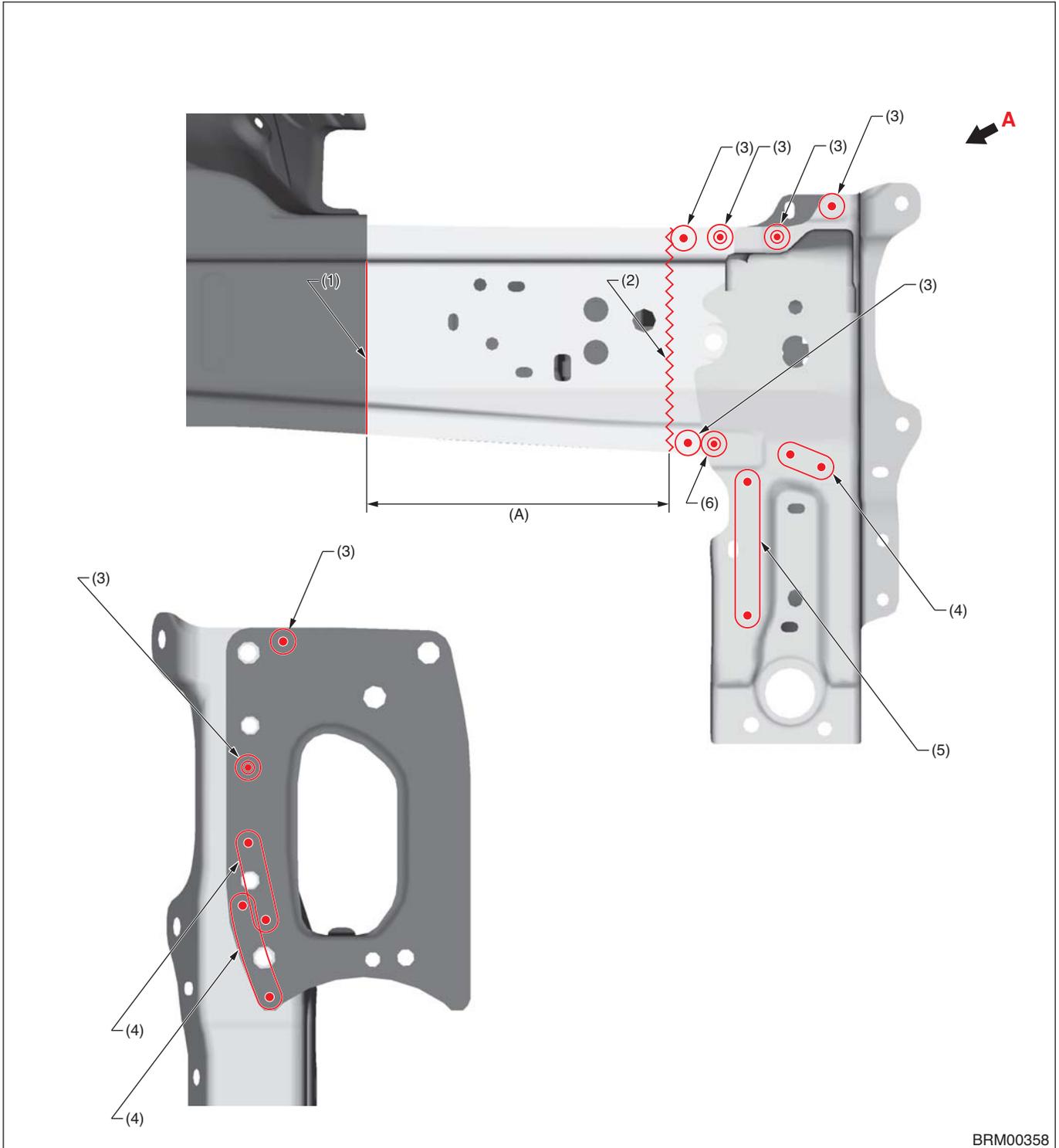
(4) 2 points (outside · 1)

(5) 4 points (outside · 1)

(6) 1 point (outside · 2)

# Panel Replacement

## • Overall view (Hybrid model)



BRM00358

(A) 210 mm [8.27 in]

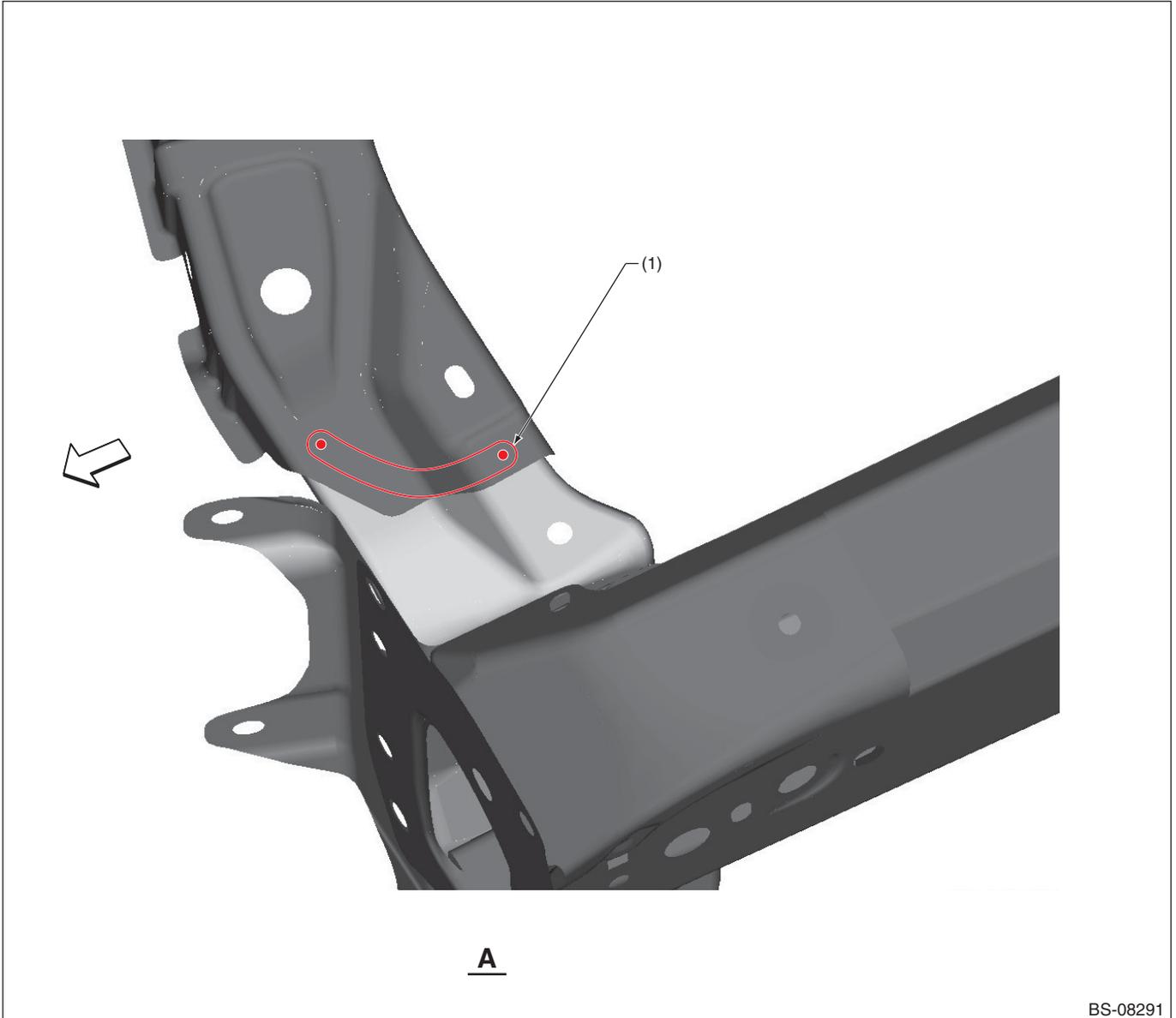
(1) Tailored line  
(2) Cut position

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

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

# Panel Replacement

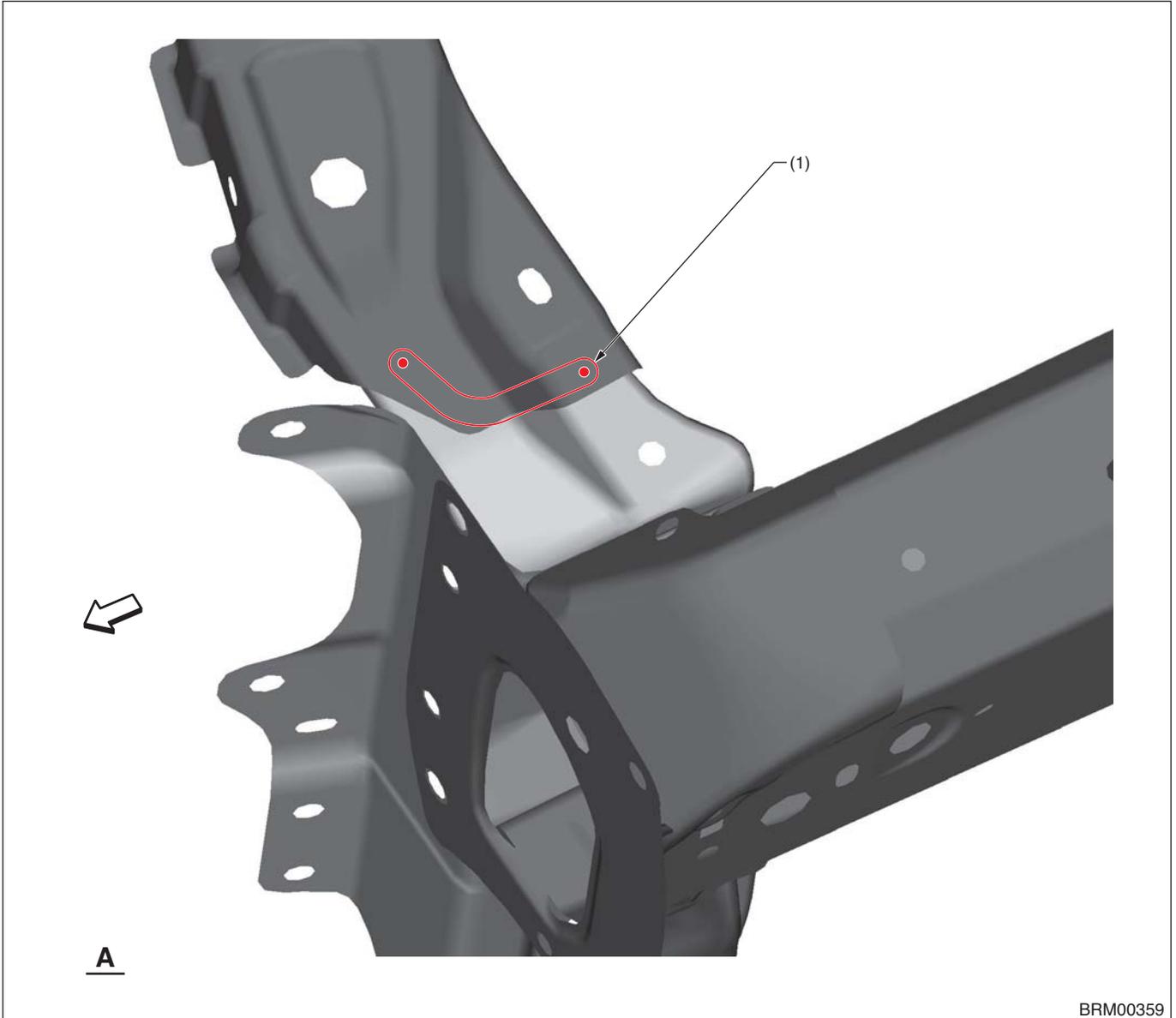
- Views A (Gasoline model)



(1) 3 points (top · 1)

# Panel Replacement

- Views A (Hybrid model)

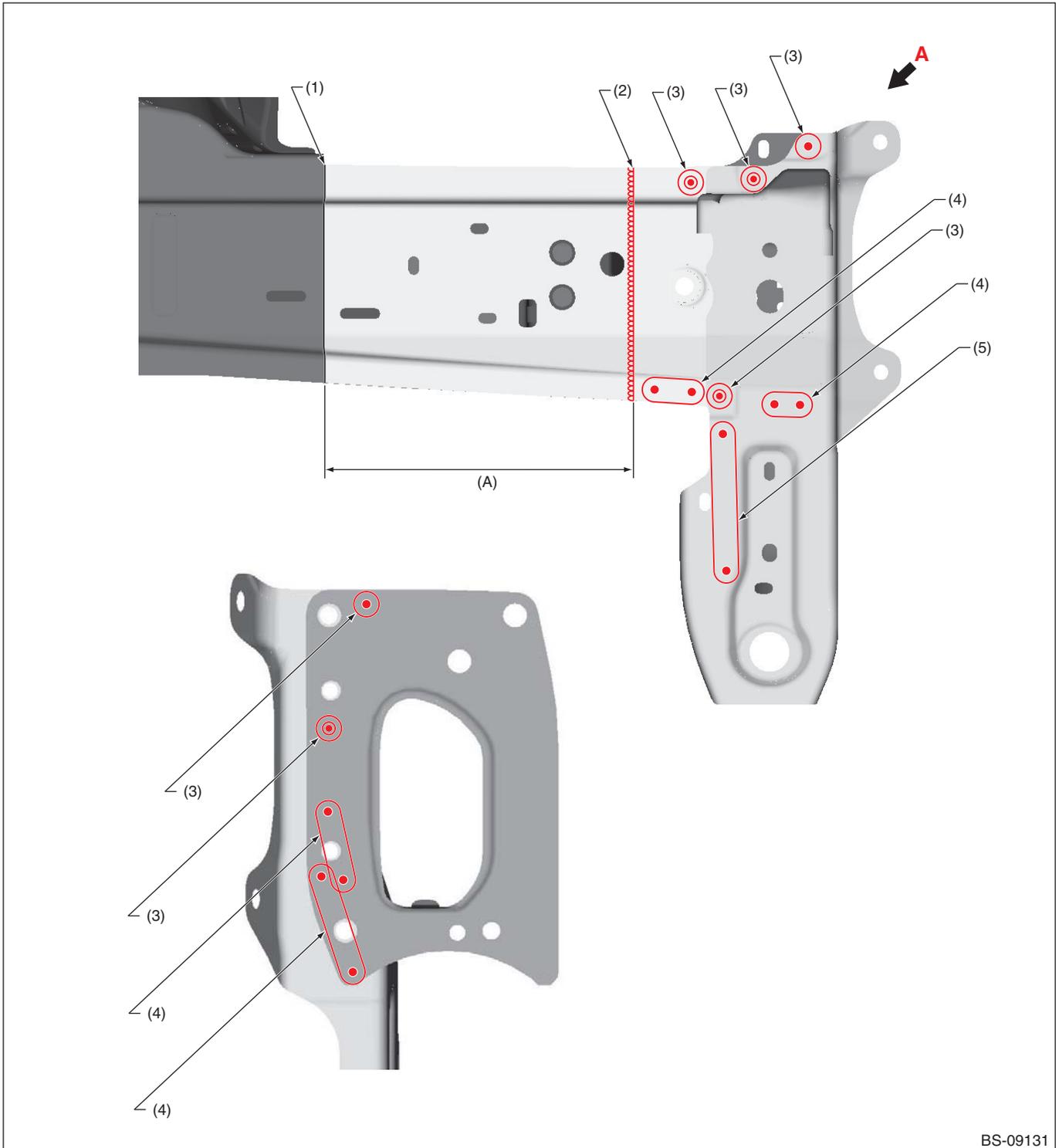


(1) 3 points (top - 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view (Gasoline model)



BS-09131

(A) 210 mm [8.27 in]

(1) Tailored line

(3) 1 point

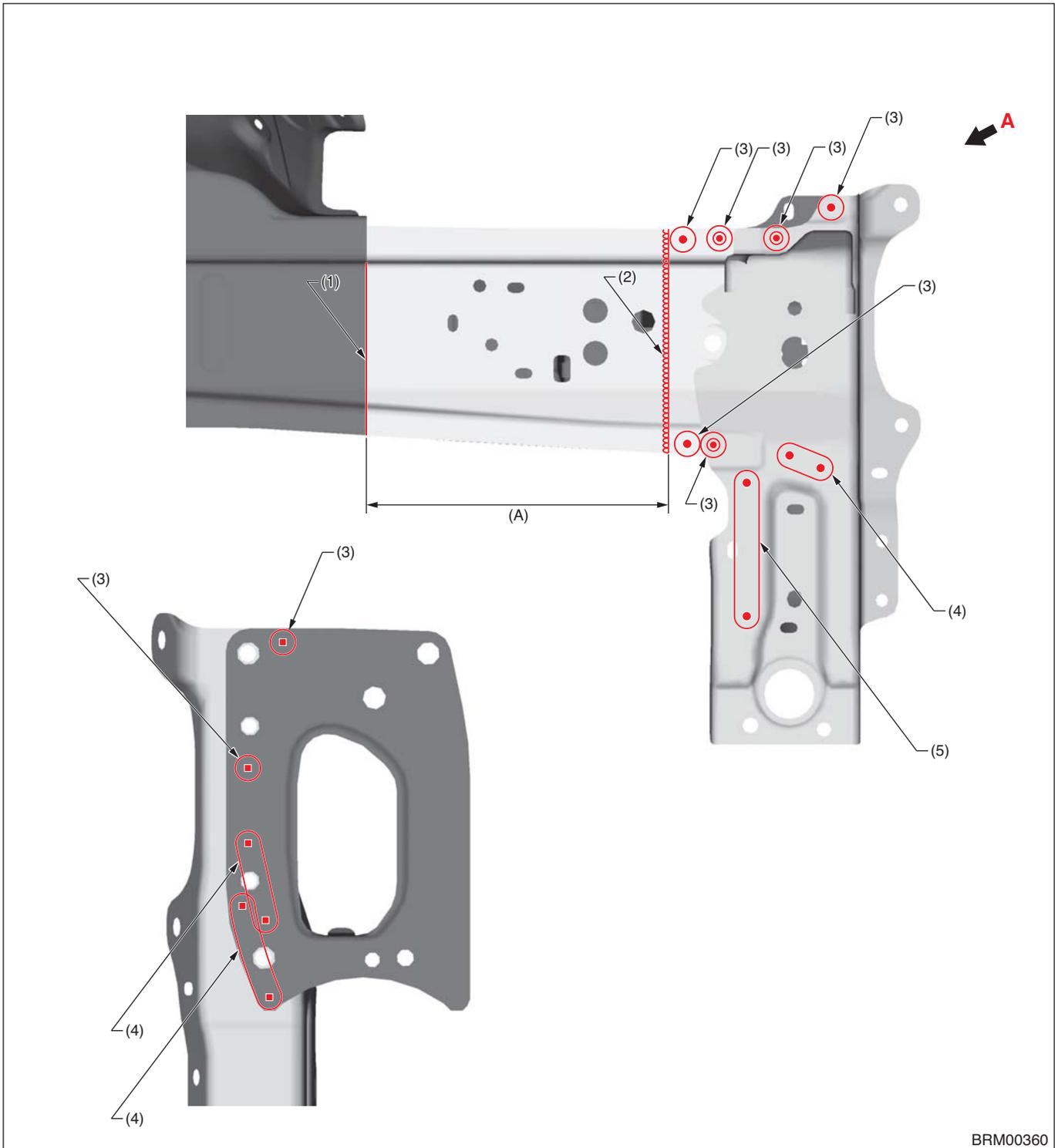
(5) 4 points

(2) 1 point (Continuous welding)

(4) 2 points

# Panel Replacement

## • Overall view (Hybrid model)



BRM00360

(A) 210 mm [8.27 in]

(1) Tailored line

(3) 1 point

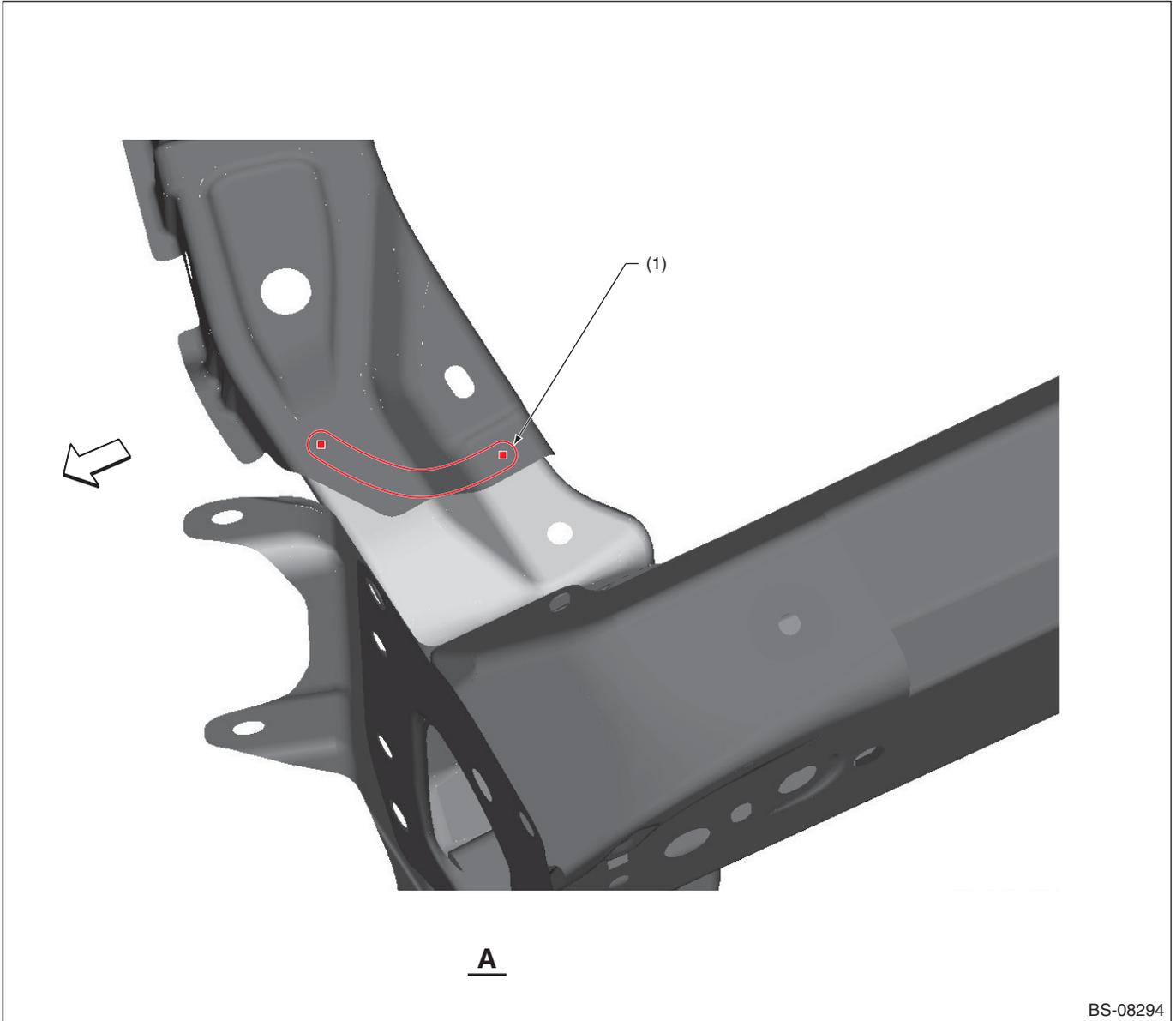
(5) 4 points

(2) 1 point (Continuous welding)

(4) 2 points

# Panel Replacement

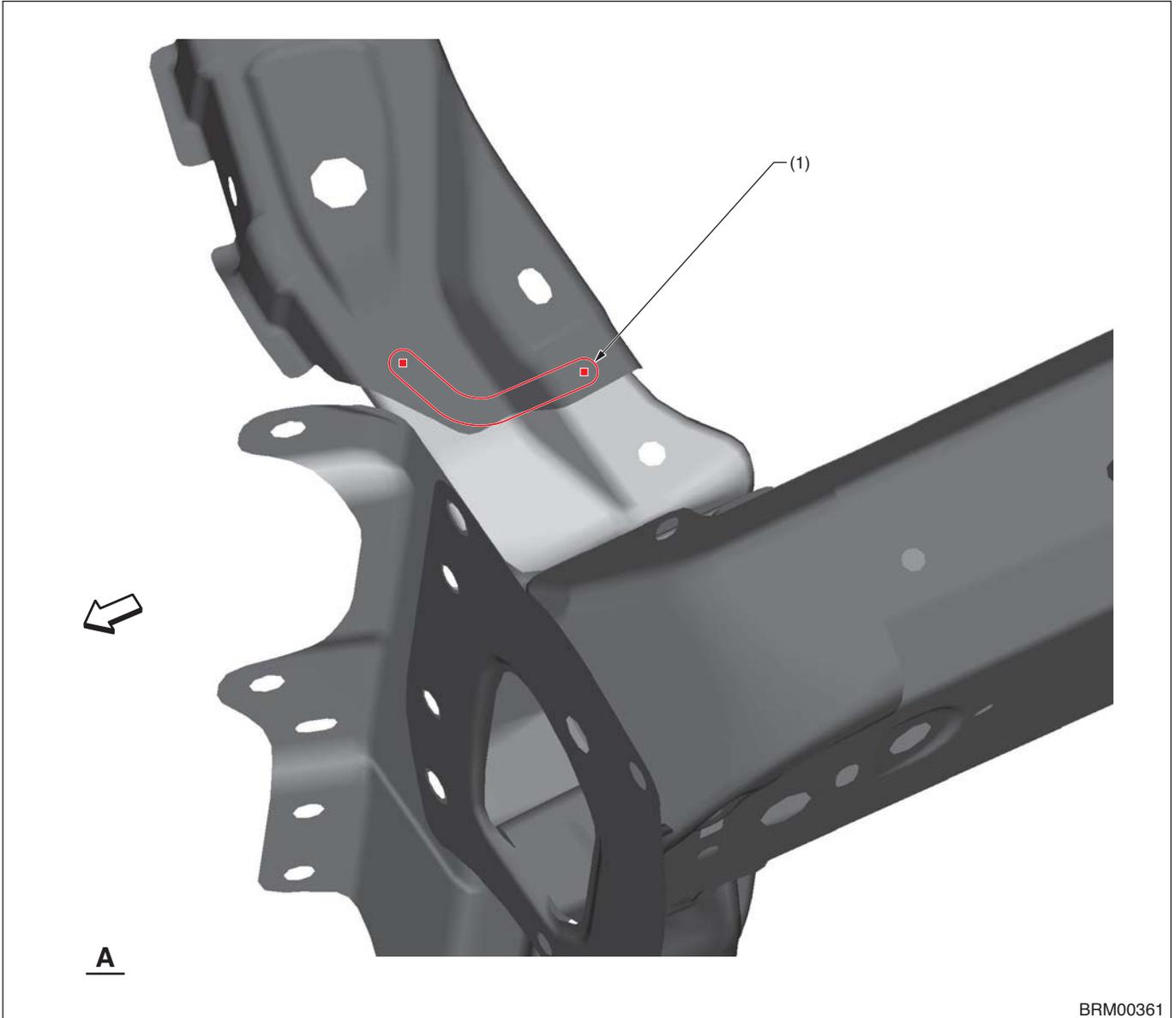
- Views A (Gasoline model)



(1) 3 points

# Panel Replacement

- Views A (Hybrid model)



BRM00361

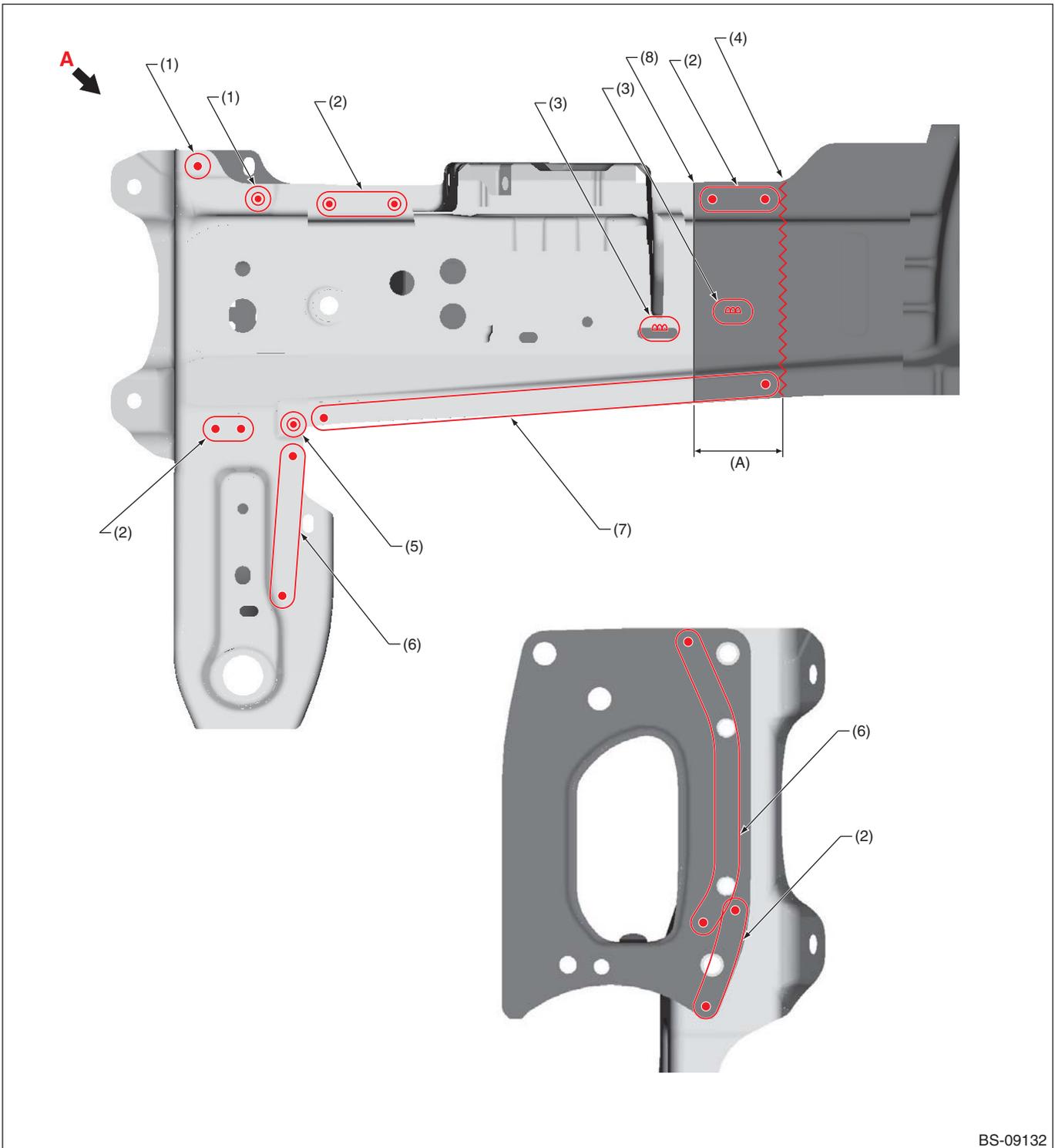
(1) 3 points

# Panel Replacement

## 8-8. Closing Plate LH (partial replacement) Pattern 2

### A: REMOVAL

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



BS-09132

(A) 55 mm [2.17 in]

(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

(3) 1 point (outside · 1 belt sander)

(4) Cut position

(5) 1 point (outside · 2)

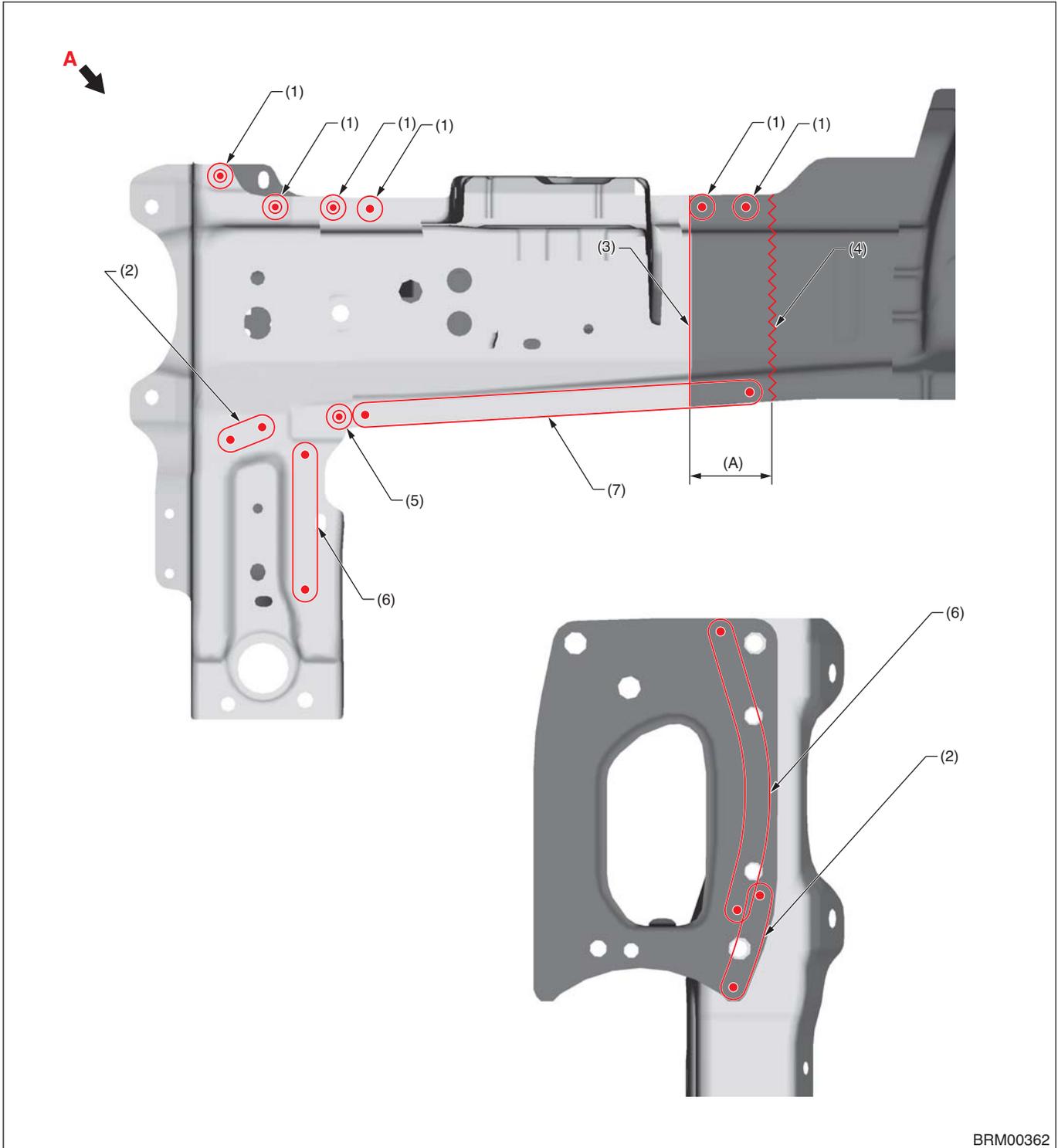
(6) 4 points (outside · 1)

(7) 12 points (outside · 1)

(8) Tailored line

# Panel Replacement

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



(A) 55 mm [2.17 in]

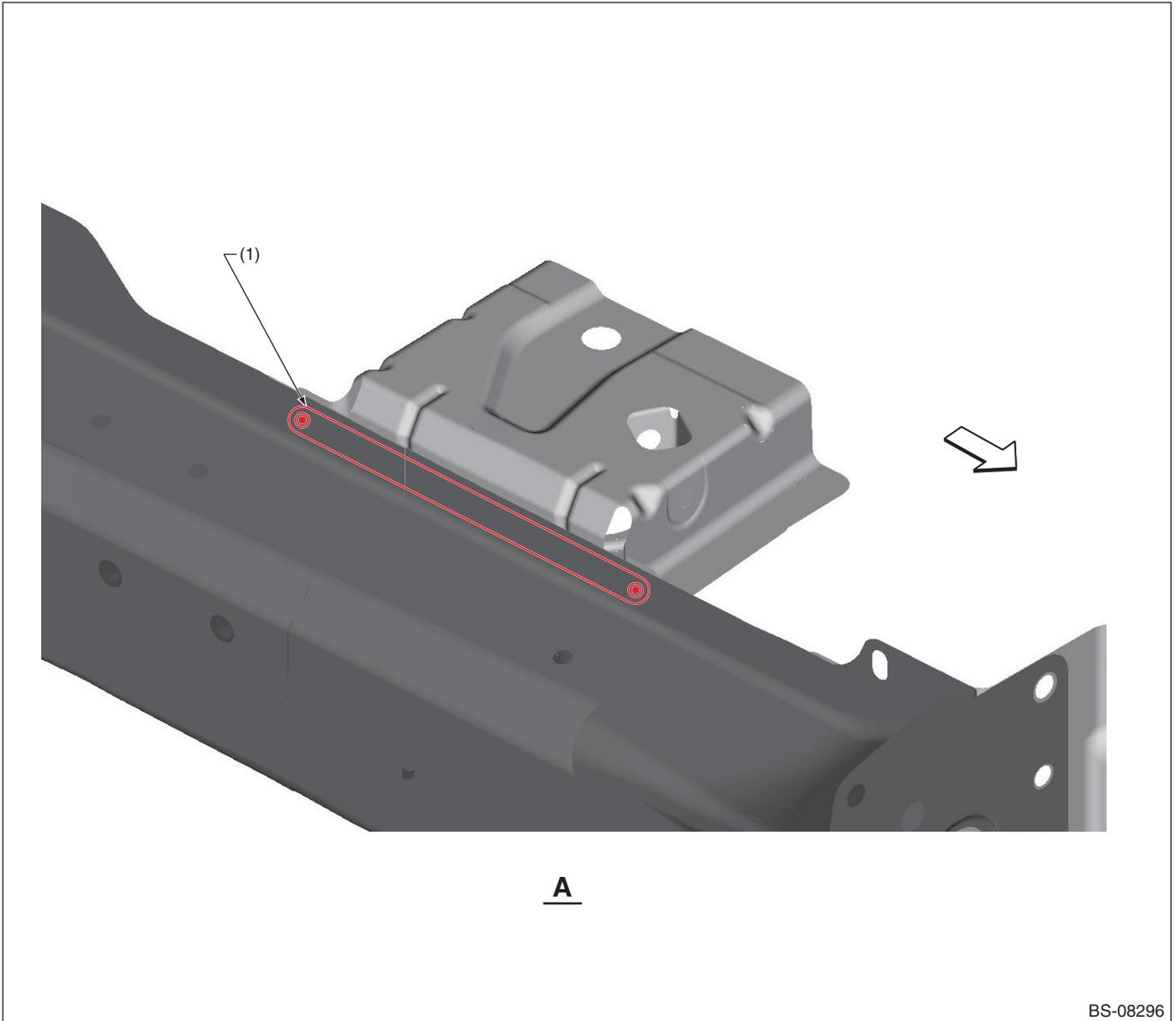
- (1) 1 point (outside · 1)
- (2) 2 points (outside · 1)
- (3) Tailored line

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

- (7) 11 points (outside · 1)

# Panel Replacement

## • Views A

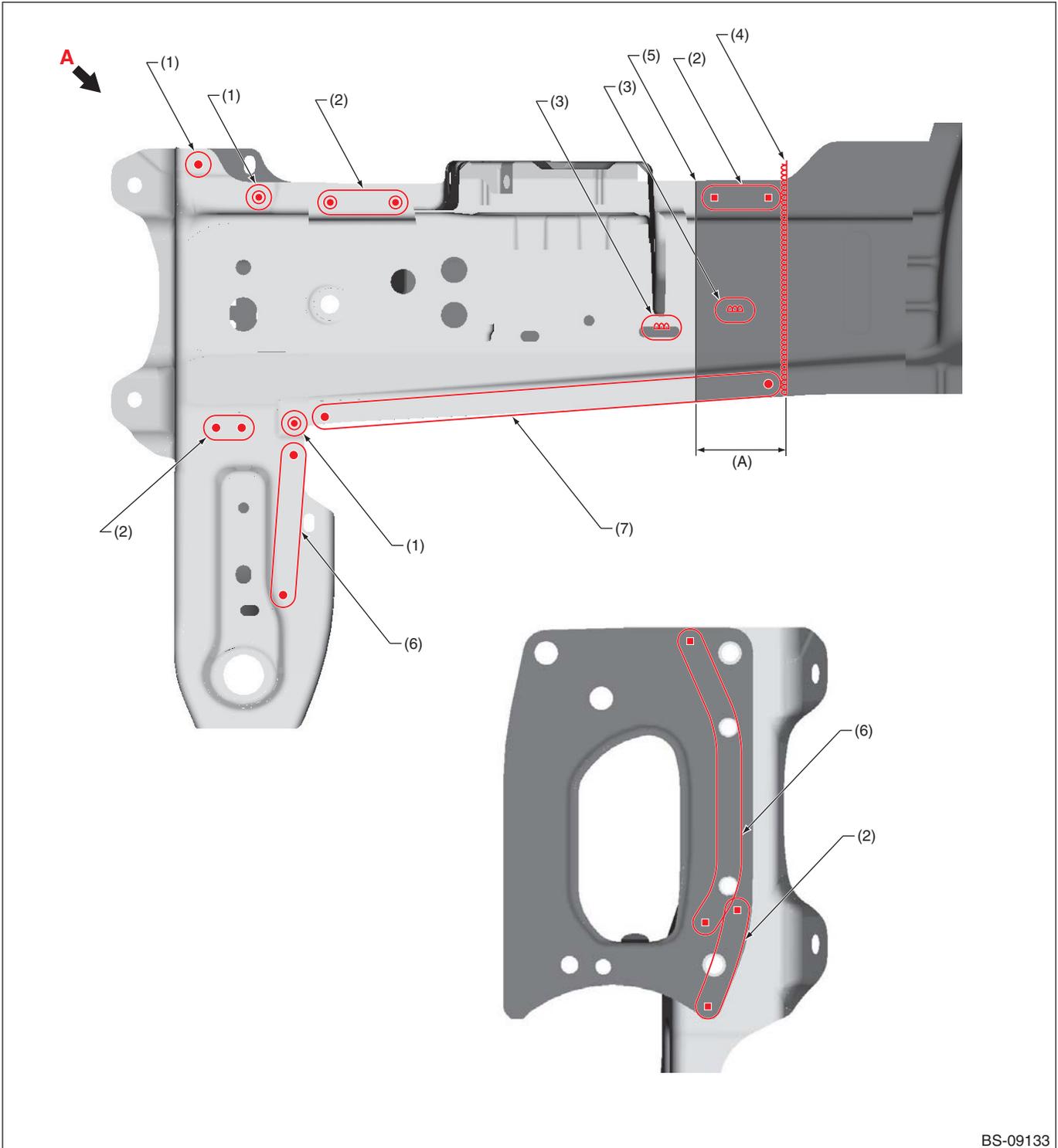


(1) 6 points (inside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view (Gasoline model)



BS-09133

(A) 55 mm [2.17 in]

(1) 1 point

(2) 2 points

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

(4) 1 point (Continuous welding)

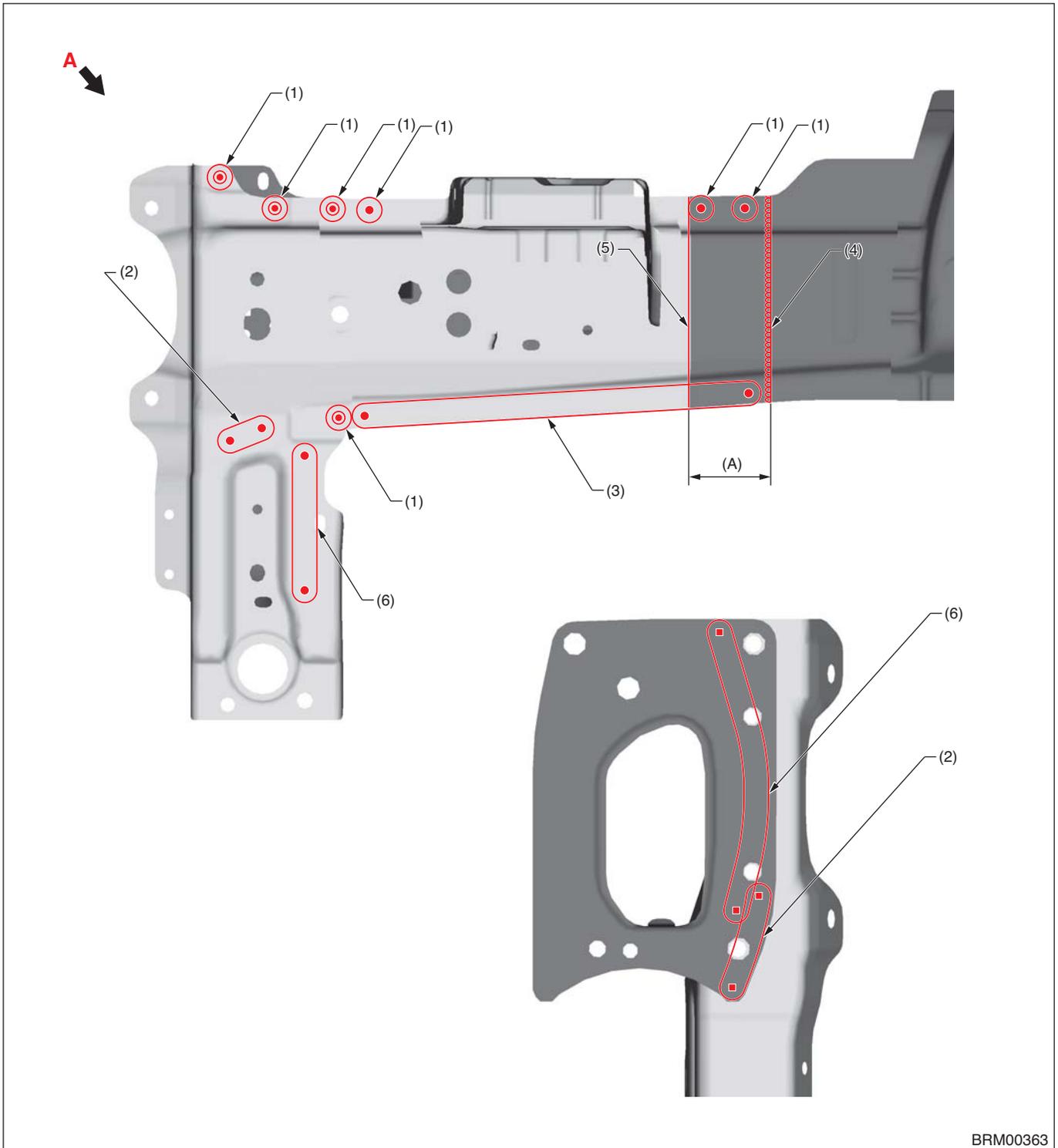
(5) Tailored line

(6) 4 points

(7) 12 points

# Panel Replacement

## • Overall view (Hybrid model)



(A) 55 mm [2.17 in]

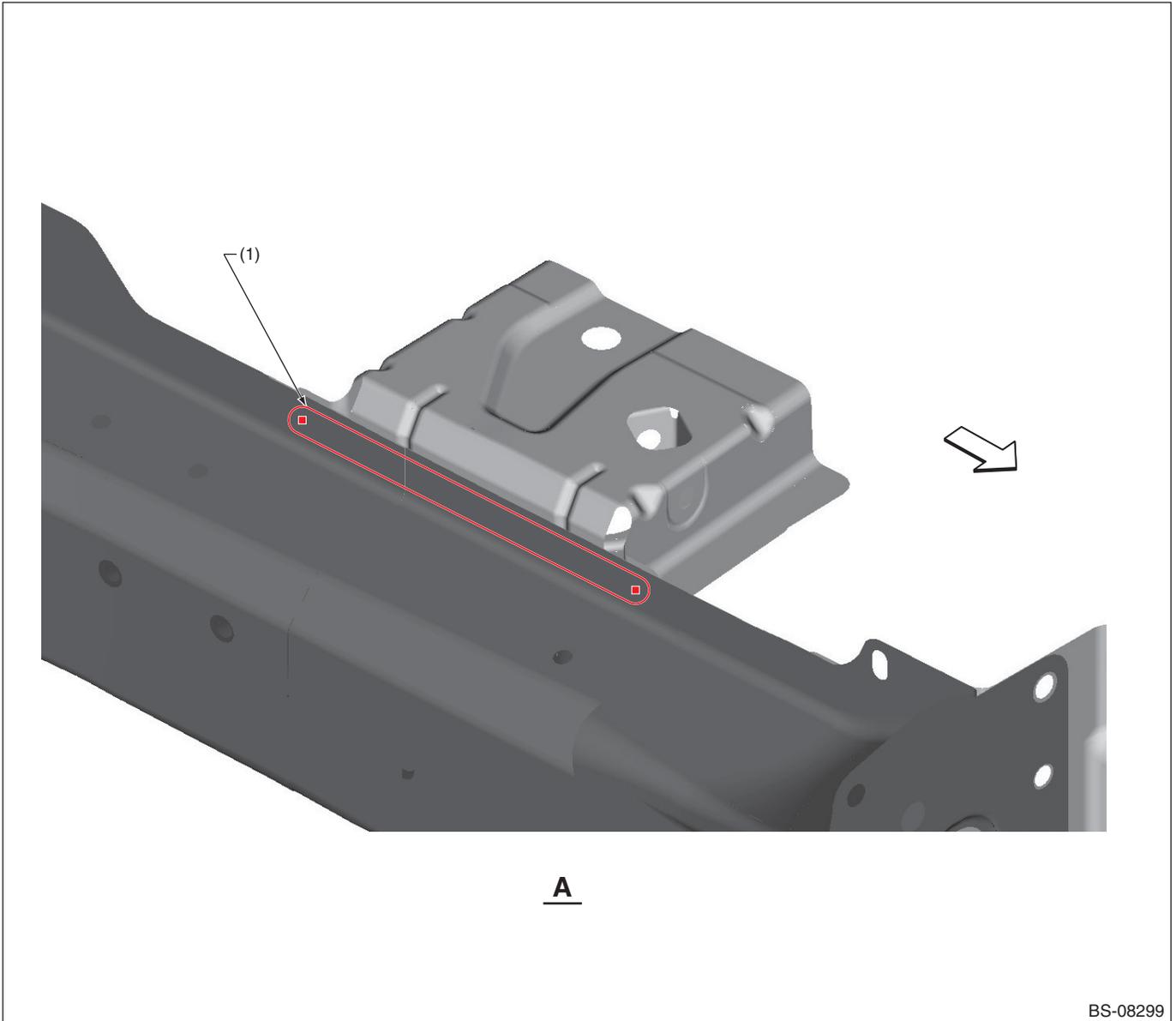
(1) 1 point  
(2) 2 points

(3) 11 points  
(4) 1 point (Continuous welding)

(5) Tailored line  
(6) 4 points

# Panel Replacement

## • Views A



BS-08299

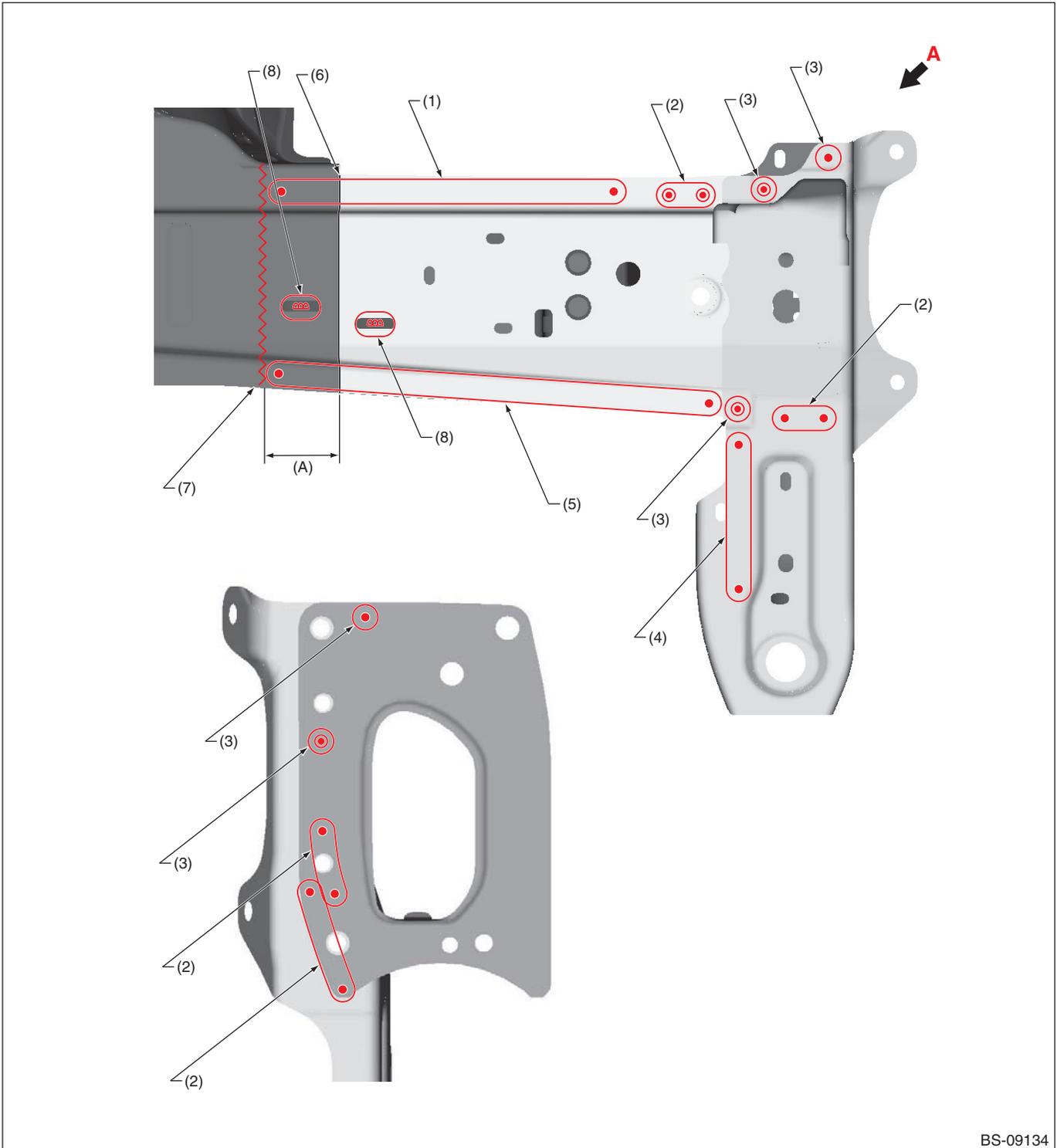
(1) 6 points (service)

# Panel Replacement

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

### A: REMOVAL

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



BS-09134

(A) 55 mm [2.17 in]

(1) 8 points (outside · 1)

(2) 2 points (outside · 1)

(3) 1 point (outside · 2)

(4) 4 points (outside · 1)

(5) 12 points (outside · 1)

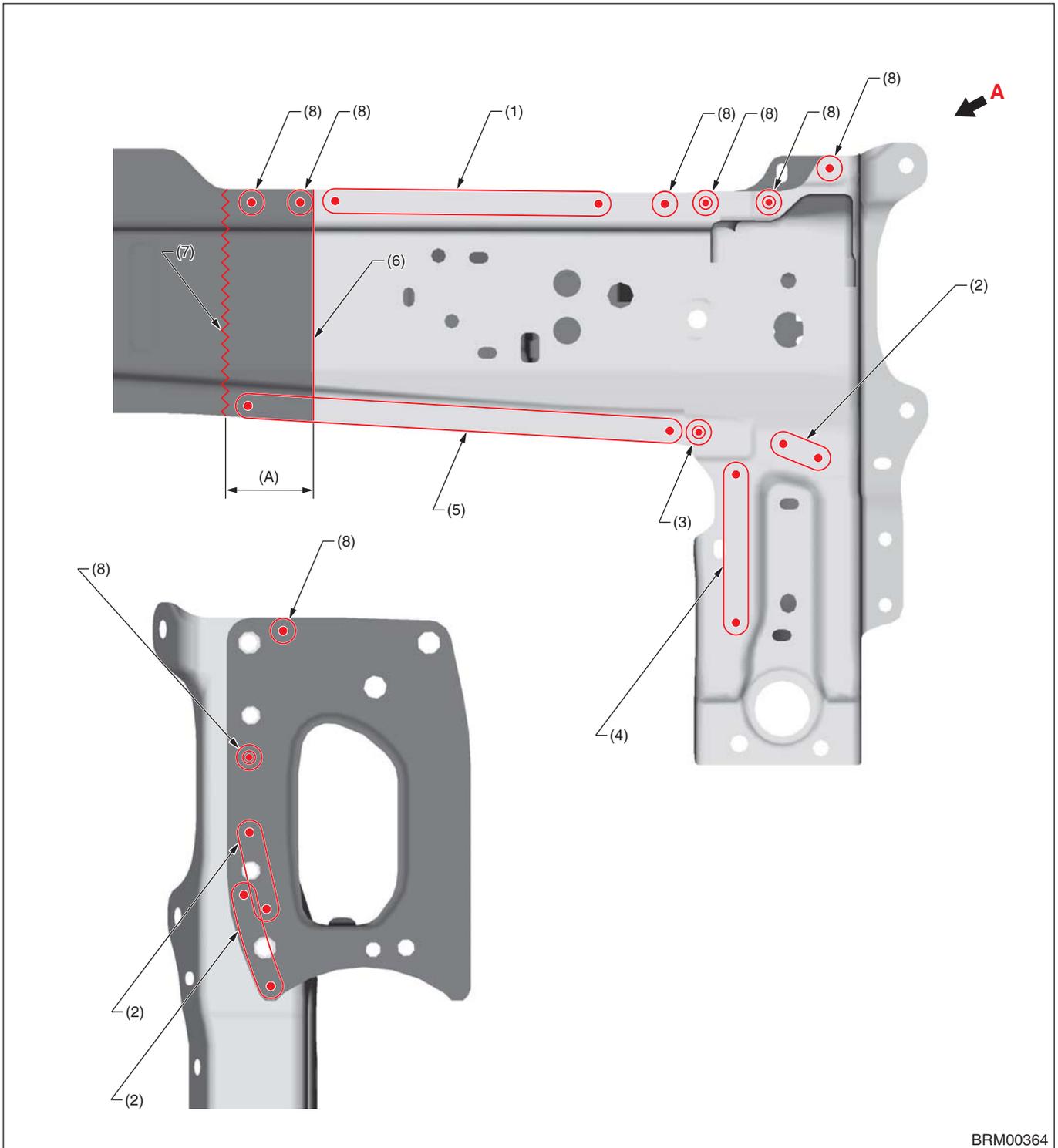
(6) Tailored line

(7) Cut position

(8) 1 point (outside · 1 belt sander)

# Panel Replacement

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



BRM00364

(A) 55 mm [2.17 in]

(1) 6 points (outside · 1)

(2) 2 points (outside · 1)

(3) 1 point (outside · 2)

(4) 4 points (outside · 1)

(5) 11 points (outside · 1)

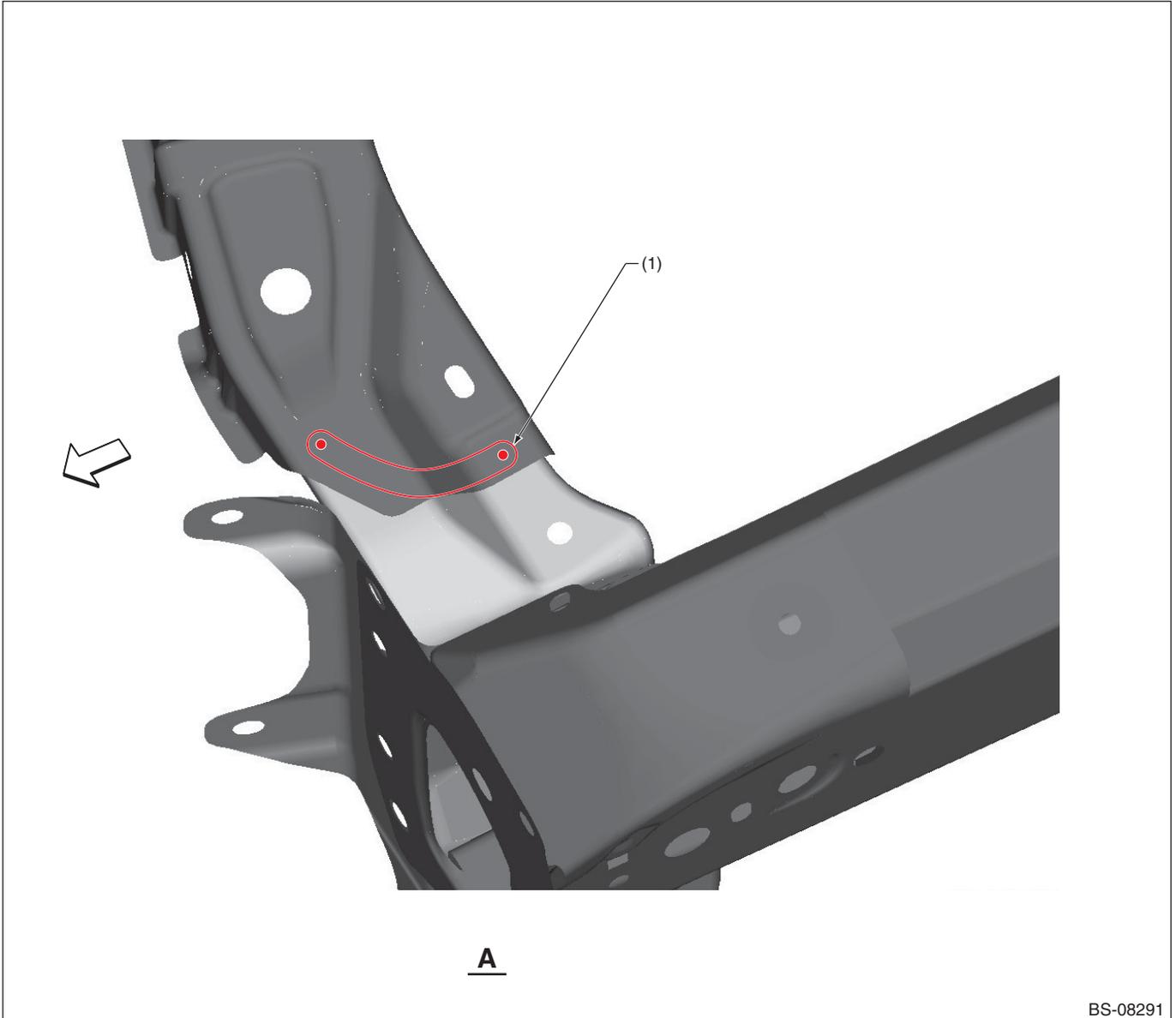
(6) Tailored line

(7) Cut position

(8) 1 point (outside · 1)

# Panel Replacement

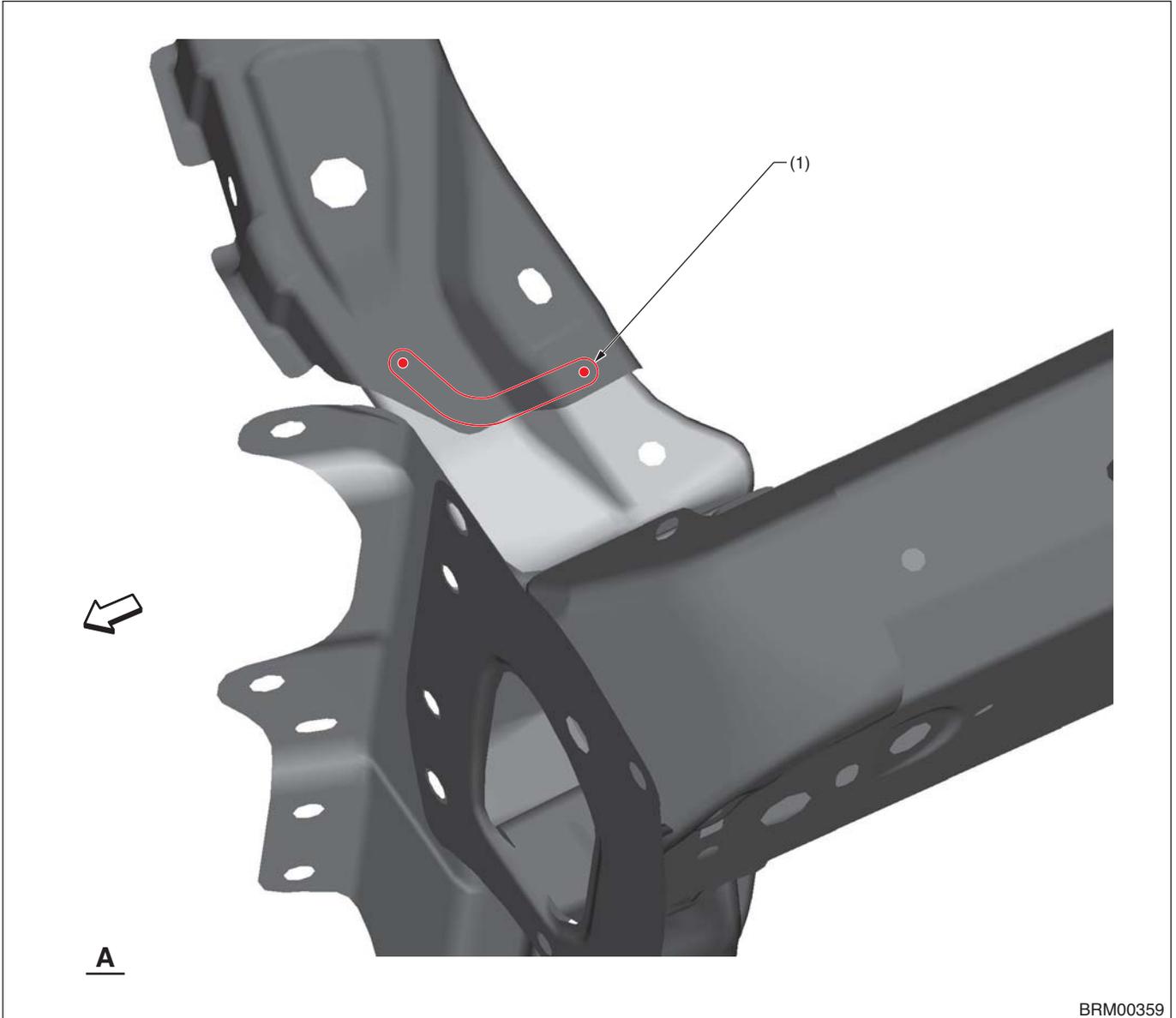
- Views A (Gasoline model)



(1) 3 points (top · 1)

# Panel Replacement

- Views A (Hybrid model)



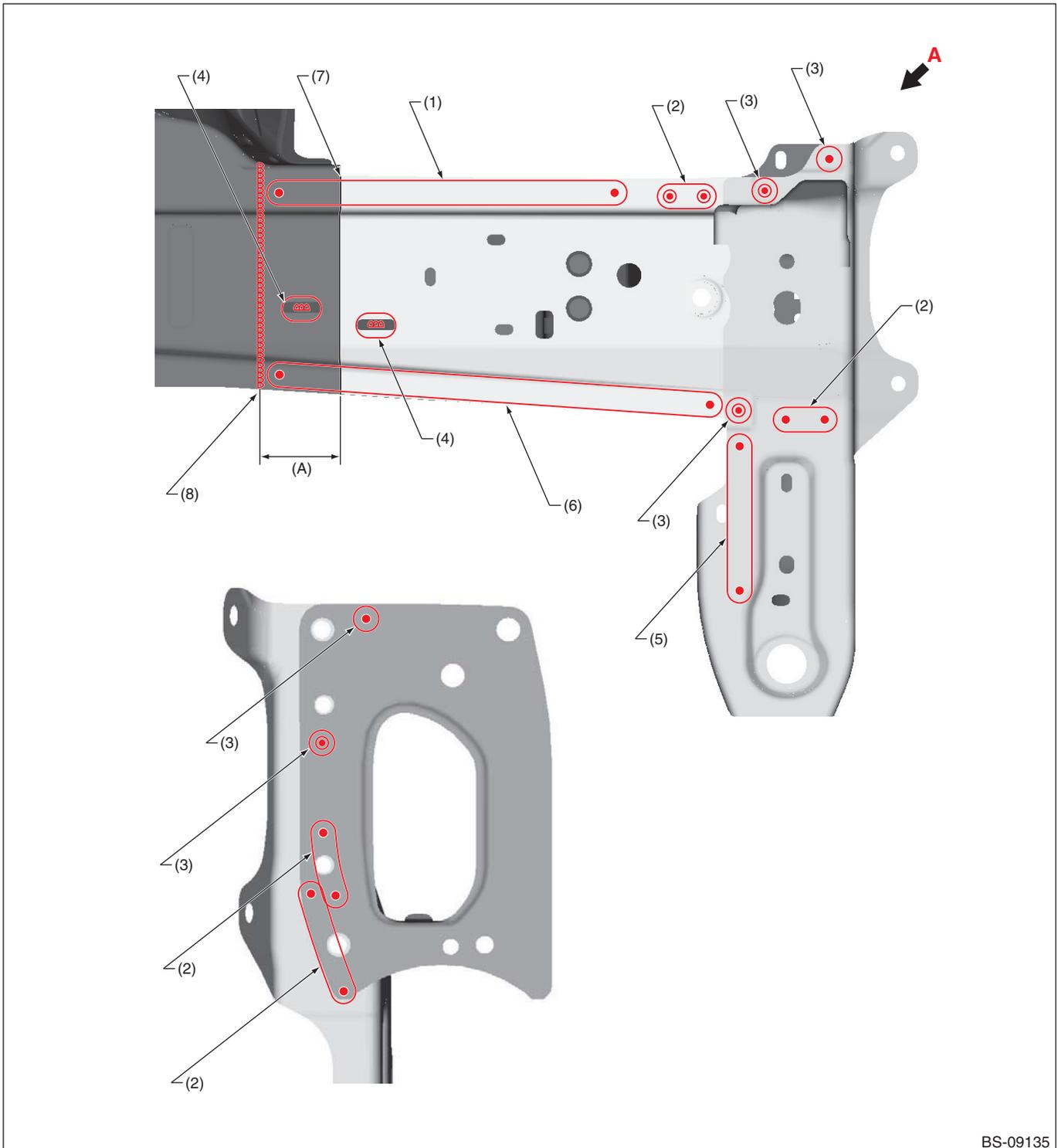
BRM00359

(1) 3 points (top - 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view (Gasoline model)



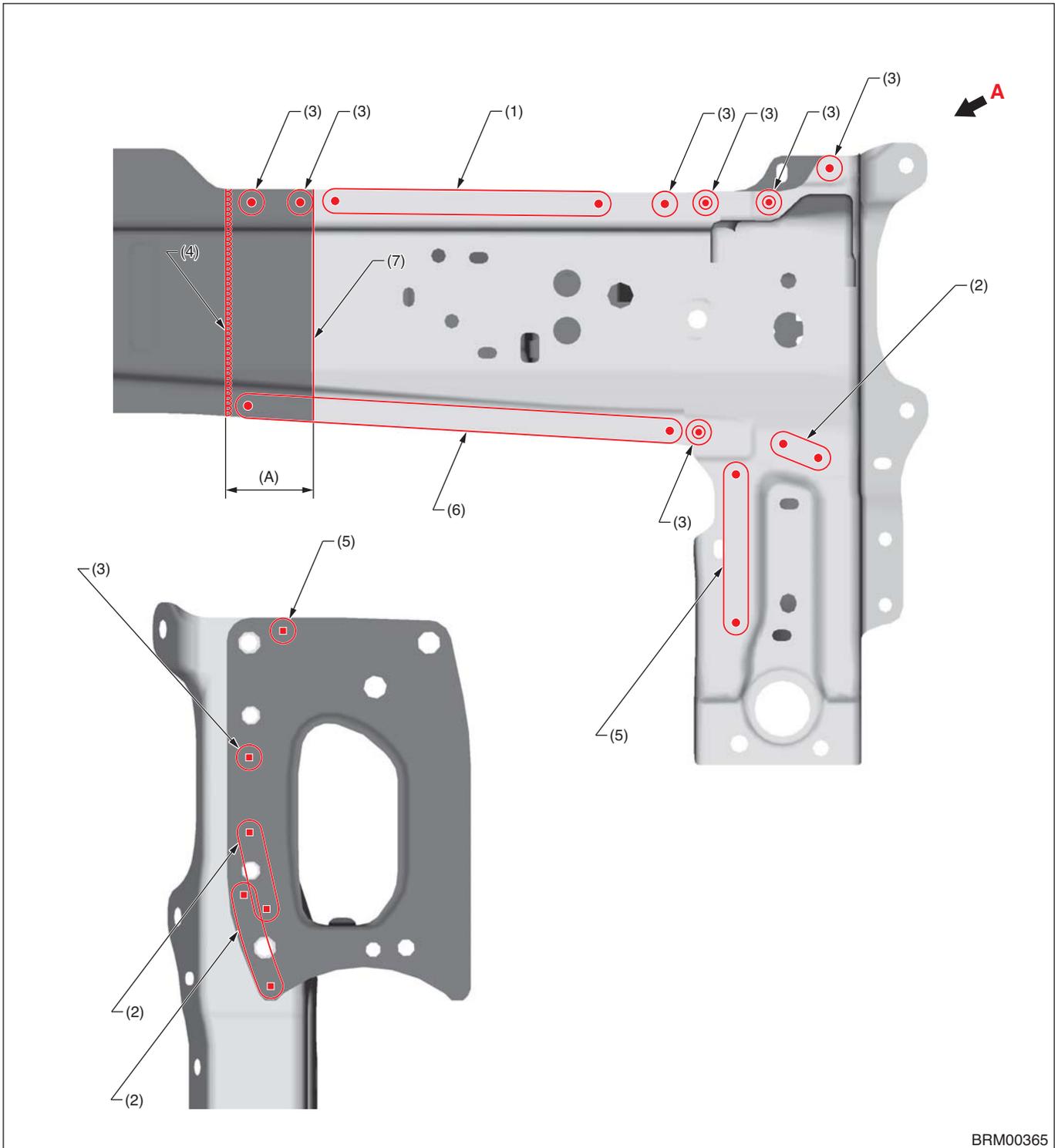
BS-09135

(A) 55 mm [2.17 in]

- |              |   |                                  |
|--------------|---|----------------------------------|
| (1) 8 points | (4) 1 point (Continuous welding)<br>(10 mm [0.39 in]) | (7) Tailored line                |
| (2) 2 points | (5) 4 points  | (8) 1 point (Continuous welding) |
| (3) 1 point  | (6) 12 points   |                                  |

# Panel Replacement

## • Overall view (Hybrid model)



BRM00365

(A) 55 mm [2.17 in]

(1) 6 points

(2) 2 points

(3) 1 point

(4) 1 point (Continuous welding)

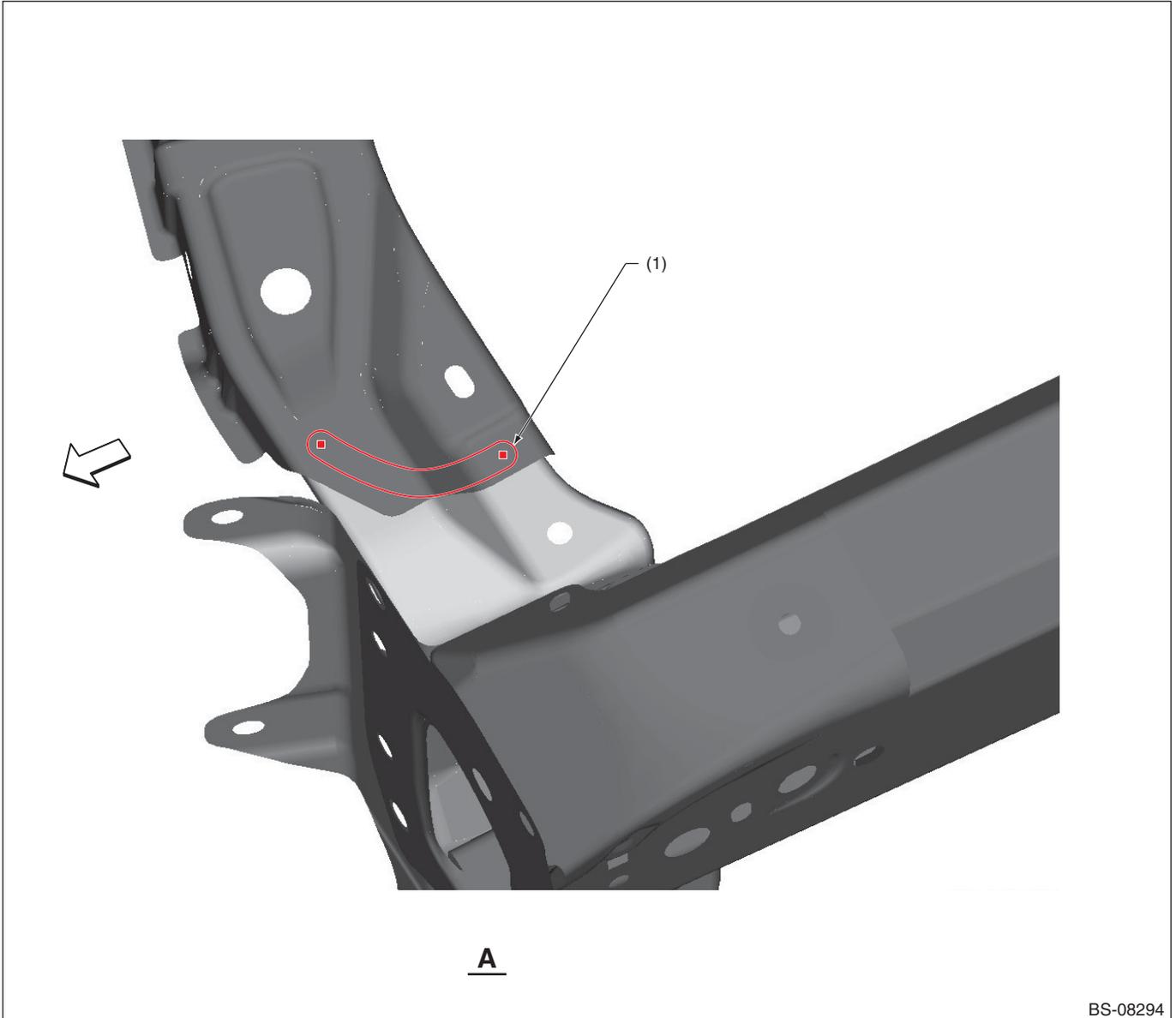
(5) 4 points

(6) 11 points

(7) Tailored line

# Panel Replacement

- Views A (Gasoline model)

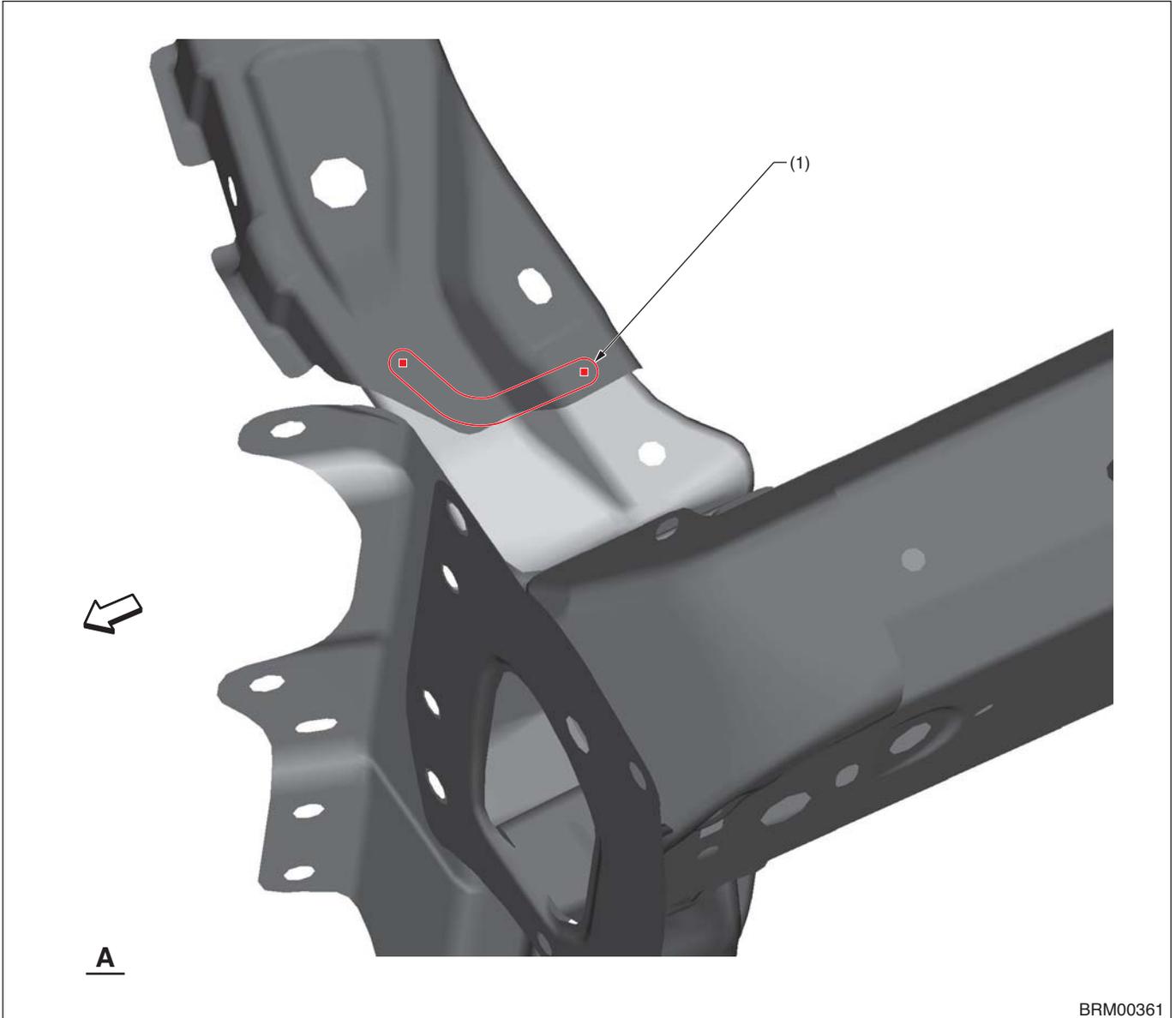


BS-08294

(1) 3 points

# Panel Replacement

- Views A (Hybrid model)



BRM00361

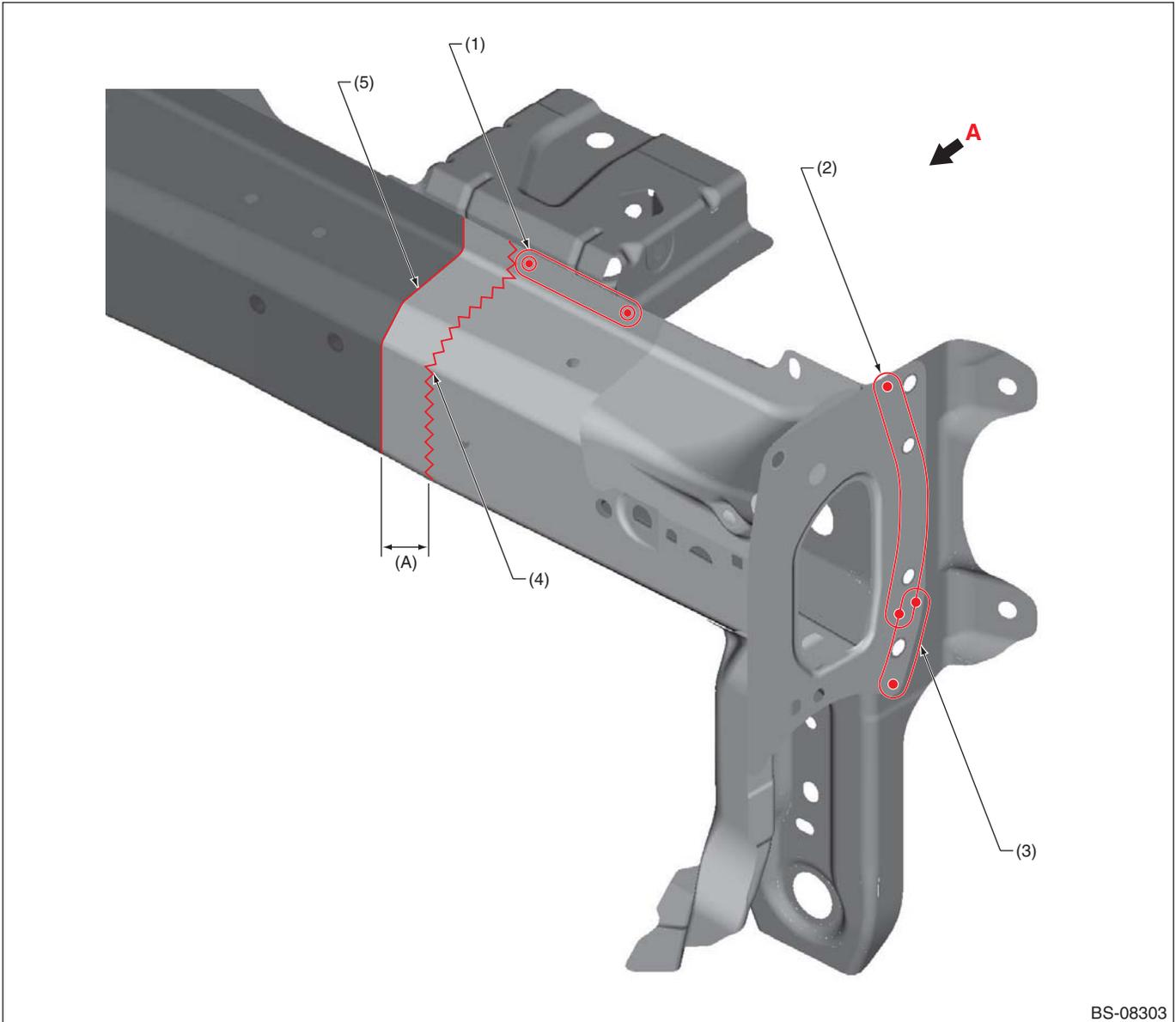
(1) 3 points

# Panel Replacement

## 8-10. Front Side Frame (partial replacement)

### A: REMOVAL

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



BS-08303

(A) 35 mm [1.38 in]

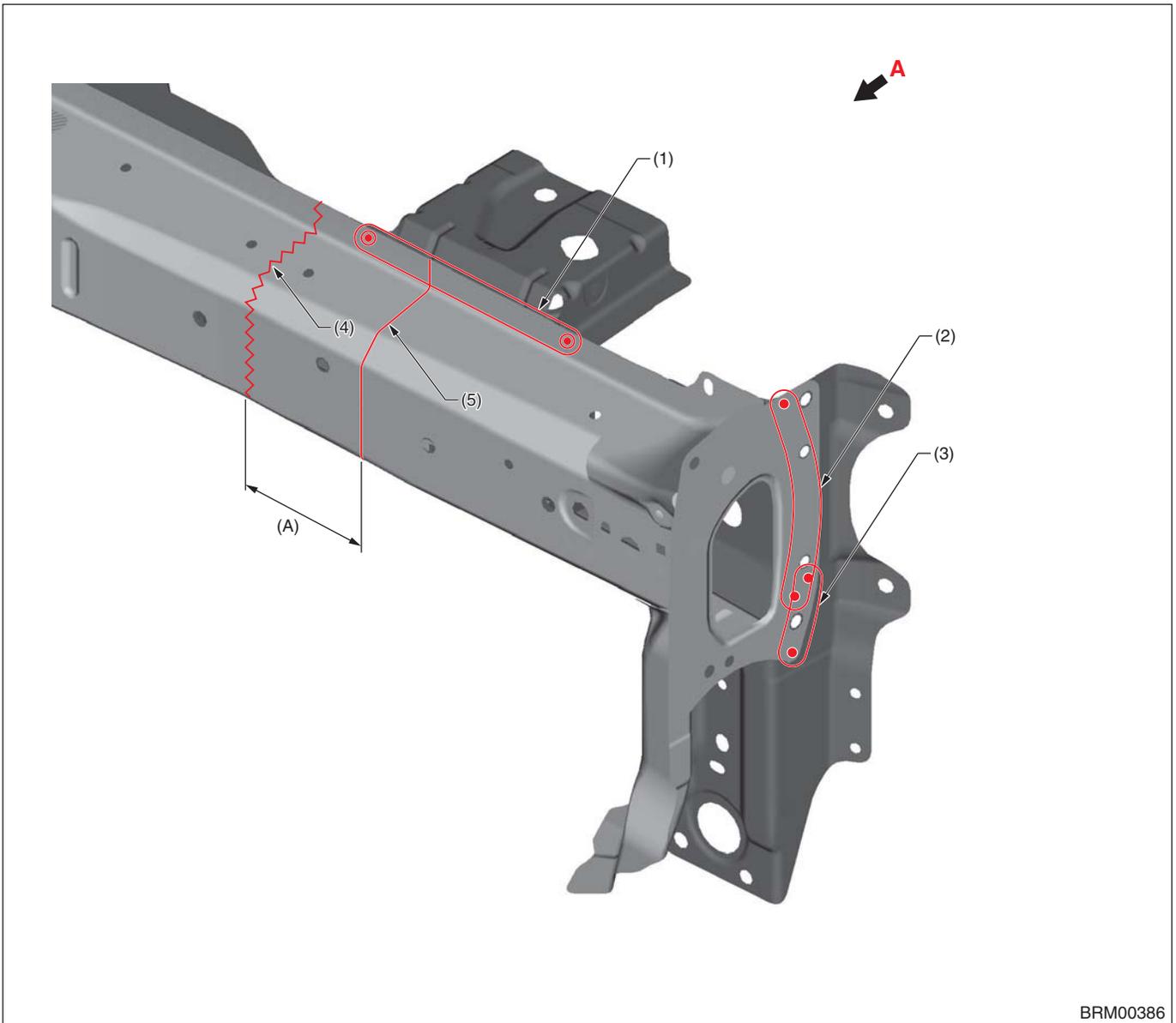
(1) 3 points (inside · 1)  
(2) 4 points (outside · 1)

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

(5) Tailored line

# Panel Replacement

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



BRM00386

(A) 90 mm [3.54 in]

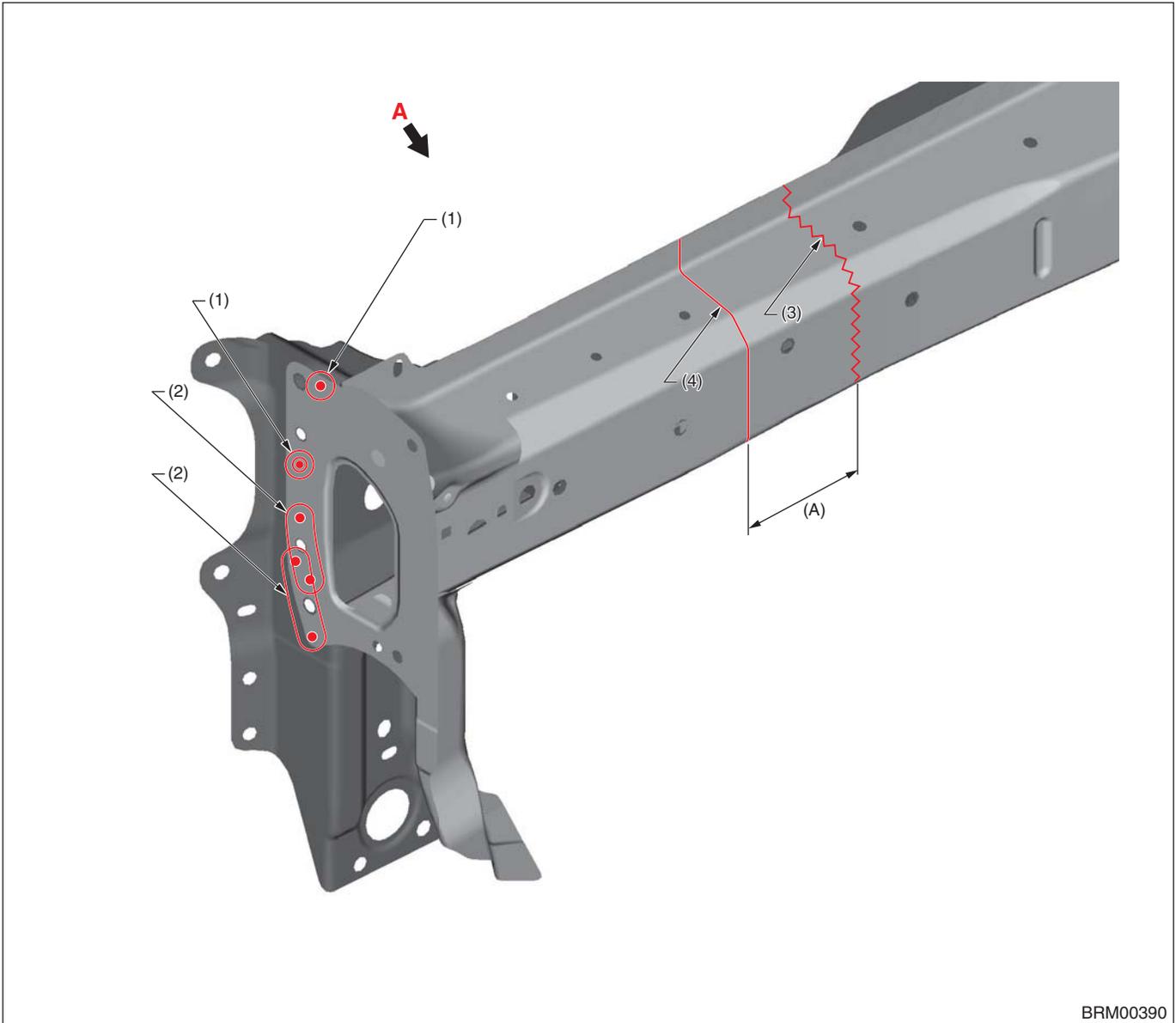
(1) 6 points (inside · 1)  
(2) 4 points (outside · 1)

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

(5) Tailored line

# Panel Replacement

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



BRM00390

(A) 90 mm [3.54 in]

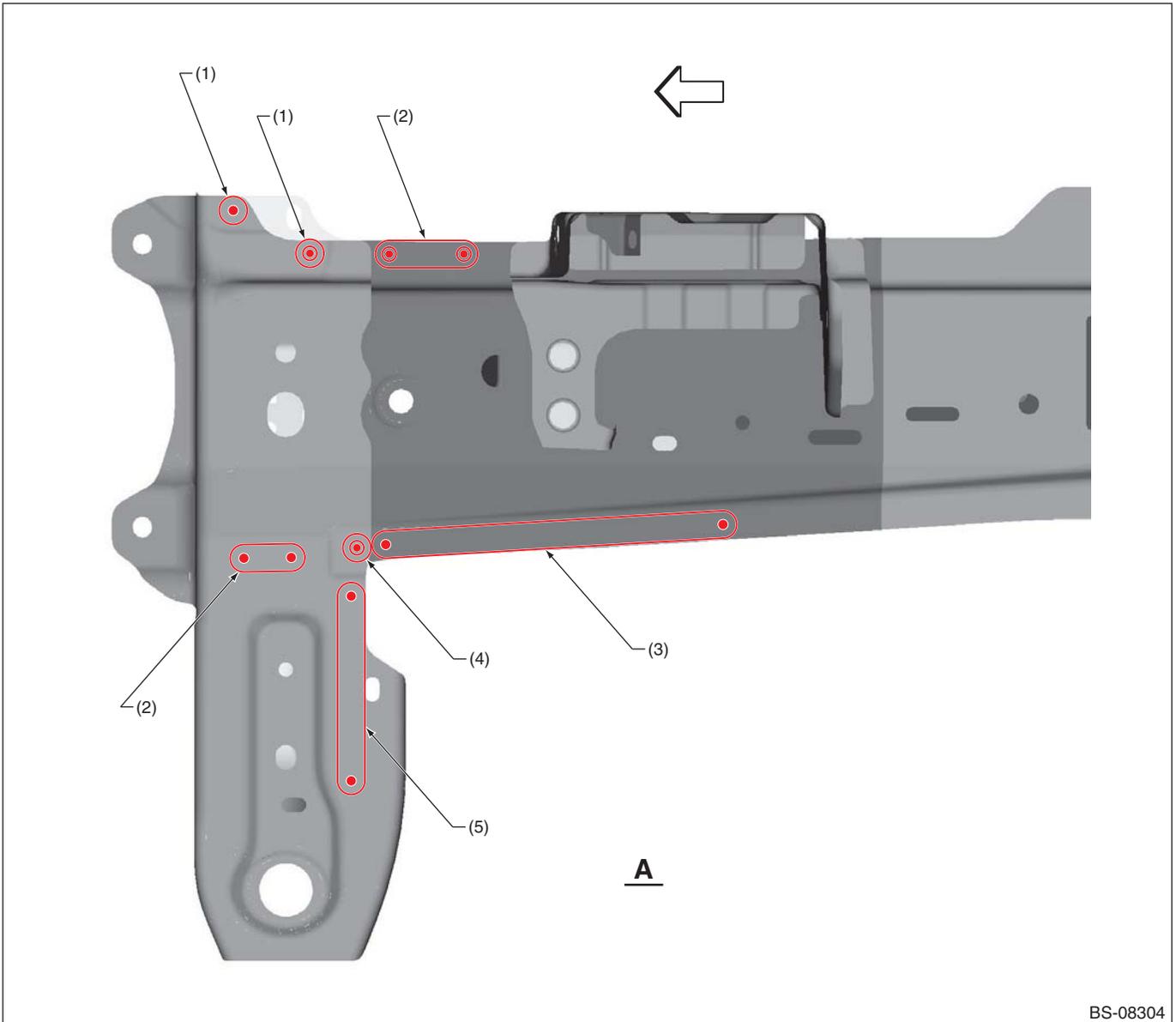
- (1) 1 point (outside · 1)
- (2) 2 points (outside · 1)

(3) Cut position

(4) Tailored line

# Panel Replacement

## • Views A (Gasoline model)



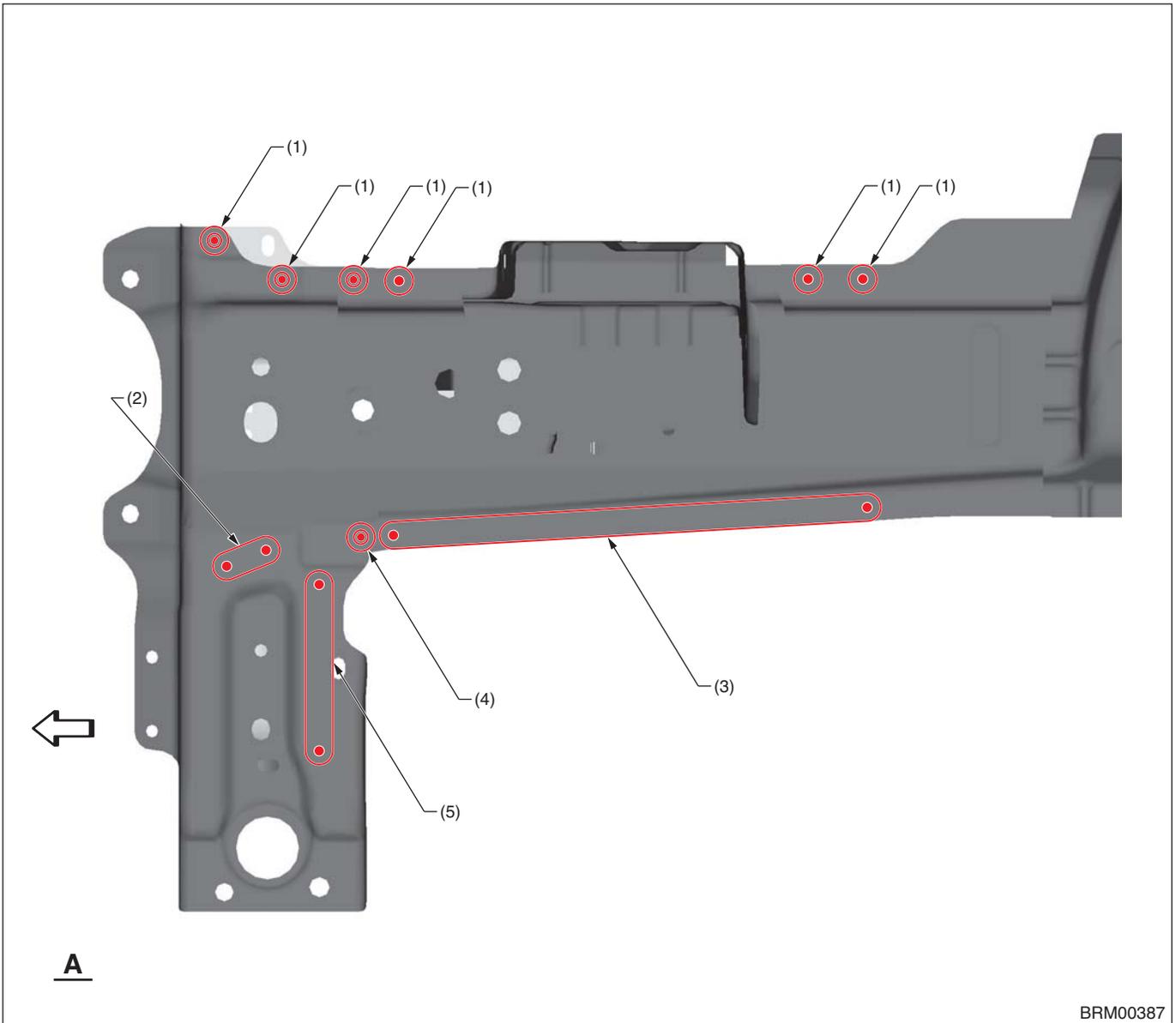
(1) 1 point (outside · 1)  
(2) 2 points (outside · 1)

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

(5) 4 points (outside · 1)

# Panel Replacement

## • Views A (LH) (Hybrid model)



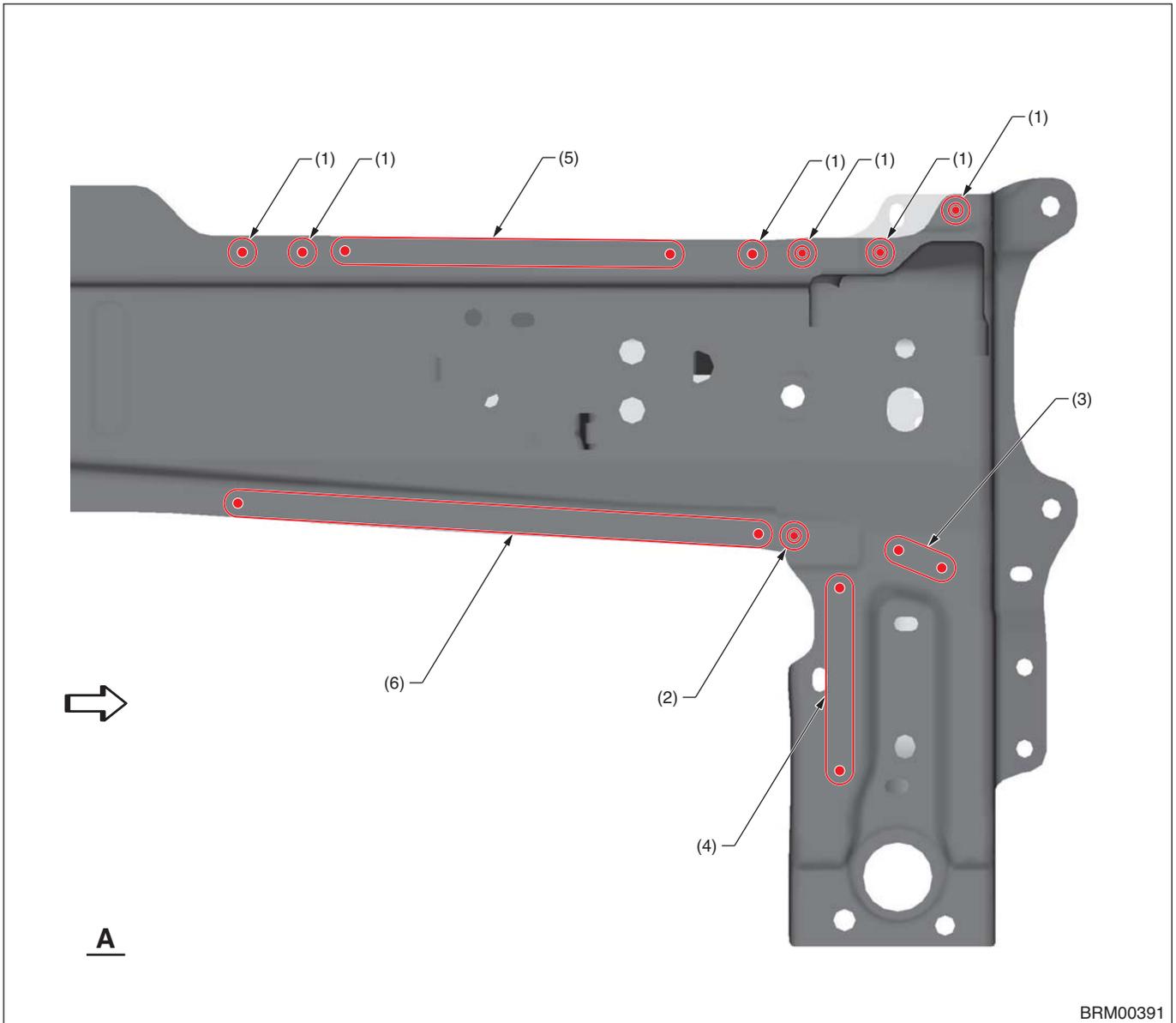
(1) 1 point (outside · 1)  
(2) 2 points (outside · 1)

(3) 11 points (outside · 1)  
(4) 1 point (outside · 2)

(5) 4 points (outside · 1)

# Panel Replacement

## • Views A (RH) (Hybrid model)



(1) 1 point (outside · 1)

(2) 1 point (outside · 2)

(3) 2 points (outside · 1)

(4) 4 points (outside · 1)

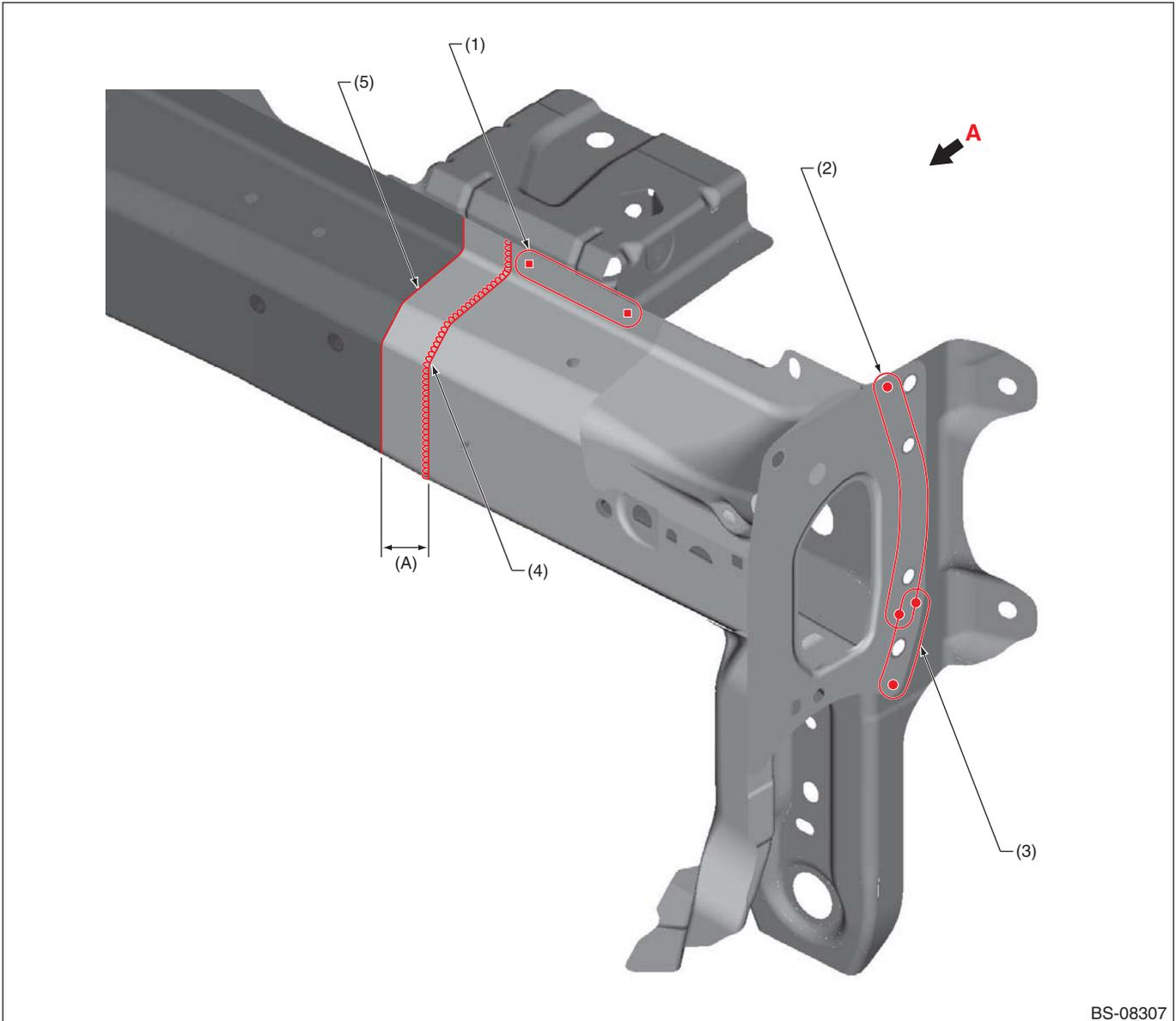
(5) 6 points (outside · 1)

(6) 11 points (outside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view (Gasoline model)



(A) 35 mm [1.38 in]

(1) 3 points (service)

(2) 4 points

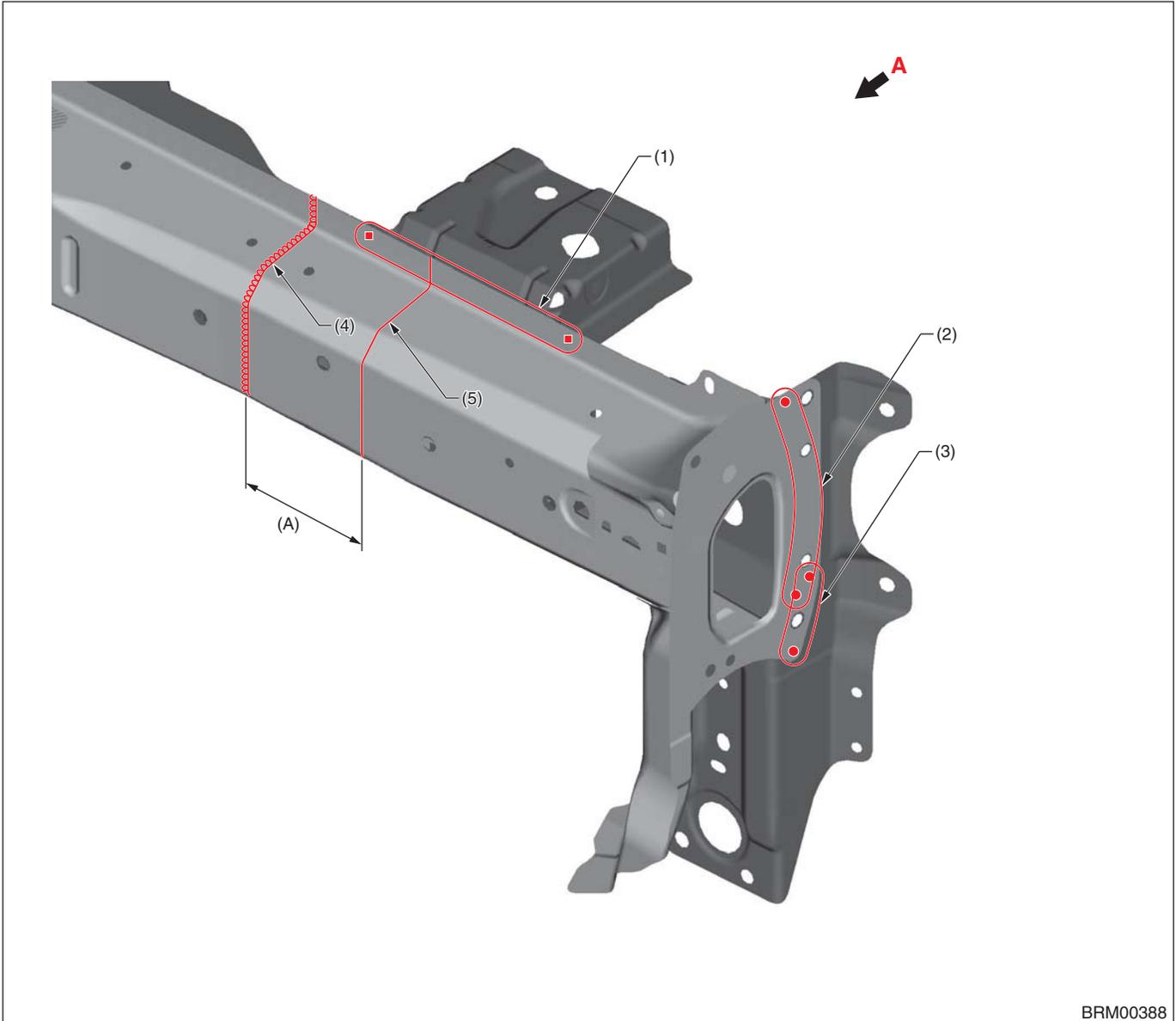
(3) 2 points

(4) 1 point (Continuous welding)

(5) Tailored line

# Panel Replacement

## • Overall view (LH) (Hybrid model)



(A) 90 mm [3.54 in]

(1) 6 points (service)

(2) 4 points

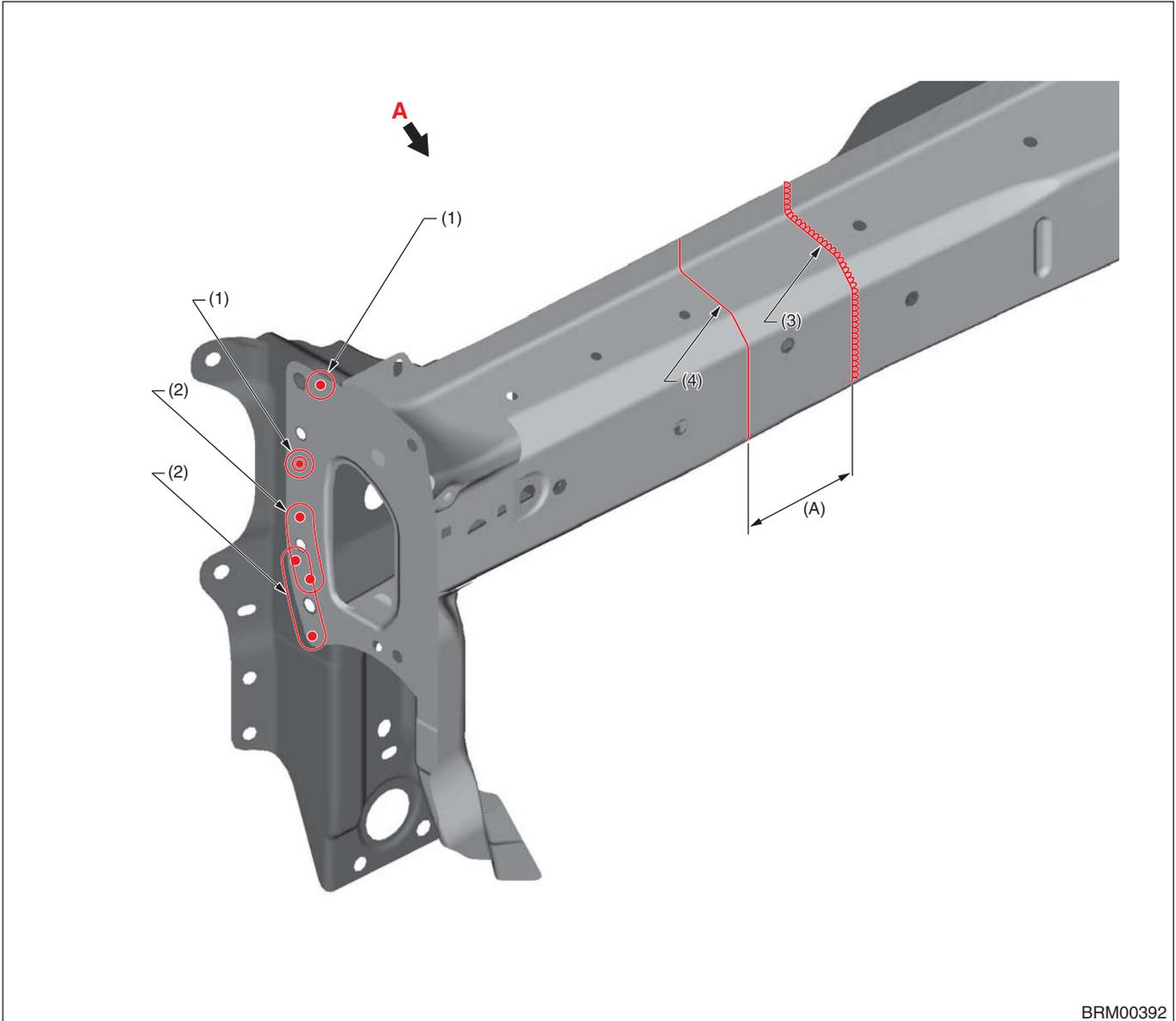
(3) 2 points

(4) 1 point (Continuous welding)

(5) Tailored line

# Panel Replacement

## • Overall view (RH) (Hybrid model)



BRM00392

(A) 90 mm [3.54 in]

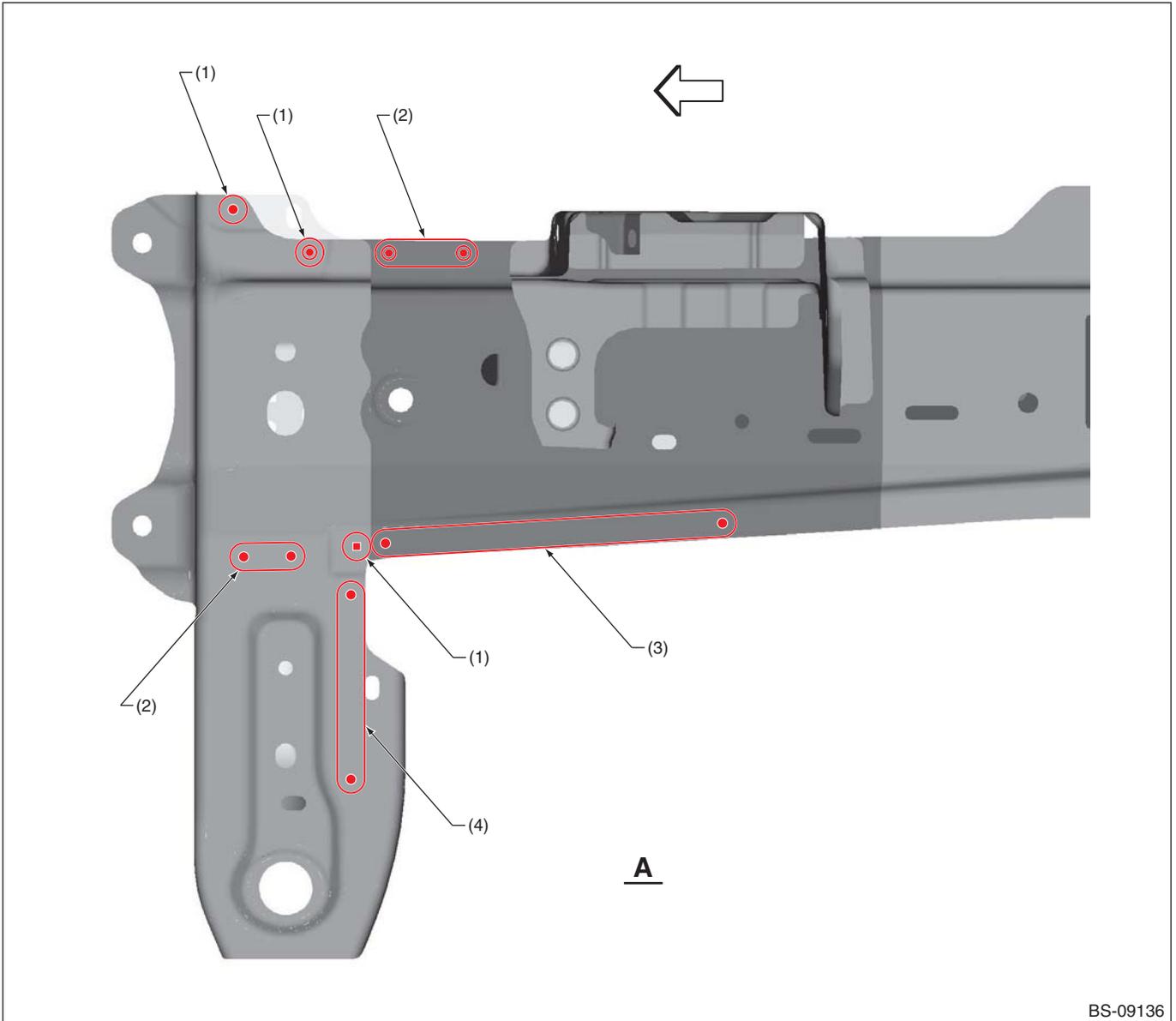
(1) 1 point  
(2) 2 points

(3) 1 point (Continuous welding)

(4) Tailored line

# Panel Replacement

## • Views A (Gasoline model)



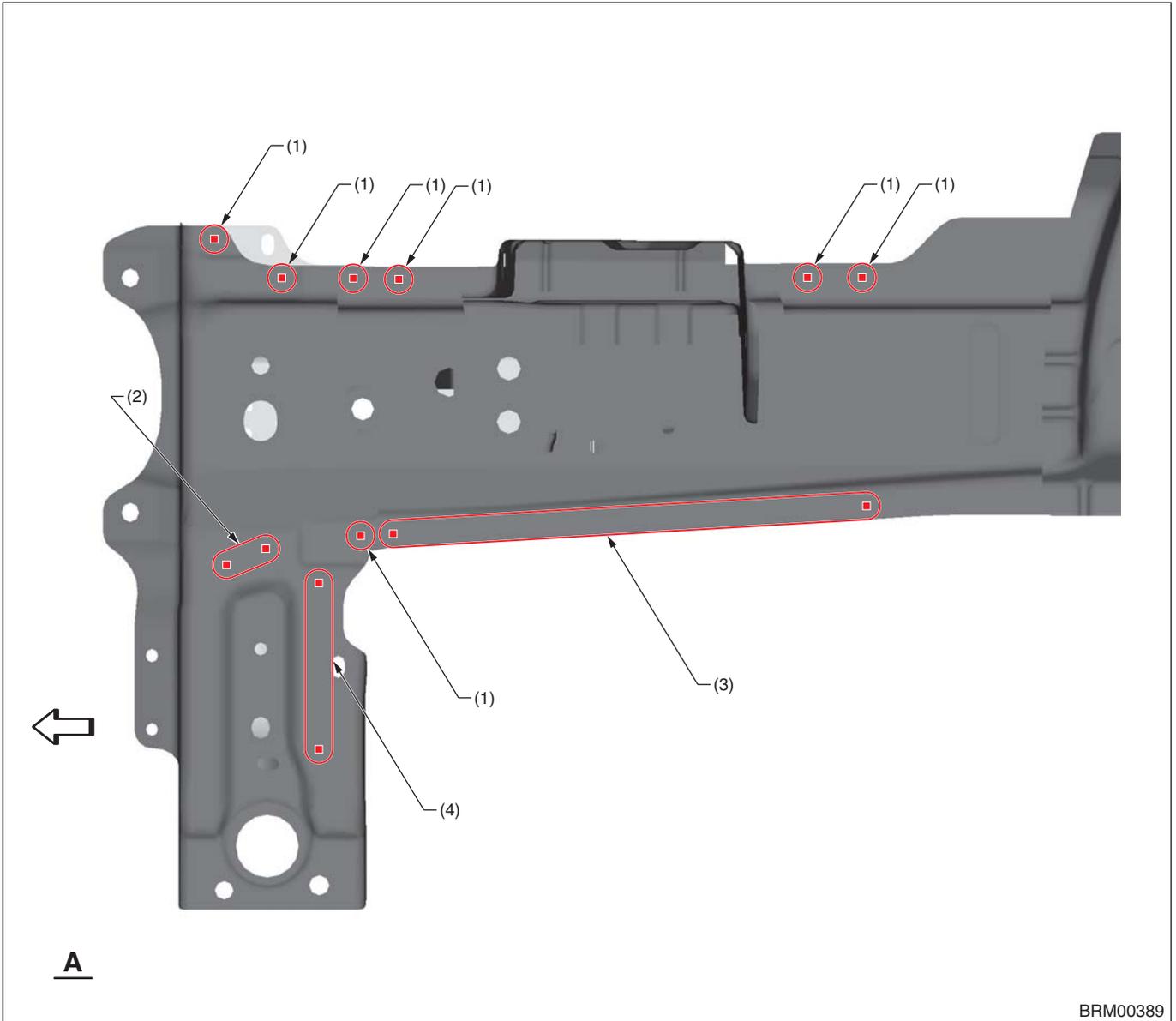
(1) 1 point  
(2) 2 points

(3) 7 points

(4) 4 points

# Panel Replacement

## • Views A (LH) (Hybrid model)



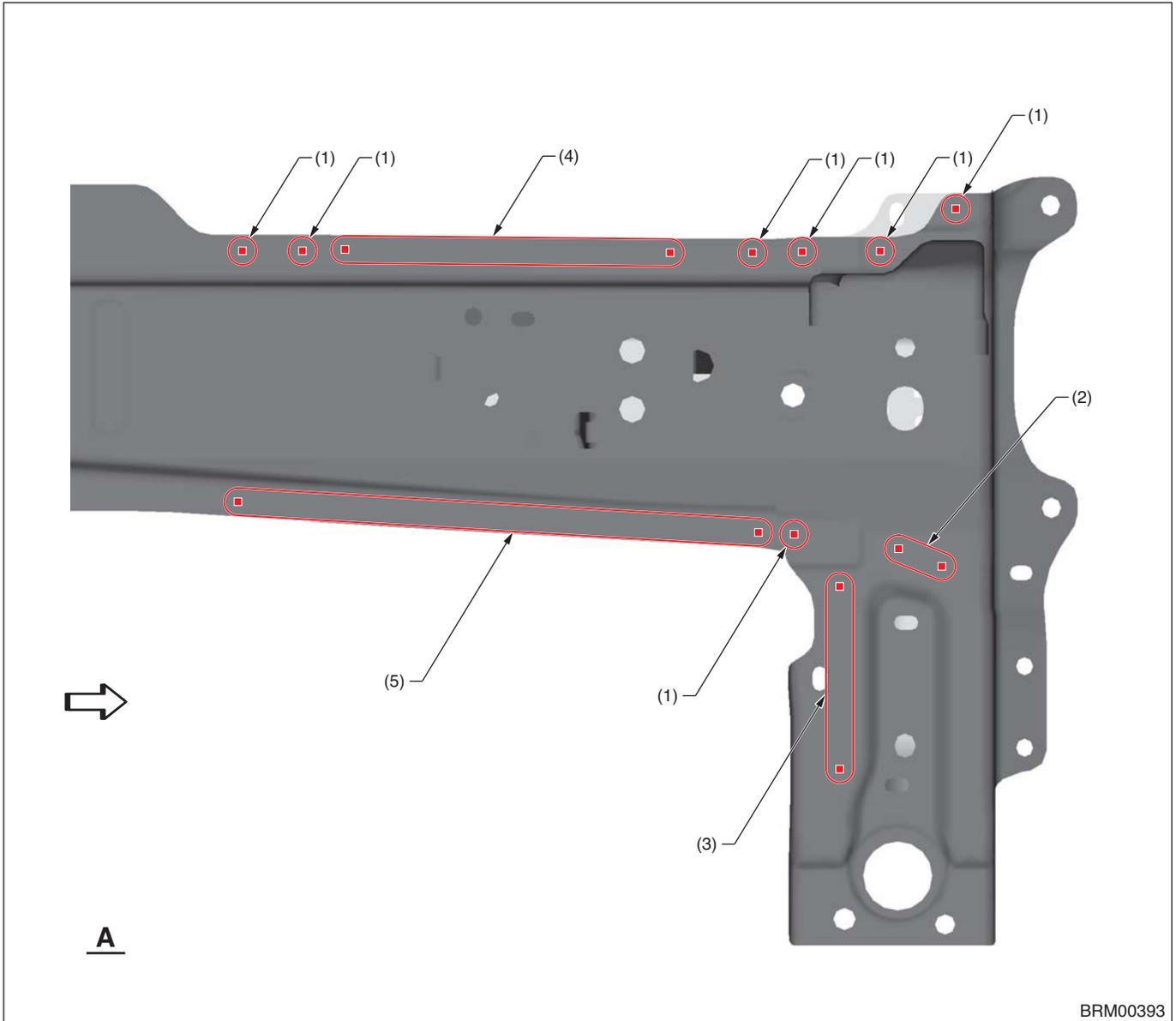
(1) 1 point  
(2) 2 points

(3) 11 points

(4) 4 points

# Panel Replacement

## • Views A (RH) (Hybrid model)



(1) 1 point  
(2) 2 points

(3) 4 points  
(4) 6 points

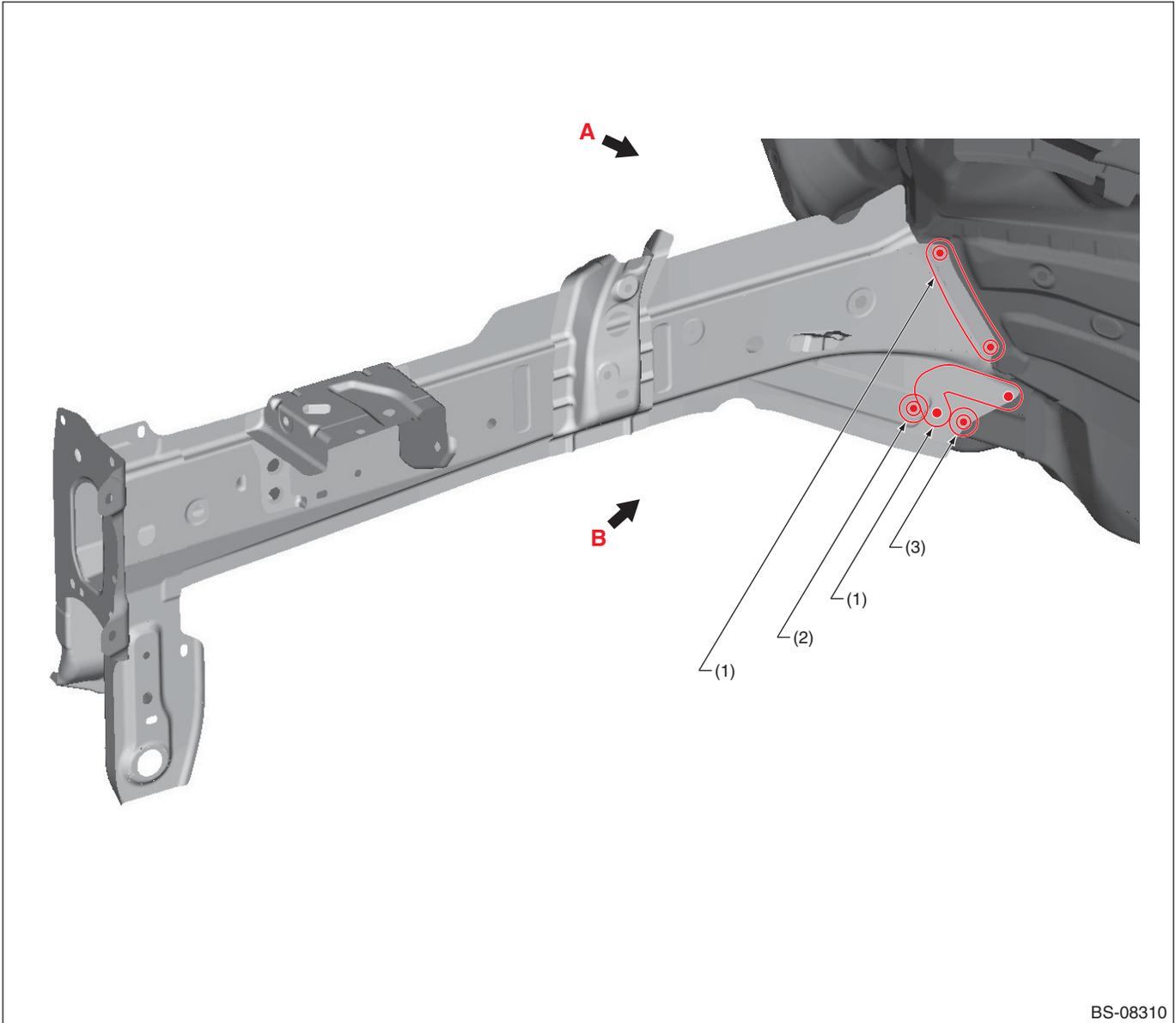
(5) 11 points

# Panel Replacement

## 8-11. Front Side Frame (total replacement)

### A: REMOVAL

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



BS-08310

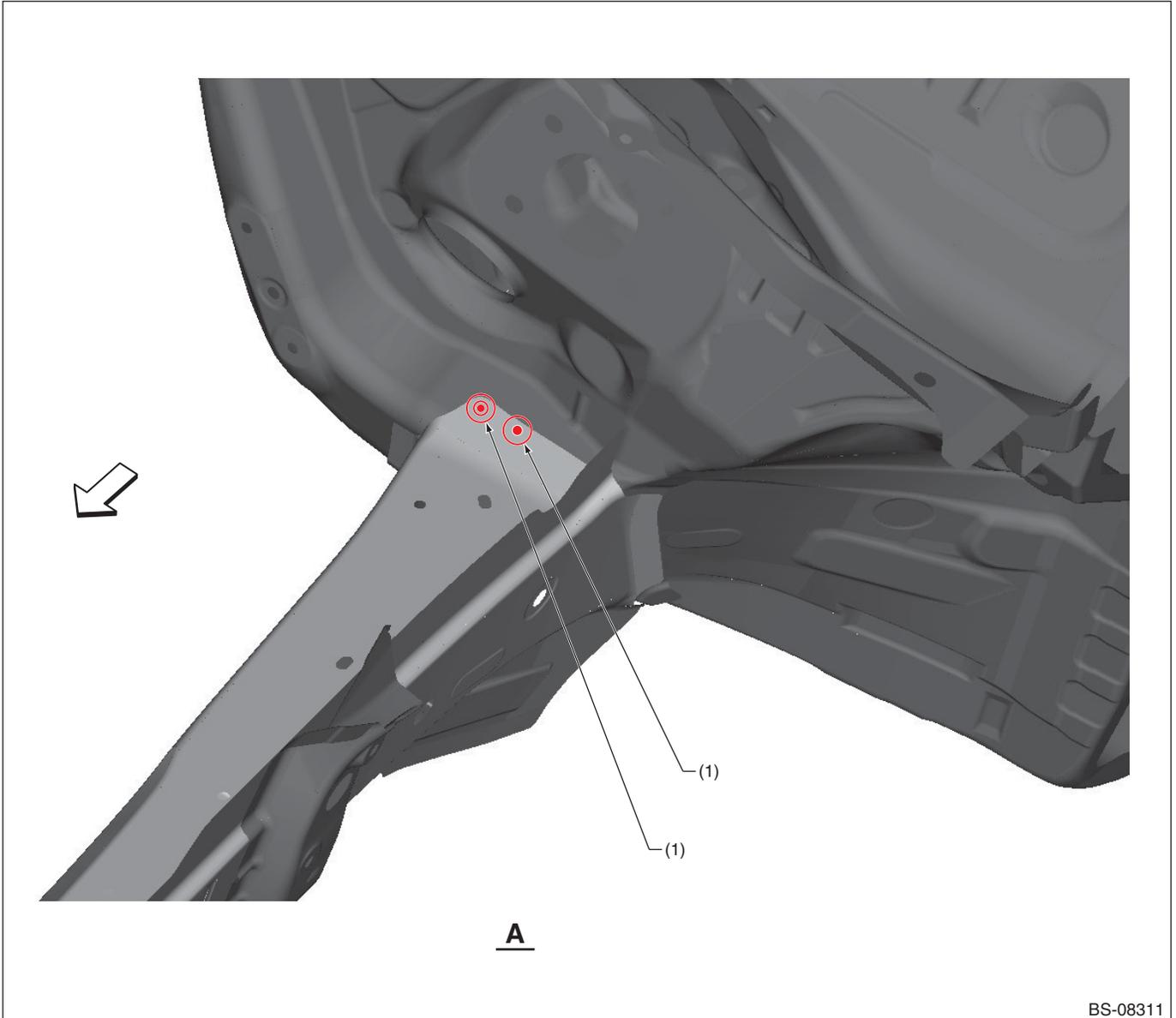
(1) 5 points (outside · 1)

(2) 1 point (outside · 2)

(3) 1 point (outside · 1)

# Panel Replacement

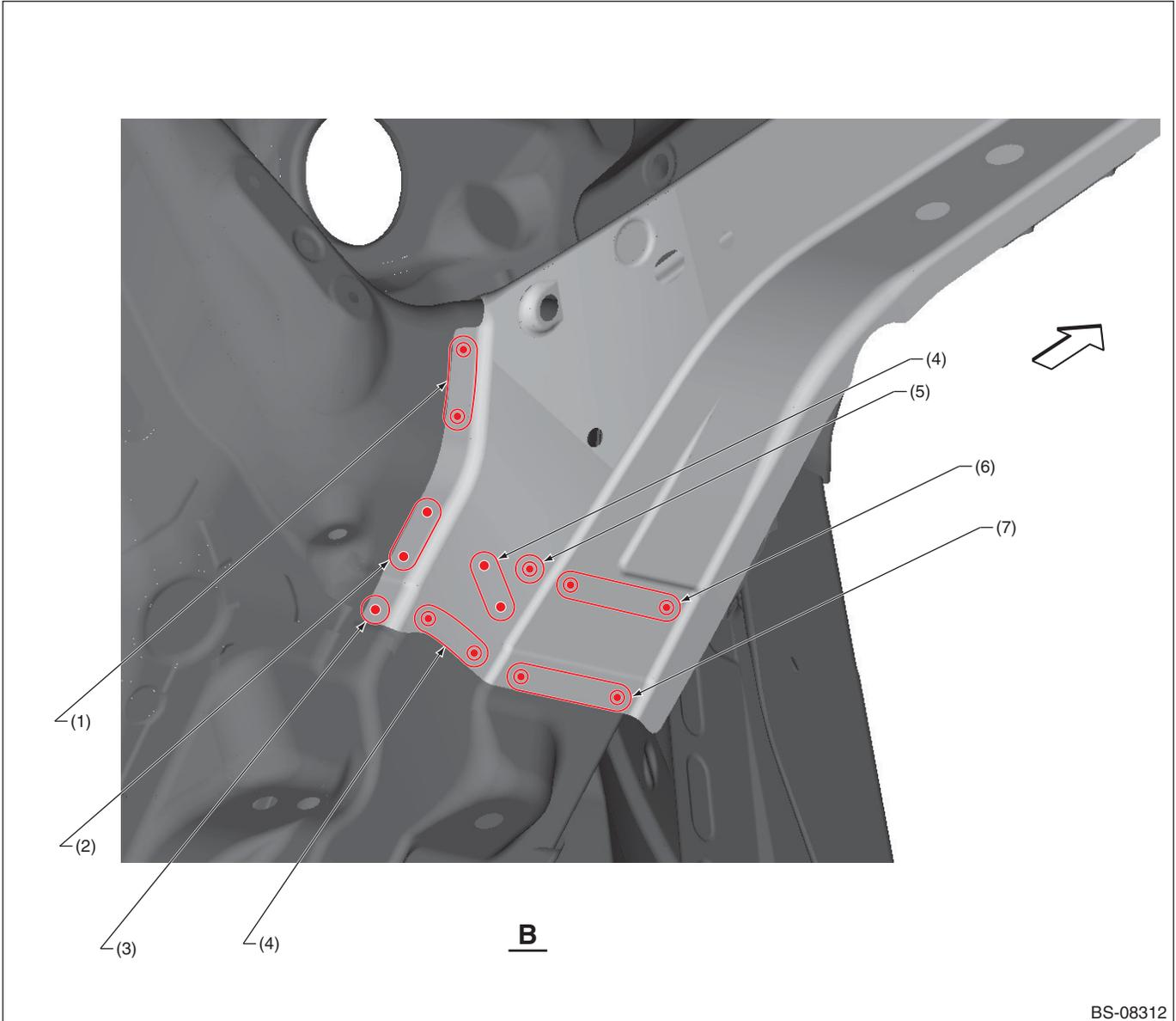
## • Views A



(1) 1 point (top · 1)

# Panel Replacement

## • Views B



BS-08312

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

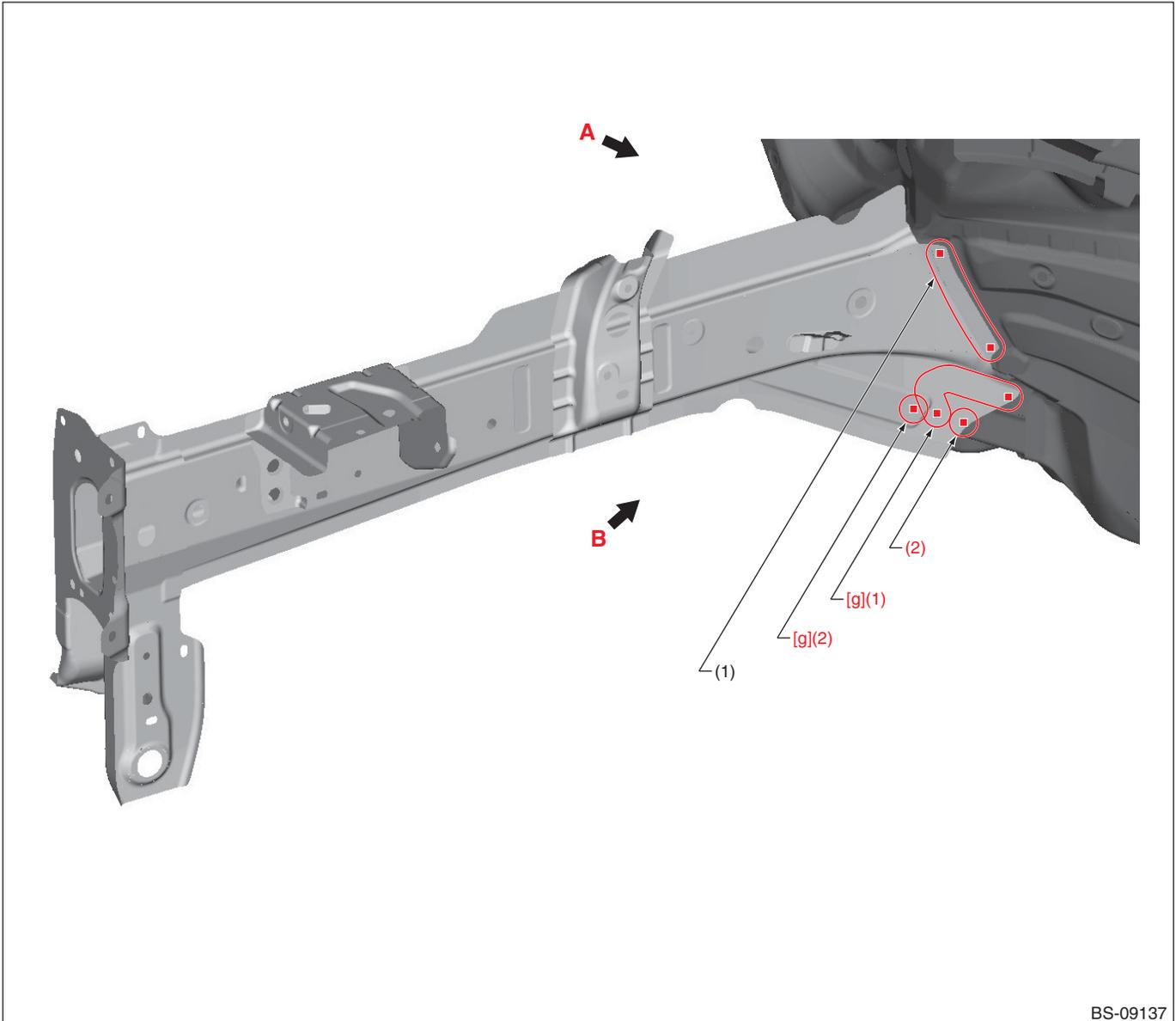
- (4) 2 points (inside · 1)
- (5) 1 point (inside · 2)
- (6) 3 points (bottom · 2)

- (7) 3 points (bottom · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09137

(1) 5 points (service)

(2) 1 point (service)

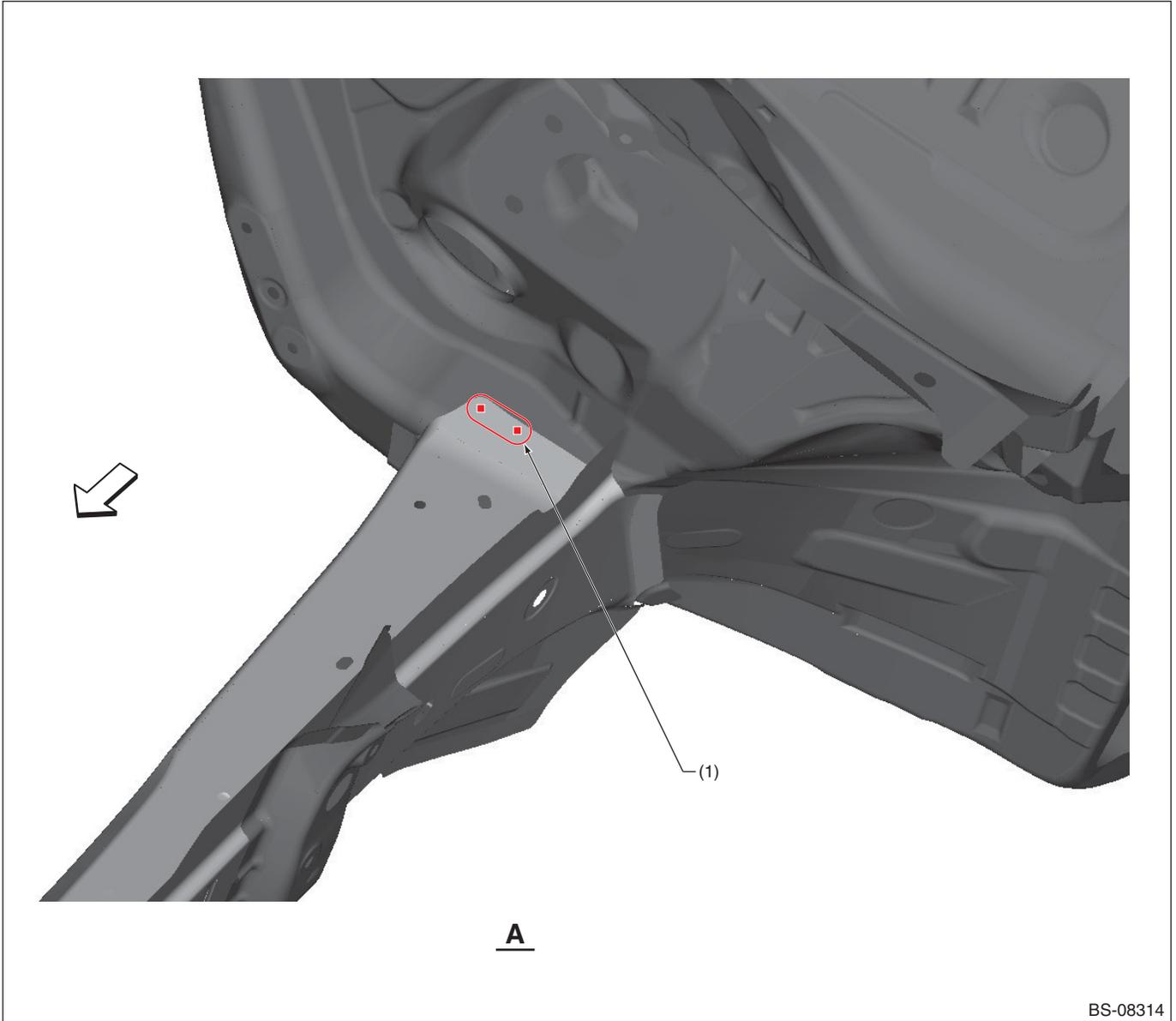
[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO<sub>2</sub>

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO<sub>2</sub>: 20 %)

# Panel Replacement

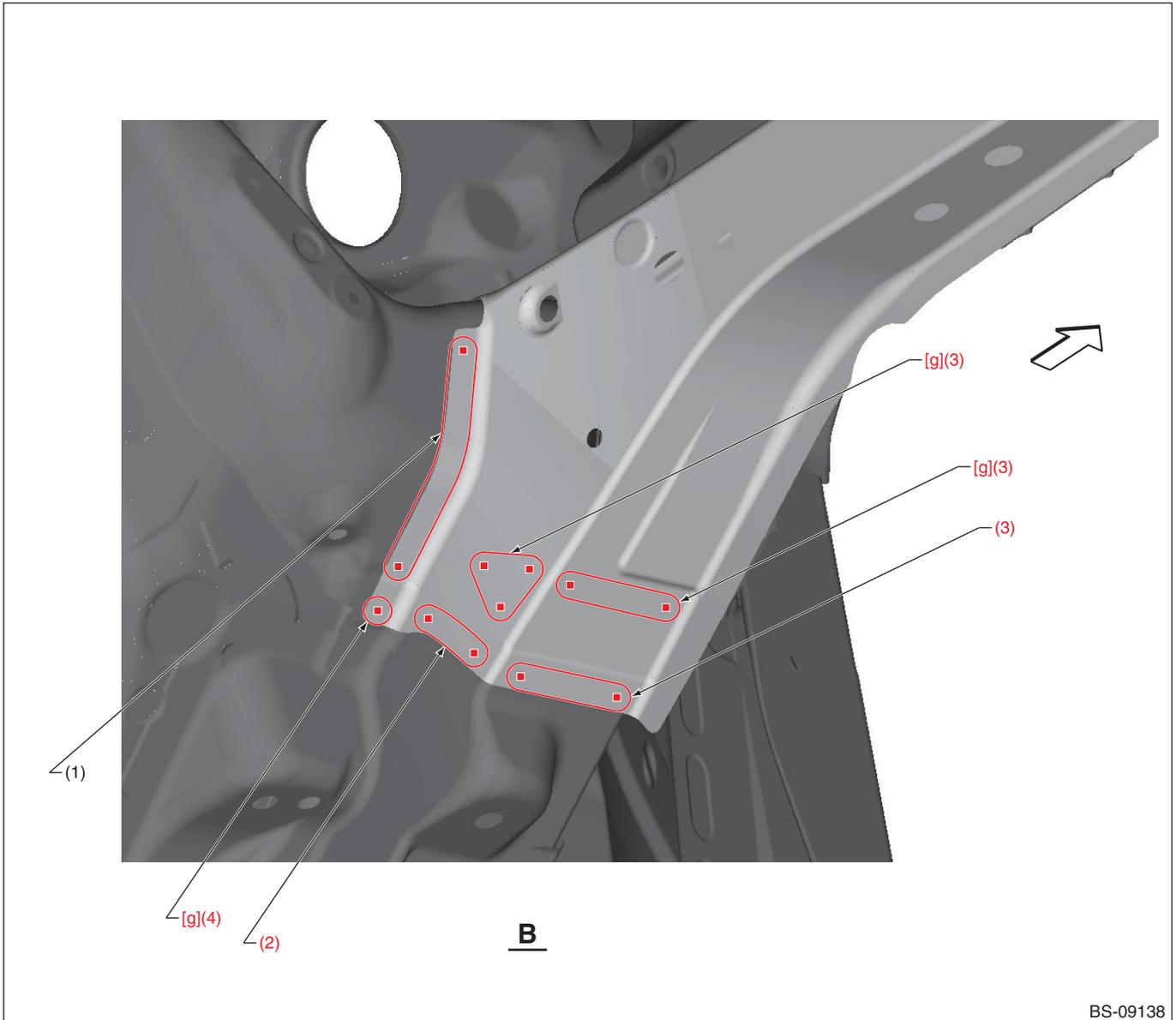
- Views A



(1) 2 points (service)

# Panel Replacement

## • Views B



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

(3) 3 points (service)

(4) 1 point (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO<sub>2</sub>

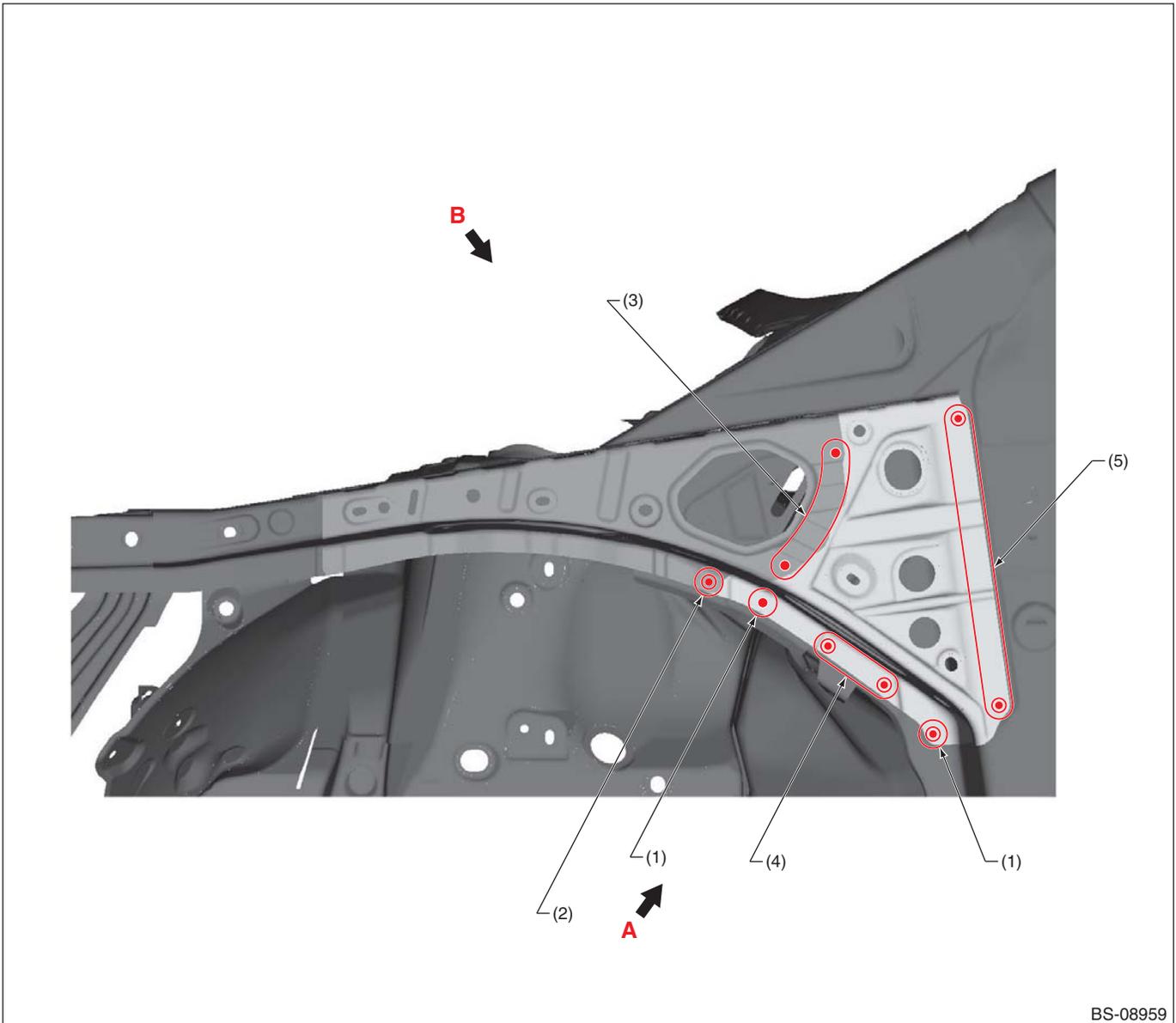
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO<sub>2</sub>: 20 %)

# Panel Replacement

## 8-12. Front Pillar Outer (partial replacement)

### A: REMOVAL

- Overall view1



BS-08959

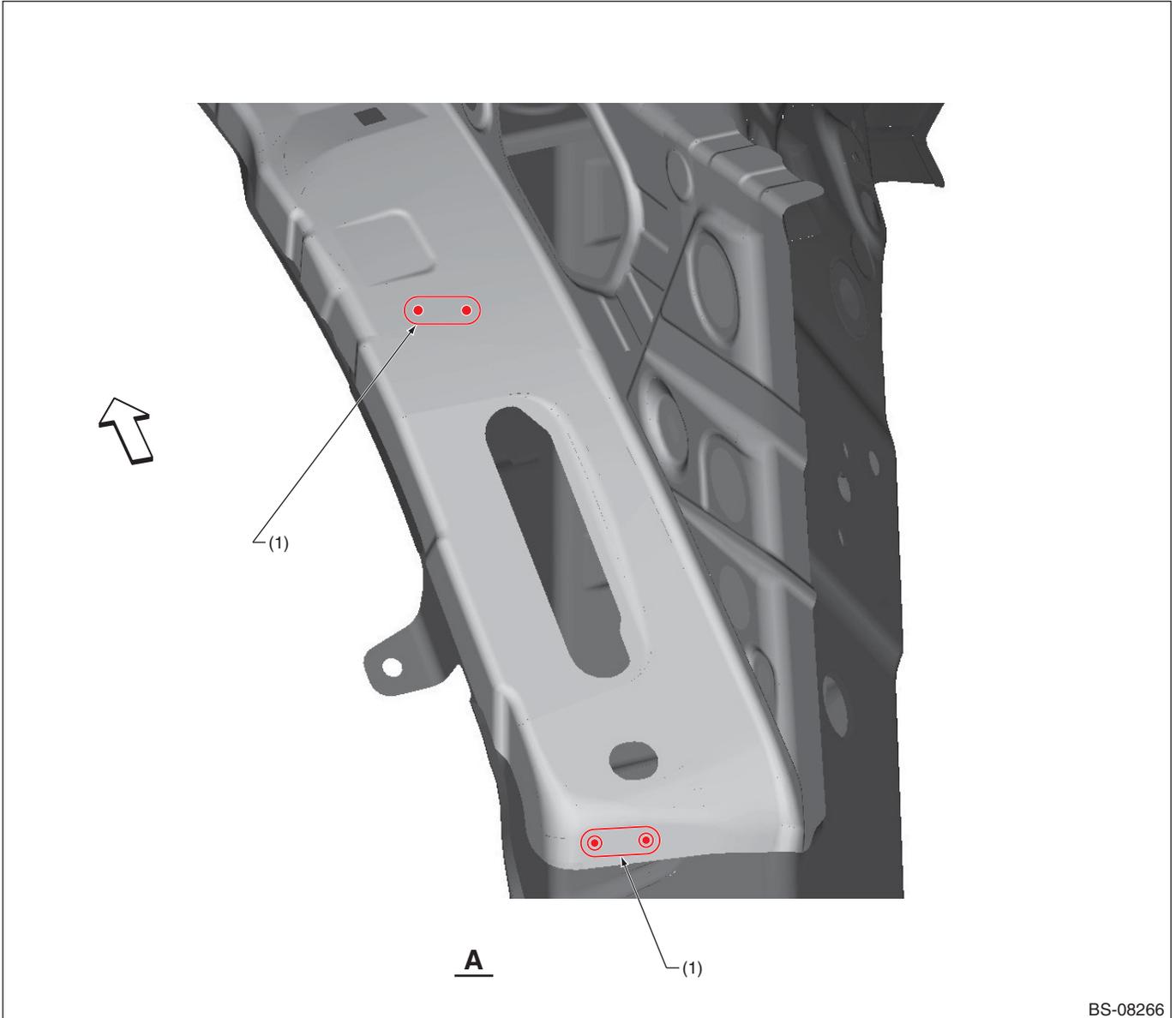
- (1) 1 point (outside · 1)
- (2) 1 point (outside · 2)

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

- (5) 5 points (outside · 1)

# Panel Replacement

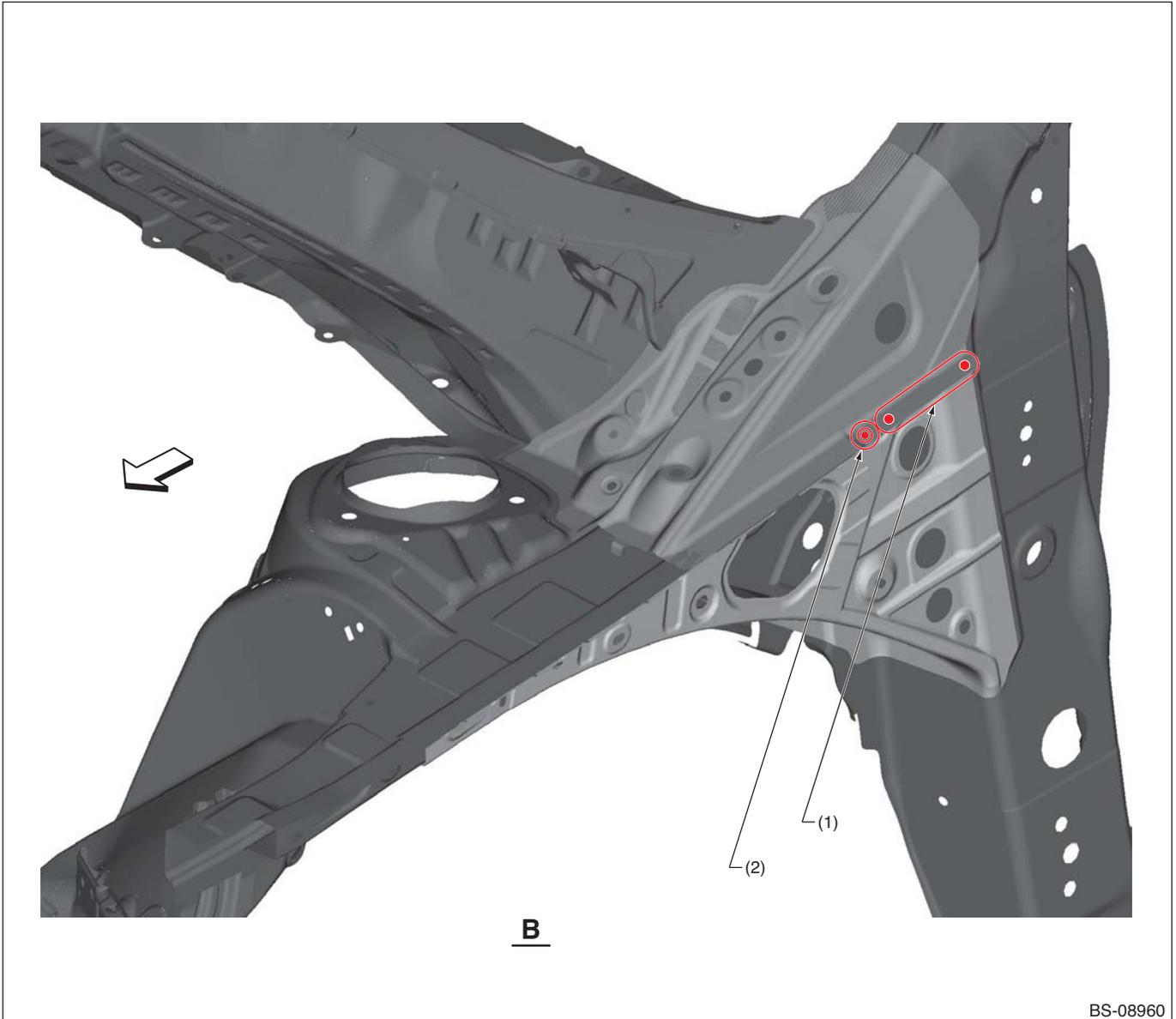
## • Views A



(1) 2 points (outside · 1)

# Panel Replacement

## • Views B

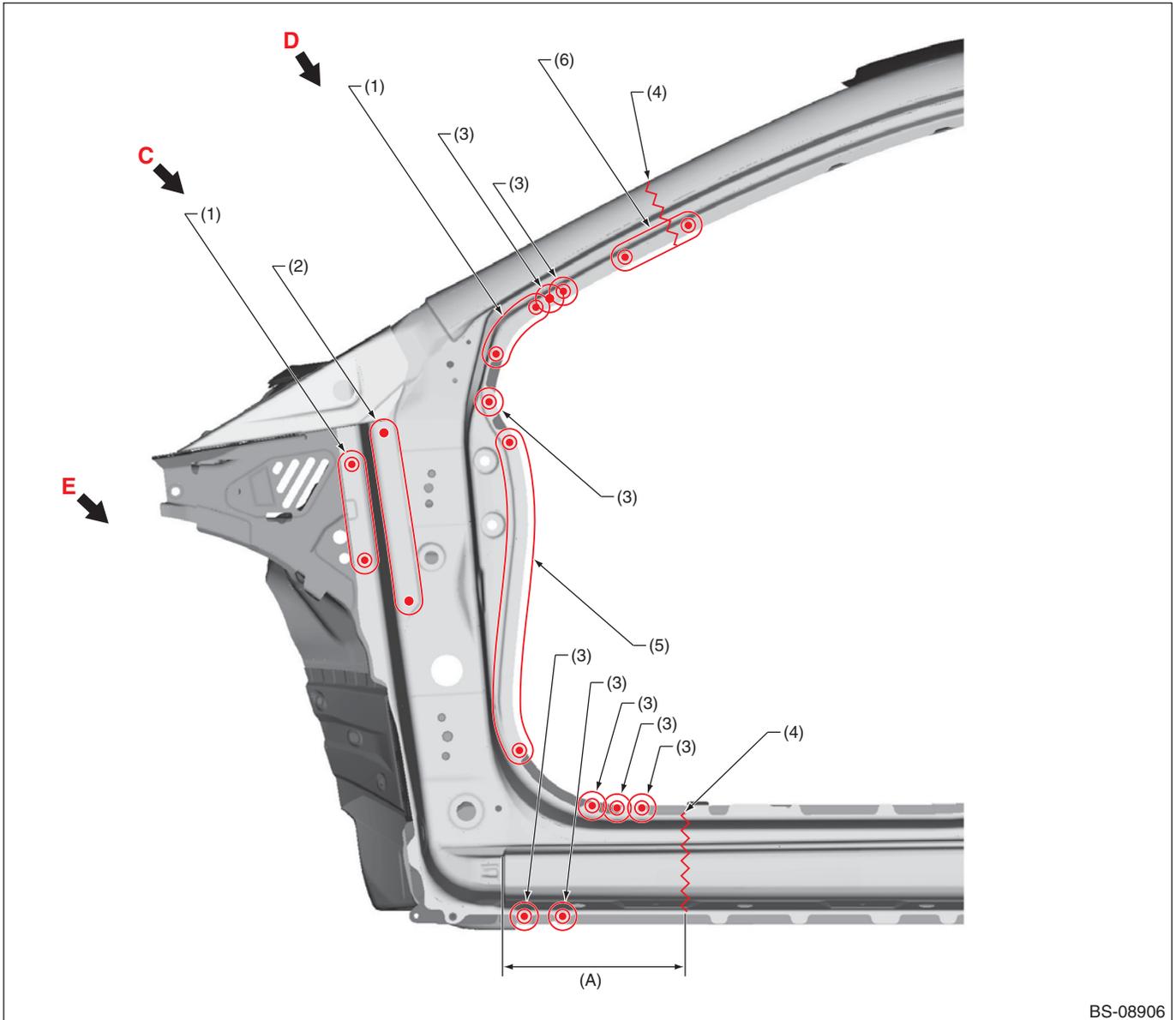


(1) 3 points (top · 1)

(2) 1 point (top · 2)

# Panel Replacement

## • Overall view2



BS-08906

(A) 260 mm [10.24 in]

(1) 3 points (outside · 1)

(2) 5 points (outside · 1)

(3) 1 point (outside · 1)

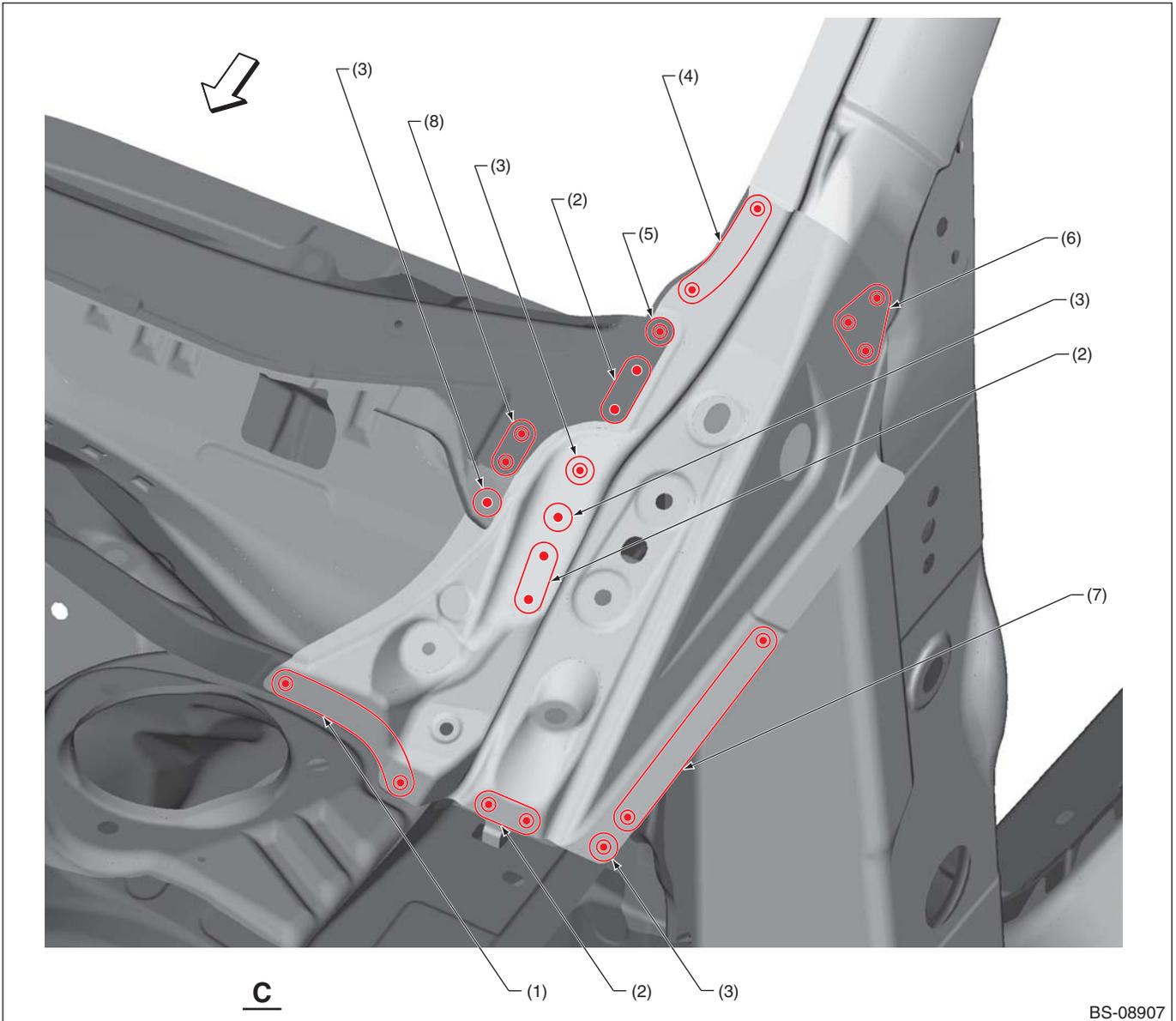
(4) Cut position

(5) 15 points (outside · 1)

(6) 4 points (outside · 1)

# Panel Replacement

## • Views C



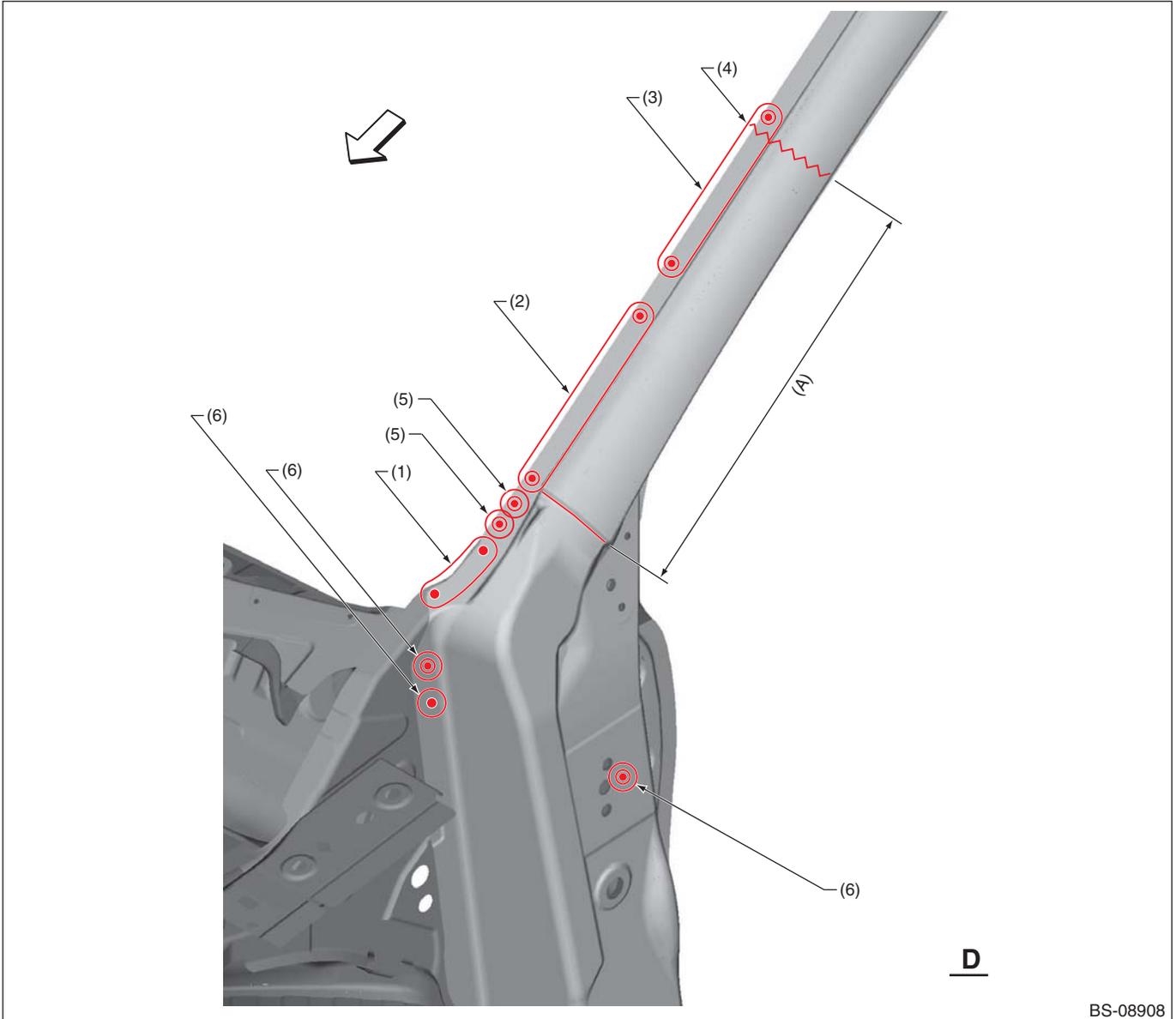
- (1) 4 points (top · 1)
- (2) 2 points (top · 1)
- (3) 1 point (top · 1)

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

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

# Panel Replacement

## • Views D



BS-08908

(A) 370 mm [14.57 in]

(1) 3 points (top · 1)

(2) 5 points (top · 1)

(3) 4 points (top · 1)

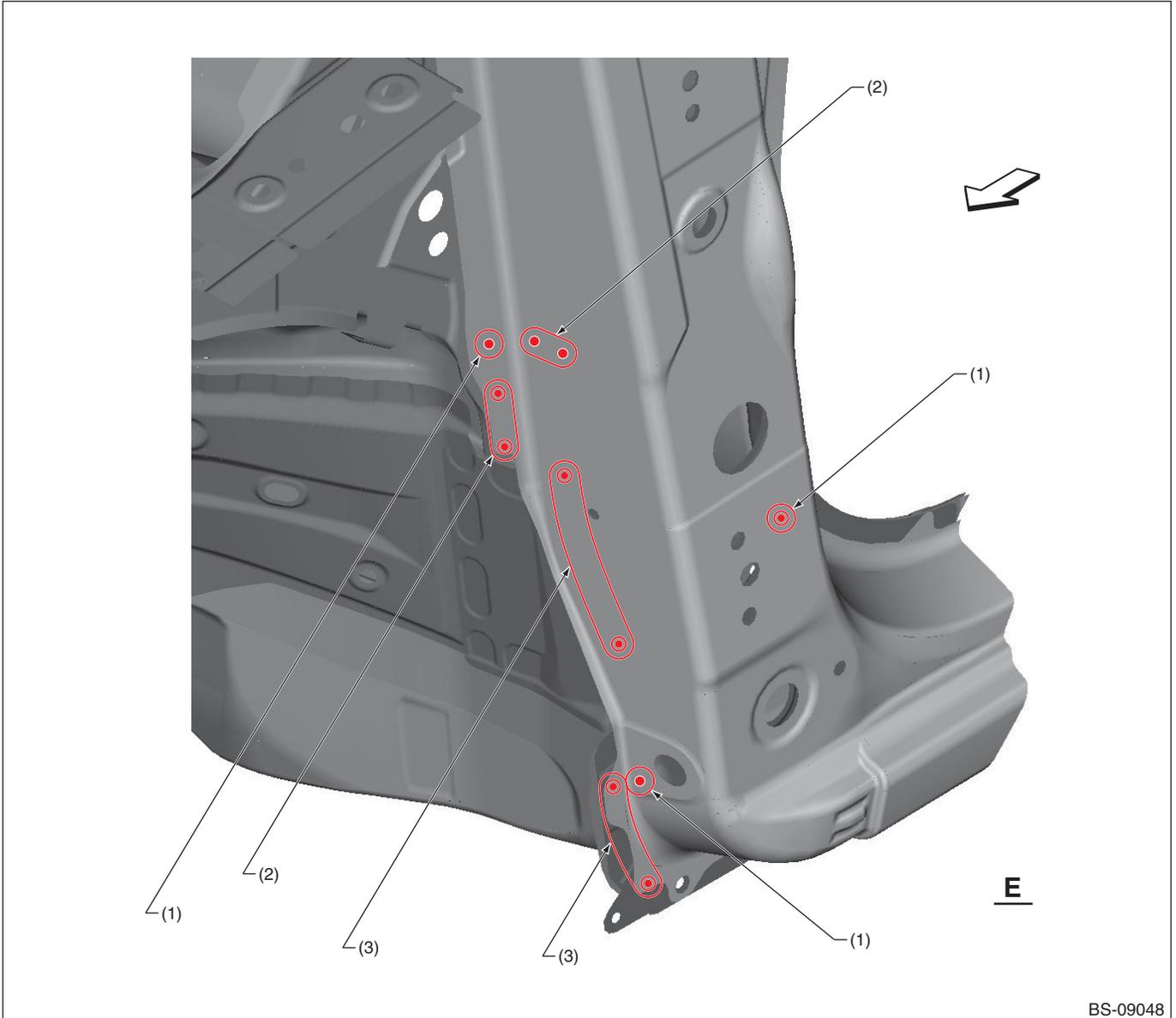
(4) Cut position

(5) 1 point (top · 1)

(6) 1 point (outside · 1)

# Panel Replacement

## • Views E



(1) 1 point (outside · 1)

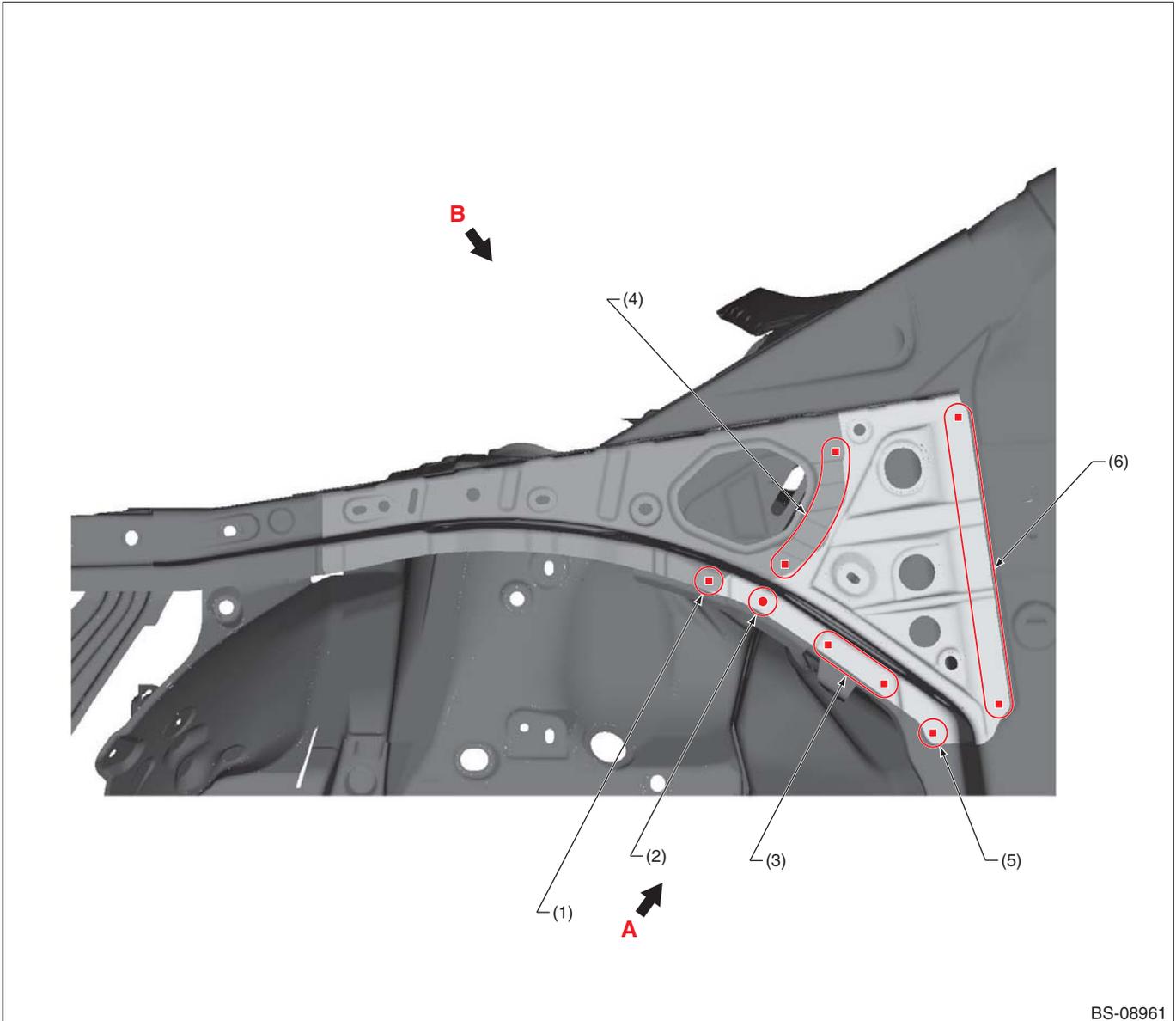
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view1



BS-08961

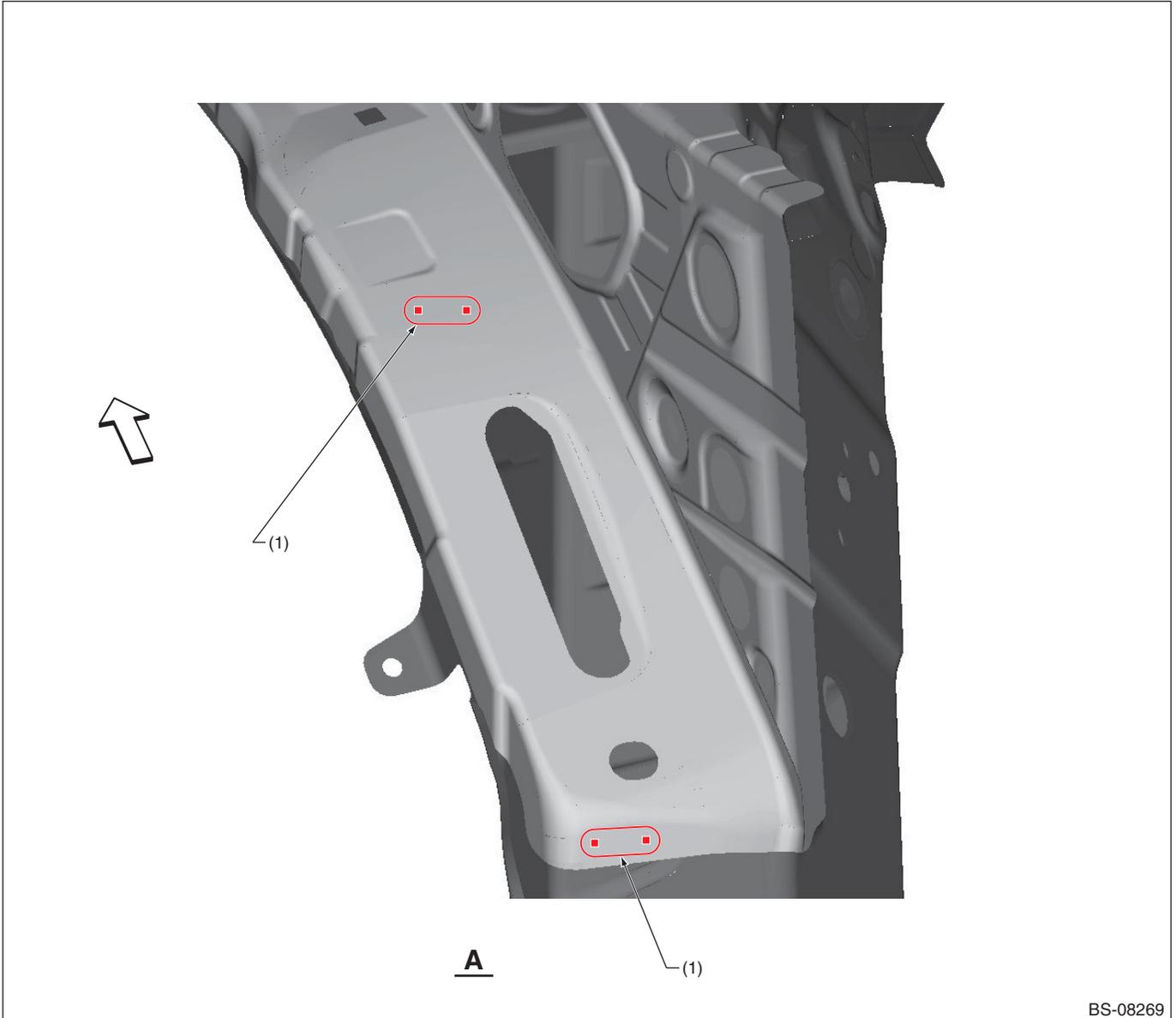
(1) 1 point (service · matching)  
(2) 1 point

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

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

# Panel Replacement

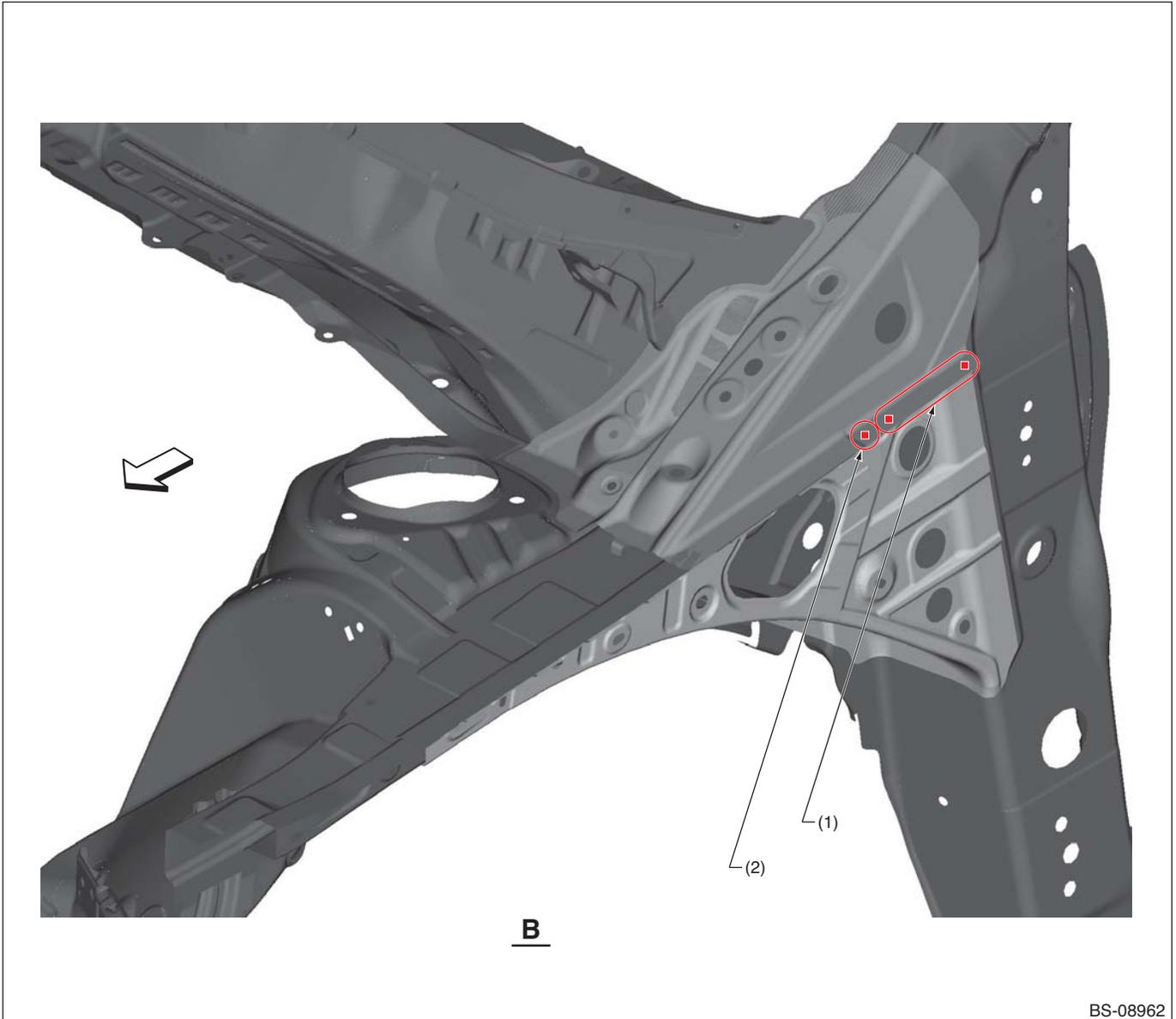
## • Views A



(1) 2 points (service)

# Panel Replacement

## • Views B

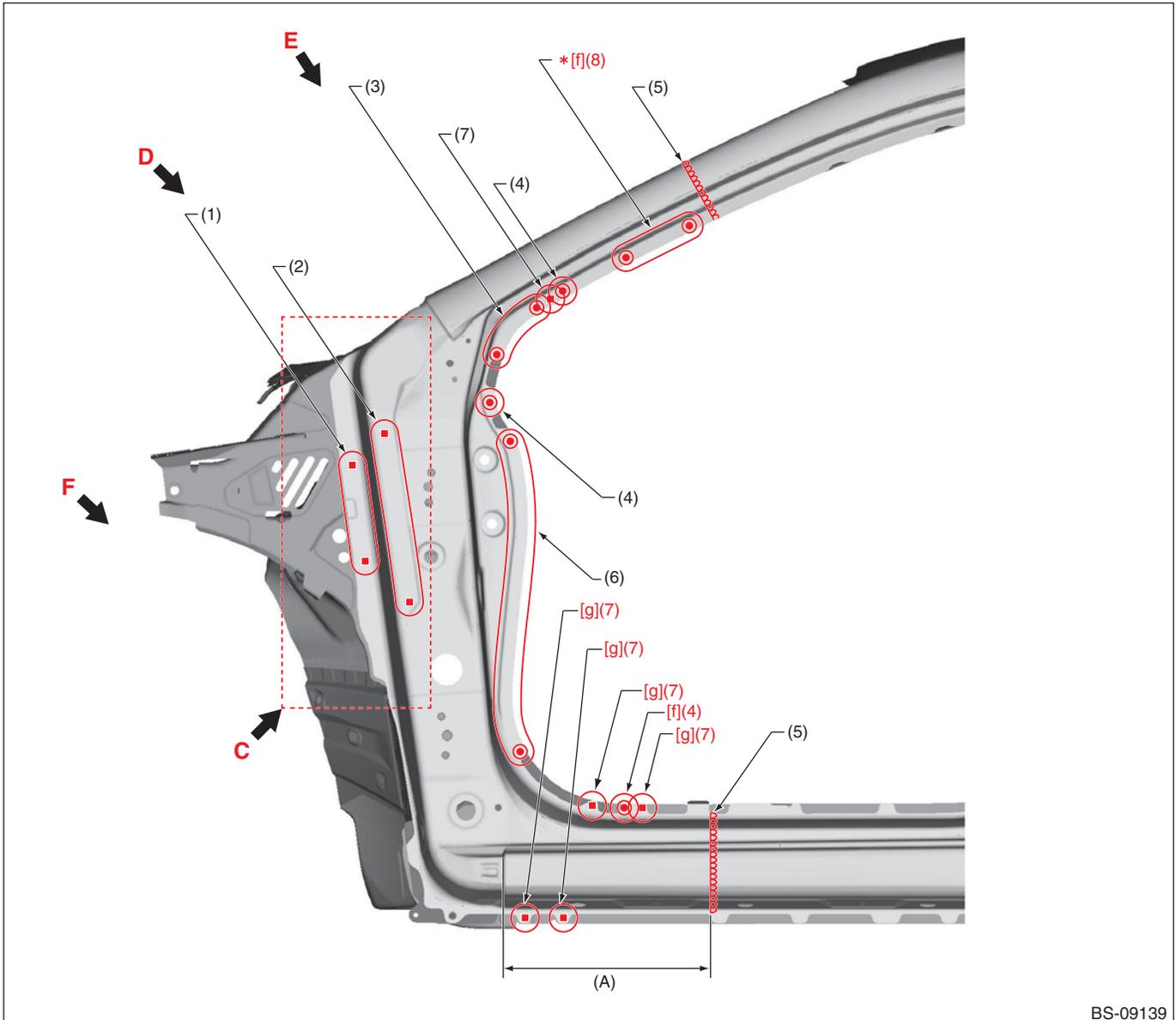


(1) 3 points

(2) 1 point

# Panel Replacement

## • Overall view2



(A) 290 mm [11.42 in]

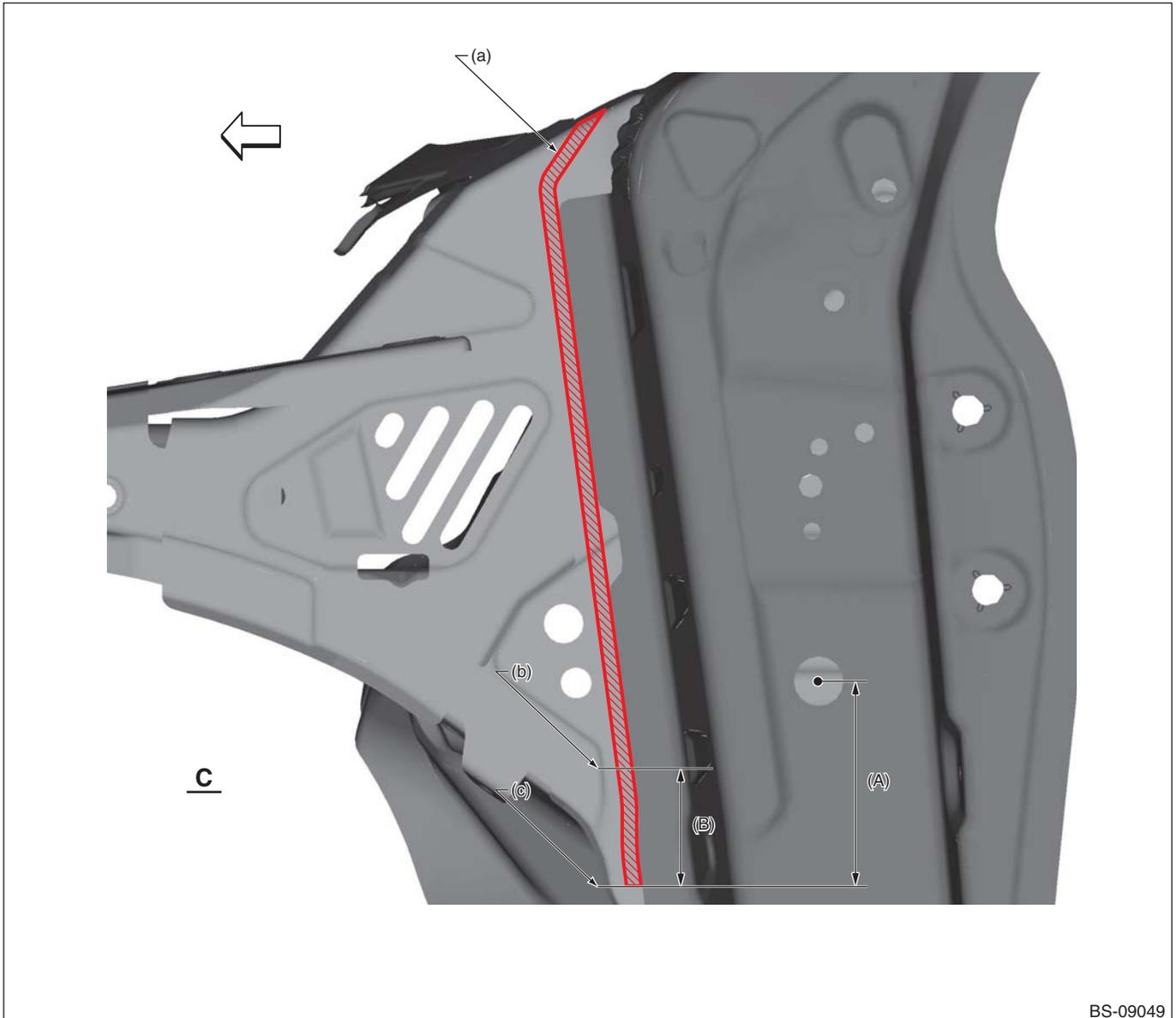
- |                        |                                  |                       |
|------------------------|----------------------------------|-----------------------|
| (1) 3 points (service) | (4) 1 point                      | (7) 1 point (service) |
| (2) 5 points (service) | (5) 1 point (Continuous welding) | (8) 4 points          |
| (3) 3 points           | (6) 15 points                    |                       |

\* : Only the LH side has welding conditions.

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

# Panel Replacement

## • Views C



BS-09049

(A) 104 mm [4.09 in]

(B) 55 mm [2.17 in]

(a) A point

(b) B point

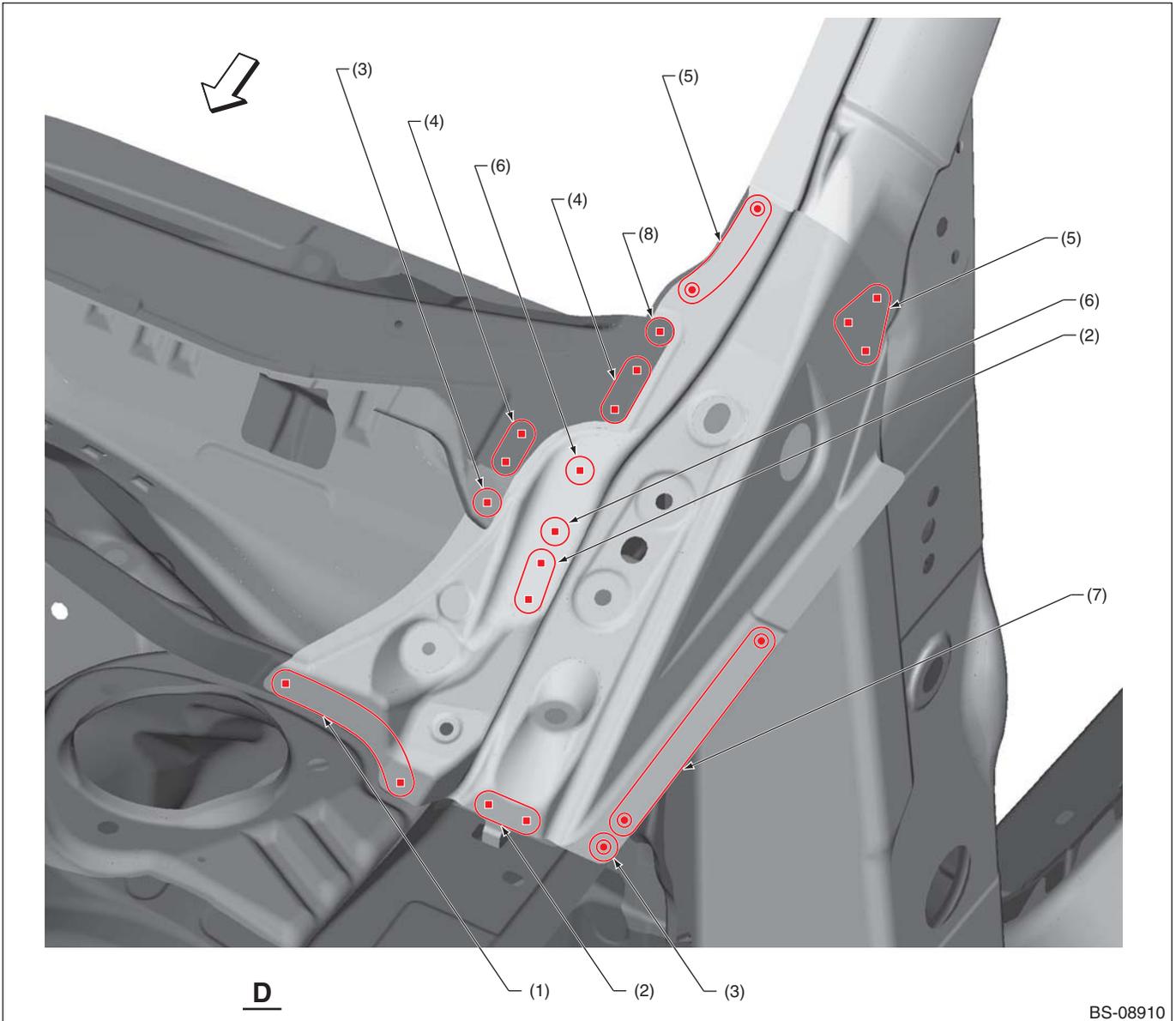
(c) C point

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

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

# Panel Replacement

## • Views D



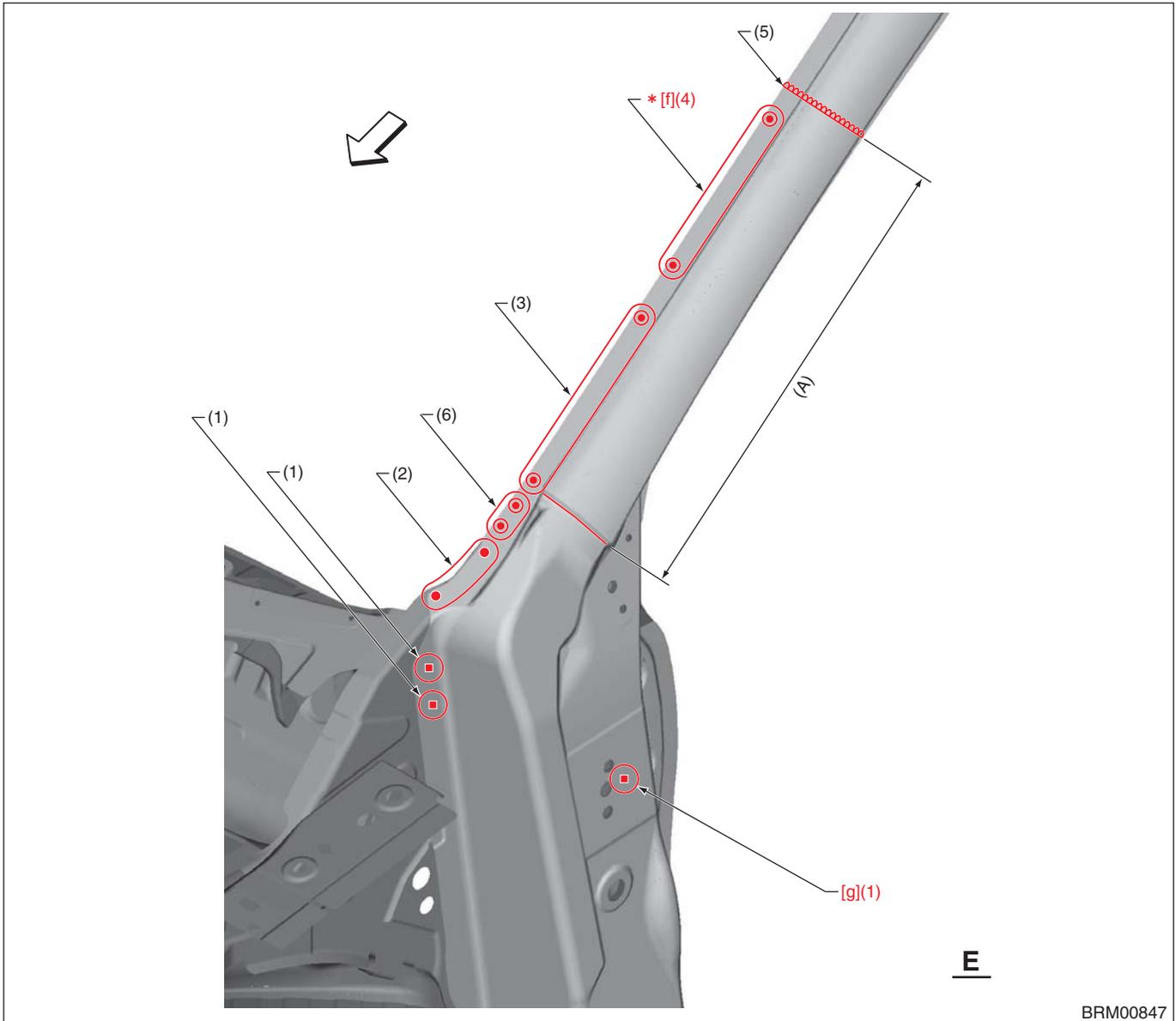
- (1) 4 points (service)
- (2) 2 points (service)
- (3) 1 point

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

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

# Panel Replacement

## • Views E



BRM00847

(A) 400 mm [15.75 in]

(1) 1 point (service)

(3) 5 points

(5) 1 point (Continuous welding)

(2) 3 points

(4) 4 points

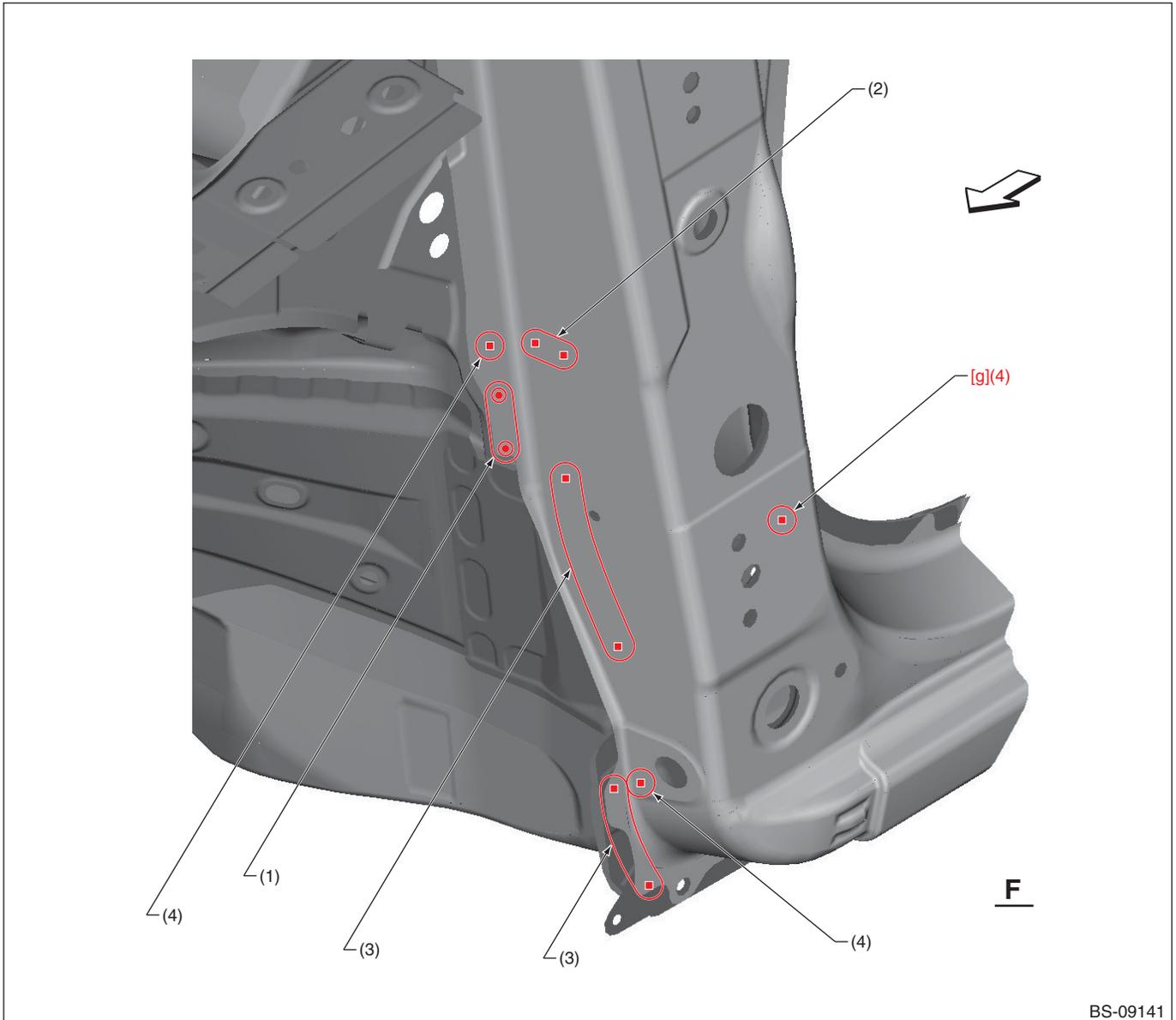
(6) 2 points

\* : Only the LH side has welding conditions.

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

# Panel Replacement

## • Views F



(1) 2 points

(2) 2 points (service)

(3) 3 points (service)

(4) 1 point (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO<sub>2</sub>

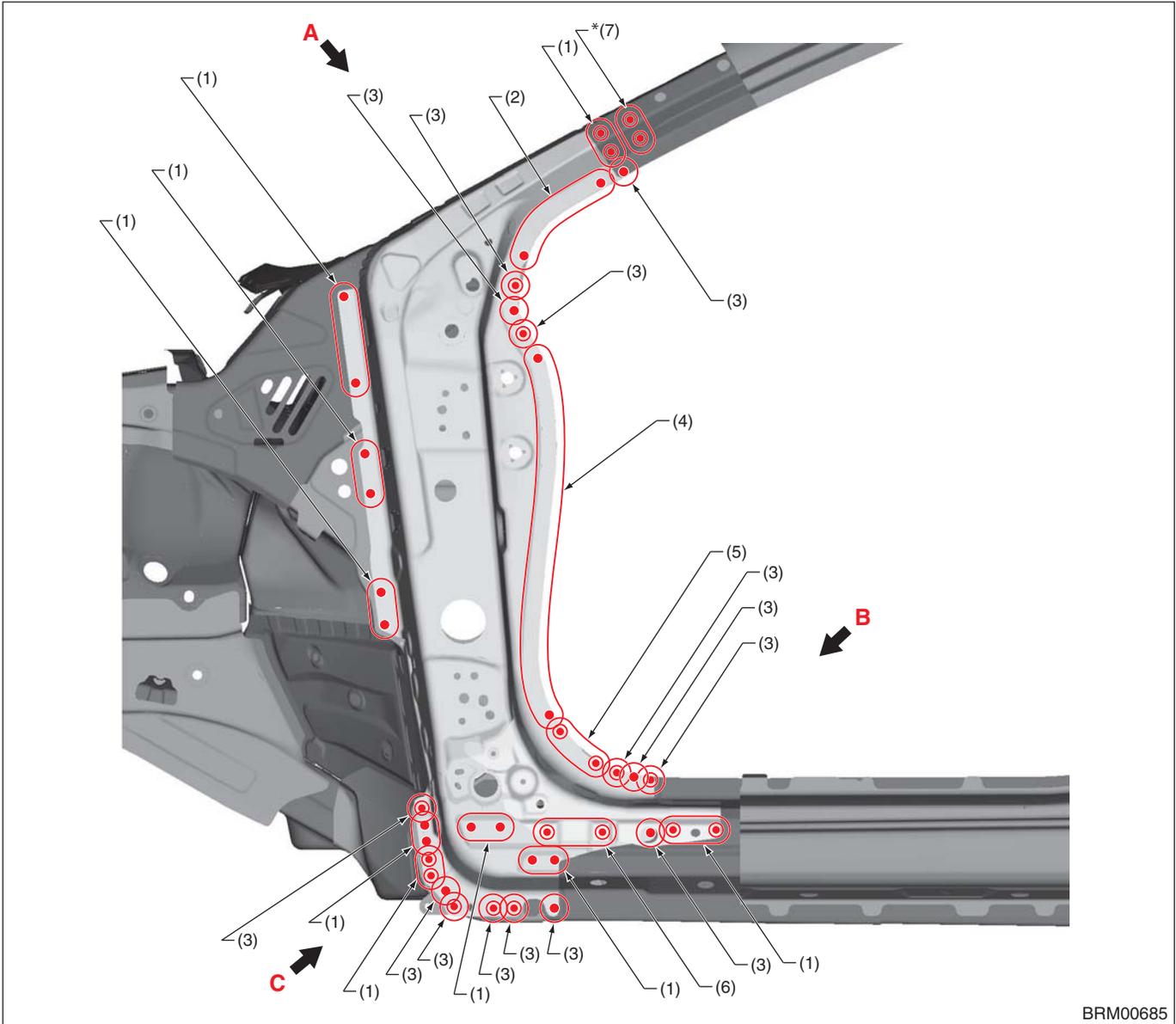
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO<sub>2</sub>: 20 %)

# Panel Replacement

## 8-13. Front Pillar Reinforcement (total replacement)

### A: REMOVAL

• Overall view (Gasoline model)



BRM00685

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

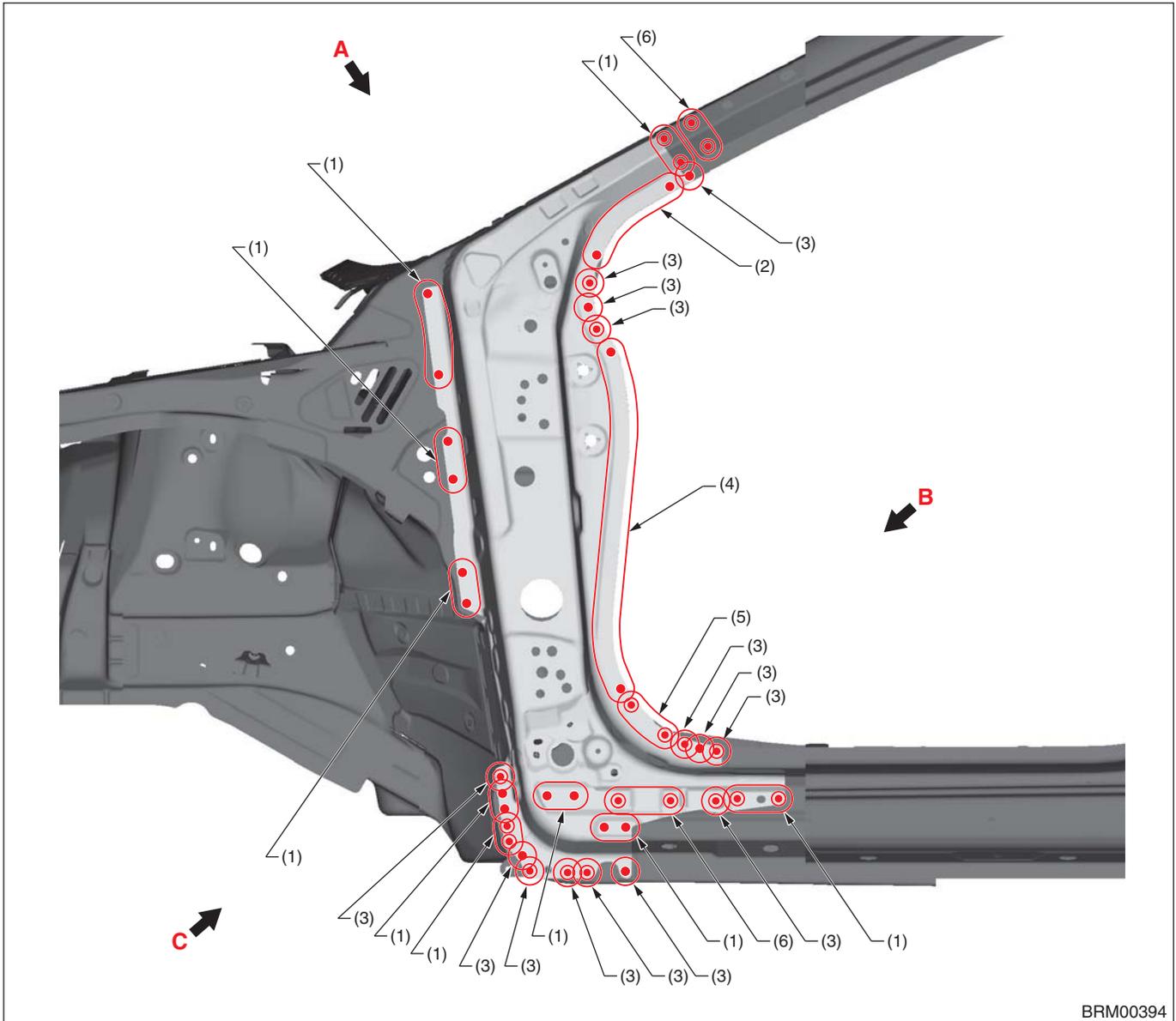
- (4) 15 points (outside · 1)
- (5) 3 points (outside · 1)
- (6) 2 points (outside · 2)

- (7) RH: 2 points (outside · 1)
- LH: 2 points (outside · 2)

\* : RH Two overlapping parts  
LH Three overlapping parts

# Panel Replacement

## • Overall view (Hybrid model)



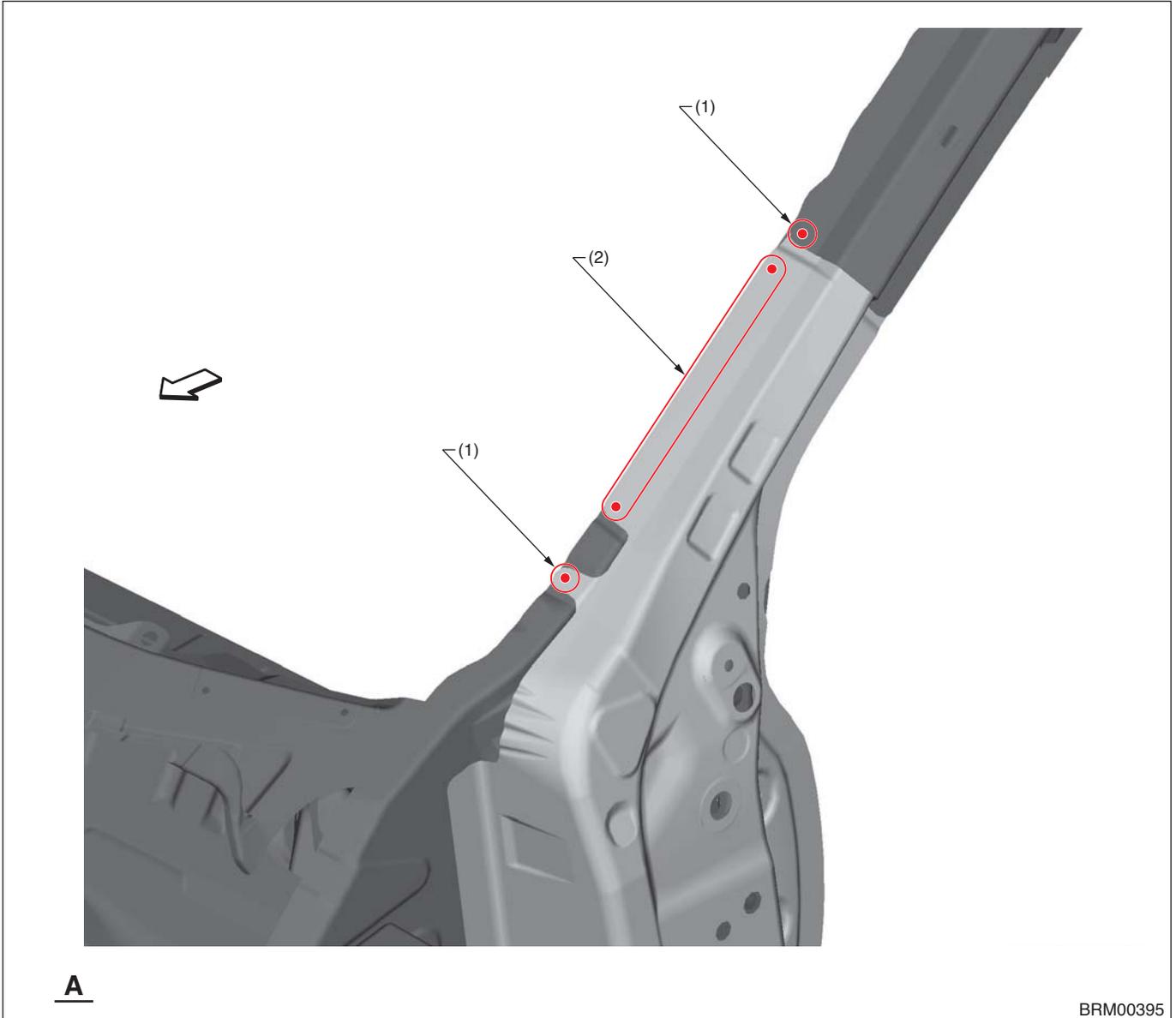
(1) 2 points (outside · 1)  
 (2) 4 points (outside · 1)

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

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

# Panel Replacement

## • Views A

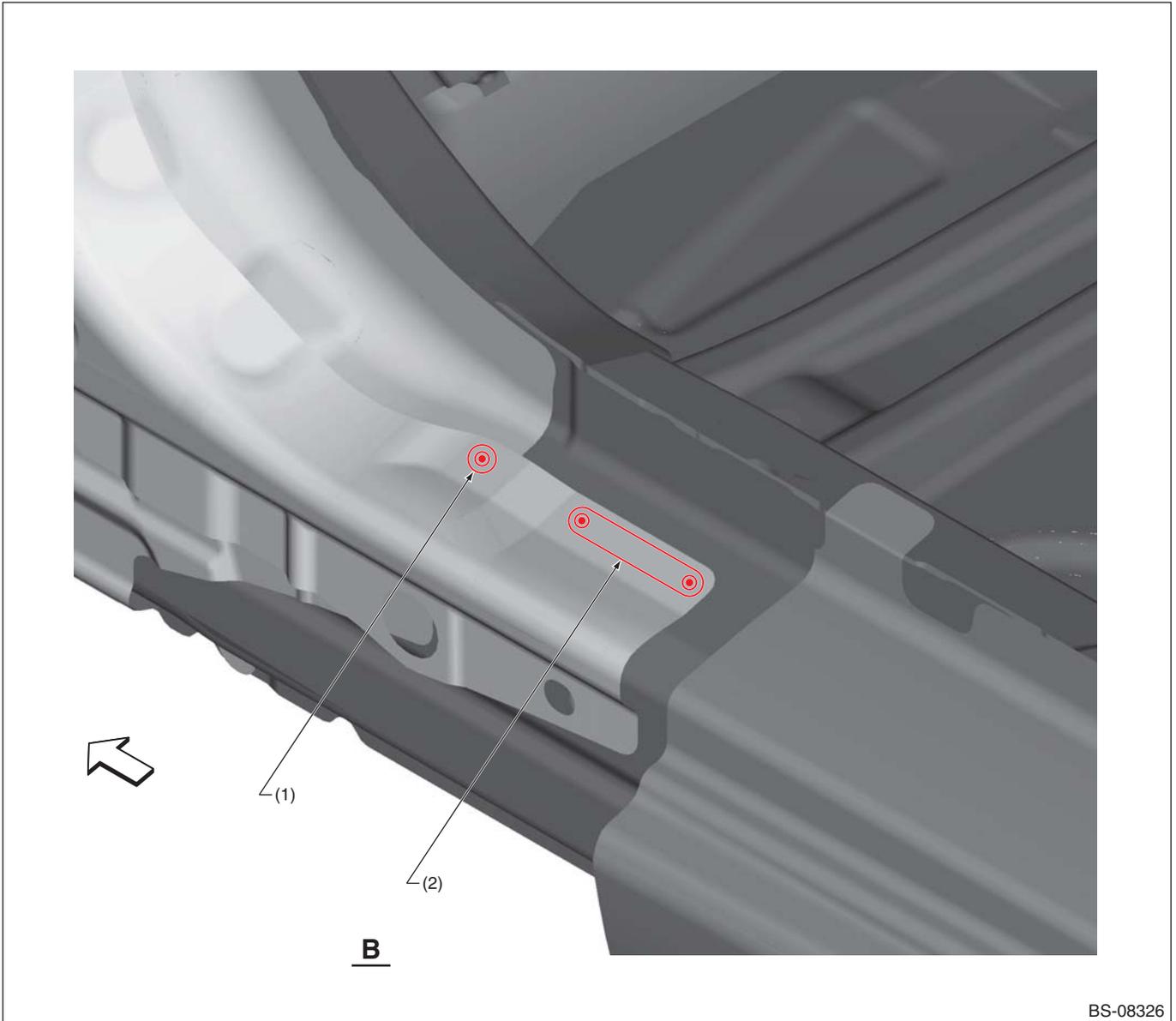


(1) 1 point (outside · 1)

(2) 5 points (top · 1)

# Panel Replacement

## • Views B

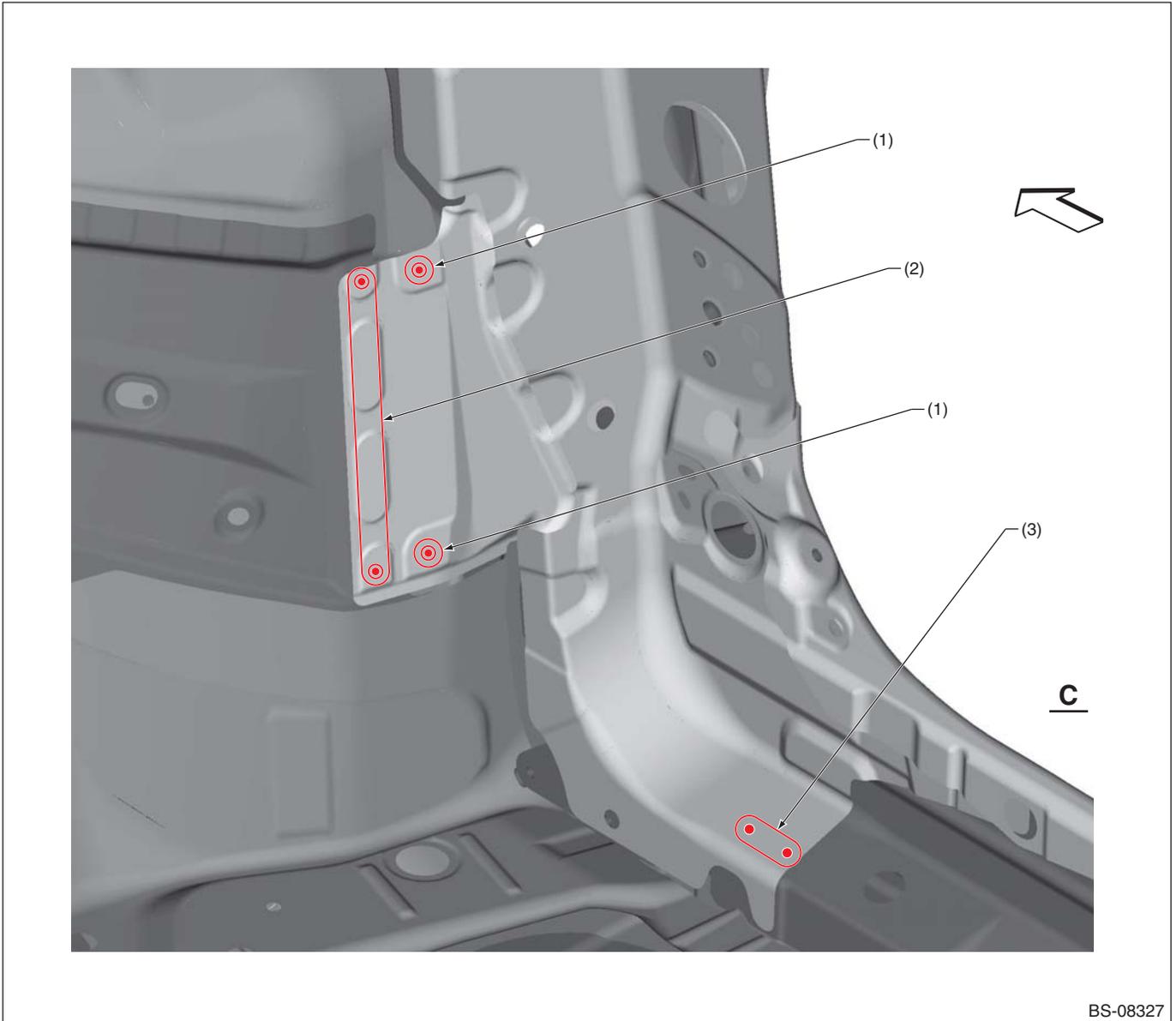


(1) 1 point (top · 2)

(2) 2 points (top · 1)

# Panel Replacement

## • Views C



(1) 1 point (outside · 1)

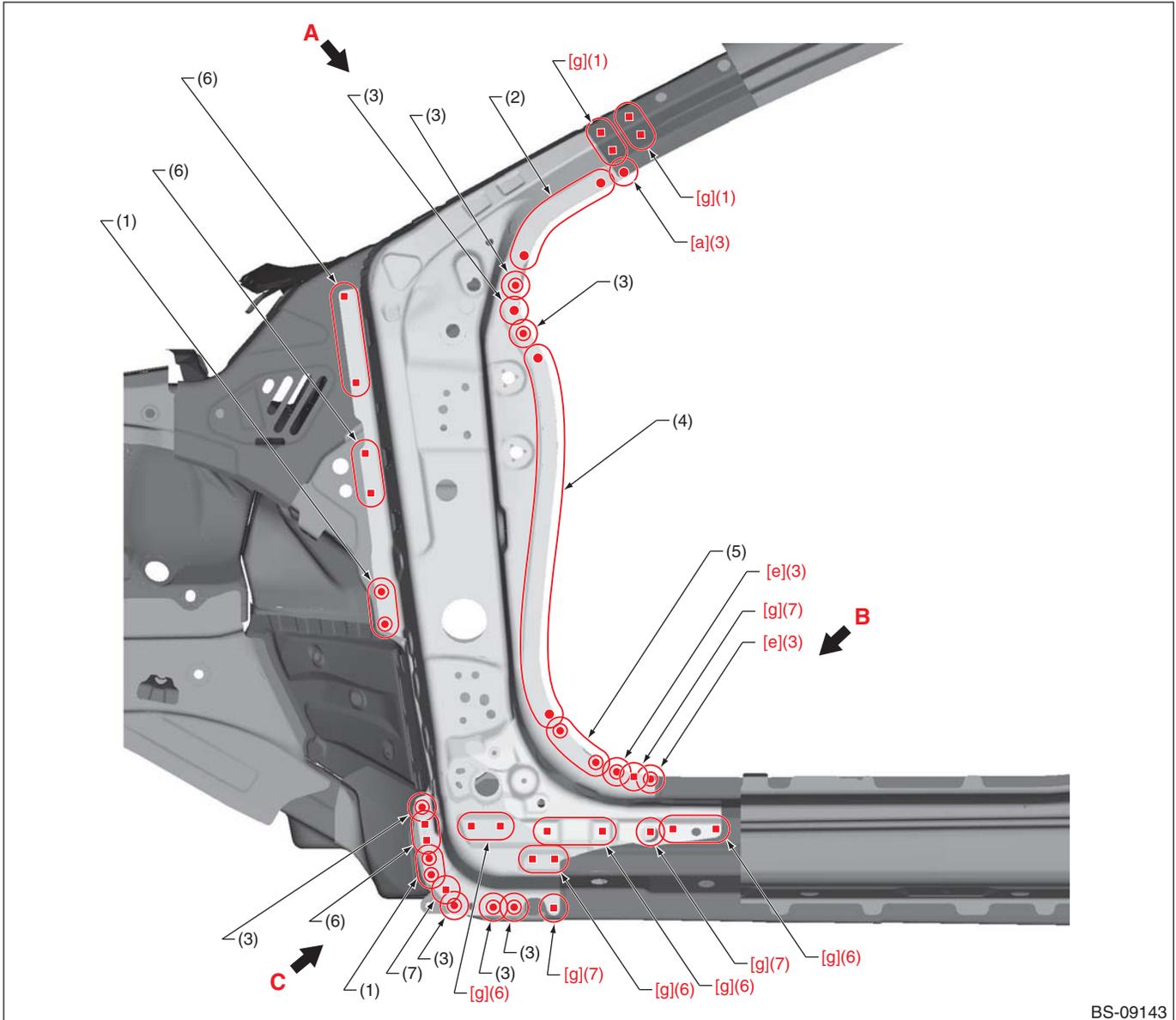
(2) 6 points (outside · 1)

(3) 2 points (bottom · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09143

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

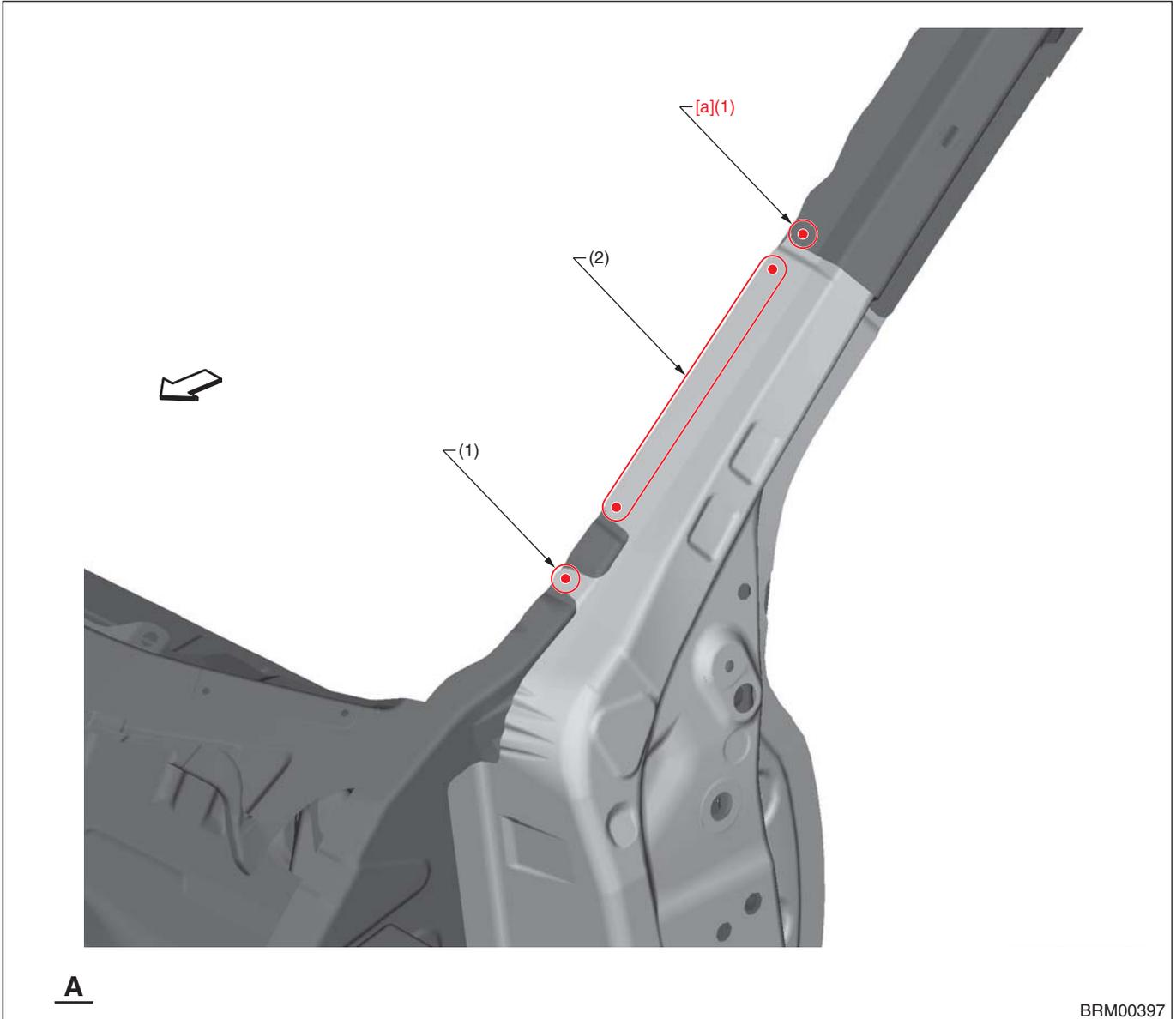
- (4) 15 points
- (5) 3 points
- (6) 2 points (service)

- (7) 1 point (service)

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

# Panel Replacement

## • Views A



(1) 1 point

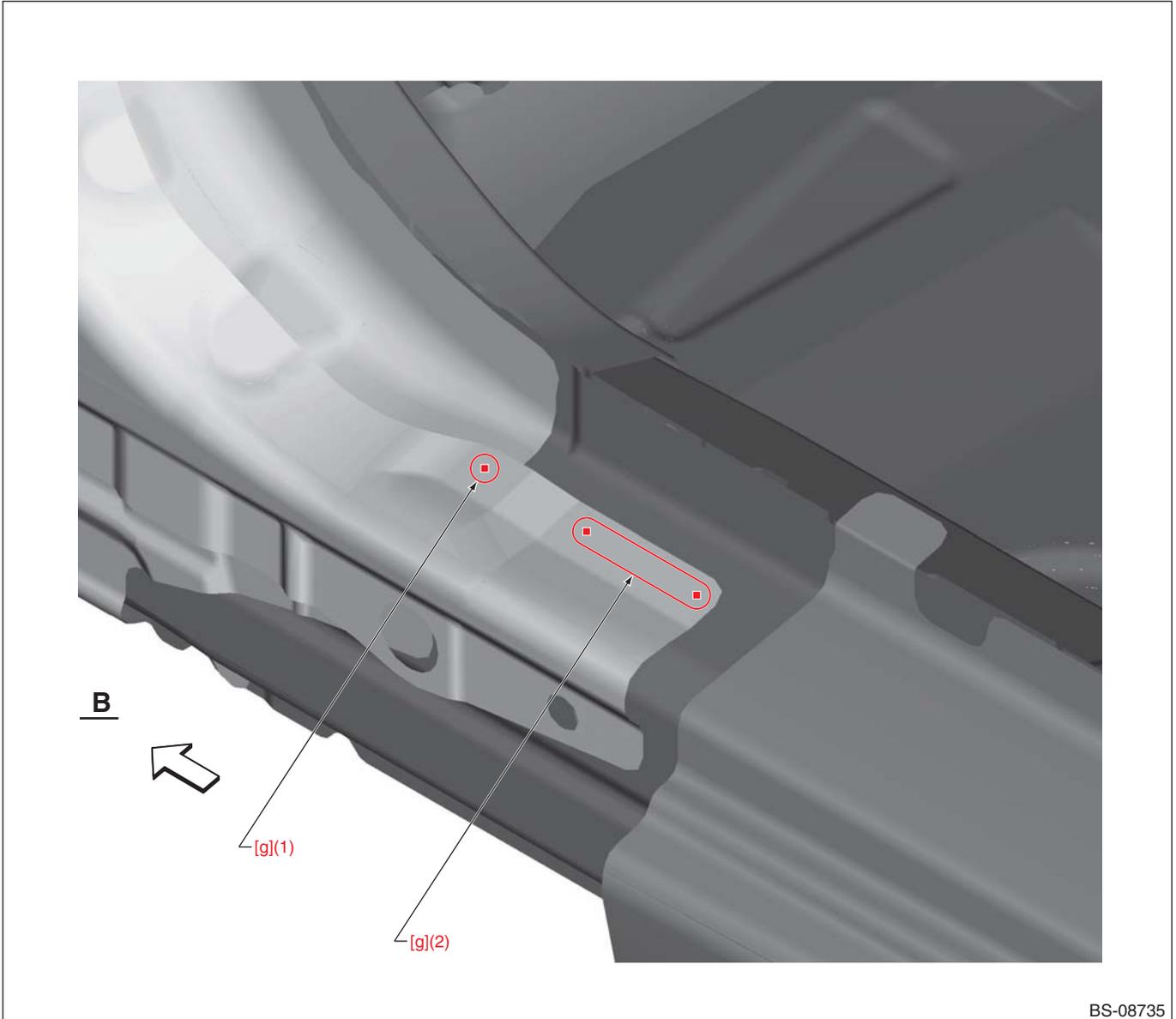
(2) 5 points

[a] Spot welding

Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc

# Panel Replacement

## • Views B



BS-08735

(1) 1 point (service)

(2) 2 points (service)

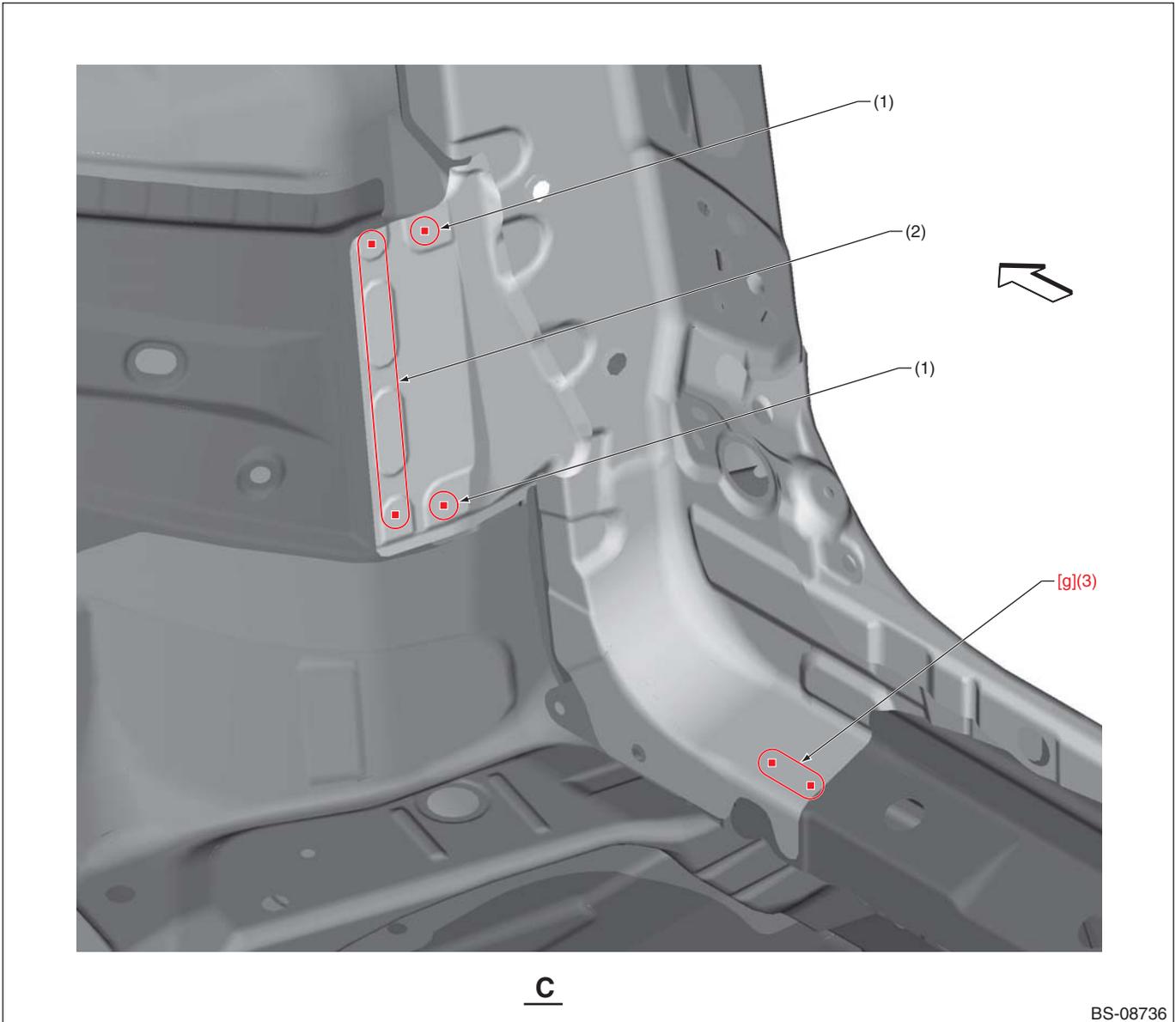
[g] Plug welding

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

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

# Panel Replacement

## • Views C



(1) 1 point (service)

(2) 6 points (service)

(3) 2 points (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO<sub>2</sub>

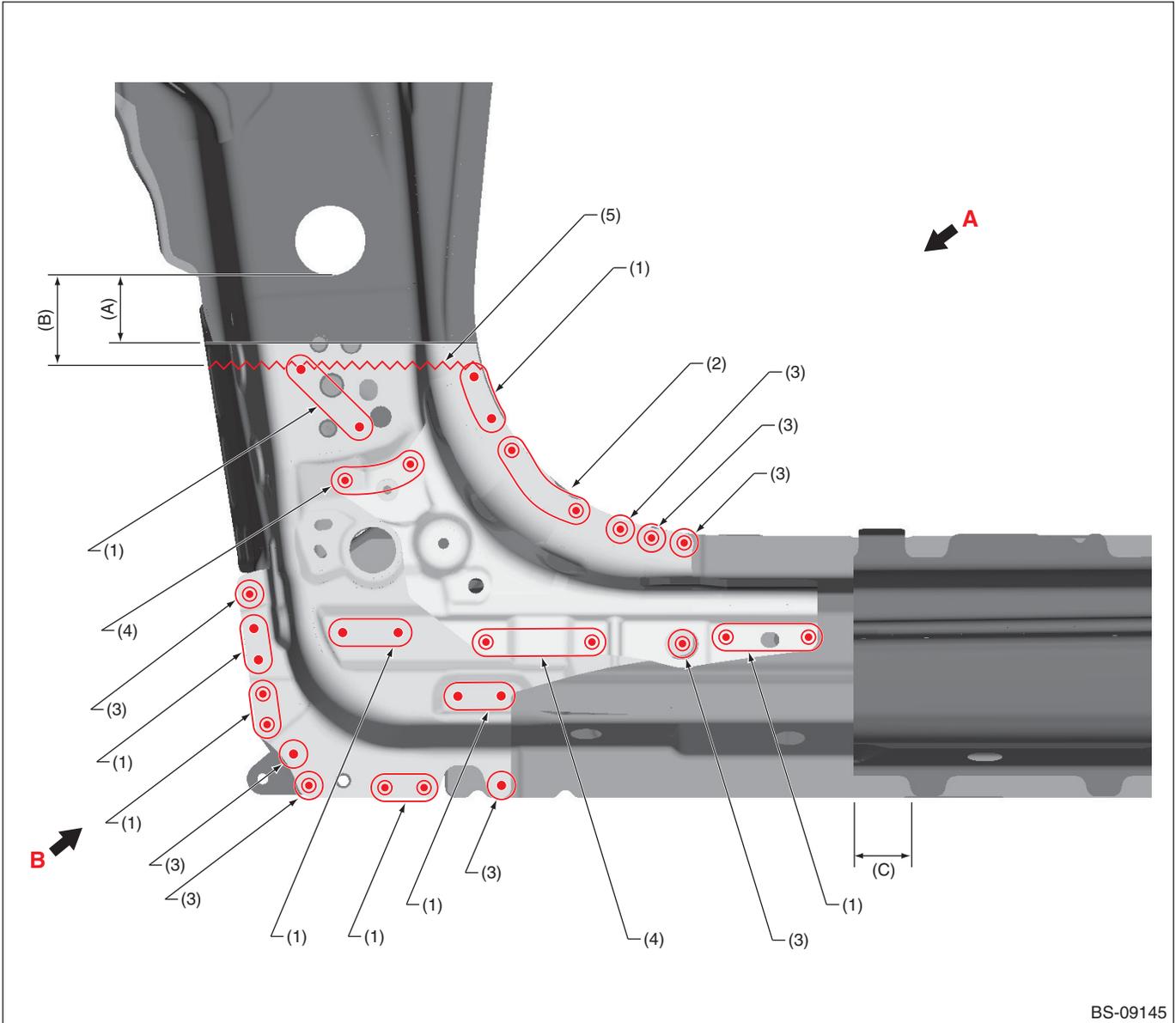
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO<sub>2</sub>: 20 %)

# Panel Replacement

## 8-14. Front Pillar Reinforcement (partial replacement)

### A: REMOVAL

#### • Overall view



(A) 40 mm [1.57 in]

(B) 60 mm [2.36 in]

(C) 35 mm [1.38 in]

(1) 2 points (outside · 1)

(3) 1 point (outside · 1)

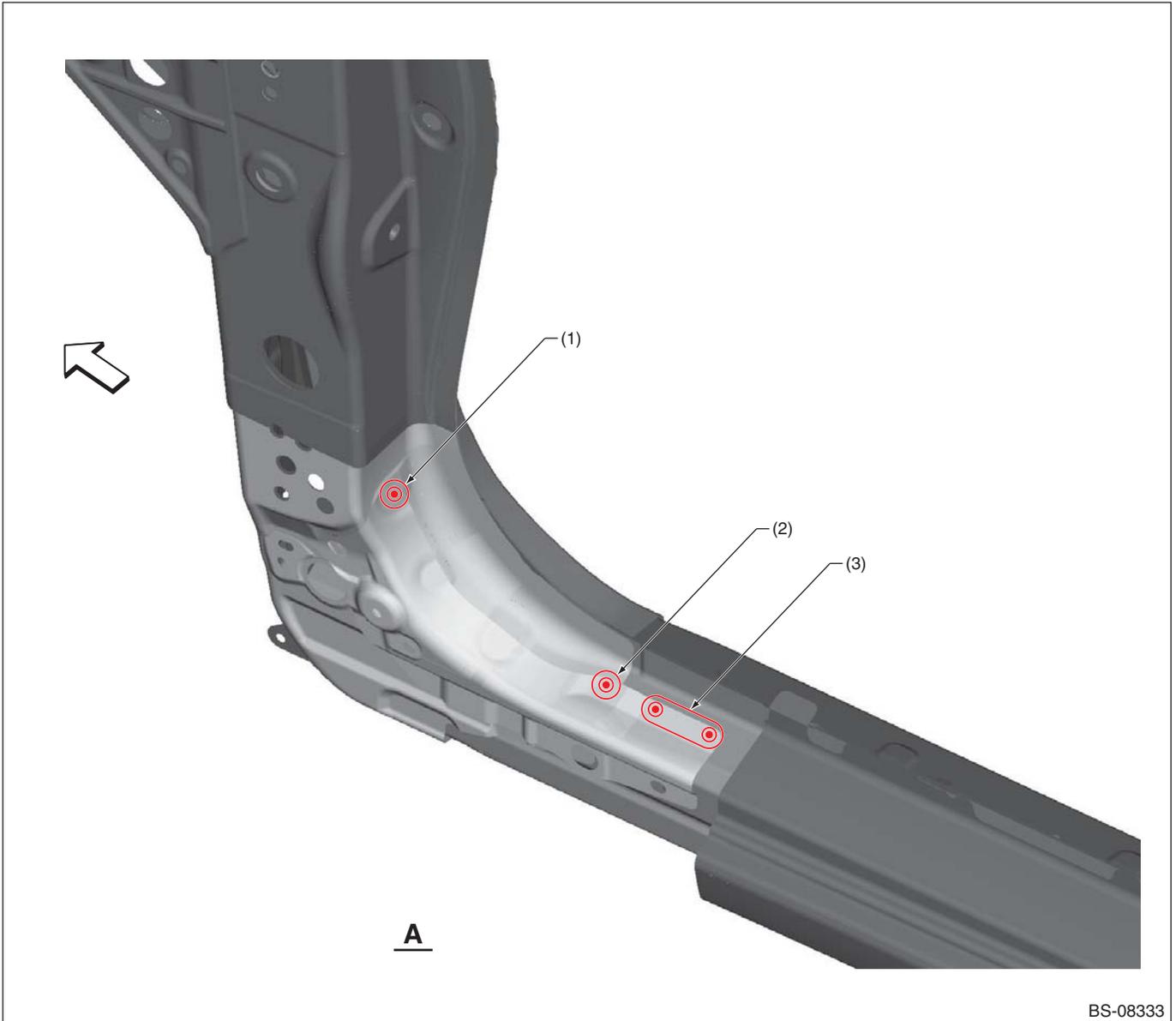
(5) Cut position

(2) 3 points (outside · 1)

(4) 2 points (outside · 2)

# Panel Replacement

## • Views A



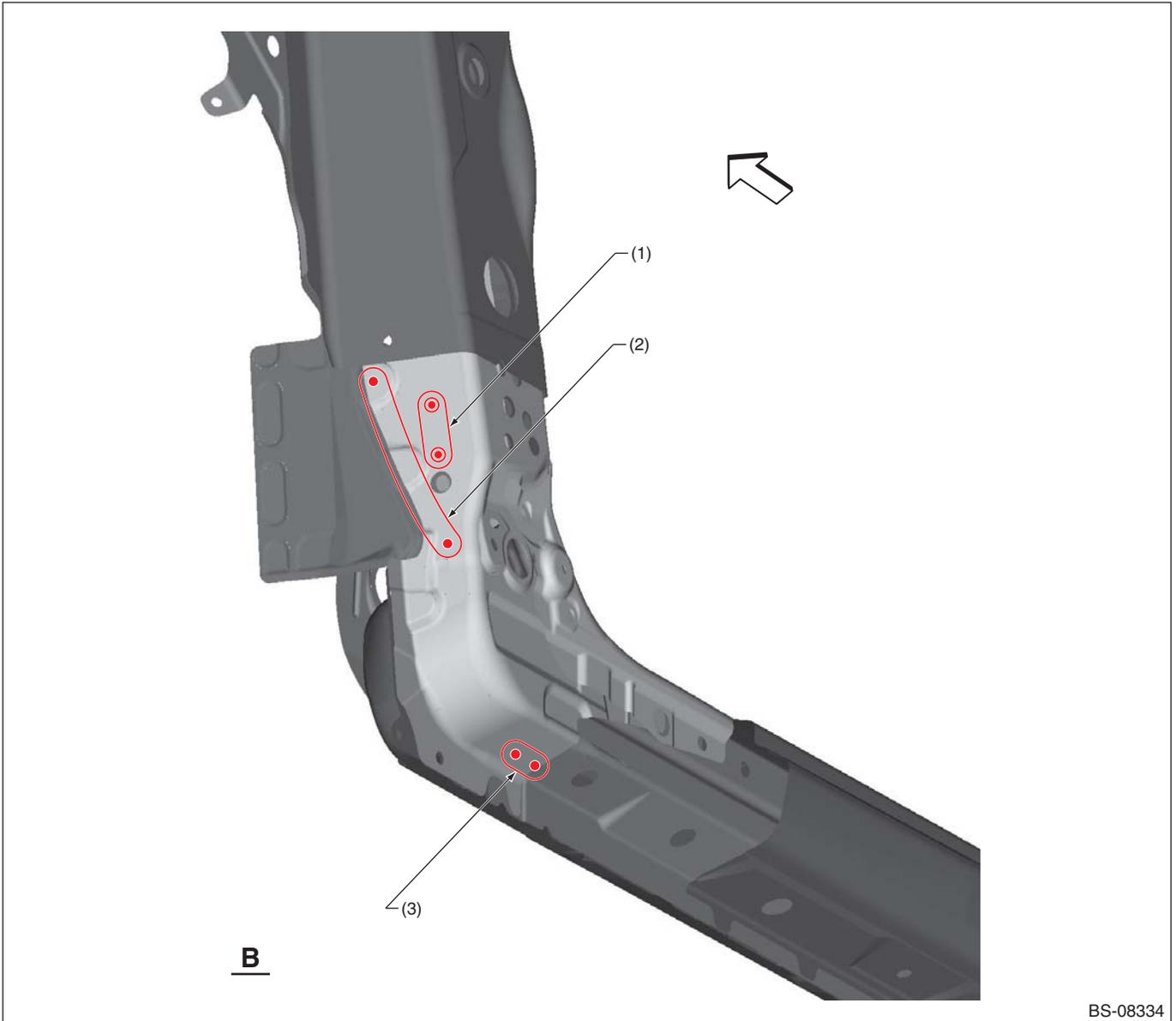
(1) 1 point (outside · 2)

(2) 1 point (top · 2)

(3) 2 points (top · 1)

# Panel Replacement

## • Views B



(1) 2 points (outside · 1)

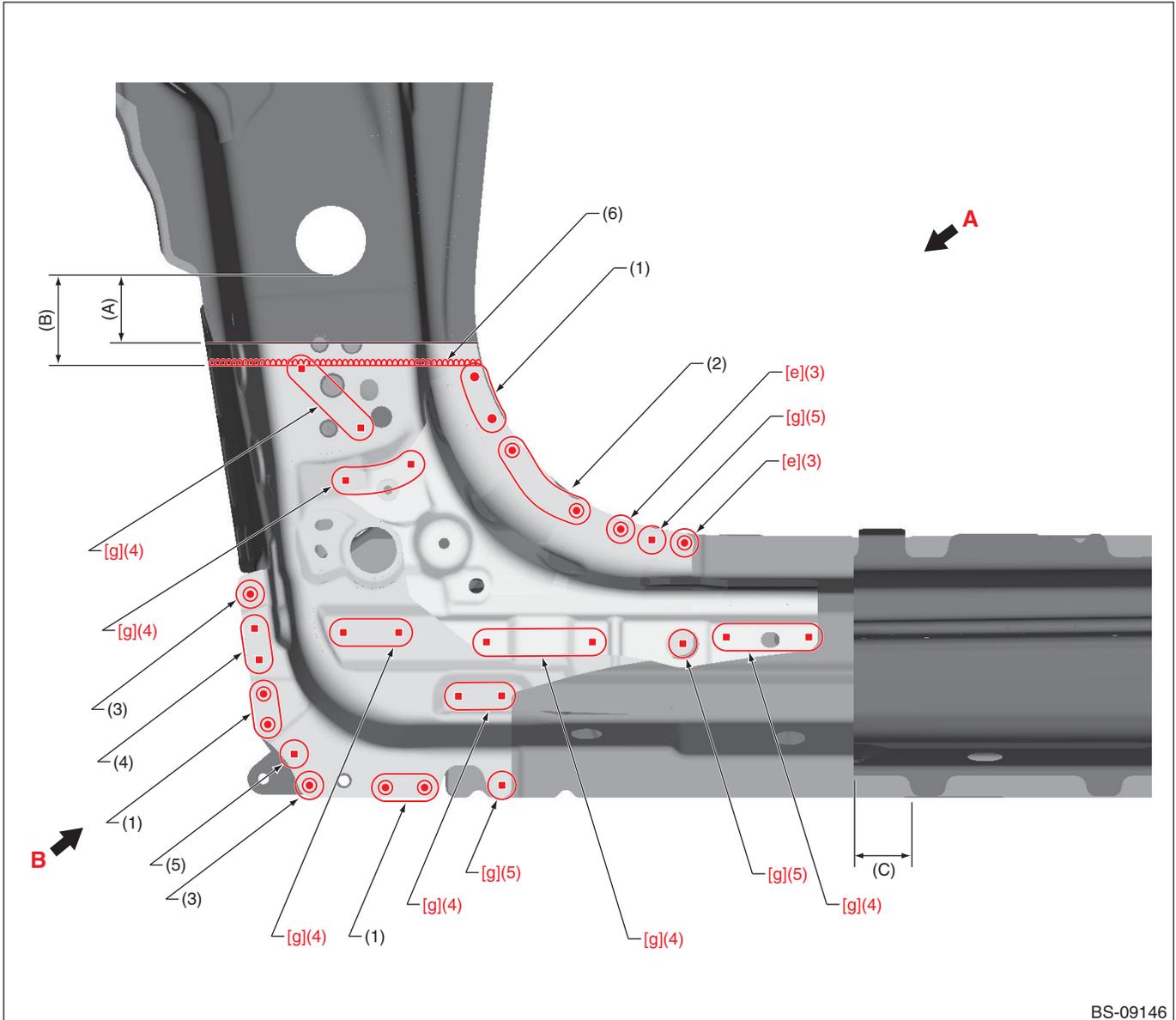
(2) 3 points (outside · 1)

(3) 2 points (bottom · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09146

(A) 40 mm [1.57 in]

(B) 60 mm [2.36 in]

(C) 35 mm [1.38 in]

(1) 2 points

(3) 1 point

(5) 1 point (service)

(2) 3 points

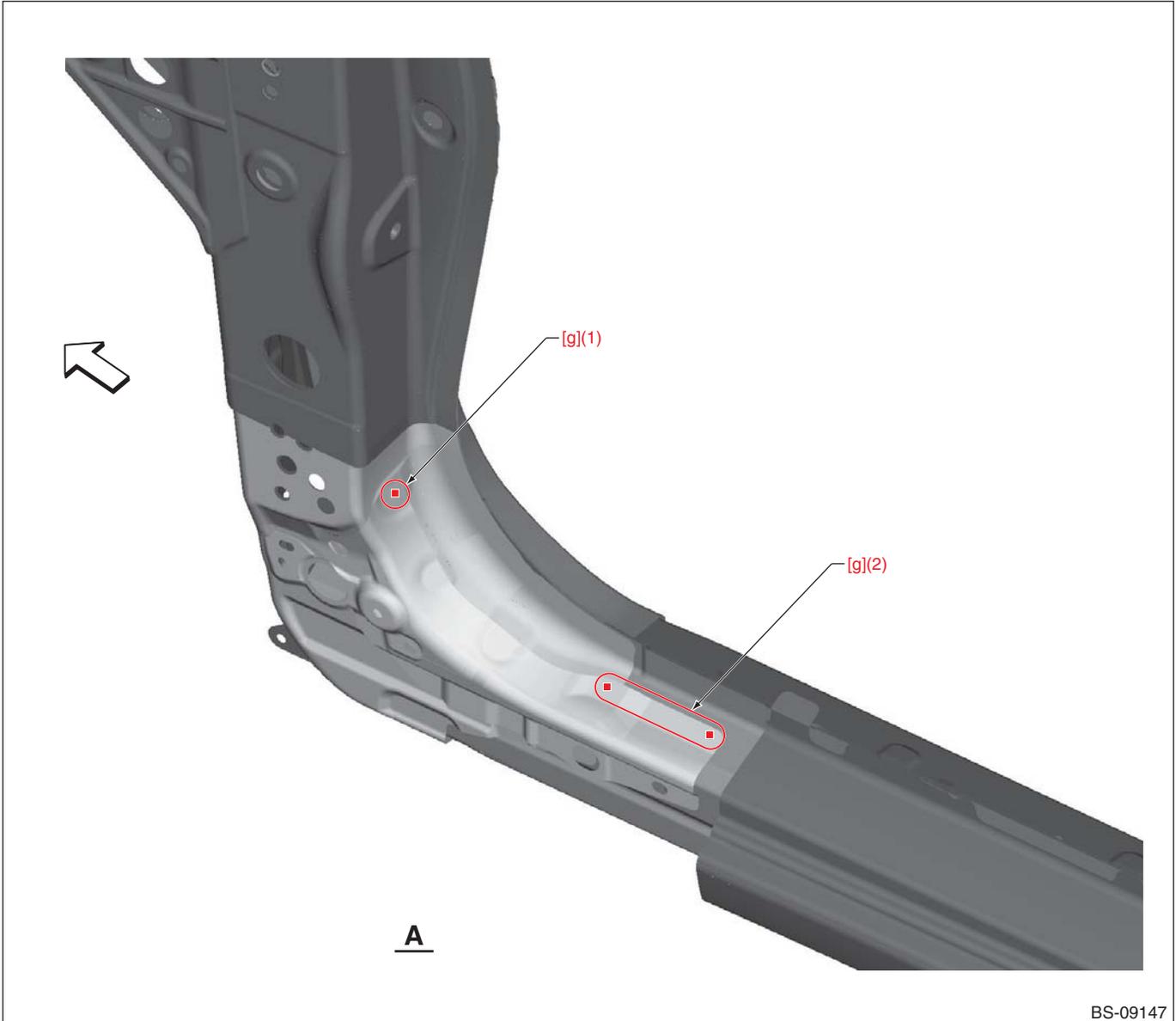
(4) 2 points (service)

(6) 1 point (Continuous welding)

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

# Panel Replacement

## • Views A



(1) 1 point (service)

(2) 3 points (service)

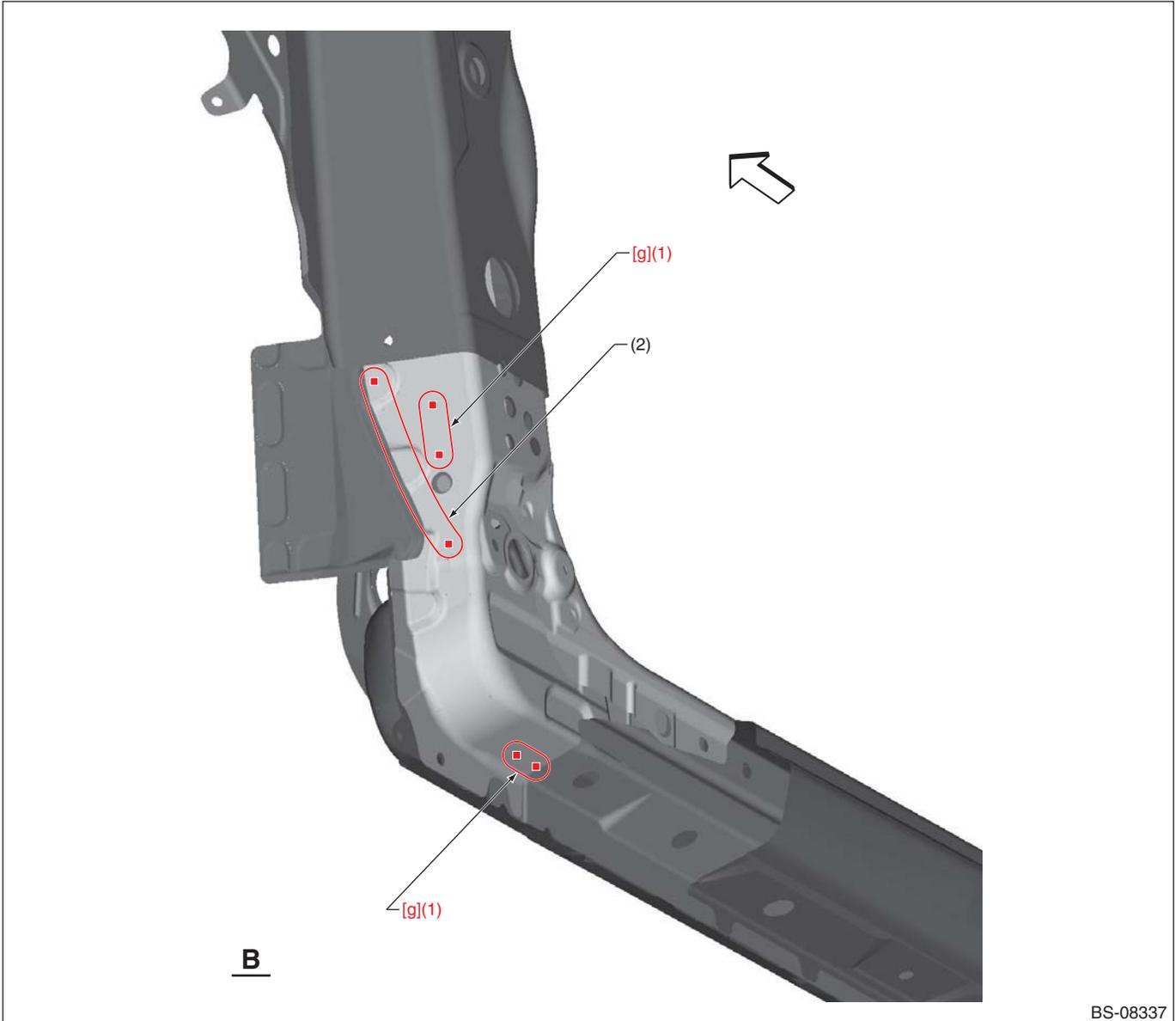
[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO<sub>2</sub>

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO<sub>2</sub>: 20 %)

# Panel Replacement

## • Views B



(1) 2 points (service)

(2) 3 points (service)

[g] Plug welding

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

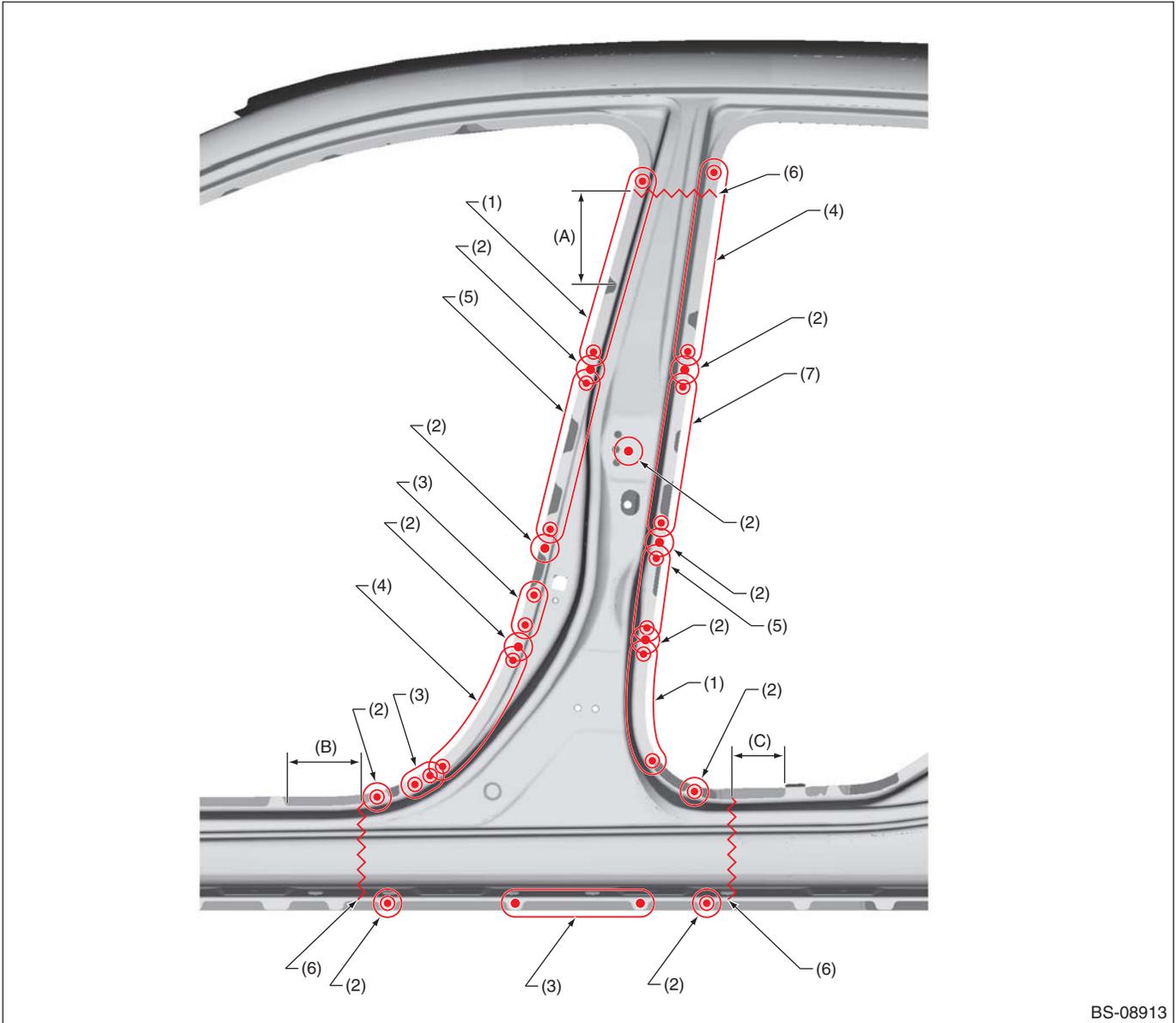
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

# Panel Replacement

## 8-15. Center Pillar Outer Panel (partial replacement)

### A: REMOVAL

- Overall view (Gasoline model)



(A) 170 mm [6.69 in]

(B) 120 mm [4.72 in]

(C) 80 mm [3.15 in]

(1) 8 points (outside · 1)

(4) 7 points (outside · 1)

(7) 4 points (outside · 1)

(2) 1 point (outside · 1)

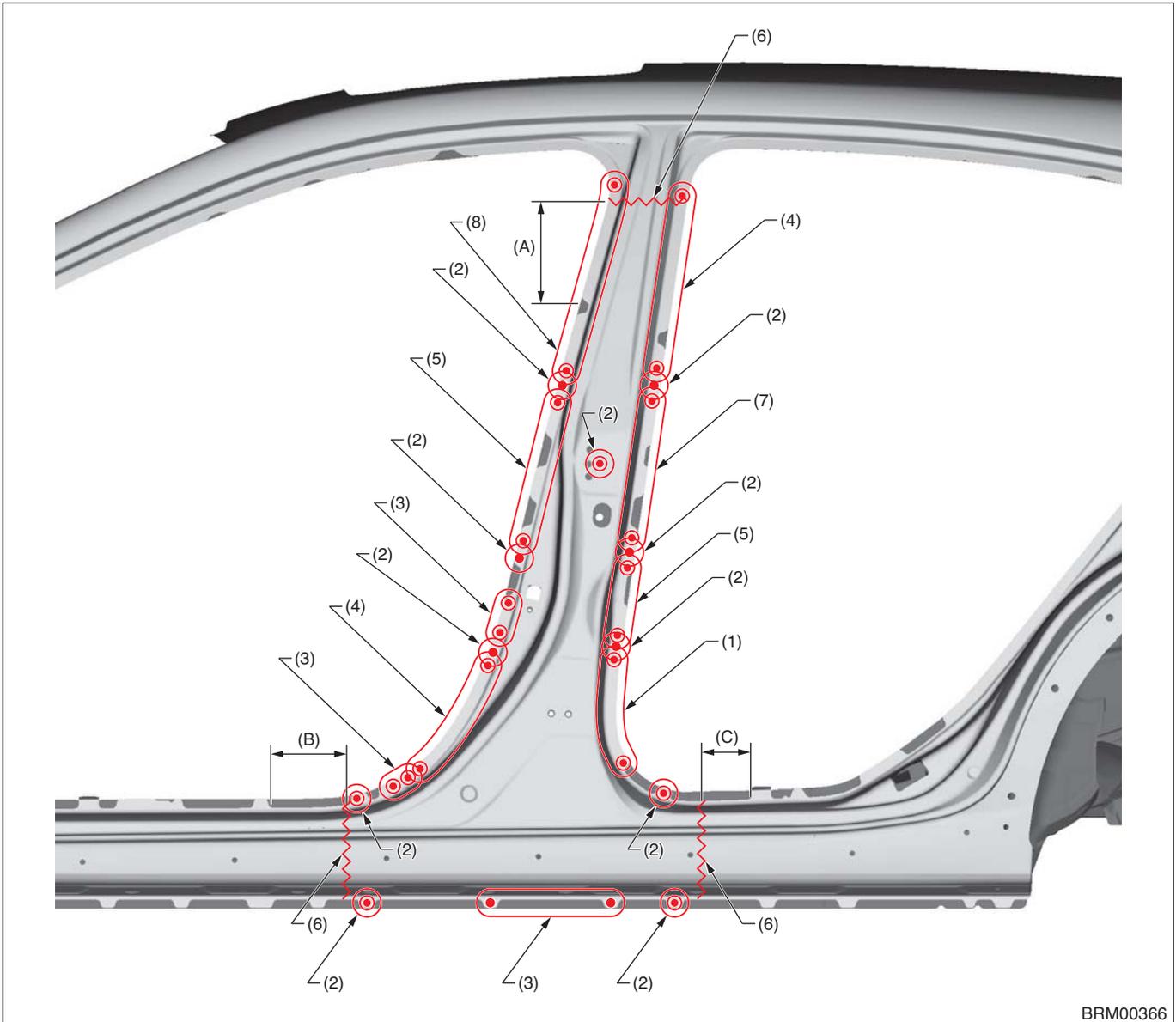
(5) 3 points (outside · 1)

(3) 2 points (outside · 1)

(6) Cut position

# Panel Replacement

## • Overall view (Hybrid model)



(A) 170 mm [6.69 in]

(B) 120 mm [4.72 in]

(C) 80 mm [3.15 in]

(1) 8 points (outside · 1)

(4) 7 points (outside · 1)

(7) 4 points (outside · 1)

(2) 1 point (outside · 1)

(5) 3 points (outside · 1)

(8) 11 points (outside · 1)

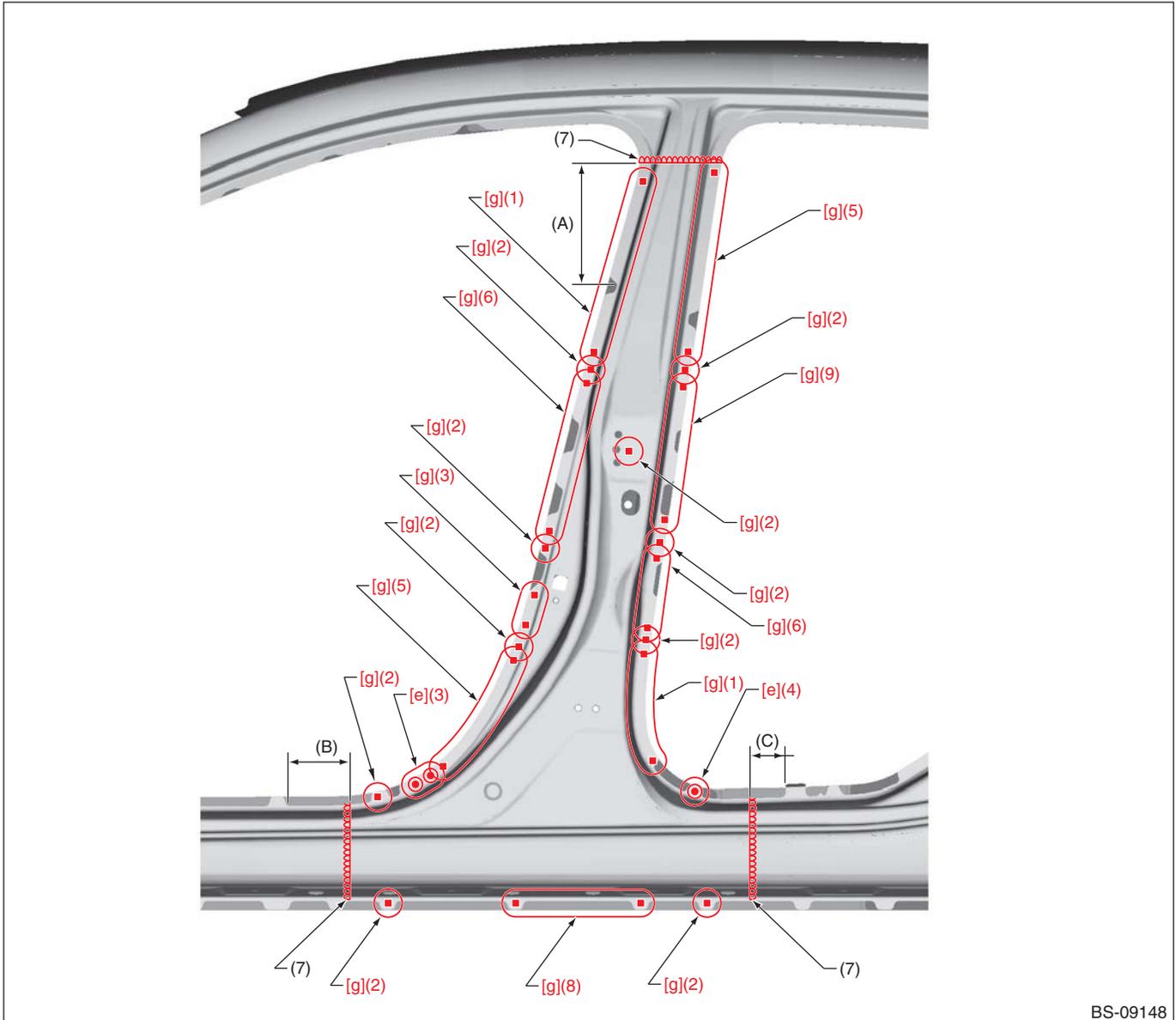
(3) 2 points (outside · 1)

(6) Cut position

# Panel Replacement

## B: INSTALLATION

### • Overall view (Gasoline model)



BS-09148

(A) 200 mm [7.87 in]

(B) 90 mm [3.54 in]

(C) 50 mm [1.97 in]

(1) 8 points

(4) 1 point

(7) 1 point (Continuous welding)

(2) 1 point (service)

(5) 7 points

(8) 2 points (service)

(3) 2 points

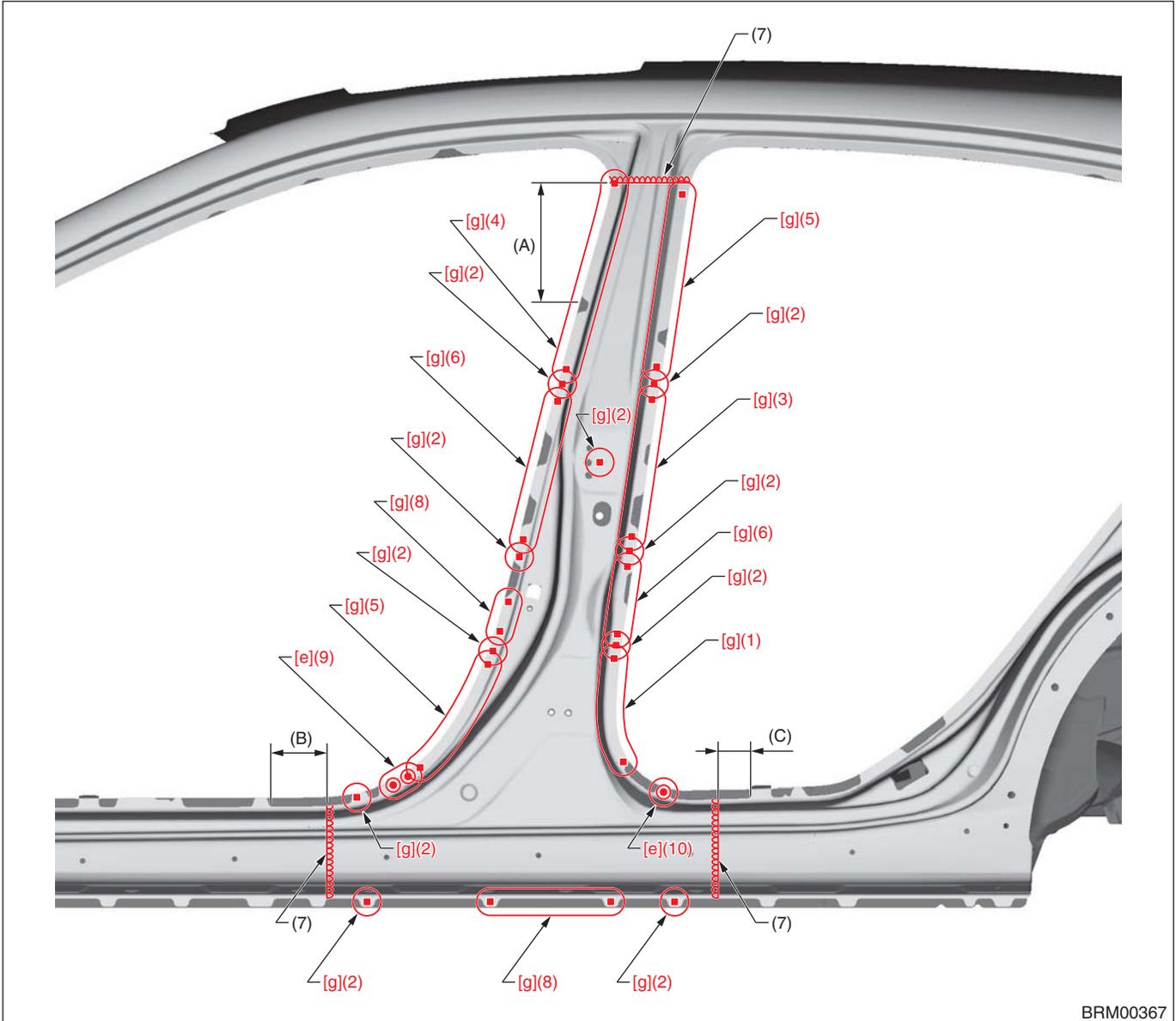
(6) 3 points

(9) 4 points

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

# Panel Replacement

## • Overall view (Hybrid model)



(A) 200 mm [7.87 in]

(B) 90 mm [3.54 in]

(C) 50 mm [1.97 in]

(1) 8 points (service)

(5) 7 points (service)

(9) 2 points

(2) 1 point (service)

(6) 3 points (service)

(10) 1 point

(3) 4 points (service)

(7) 1 point (Continuous welding)

(4) 11 points (service)

(8) 2 points (service)

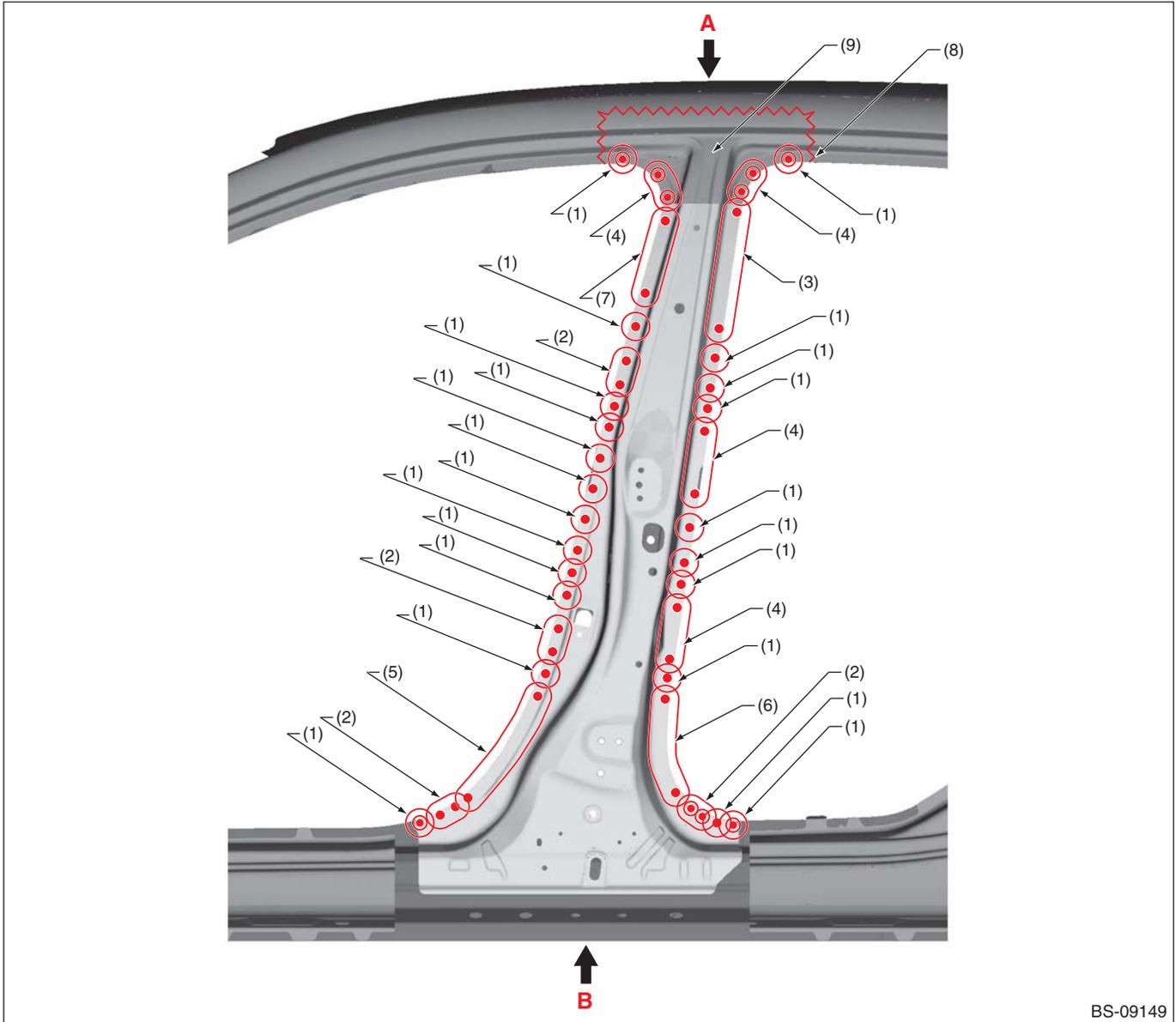
[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

# Panel Replacement

## 8-16. Center Pillar Reinforcement Outer (total replacement)

### A: REMOVAL

• Overall view (Gasoline model)

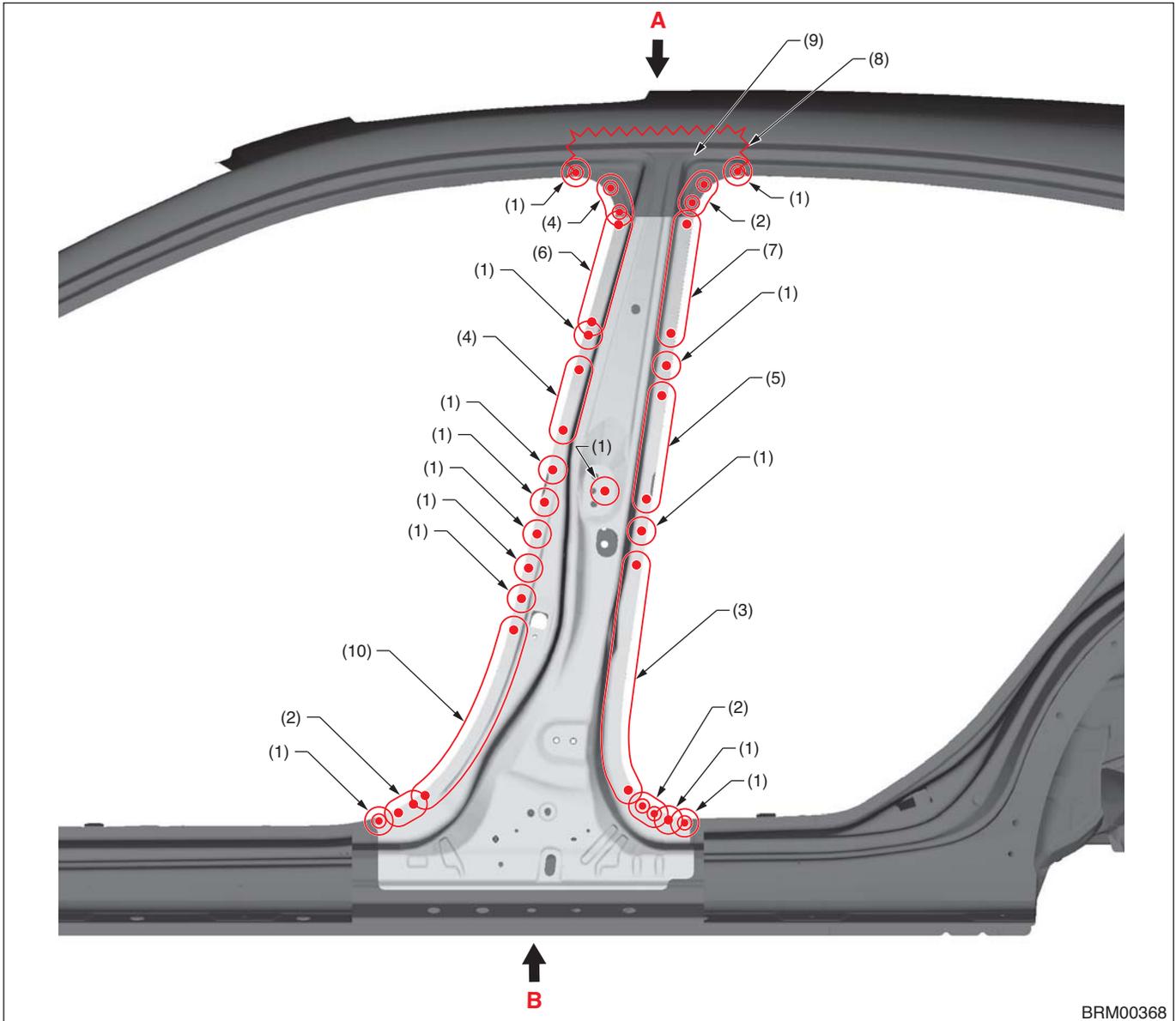


- |                            |                            |                                  |
|----------------------------|----------------------------|----------------------------------|
| (1) 1 point (outside · 1)  | (4) 3 points (outside · 1) | (7) 6 points (outside · 1)       |
| (2) 2 points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

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

# Panel Replacement

## • Overall view (Hybrid model)



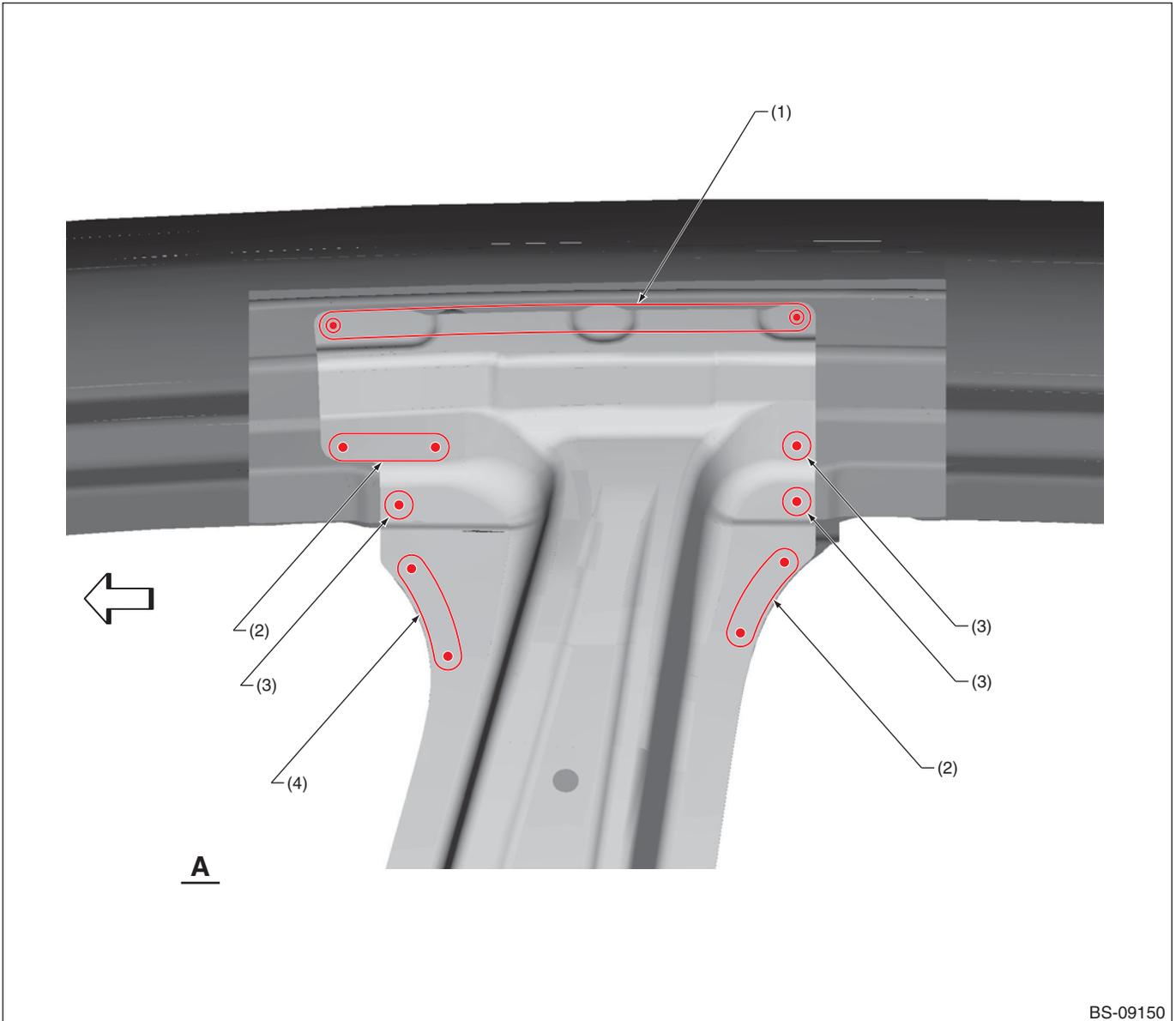
BRM00368

- |                             |                            |                                  |
|-----------------------------|----------------------------|----------------------------------|
| (1) 1 point (outside · 1)   | (5) 4 points (outside · 1) | (9) The part that can be reused. |
| (2) 2 points (outside · 1)  | (6) 8 points (outside · 1) | (10) 9 points (outside · 1)      |
| (3) 12 points (outside · 1) | (7) 6 points (outside · 1) |                                  |
| (4) 3 points (outside · 1)  | (8) Rough cutting          |                                  |

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

# Panel Replacement

## • Views A



BS-09150

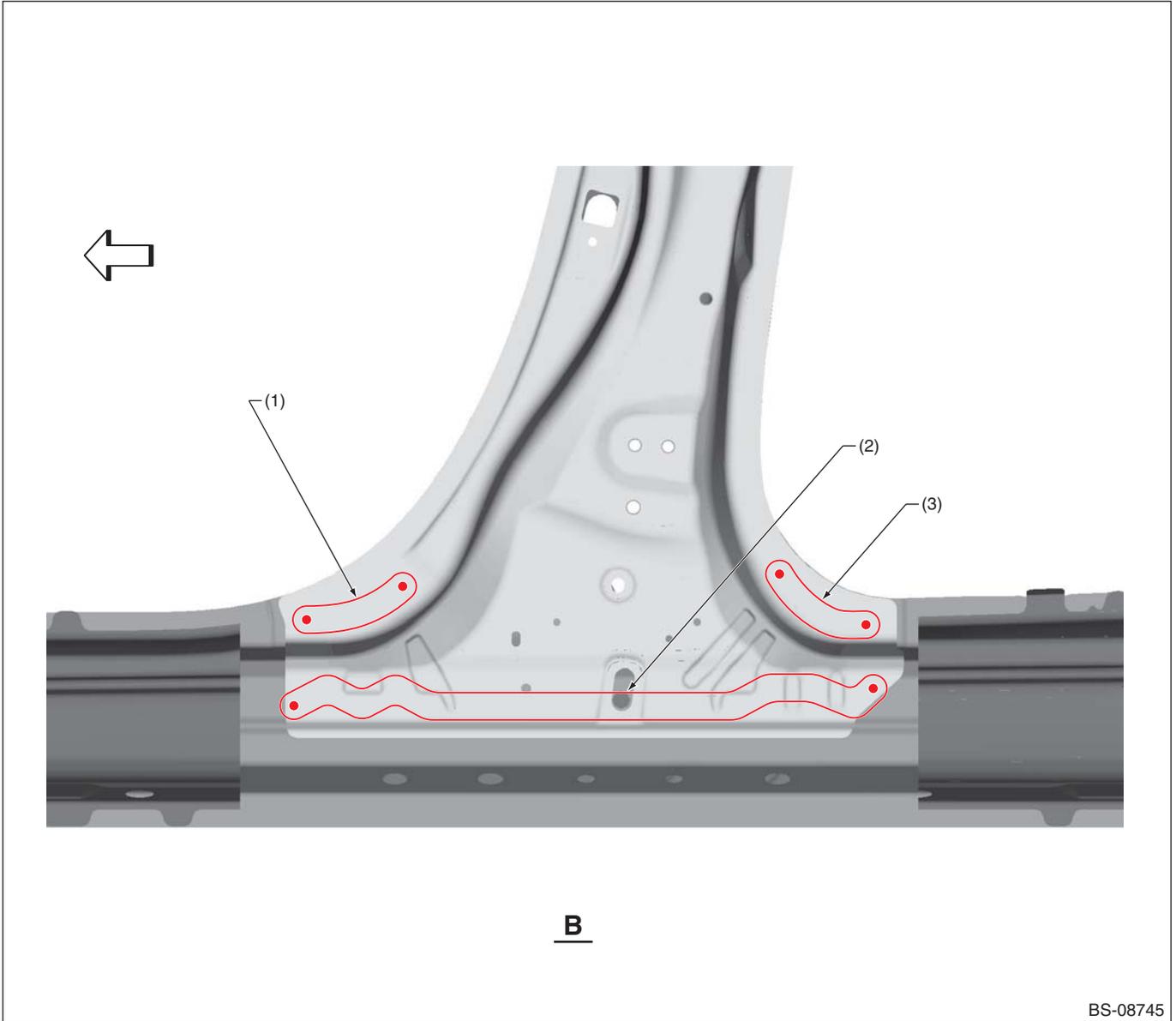
(1) 4 points (outside · 1)  
(2) 2 points (outside · 1)

(3) 1 point (outside · 1)

(4) 3 points (outside · 1)

# Panel Replacement

## • Views B (Gasoline model)



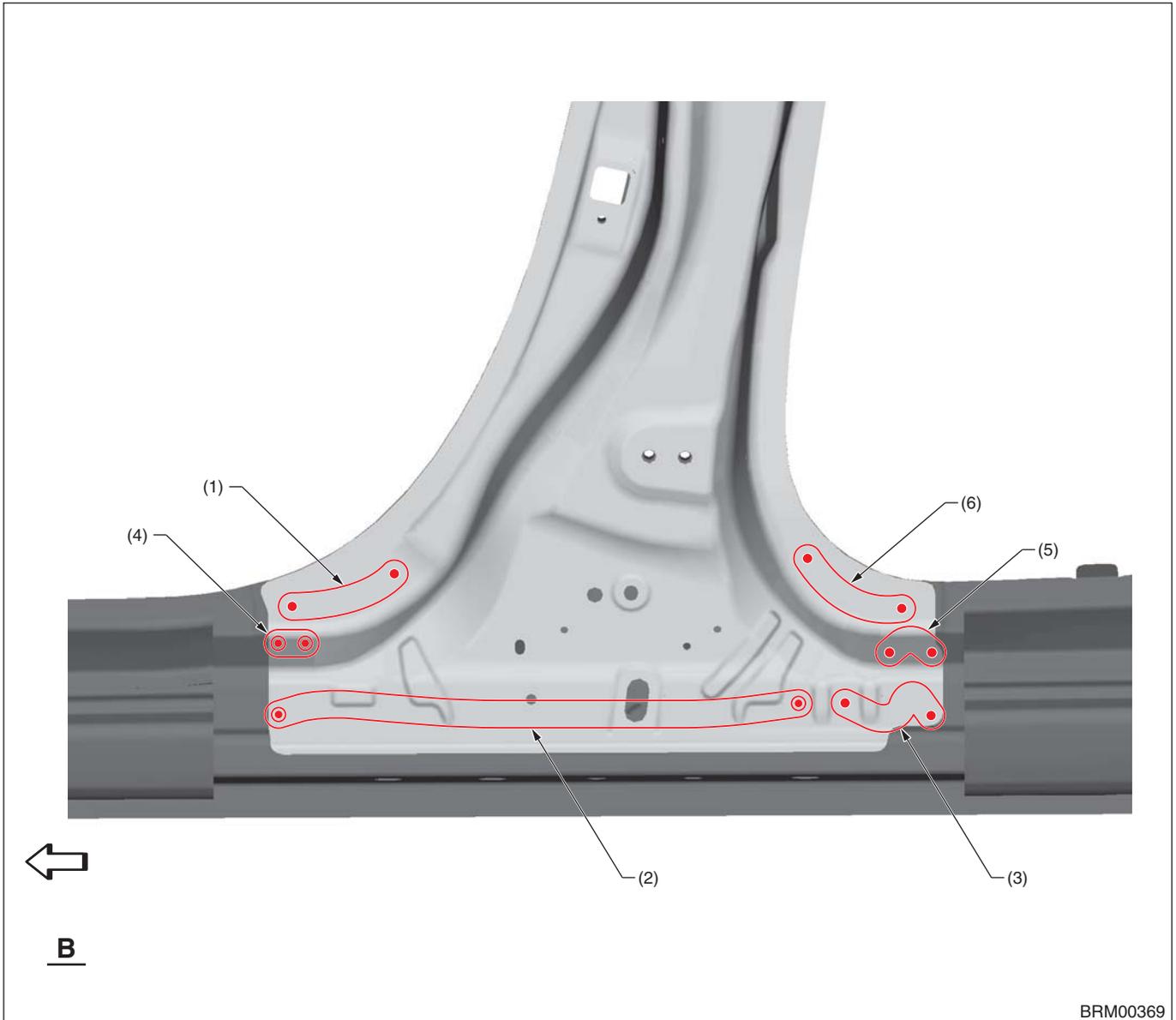
(1) 5 points (outside · 1)

(2) 16 points (outside · 1)

(3) 4 points (outside · 1)

# Panel Replacement

## • Views B (Hybrid model)



(1) 5 points (outside · 1)  
(2) 10 points (outside · 1)

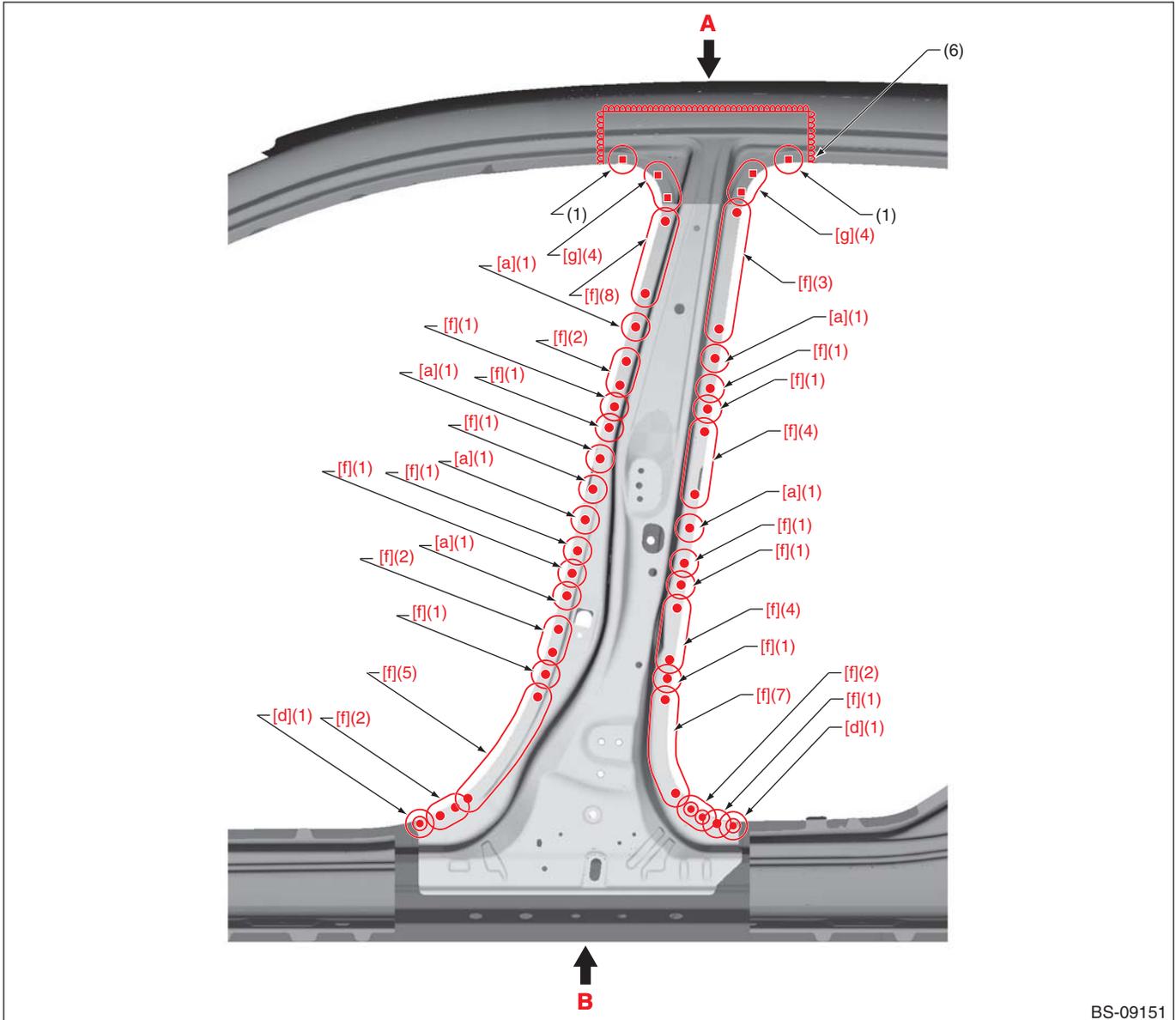
(3) 4 points (outside · 1)  
(4) 2 points (top · 1)

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

# Panel Replacement

## B: INSTALLATION

### • Overall view (Gasoline model)



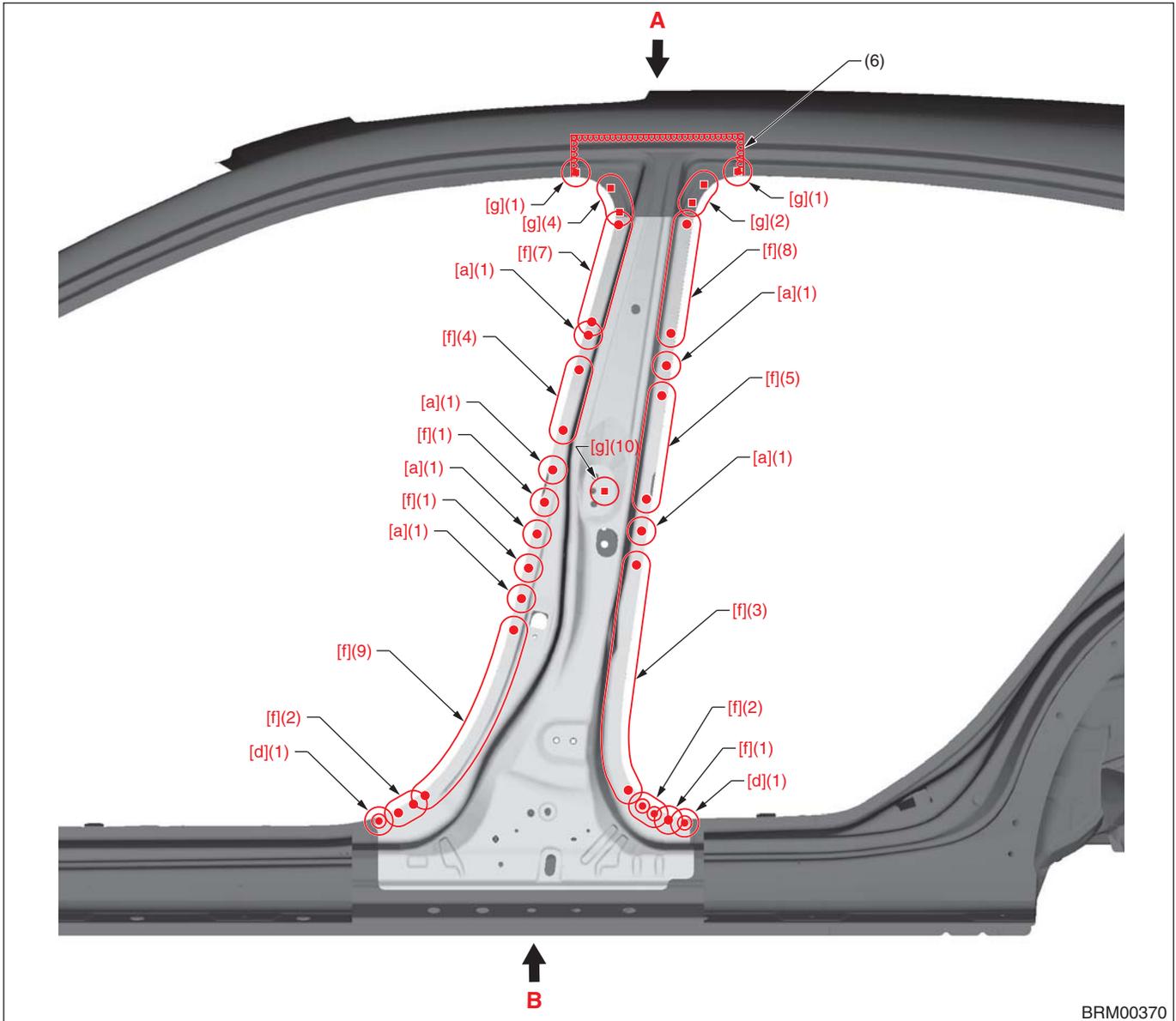
BS-09151

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

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

# Panel Replacement

## • Overall view (Hybrid model)



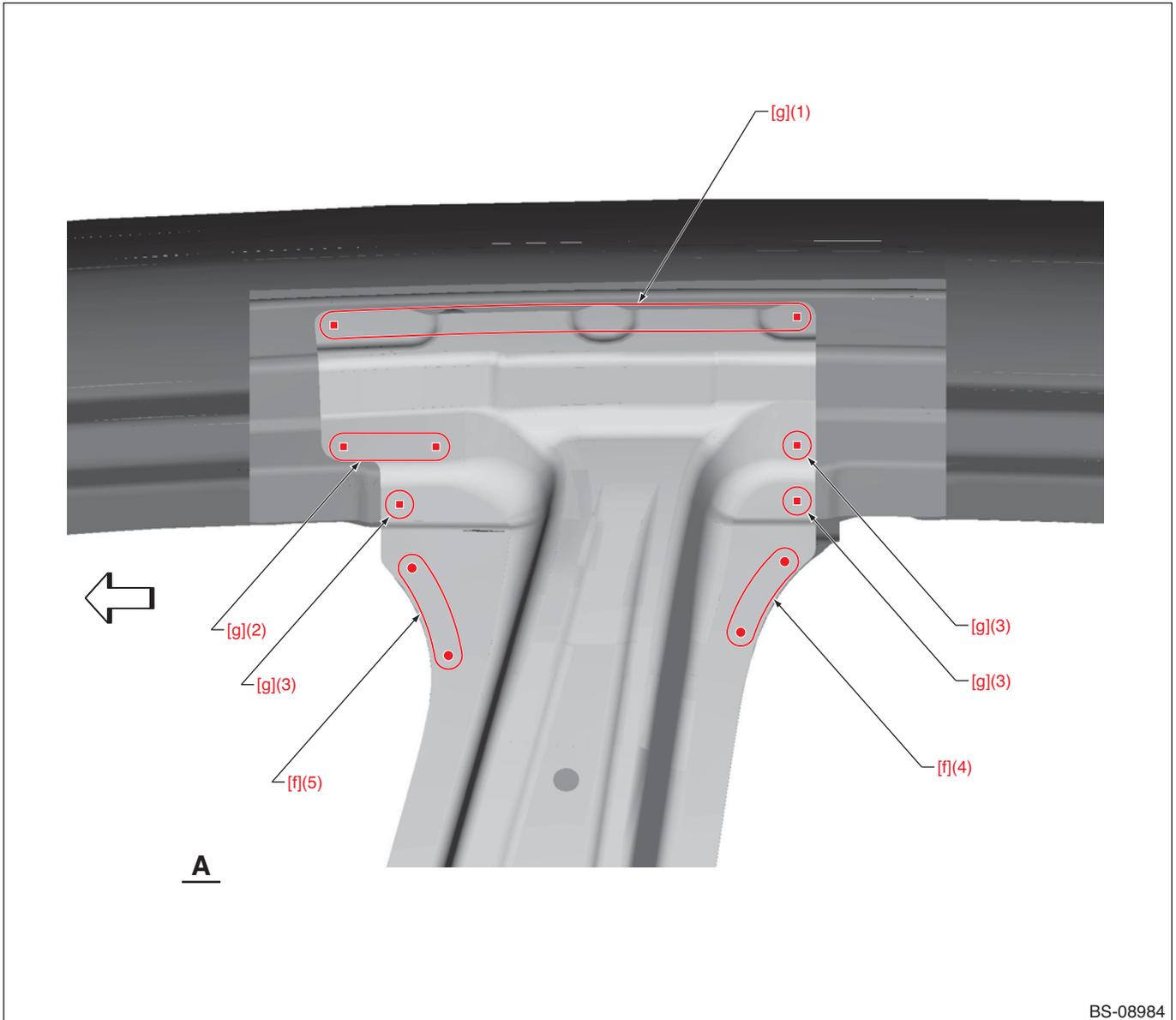
BRM00370

- |               |                                  |                        |
|---------------|----------------------------------|------------------------|
| (1) 1 point   | (5) 4 points                     | (9) 9 points           |
| (2) 2 points  | (6) 1 point (Continuous welding) | (10) 1 point (service) |
| (3) 12 points | (7) 8 points                     |                        |
| (4) 3 points  | (8) 6 points                     |                        |

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

# Panel Replacement

## • Views A



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

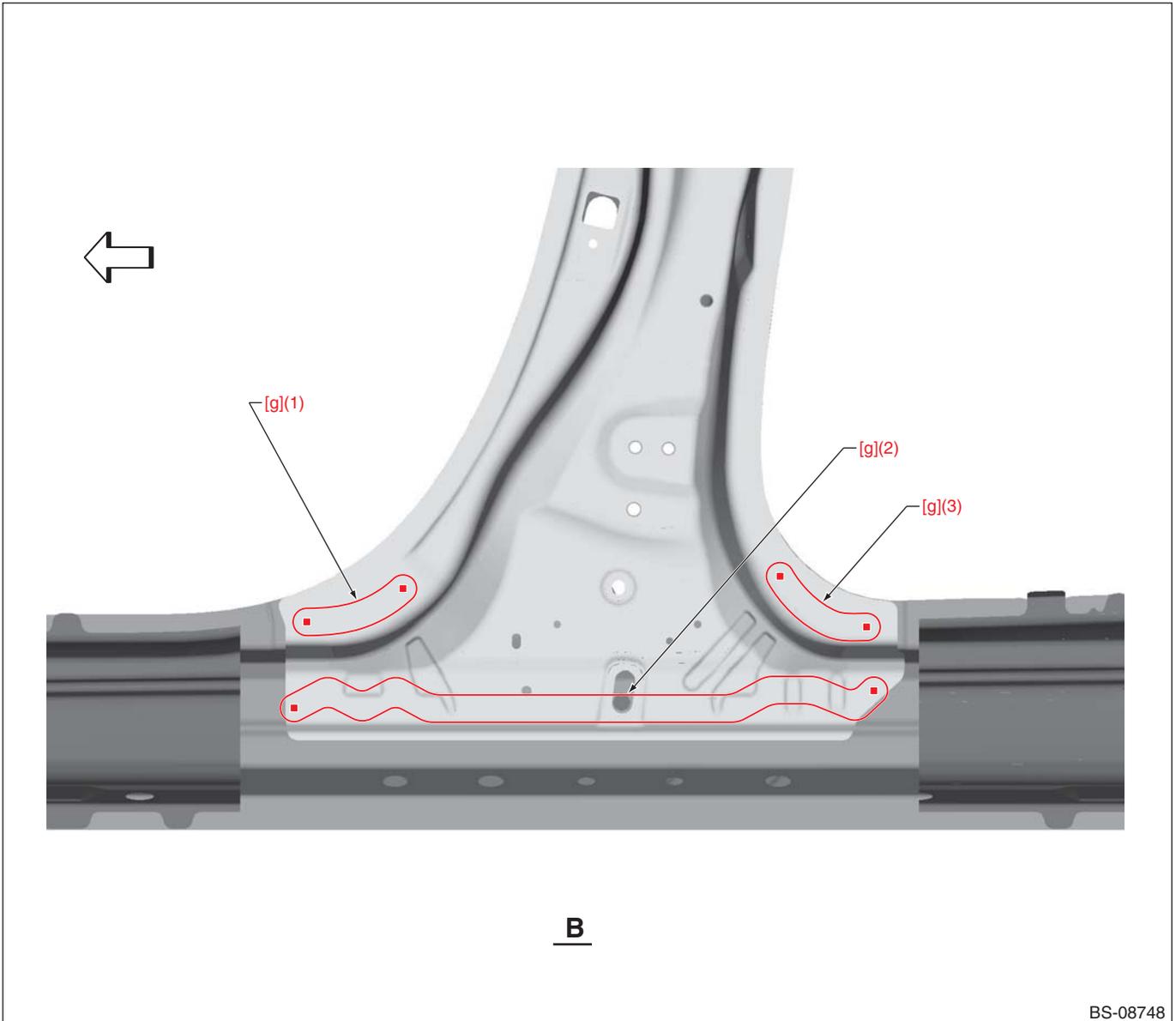
(3) 1 point (service)  
 (4) 2 points

(5) 3 points

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

# Panel Replacement

## • Views B (Gasoline model)



(1) 5 points (service)

(2) 16 points (service)

(3) 4 points (service)

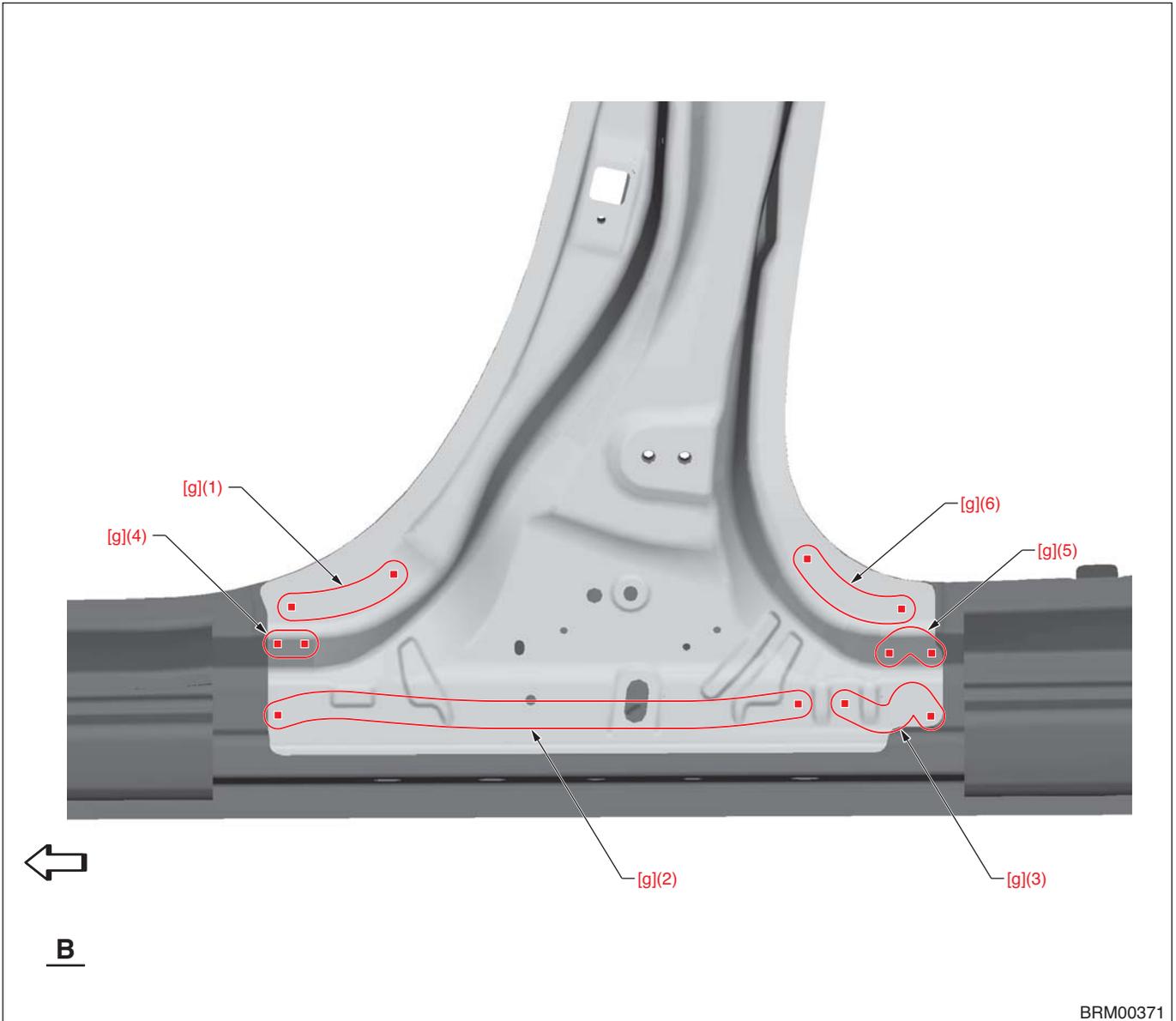
[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO<sub>2</sub>

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO<sub>2</sub>: 20 %)

# Panel Replacement

## • Views B (Hybrid model)



BRM00371

(1) 5 points (service)  
(2) 10 points (service)

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

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

[g] Plug welding

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

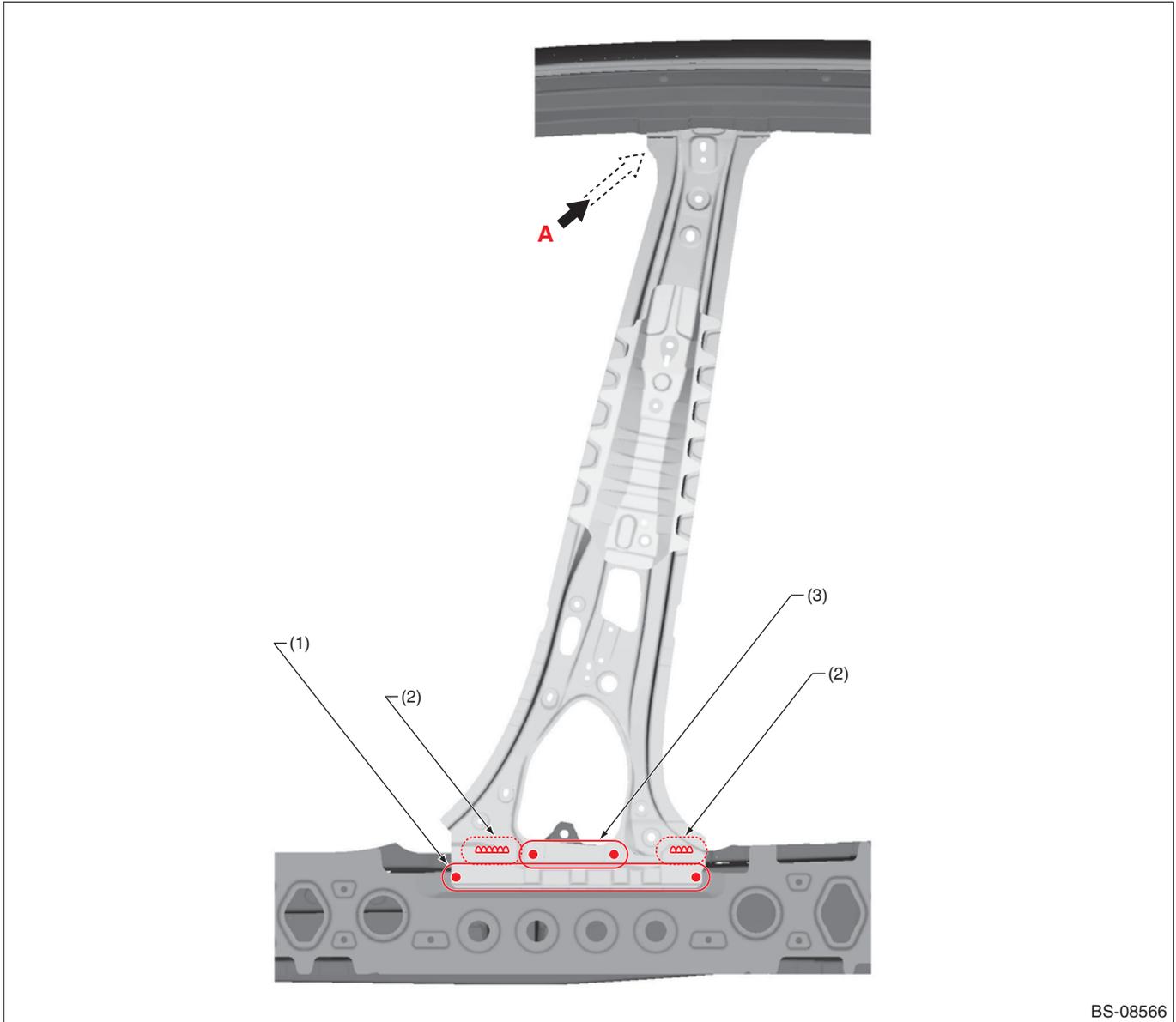
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

# Panel Replacement

## 8-17. Center Pillar Inner (total replacement)

### A: REMOVAL

- Overall view



BS-08566

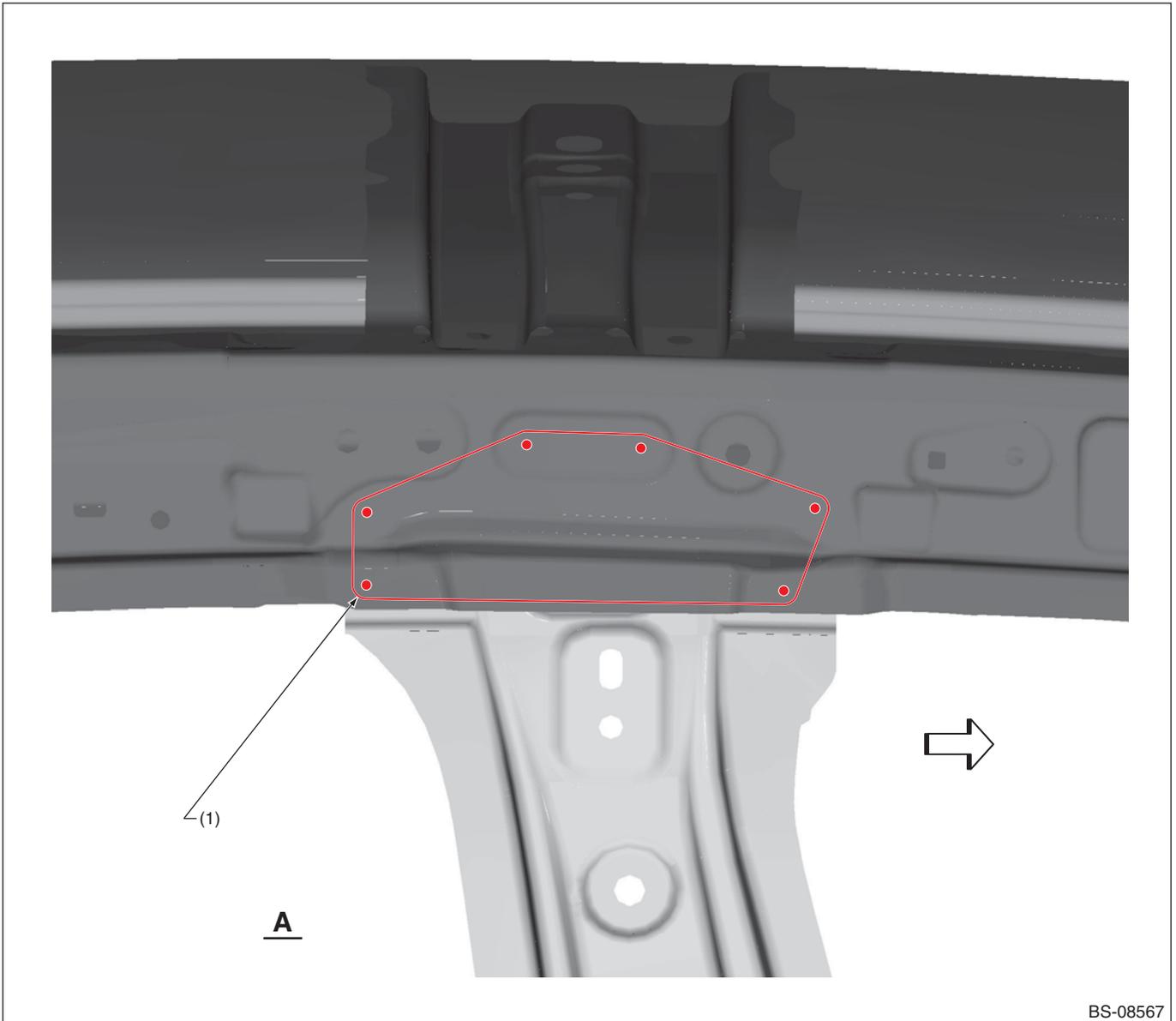
(1) 9 points (outside · 1)

(2) 1 point (inside · 1 belt sander)

(3) 2 points (outside · 1)

# Panel Replacement

- Views A

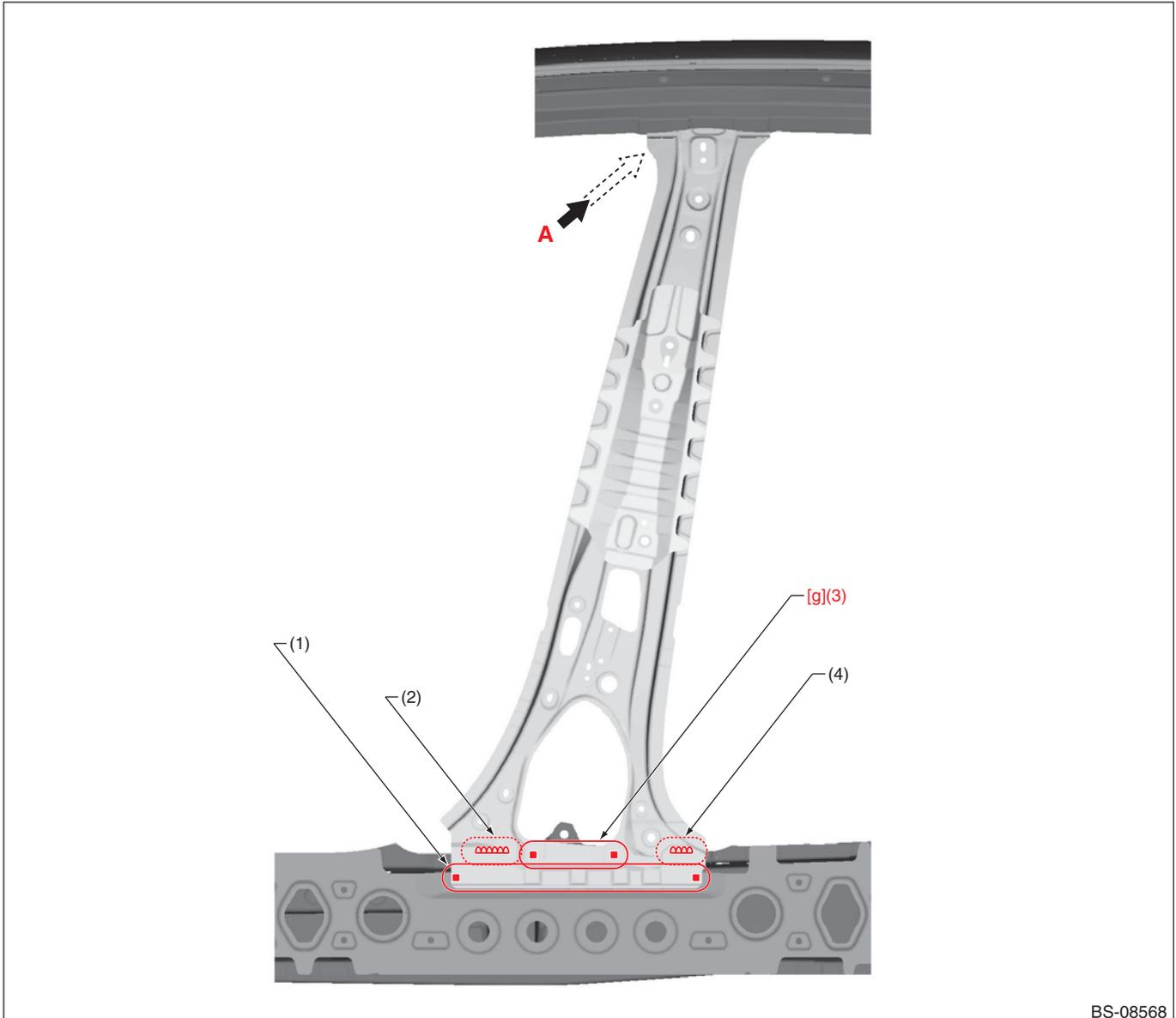


(1) 7 points (inside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-08568

(1) 9 points (service)

(3) 2 points (service)

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

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

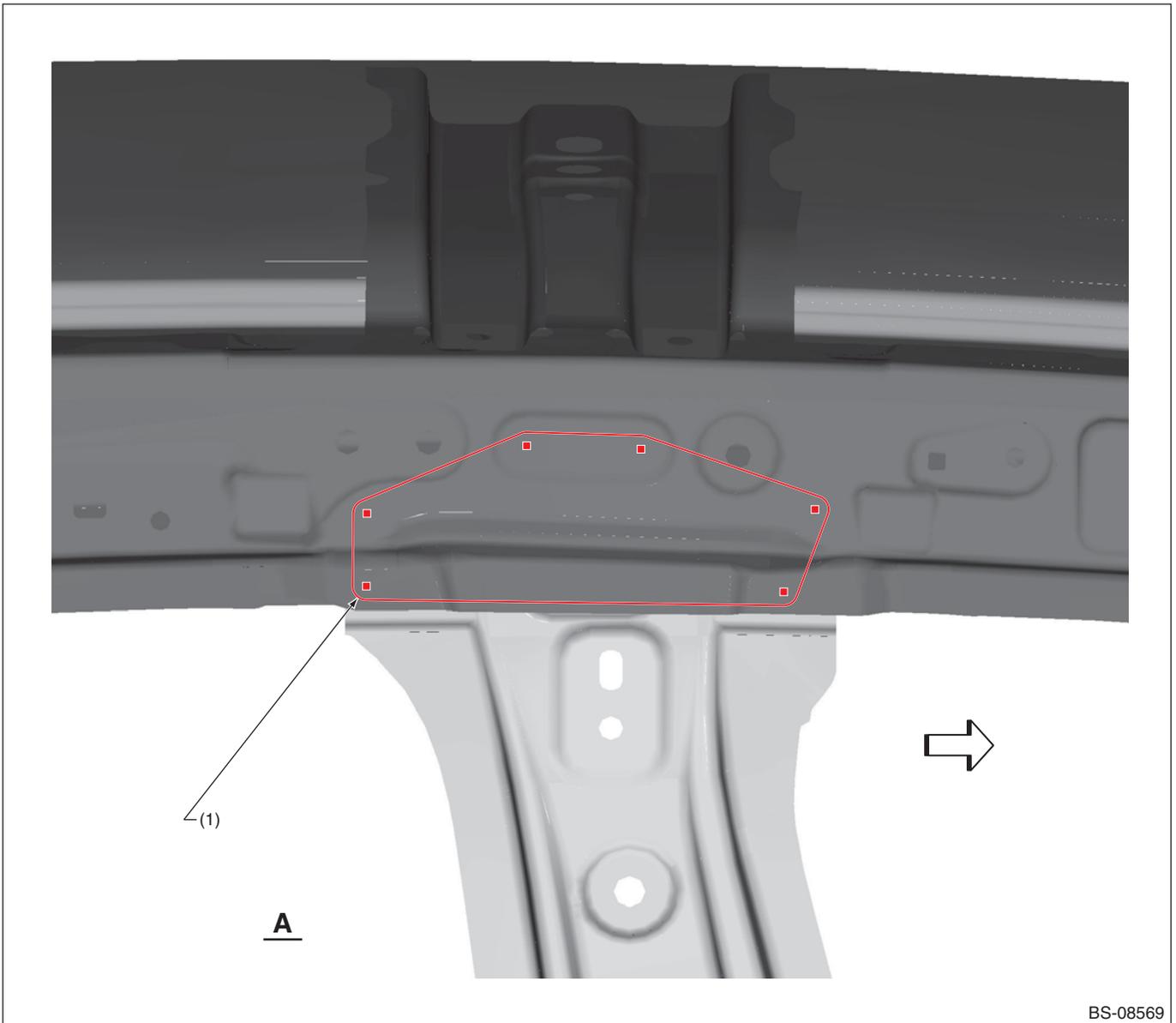
[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO<sub>2</sub>

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO<sub>2</sub>: 20 %)

# Panel Replacement

- Views A



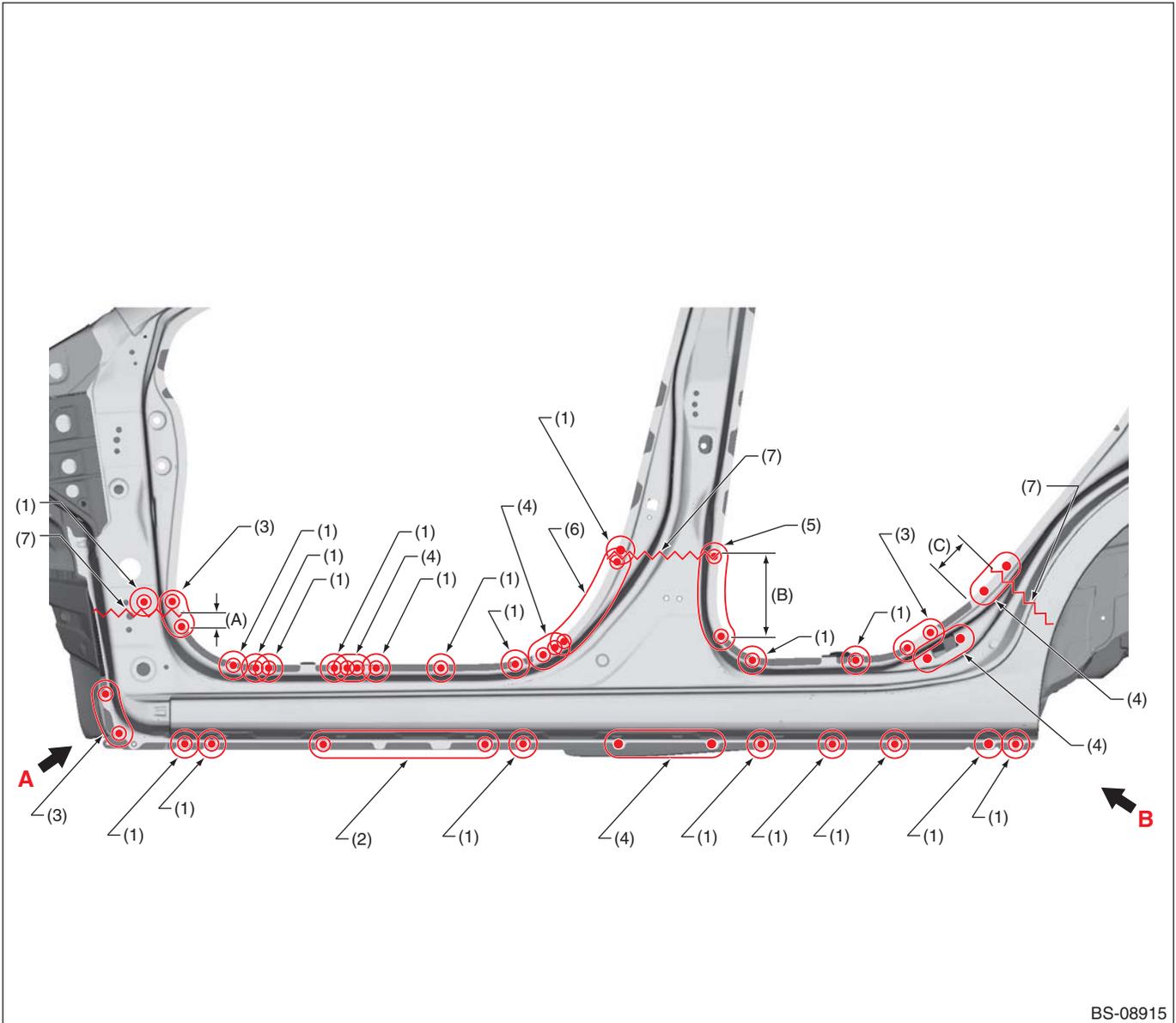
(1) 7 points

# Panel Replacement

## 8-18. Side Sill Outer Panel (partial replacement)

### A: REMOVAL

#### • Overall view



BS-08915

(A) 50 mm [1.97 in]

(B) 150 mm [5.91 in]

(C) 90 mm [3.54 in]

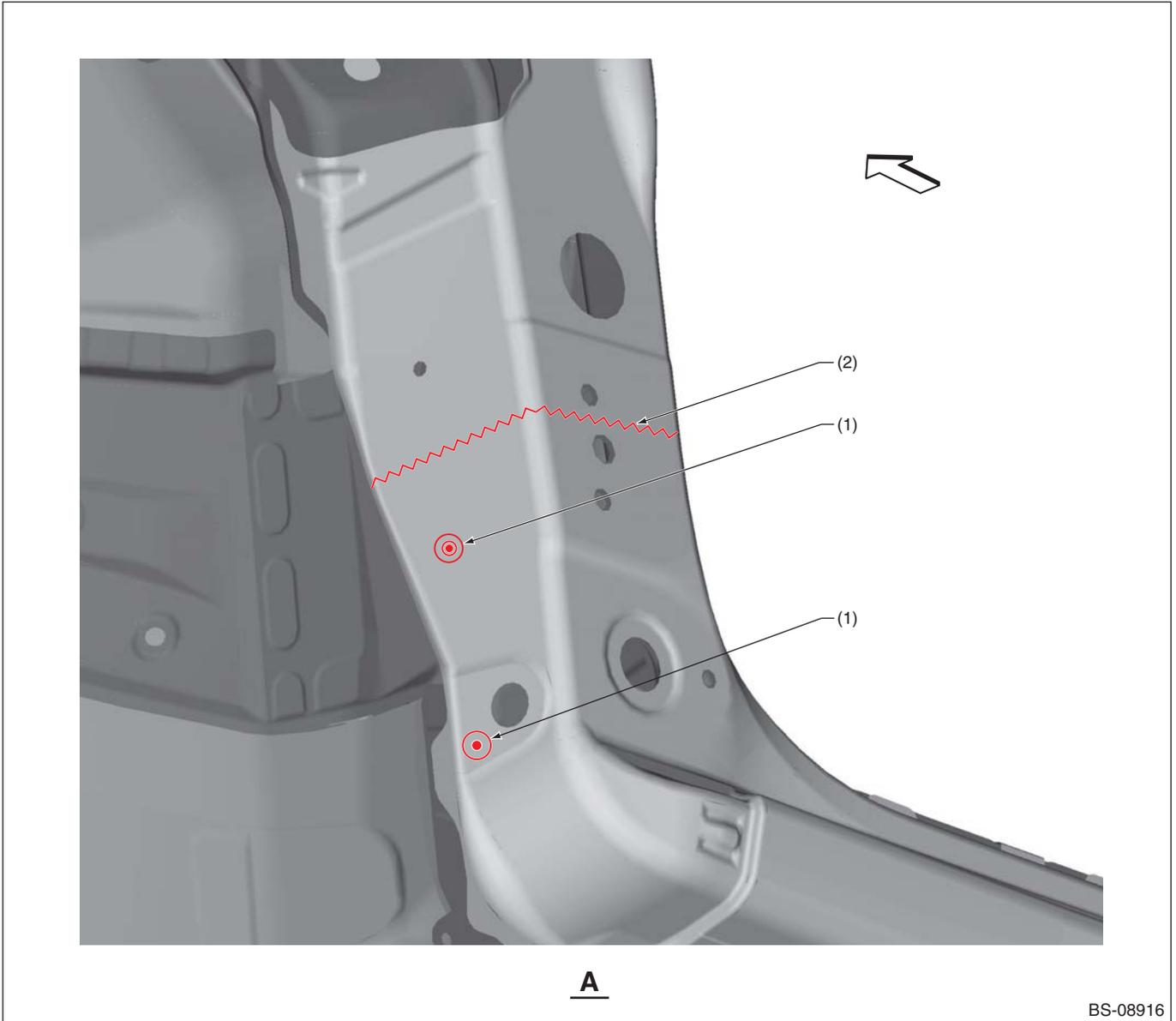
- (1) 1 point (outside · 1)
- (2) 4 points (outside · 1)
- (3) 3 points (outside · 1)

- (4) 2 points (outside · 1)
- (5) 8 points (outside · 1)
- (6) 7 points (outside · 1)

- (7) Cut position

# Panel Replacement

## • Views A

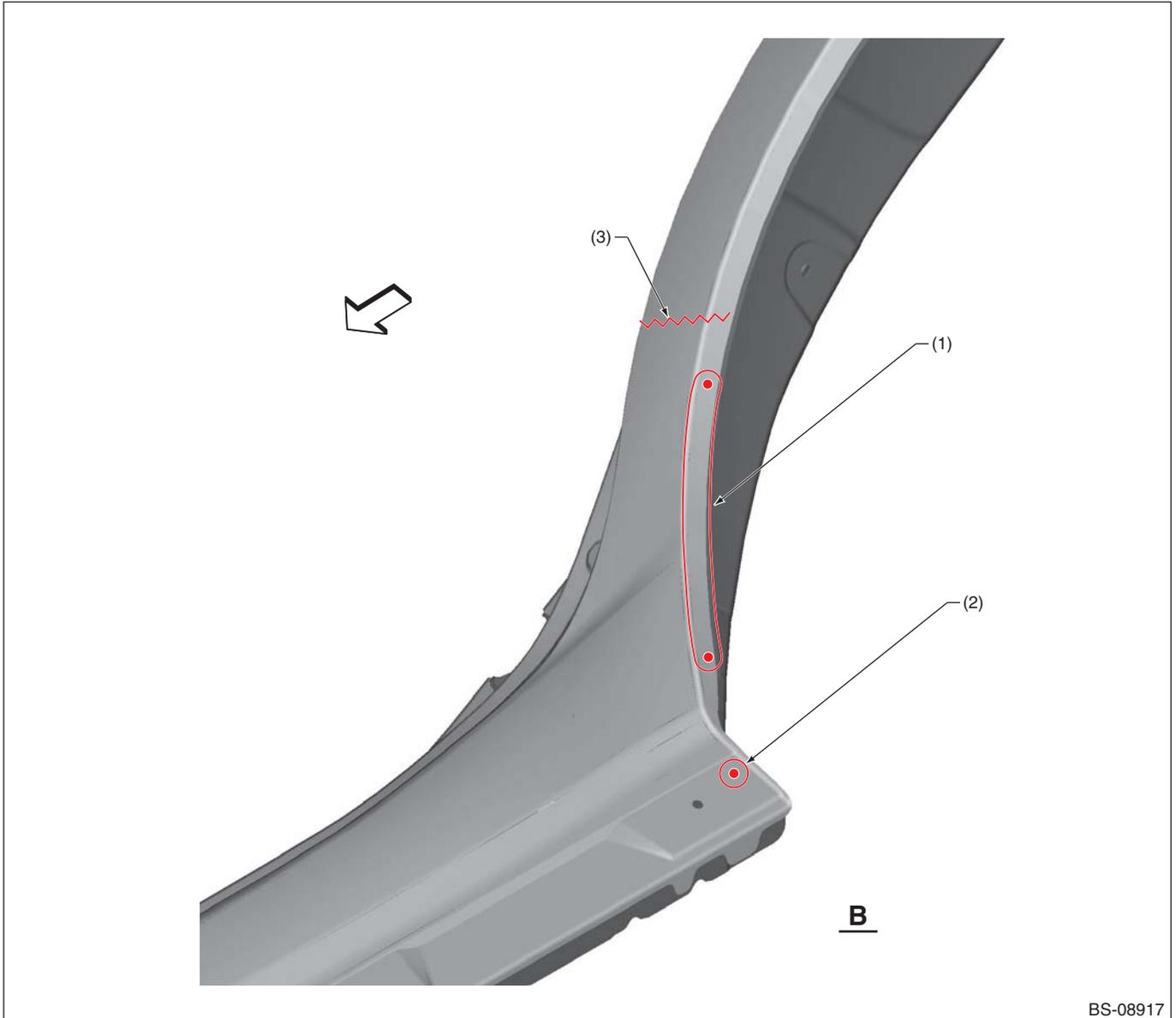


(1) 1 point (outside · 1)

(2) Cut position

# Panel Replacement

## • Views B (5D/4D model)



BS-08917

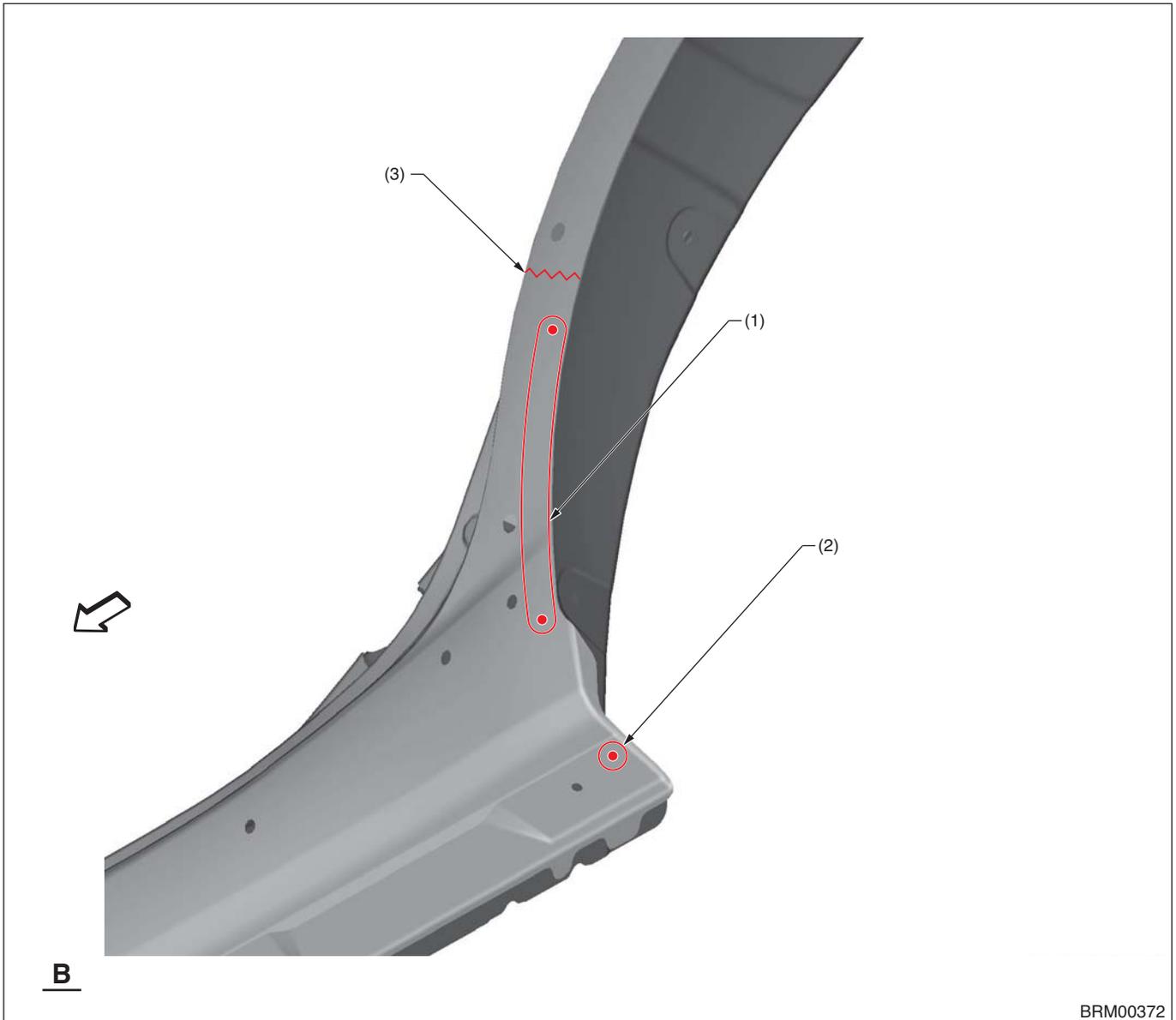
(1) 3 points (outside · 1)

(2) 1 point (bottom · 1)

(3) Cut position

# Panel Replacement

## • Views B (XV / Hybrid model)



(1) 3 points (outside · 1)

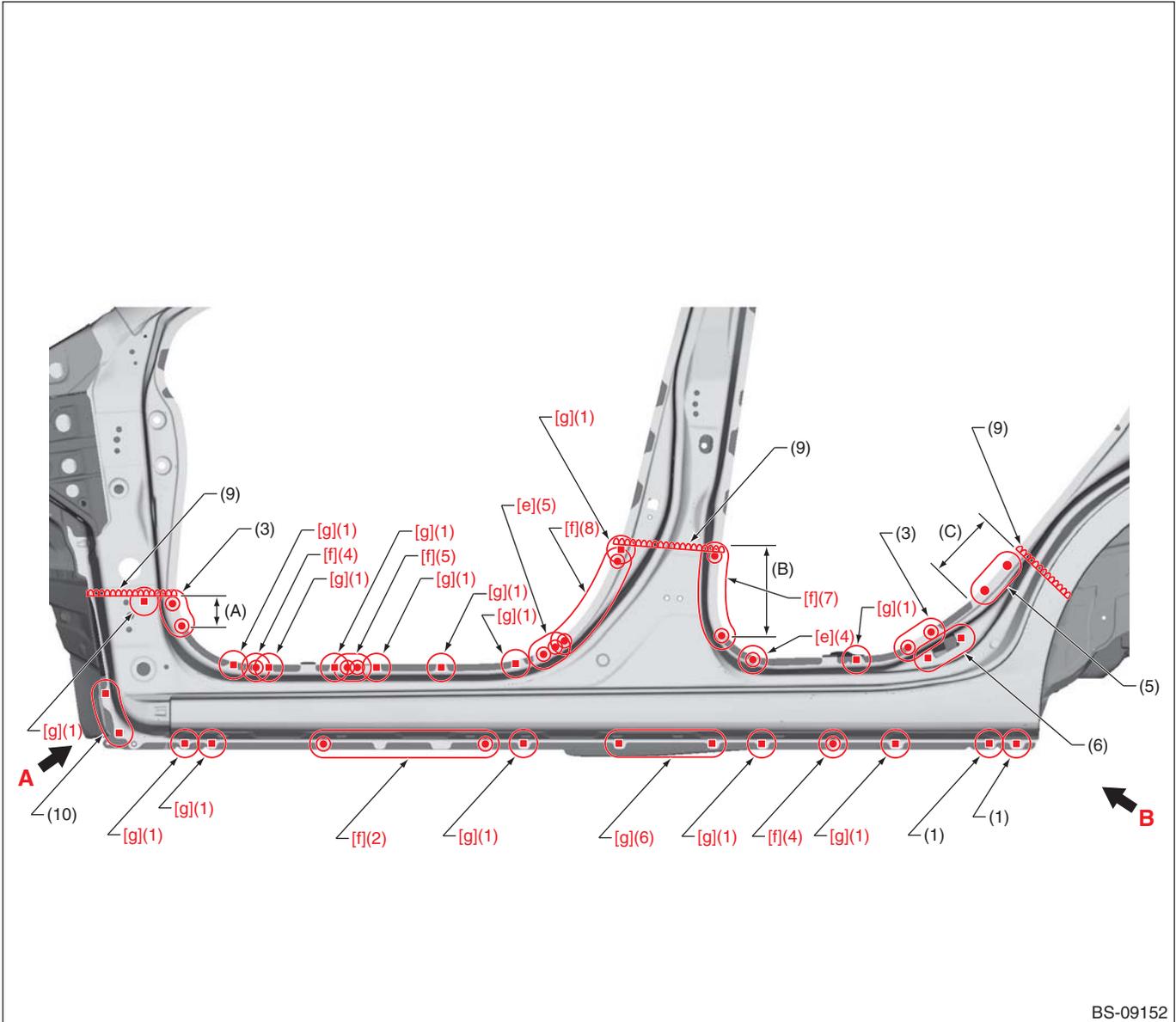
(2) 1 point (bottom · 1)

(3) Cut position

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09152

(A) 70 mm [2.76 in]

(B) 170 mm [6.69 in]

(C) 120 mm [4.72 in]

(1) 1 point (service)

(5) 2 points

(9) 1 point (Continuous welding)

(2) 4 points

(6) 2 points (service)

(10) 3 points (service)

(3) 3 points

(7) 8 points

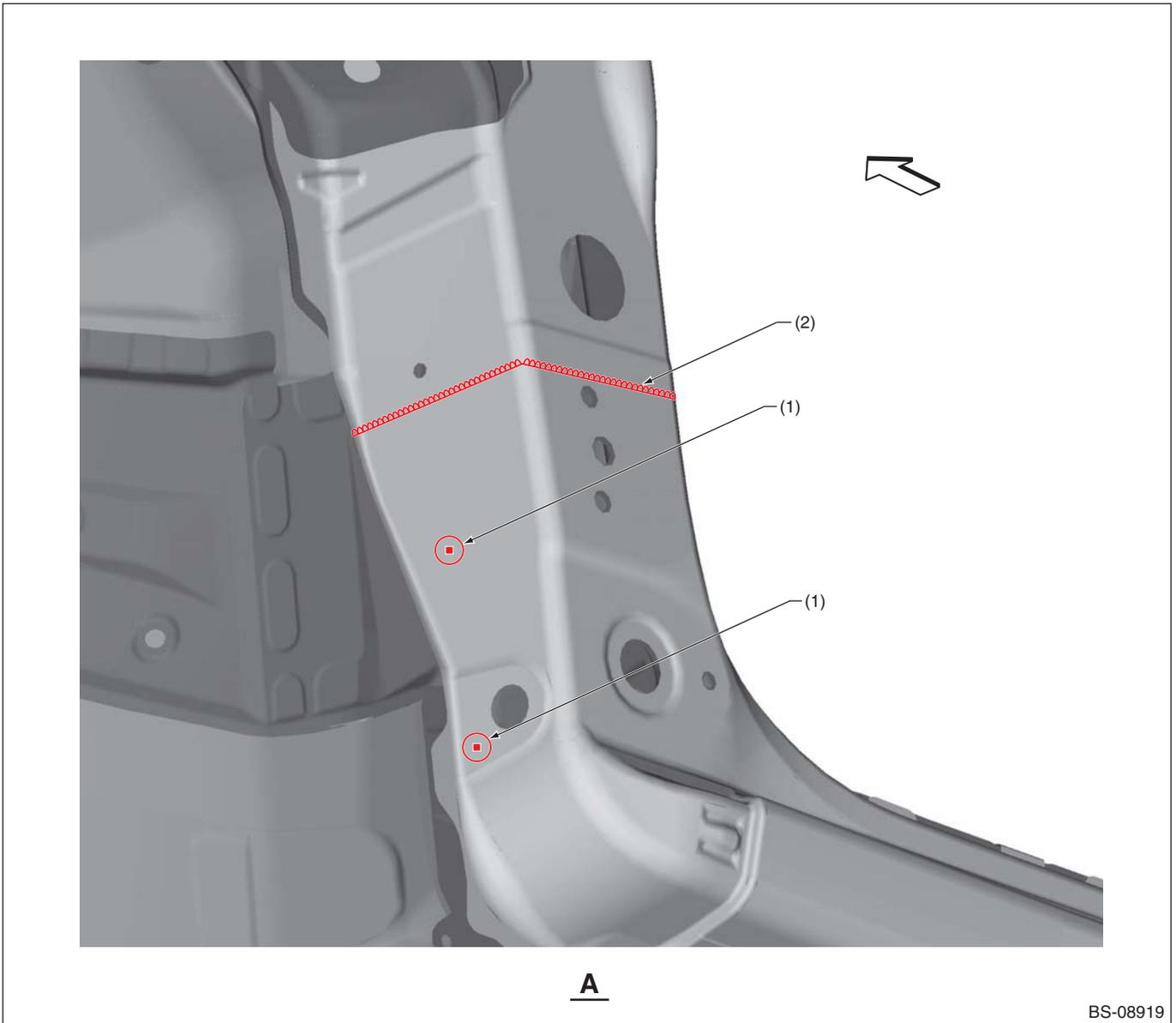
(4) 1 point

(8) 7 points

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

# Panel Replacement

## • Views A

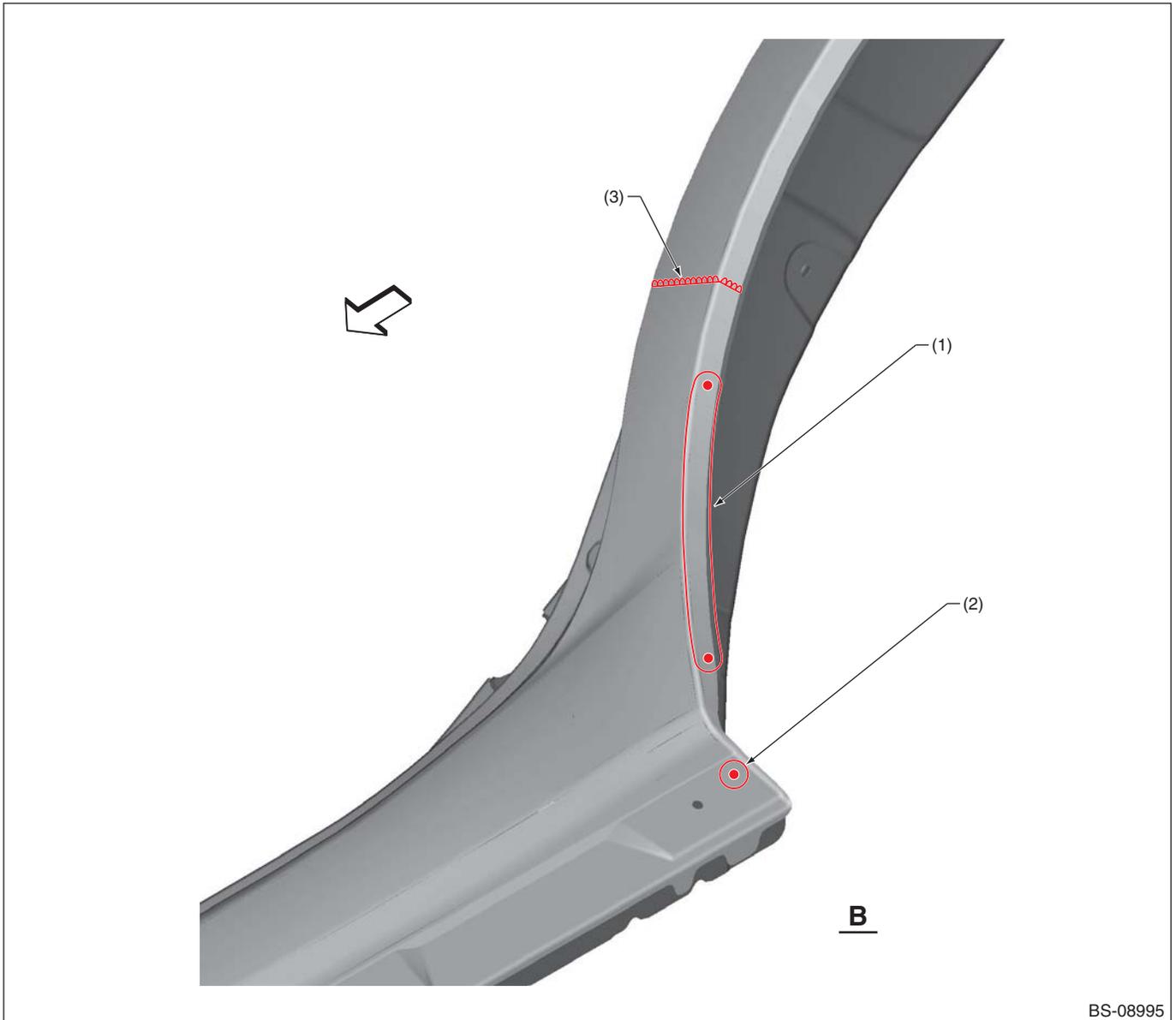


(1) 1 point (service)

(2) 1 point (Continuous welding)

# Panel Replacement

## • Views B (5D/4D model)



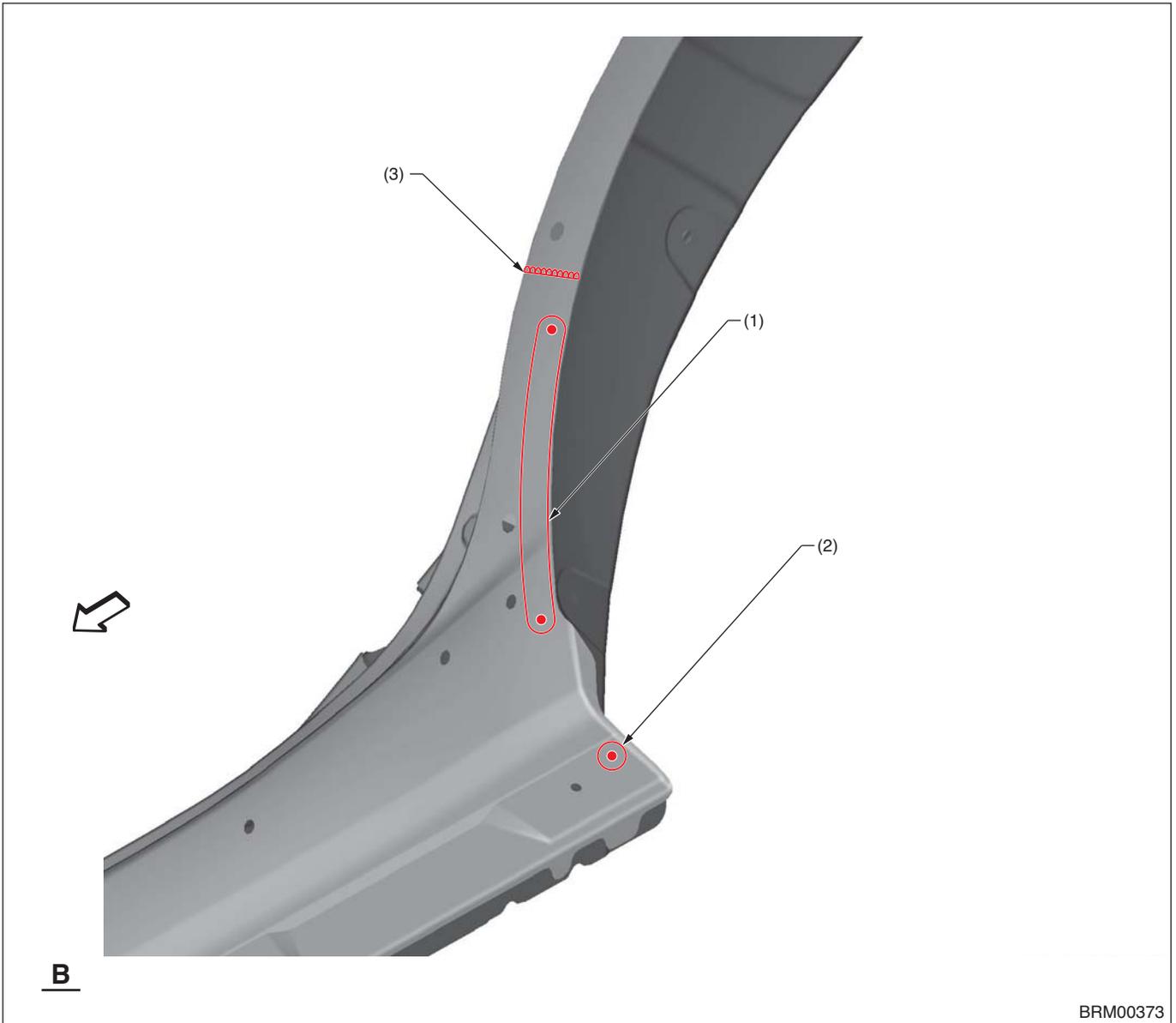
(1) 3 points

(2) 1 point

(3) 1 point (Continuous welding)

# Panel Replacement

## • Views B (XV / Hybrid model)



(1) 3 points

(2) 1 point

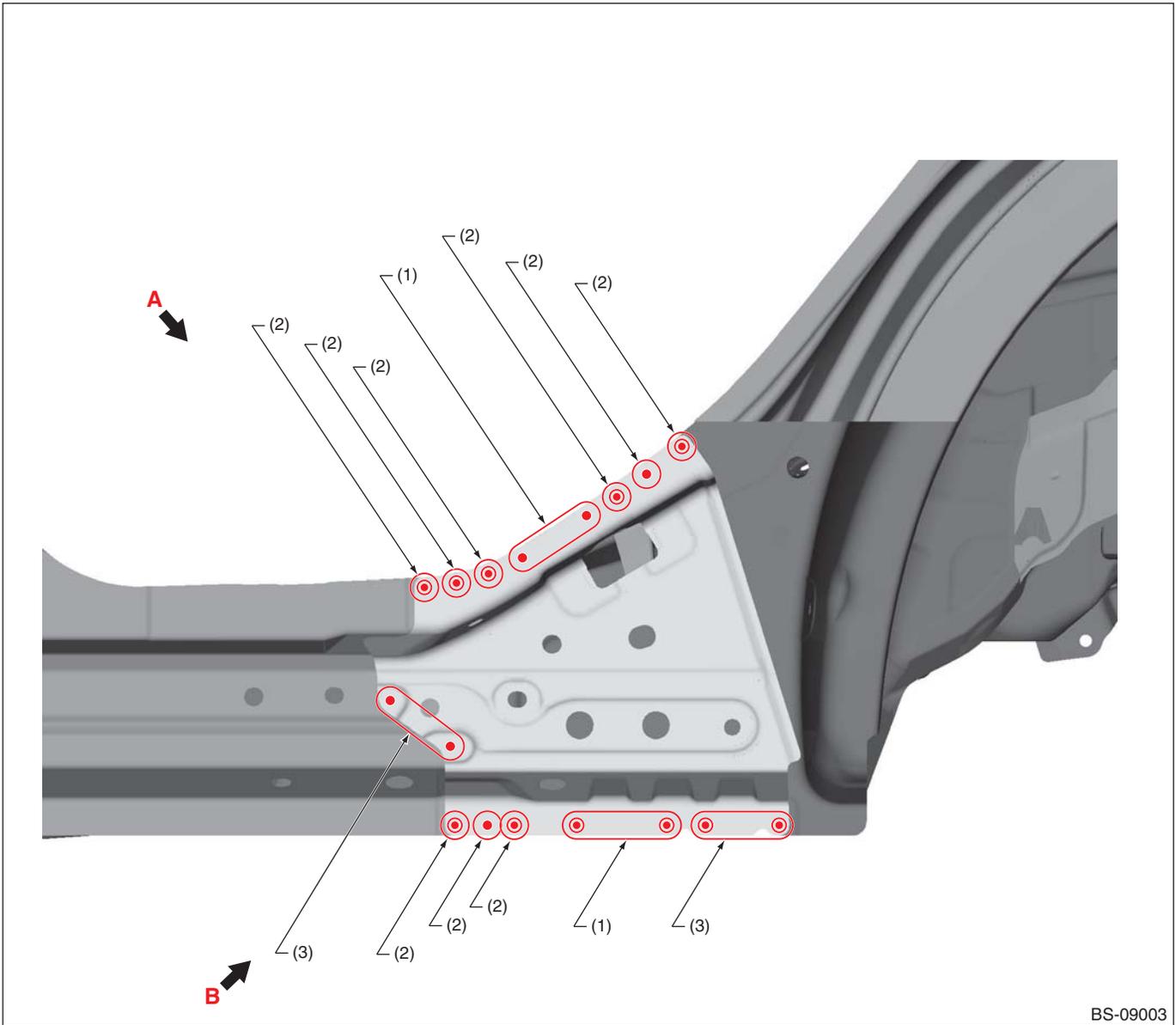
(3) 1 point (Continuous welding)

# Panel Replacement

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

### A: REMOVAL

- Overall view



BS-09003

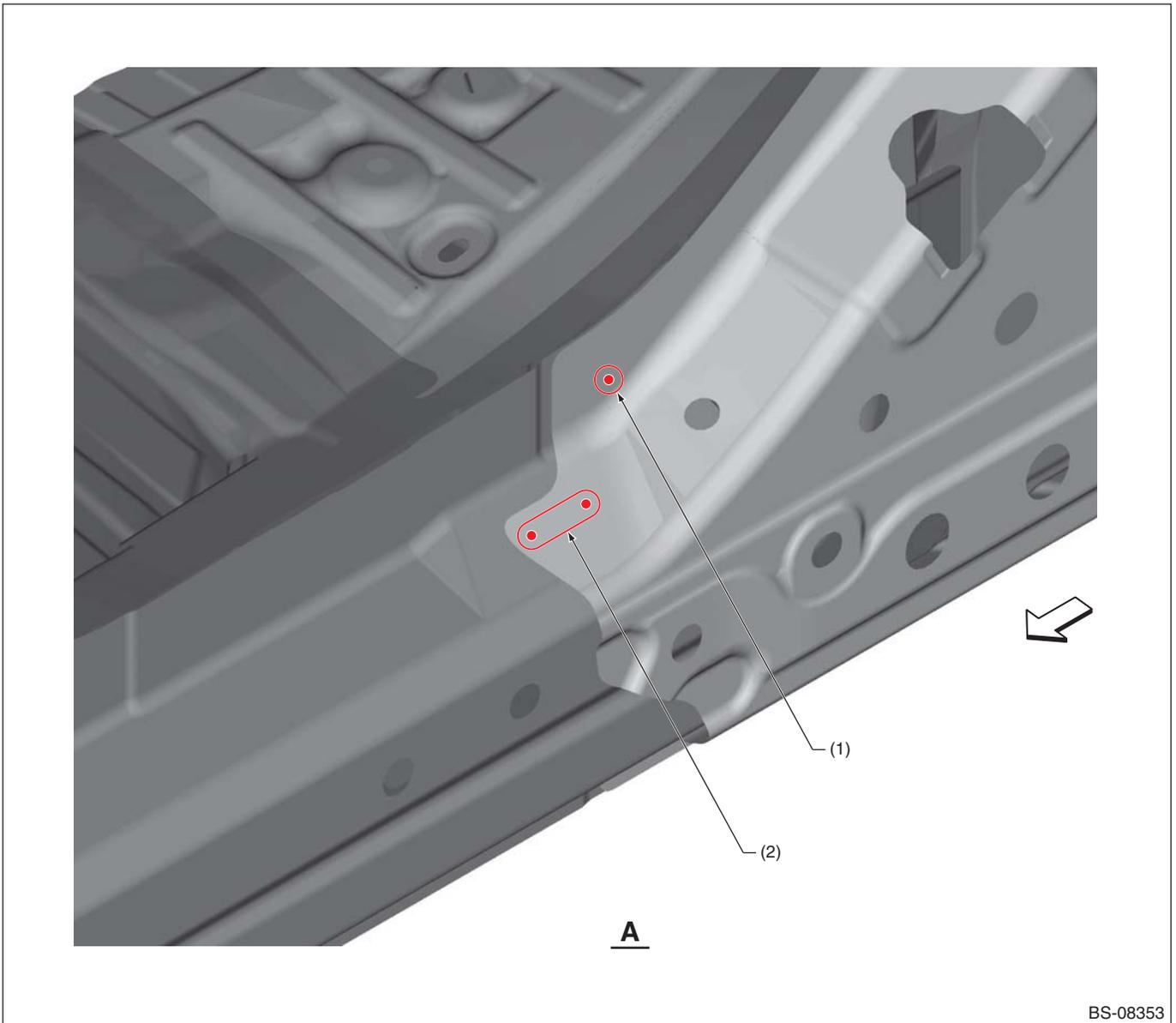
(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

(3) 2 points (outside · 1)

# Panel Replacement

## • Views A



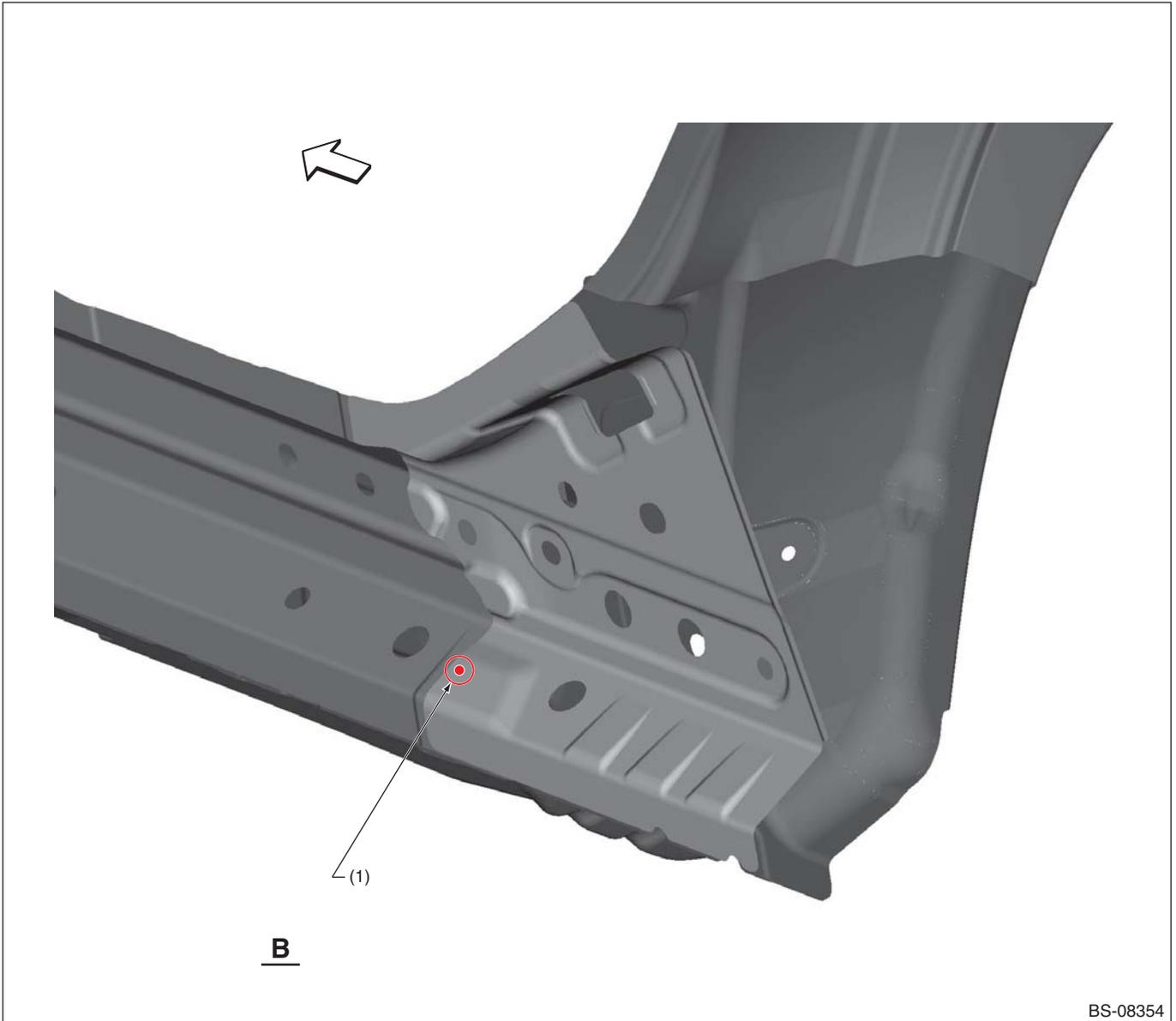
BS-08353

(1) 1 point (outside - 1)

(2) 2 points (top - 1)

# Panel Replacement

## • Views B

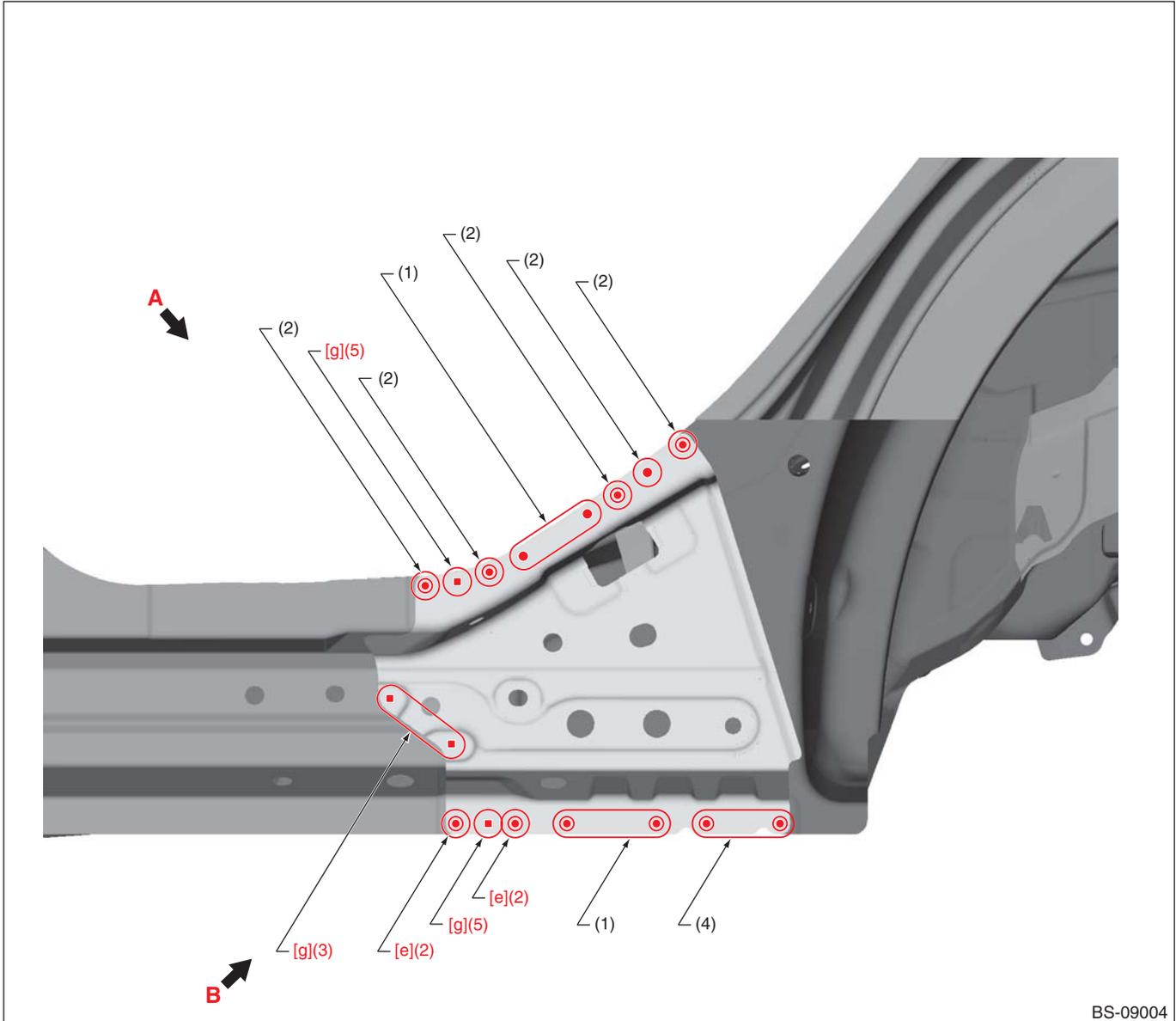


(1) 1 point (bottom · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09004

(1) 3 points  
(2) 1 point

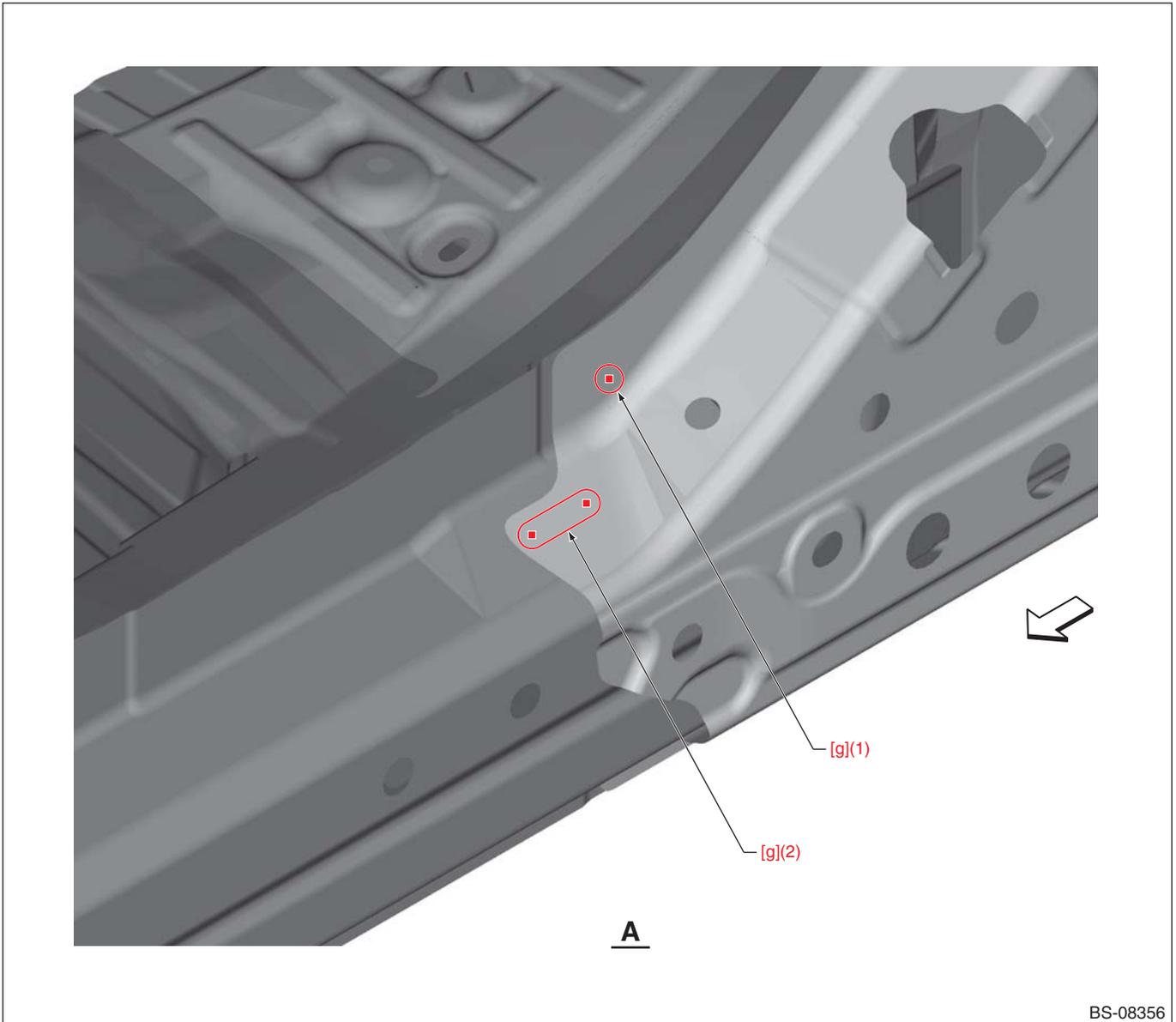
(3) 2 points (service)  
(4) 2 points

(5) 1 point (service)

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

# Panel Replacement

## • Views A



(1) 1 point (service)

(2) 2 points (service)

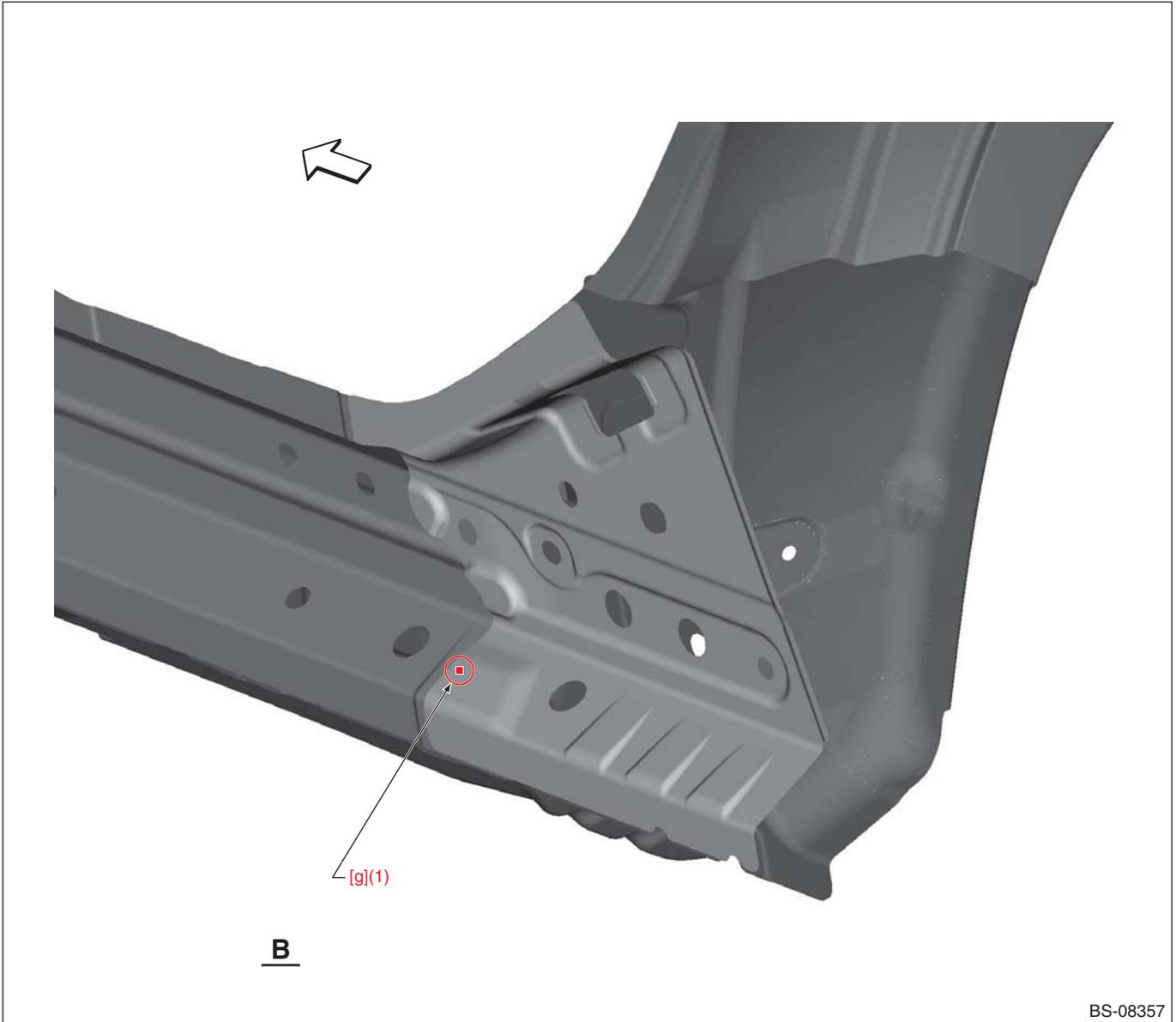
[g] Plug welding

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

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

# Panel Replacement

## • Views B



(1) 1 point (service)

[g] Plug welding

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

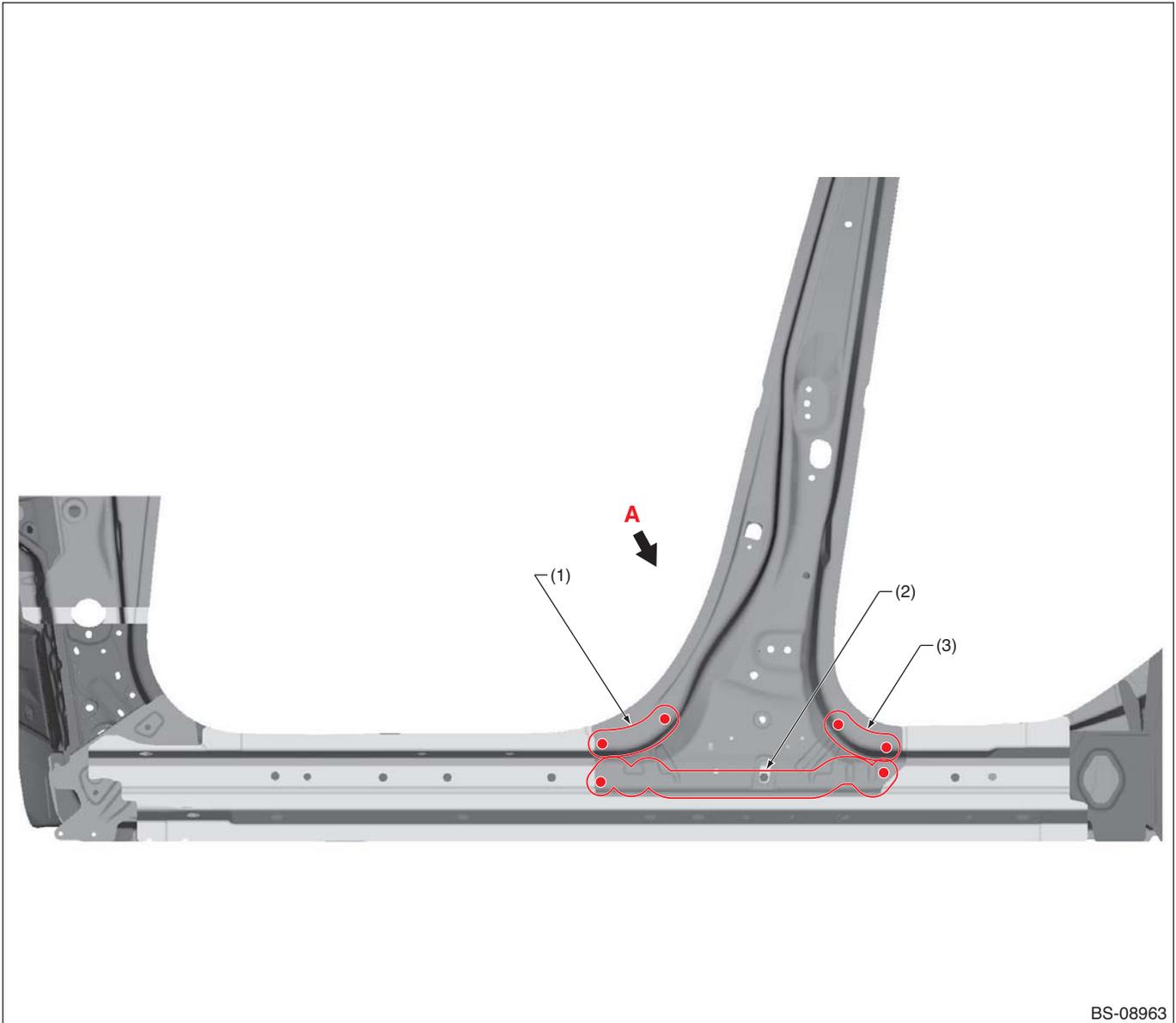
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

# Panel Replacement

## 8-20. Side Sill Reinforcement Outer (total replacement)

### A: REMOVAL

- Overall view1 (Gasoline model)



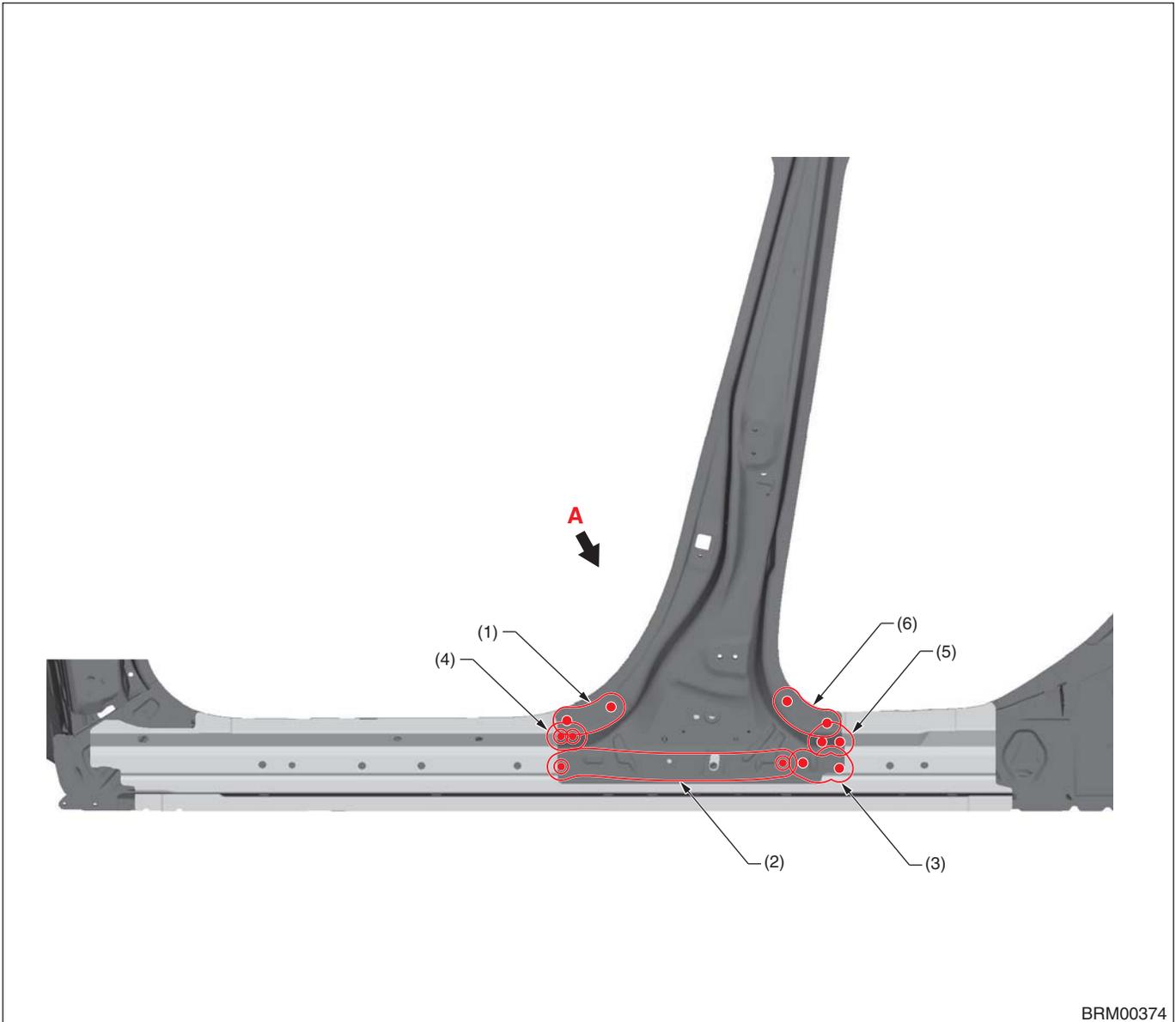
(1) 5 points (outside · 1)

(2) 16 points (outside · 1)

(3) 4 points (outside · 1)

# Panel Replacement

## • Overall view1 (Hybrid model)



BRM00374

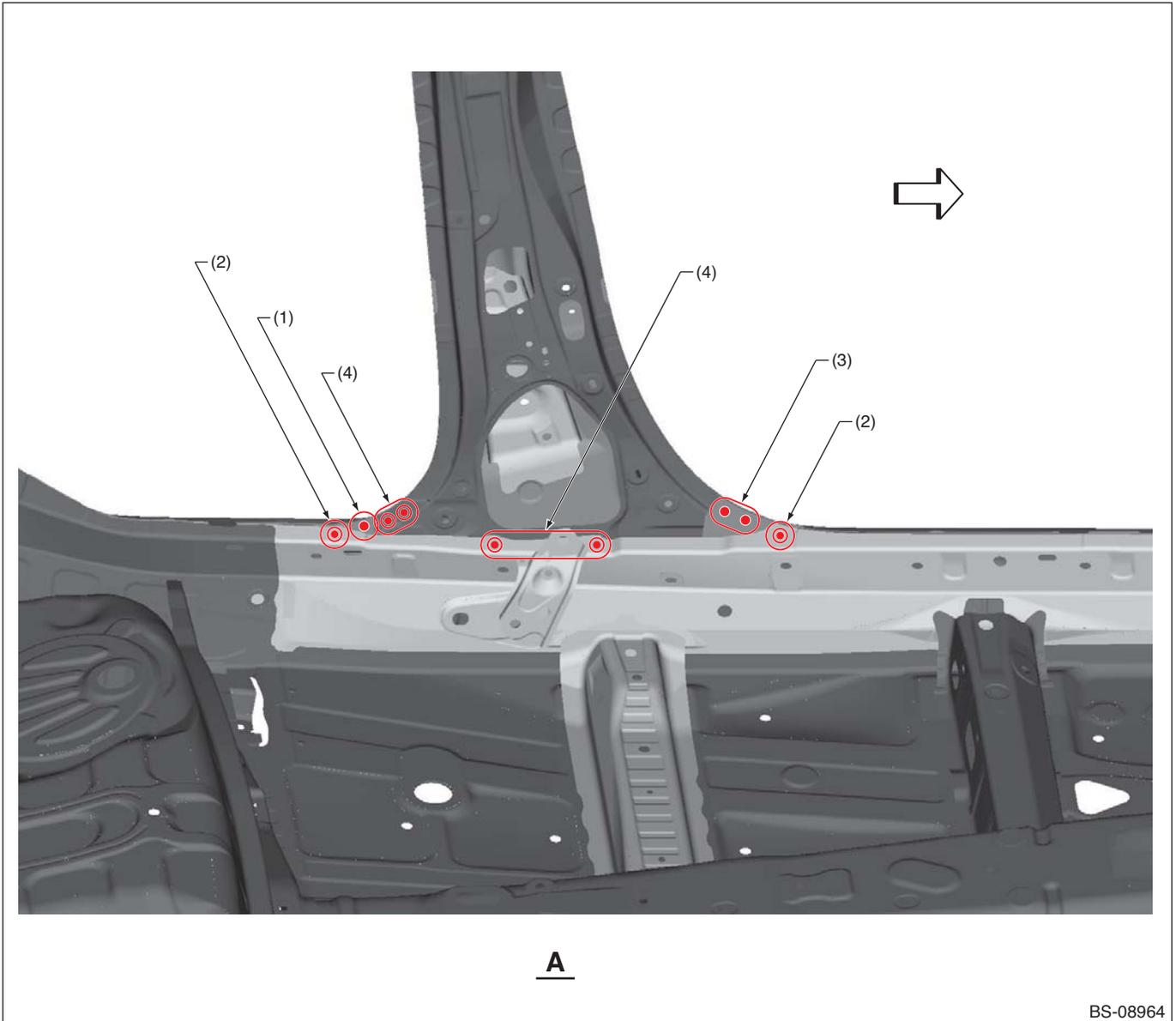
(1) 5 points (outside · 1)  
(2) 10 points (outside · 1)

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

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

# Panel Replacement

## • Views A



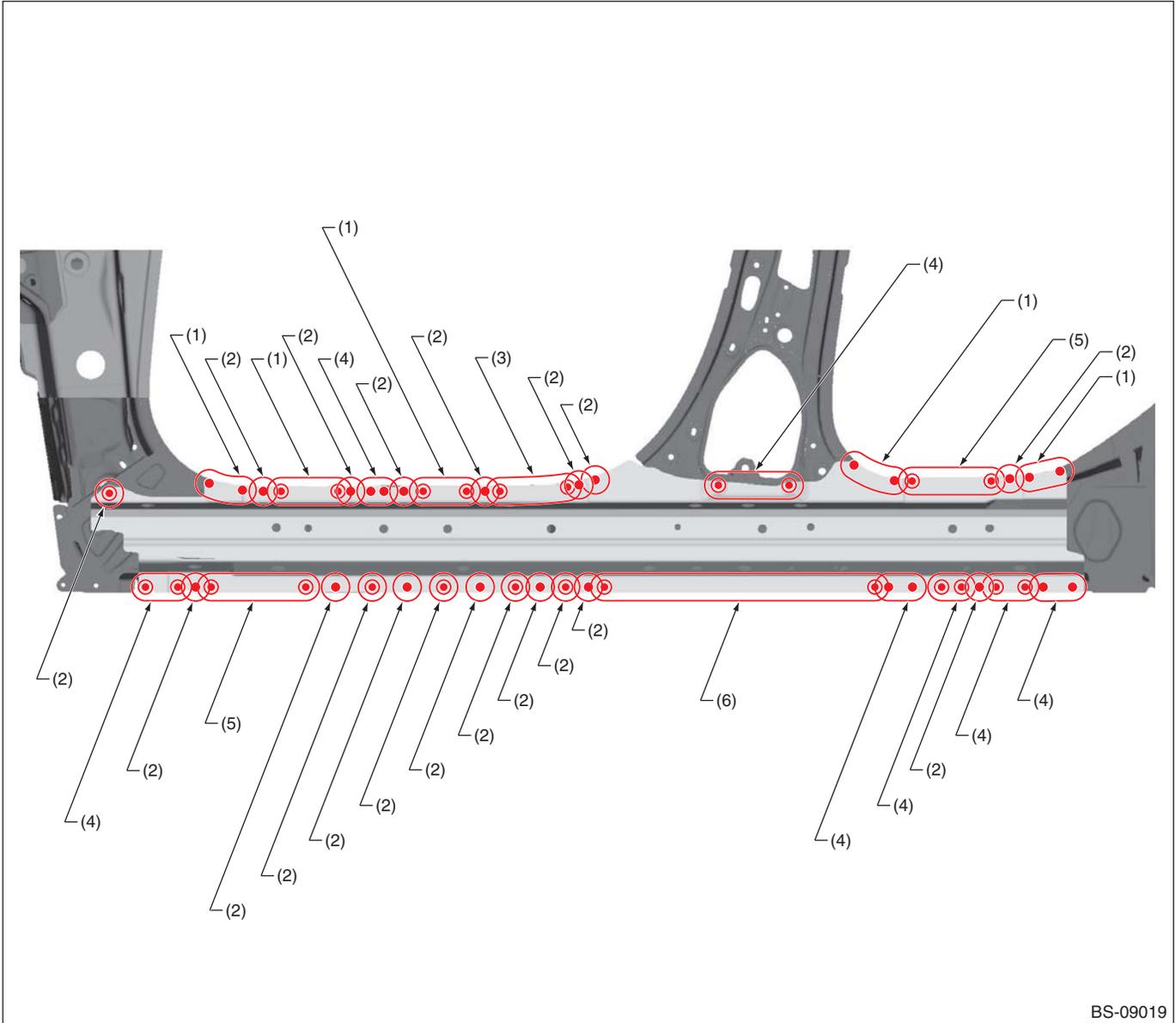
(1) 1 point (inside · 1)  
(2) 1 point (inside · 2)

(3) 2 points (inside · 1)

(4) 2 points (inside · 2)

# Panel Replacement

## • Overall view2 (Gasoline model)



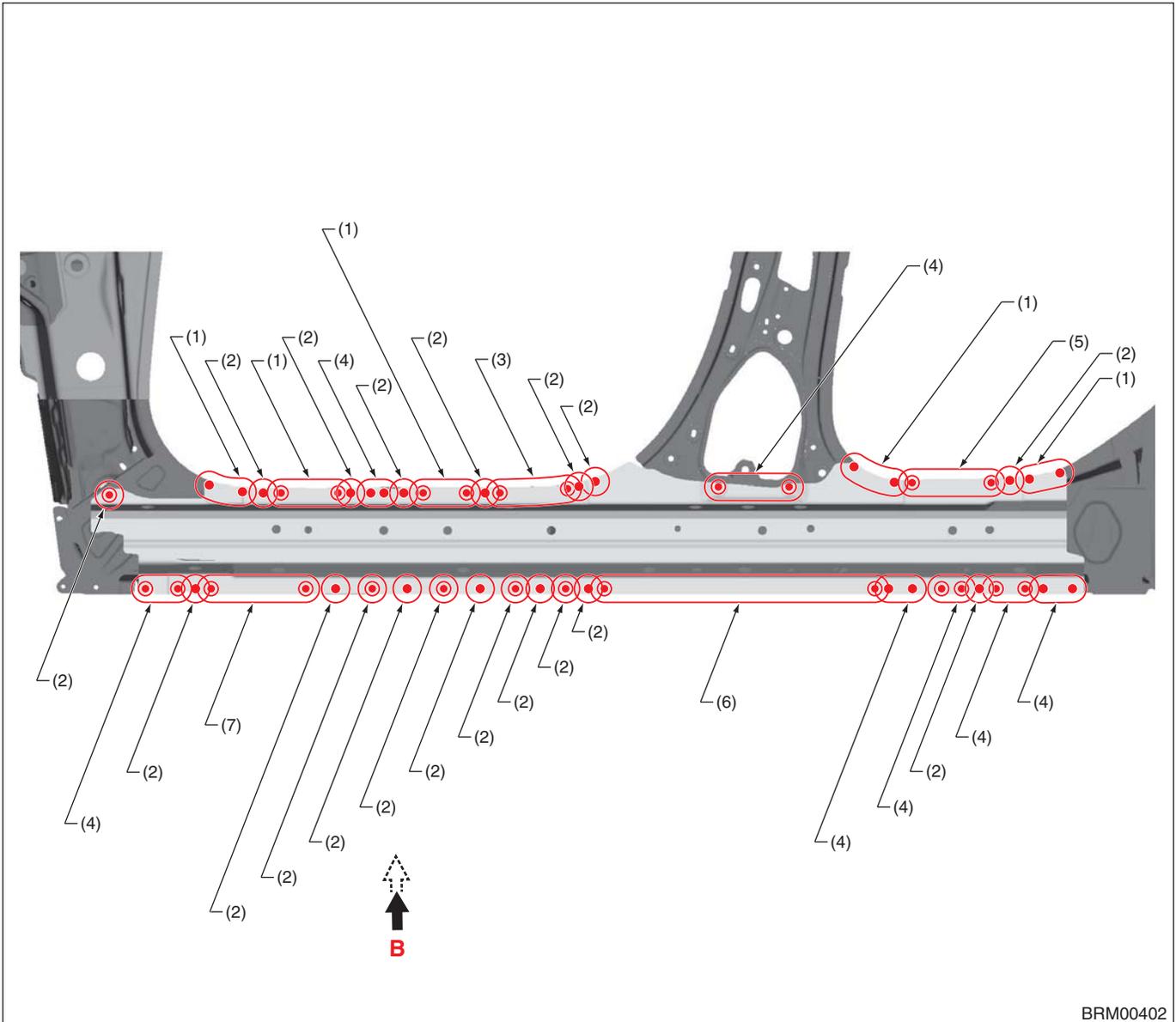
(1) 3 points (outside · 1)  
 (2) 1 point (outside · 1)

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

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

# Panel Replacement

## • Overall view2 (Hybrid model)



BRM00402

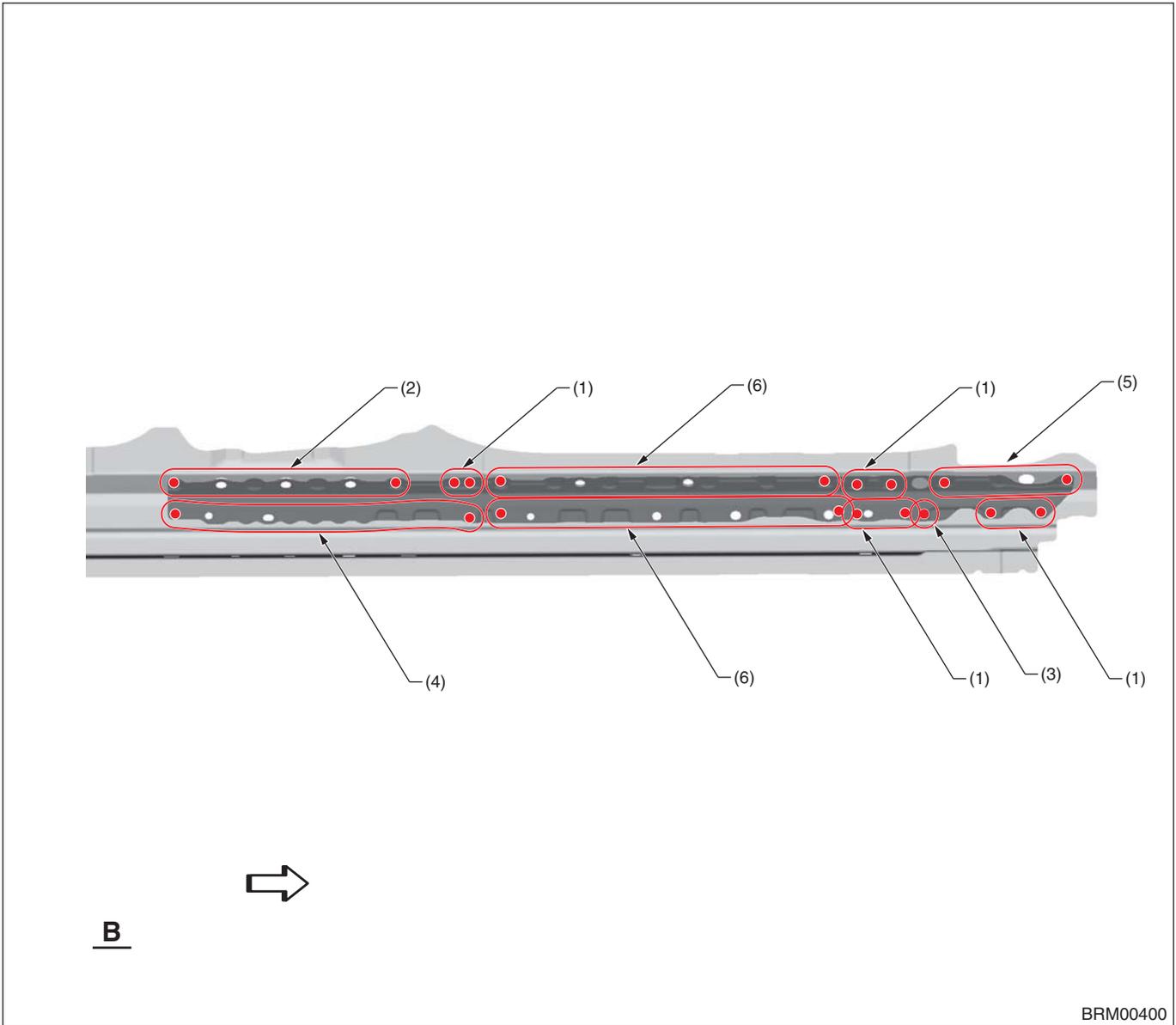
- (1) 3 points (outside · 1)
- (2) 1 point (outside · 1)
- (3) 7 points (outside · 1)

- (4) 2 points (outside · 1)
- (5) 5 points (outside · 1)
- (6) 11 points (outside · 1)

- (7) 6 points (outside · 1)

# Panel Replacement

## • Views B (Hybrid model)



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

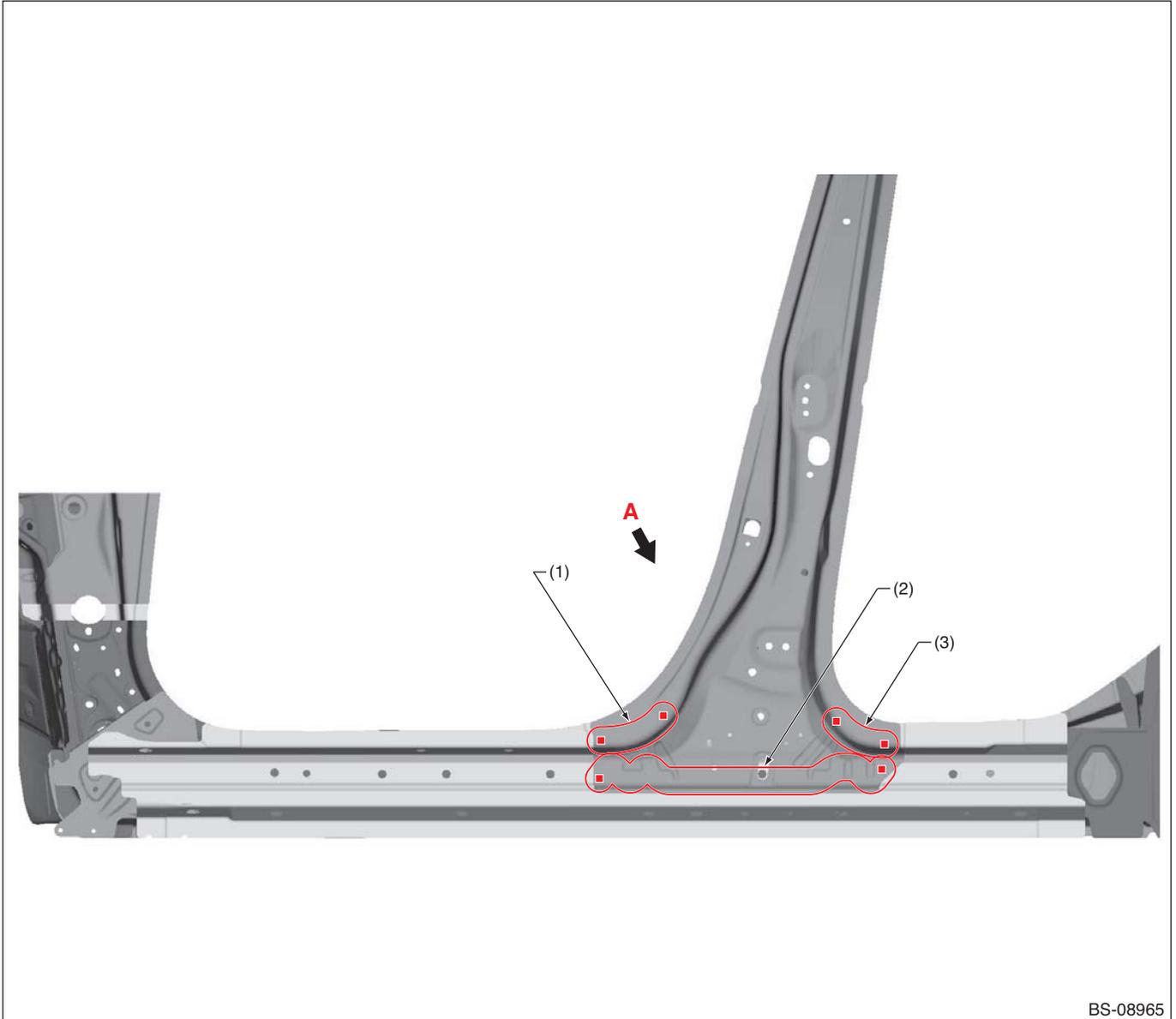
(3) 1 point (inside · 1)  
(4) 10 points (inside · 1)

(5) 3 points (inside · 1)  
(6) 7 points (inside · 1)

# Panel Replacement

## B: INSTALLATION

• Overall view1 (Gasoline model)



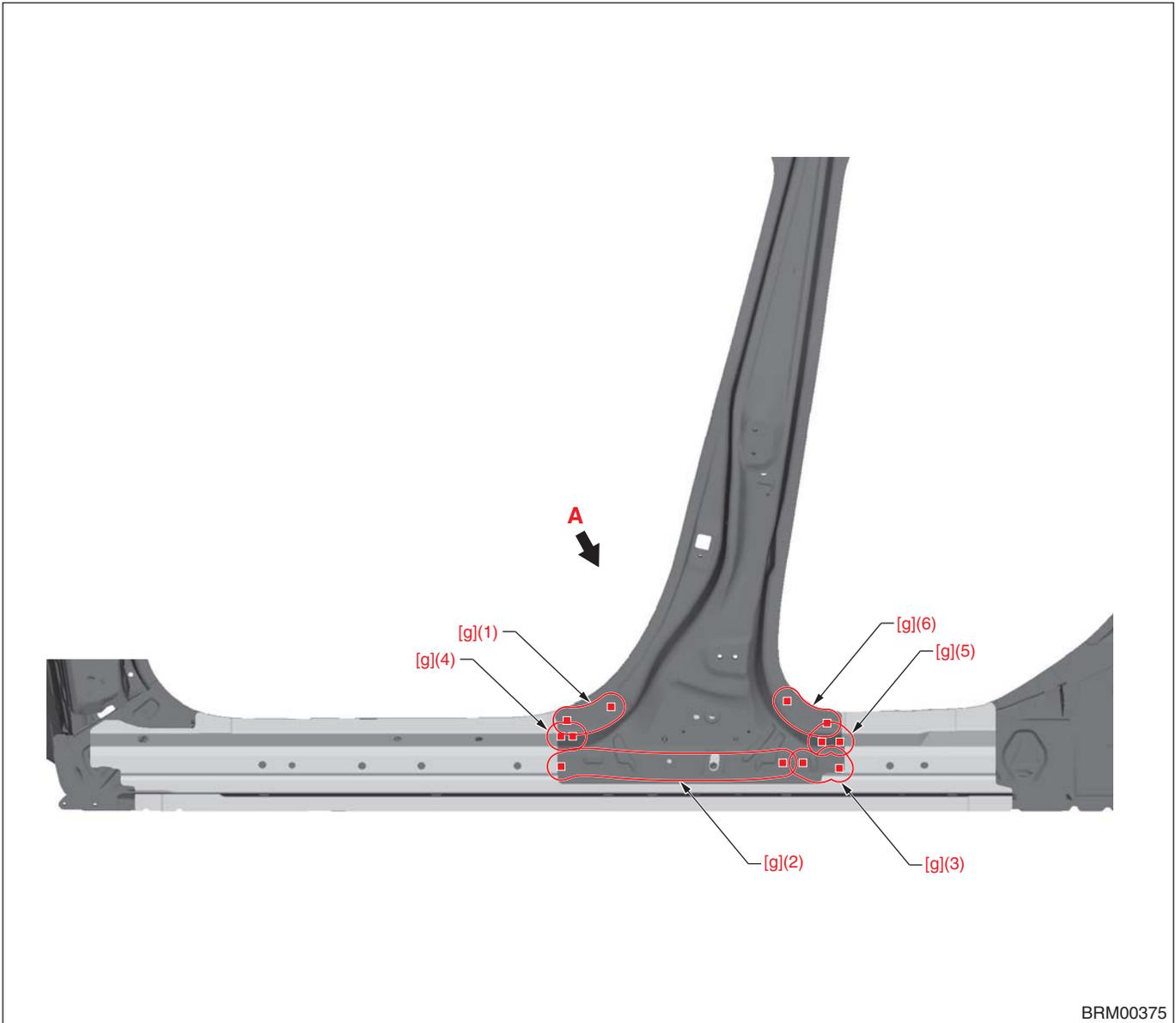
(1) 5 points

(2) 16 points

(3) 4 points

# Panel Replacement

- Overall view1 (Hybrid model)



BRM00375

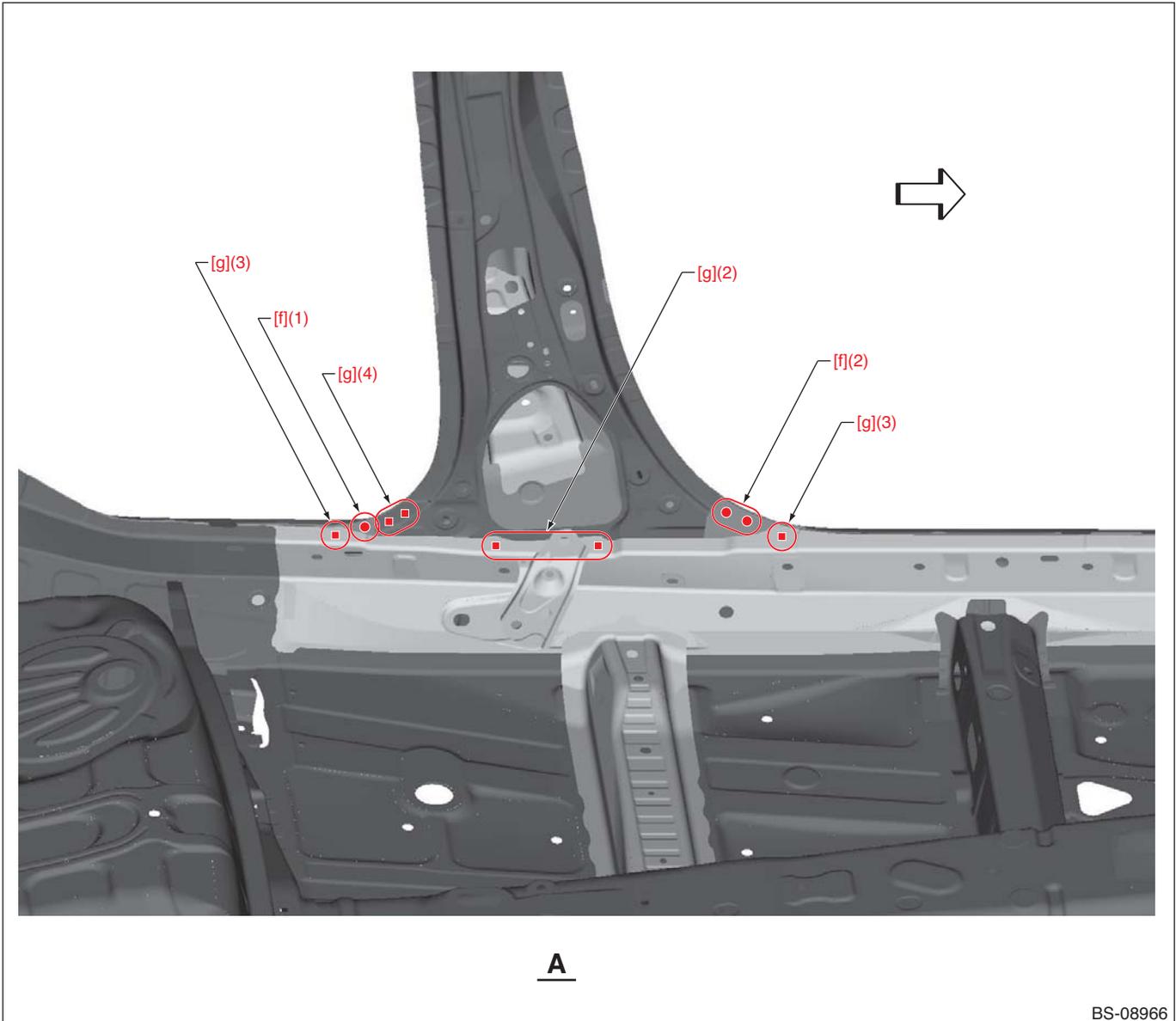
(1) 5 points  
(2) 10 points

(3) 4 points  
(4) 2 points

(5) 3 points  
(6) 6 points

# Panel Replacement

## • Views A



(1) 1 point  
(2) 2 points

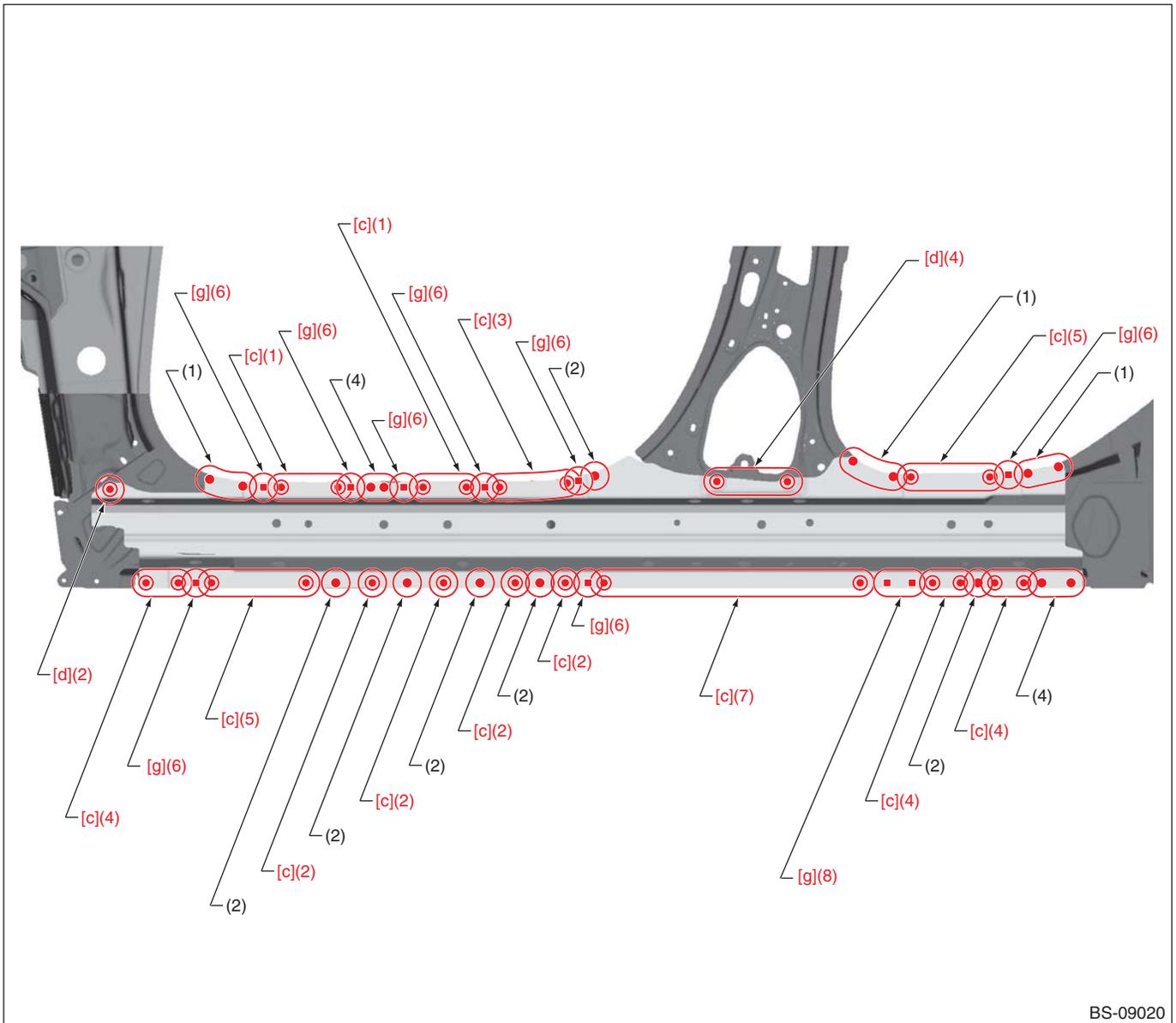
(3) 1 point (service · matching)

(4) 2 points (service · matching)

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

# Panel Replacement

## • Overall view2 (Gasoline model)



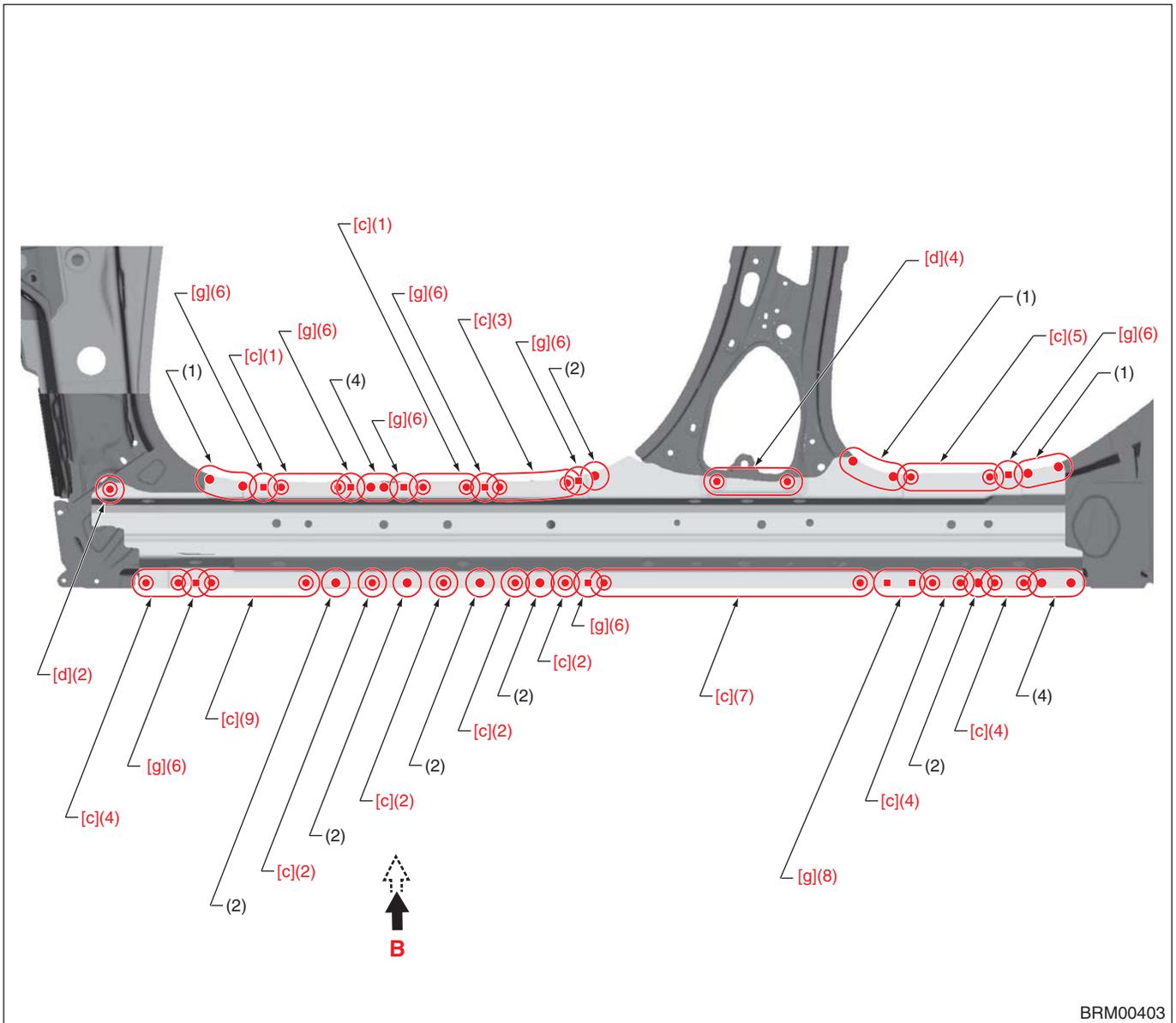
BS-09020

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

[c] Spot welding	Compression: 3.0 kN, Current: 6.5 kA, Welding time: 25 cyc
[d] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 25 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

# Panel Replacement

## • Overall view2 (Hybrid model)



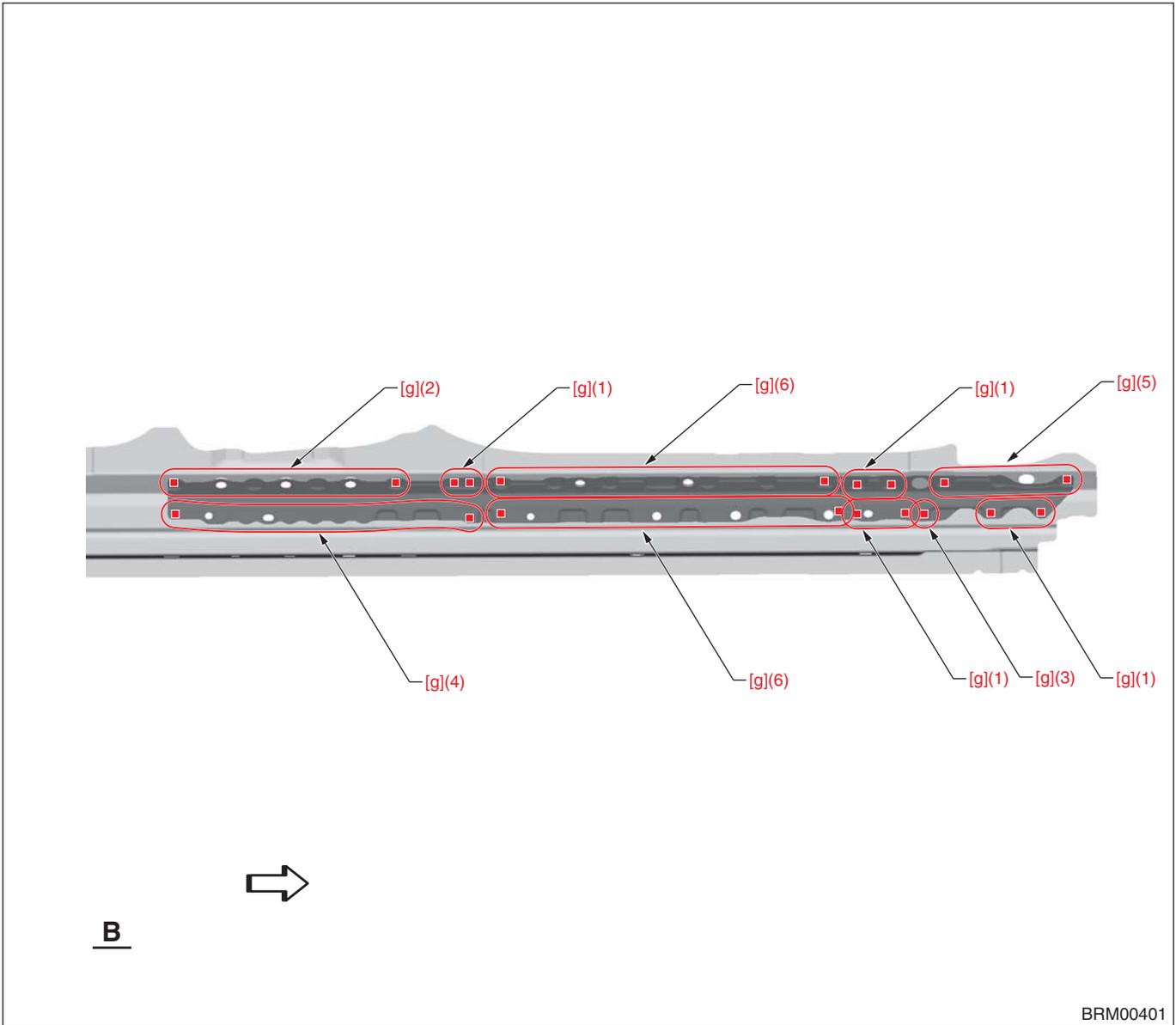
BRM00403

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

[c] Spot welding	Compression: 3.0 kN, Current: 6.5 kA, Welding time: 25 cyc
[d] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 25 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

# Panel Replacement

## • Views B (Hybrid model)



(1) 2 points  
(2) 4 points

(3) 1 point  
(4) 10 points

(5) 3 points  
(6) 7 points

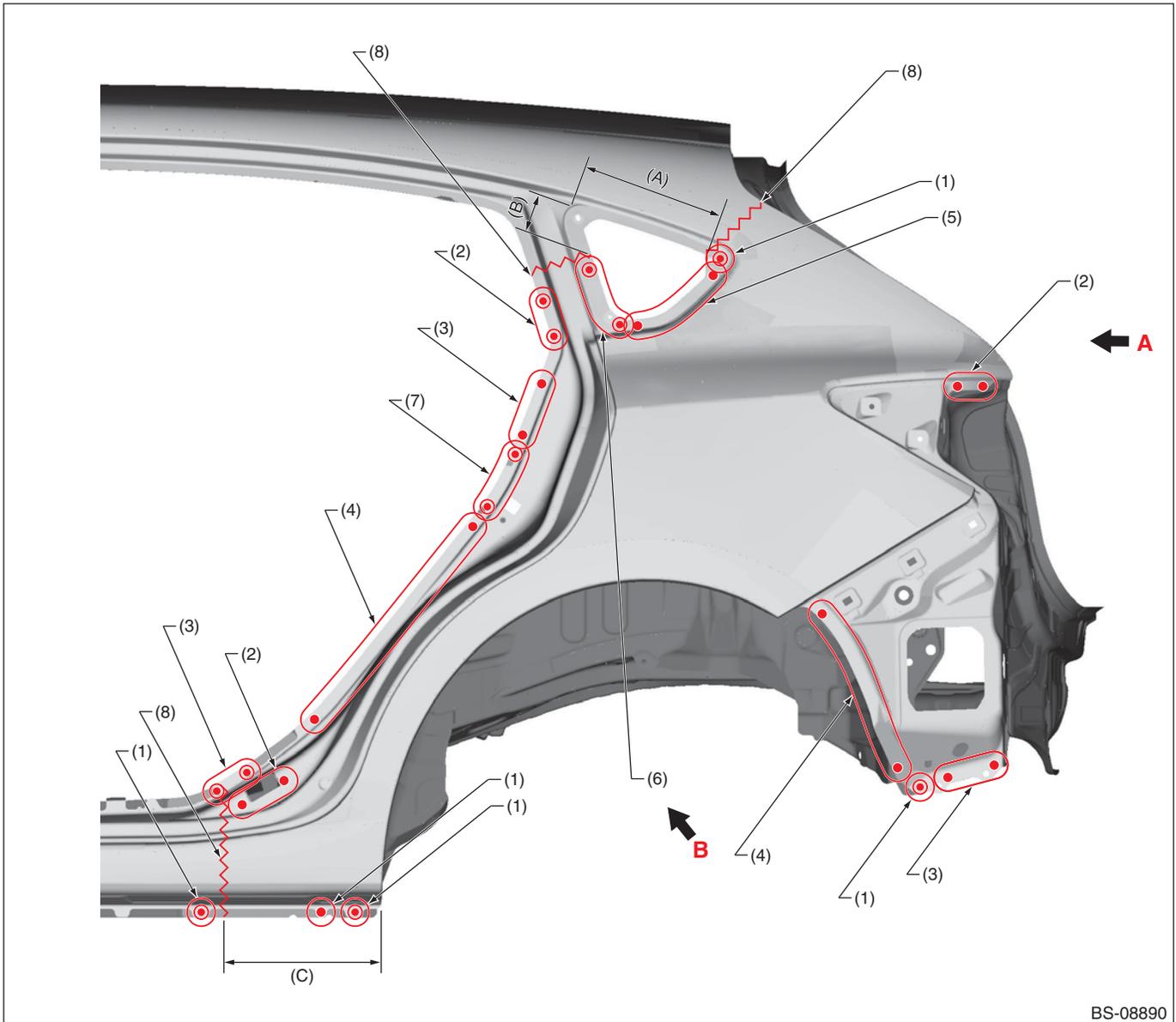
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)
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# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-08890

(A) 250 mm [9.84 in]

(B) 130 mm [5.12 in]

(C) 250 mm [9.84 in]

(1) 1 point (outside · 1)

(4) 7 points (outside · 1)

(7) 2 points (outside · 2)

(2) 2 points (outside · 1)

(5) 5 points (outside · 1)

(8) Cut position

(3) 3 points (outside · 1)

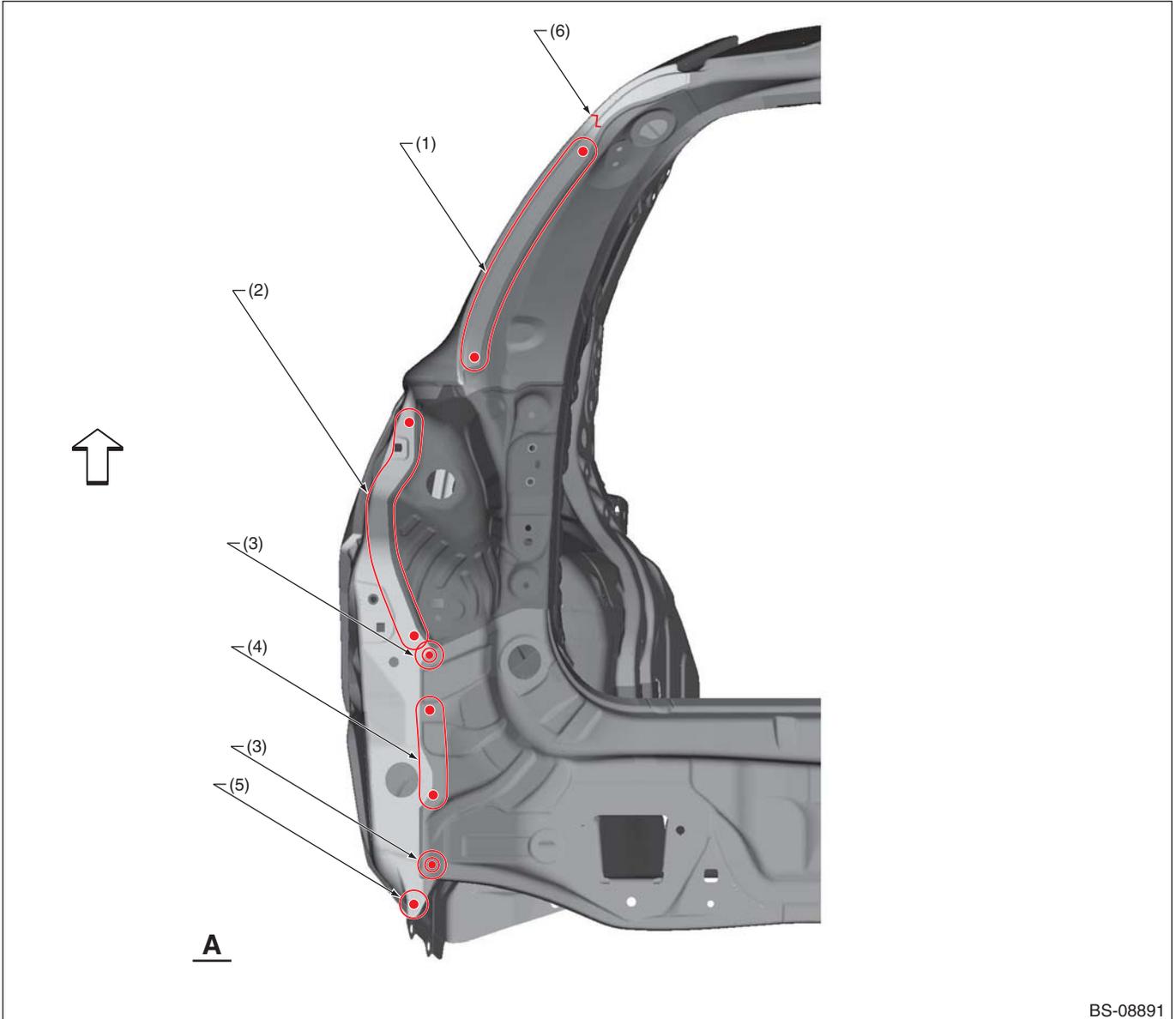
(6) 4 points (outside · 1)

Note: The illustration shows a gasoline model.

The Hybrid model has a different panel shape from the gasoline model, but the number of welding points and their locations are the same as with the gasoline model.

# Panel Replacement

## • Views A



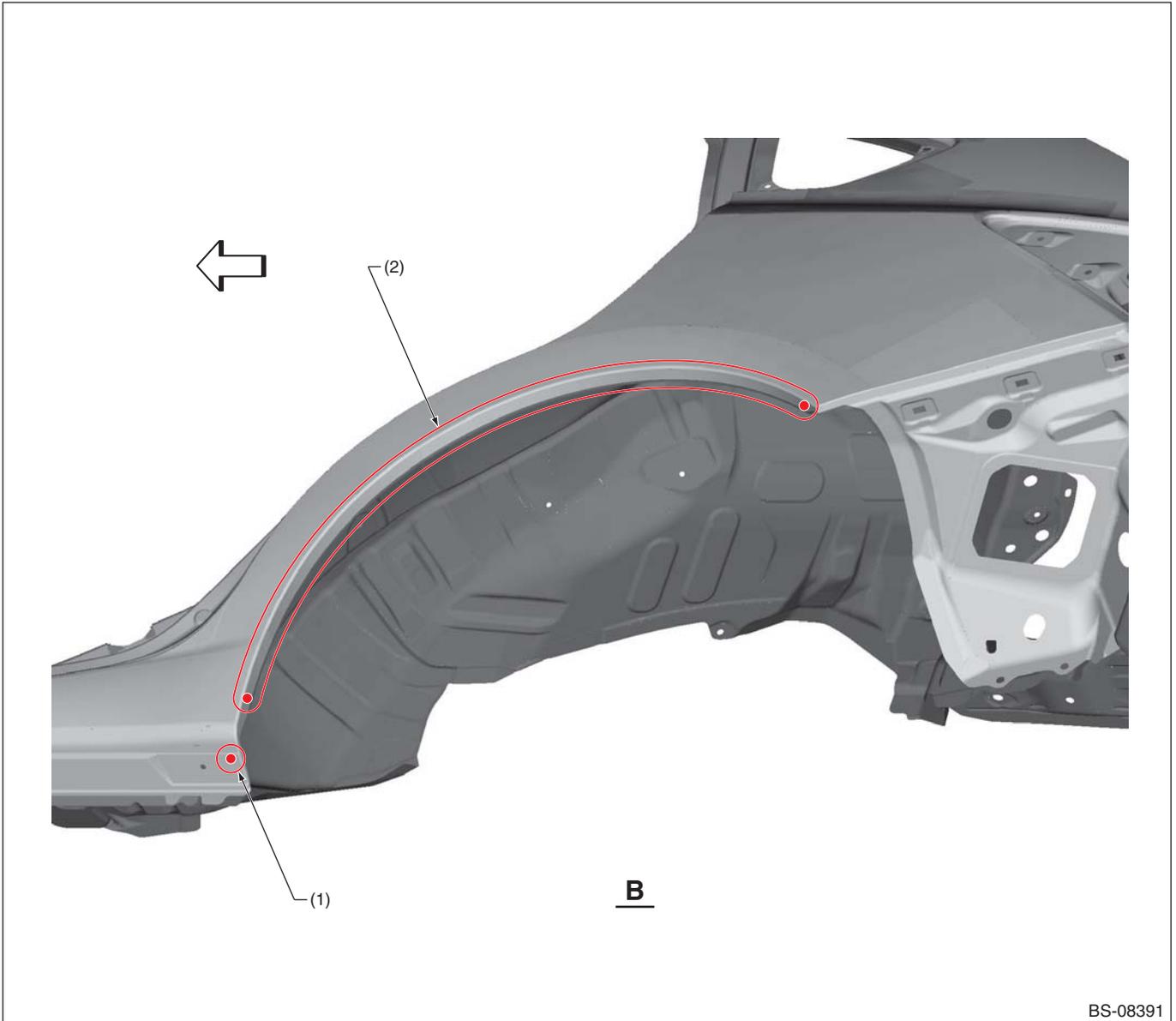
(1) 8 points (outside · 1)  
(2) 6 points (outside · 1)

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

(5) 1 point (outside · 1)  
(6) Cut position

# Panel Replacement

## • Views B (Gasoline model)

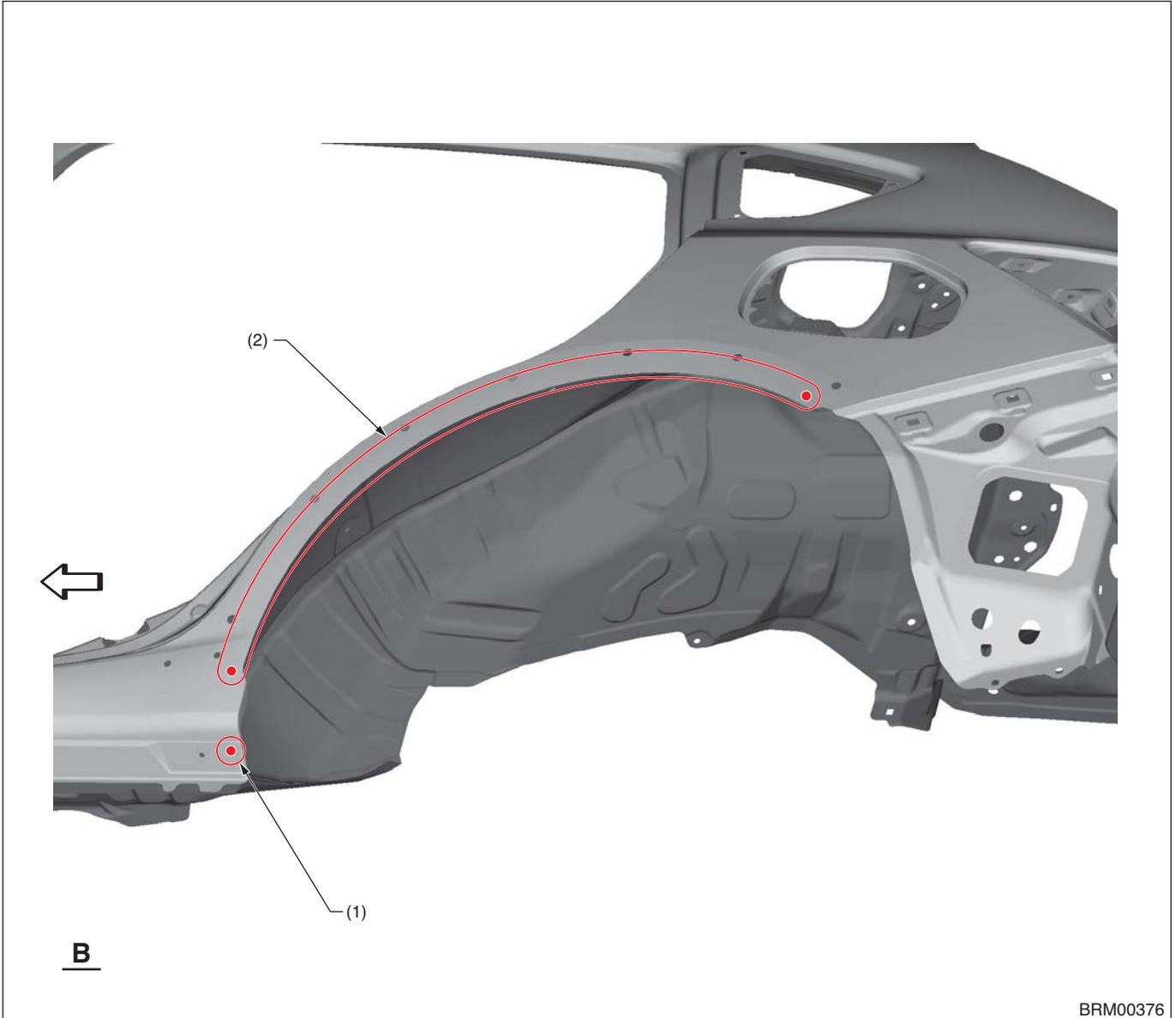


(1) 1 point (bottom · 1)

(2) 14 points (bottom · 1)

# Panel Replacement

## • Views B (XV / Hybrid model)



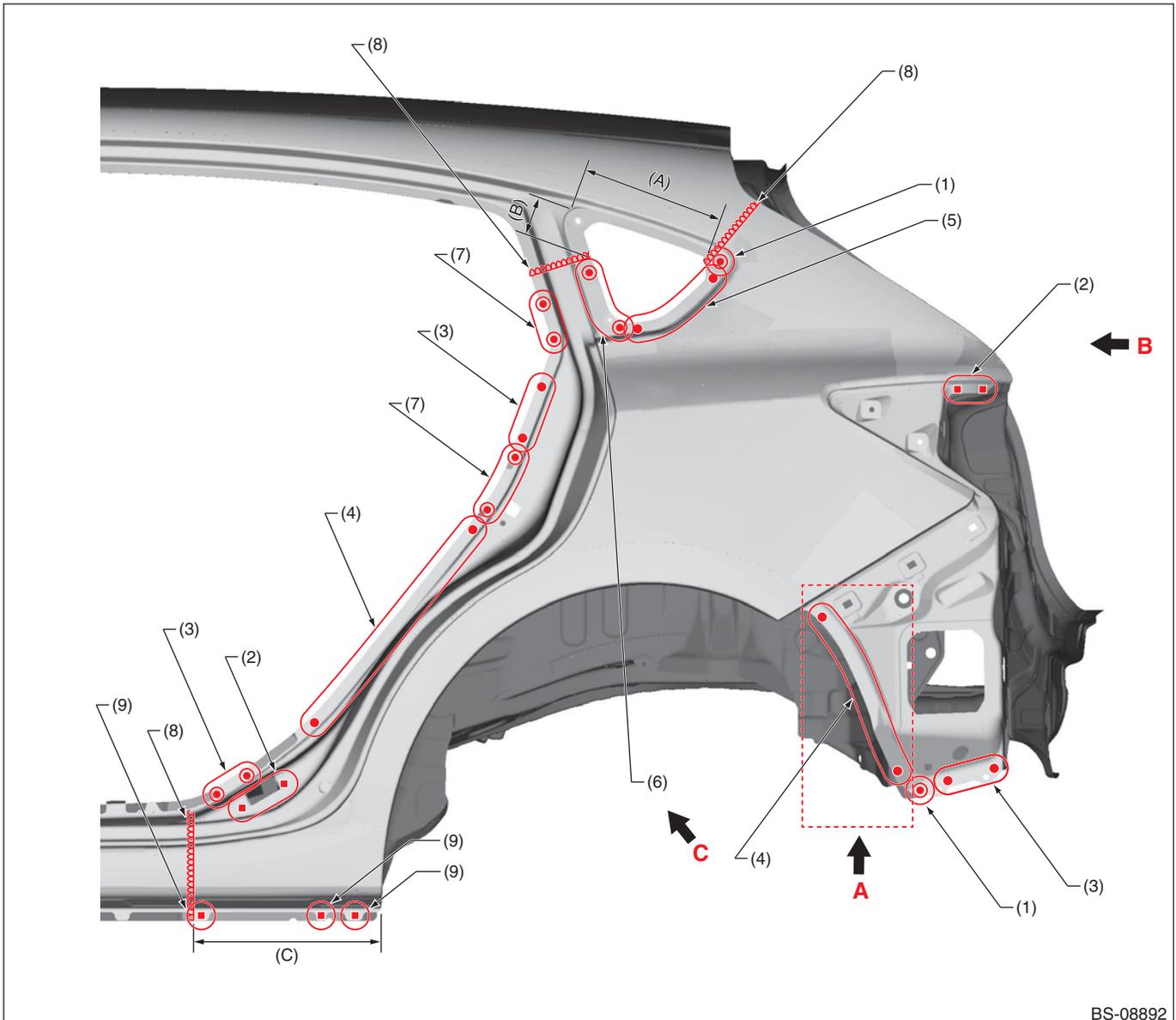
(1) 1 point (bottom · 1)

(2) 12 points (outside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



(A) 230 mm [9.06 in]

(B) 110 mm [4.33 in]

(C) 289 mm [11.38 in]

(1) 1 point

(4) 7 points

(7) 2 points

(2) 2 points (service)

(5) 5 points

(8) 1 point (Continuous welding)

(3) 3 points

(6) 4 points

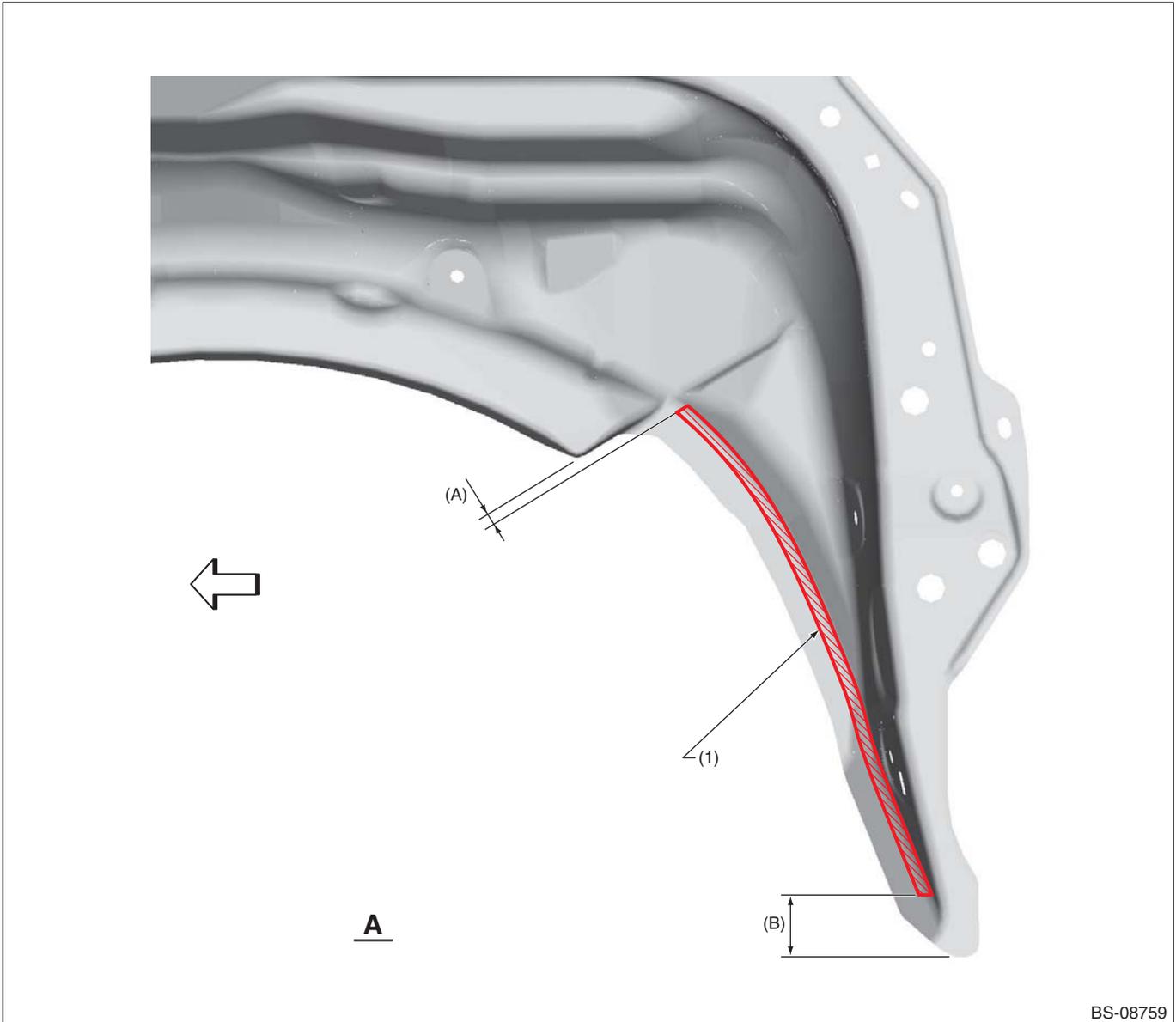
(9) 1 point (service)

Note: The illustration shows a gasoline model.

The Hybrid model has a different panel shape from the gasoline model, but the number of welding points and their locations are the same as with the gasoline model.

# Panel Replacement

## • Views A



(A) 5 mm [0.02 in]

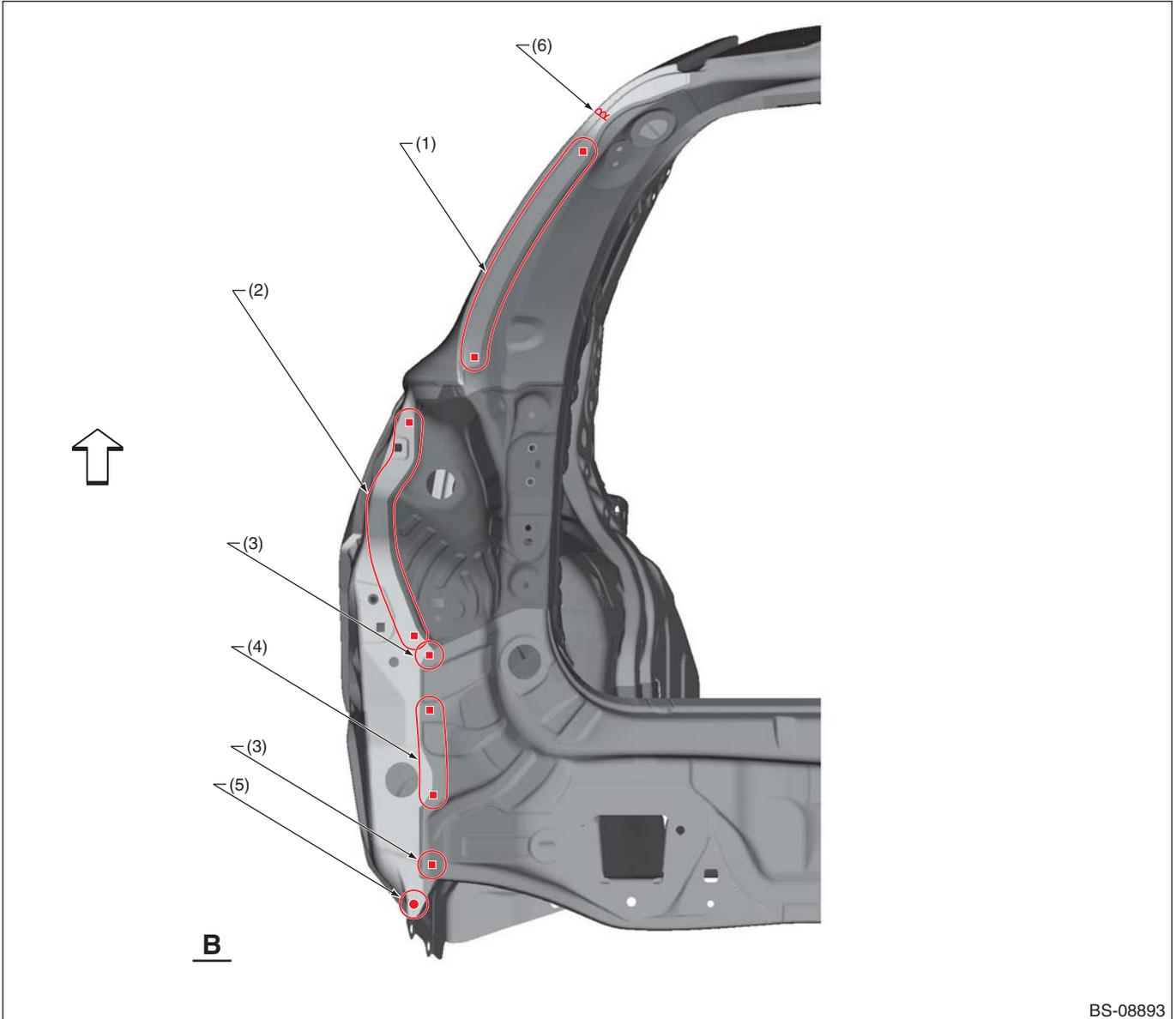
(B) 34 mm [1.34 in]

(1) Spotting sealer

 : Spotting sealer application location (Spotting sealer or sealing [Three Bond 4101 (004403063)])  
Note: Fill spotting sealer between the panel side out and arch rear inner.

# Panel Replacement

## • Views B



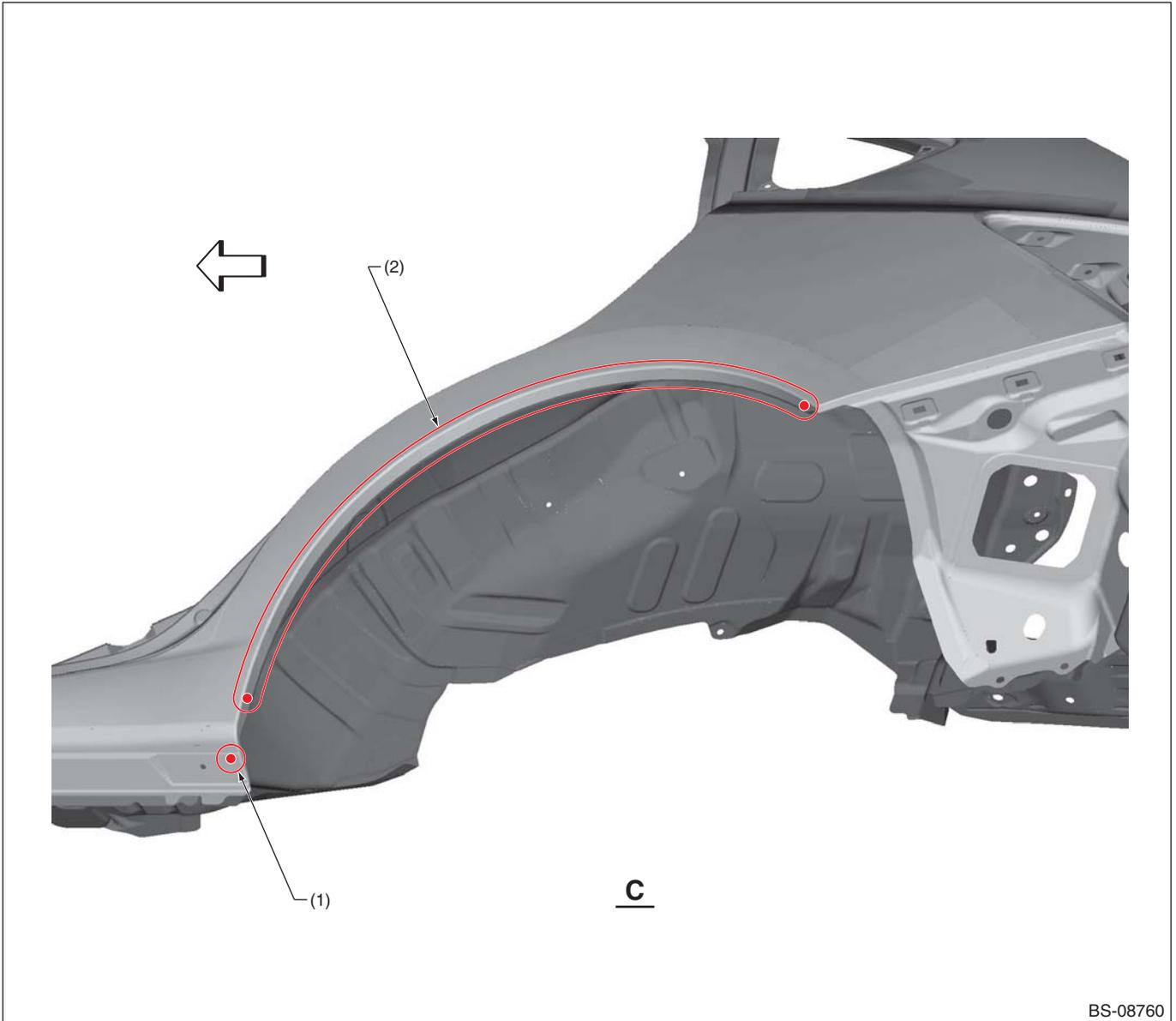
(1) 8 points (service)  
(2) 6 points (service)

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

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

# Panel Replacement

- Views C (Gasoline model)



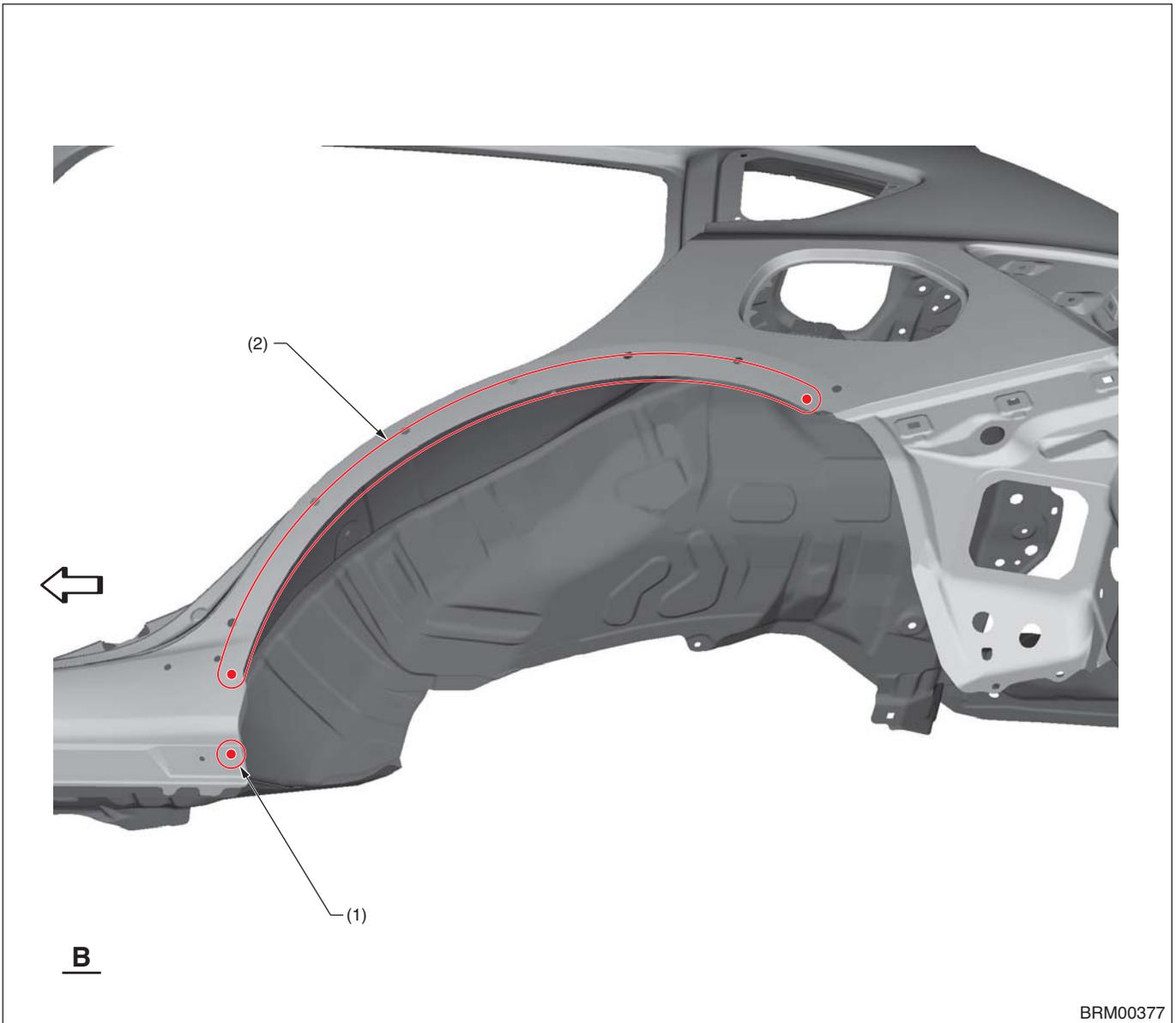
BS-08760

(1) 1 point

(2) 14 points

# Panel Replacement

- Views C (XV / Hybrid model)



(1) 1 point

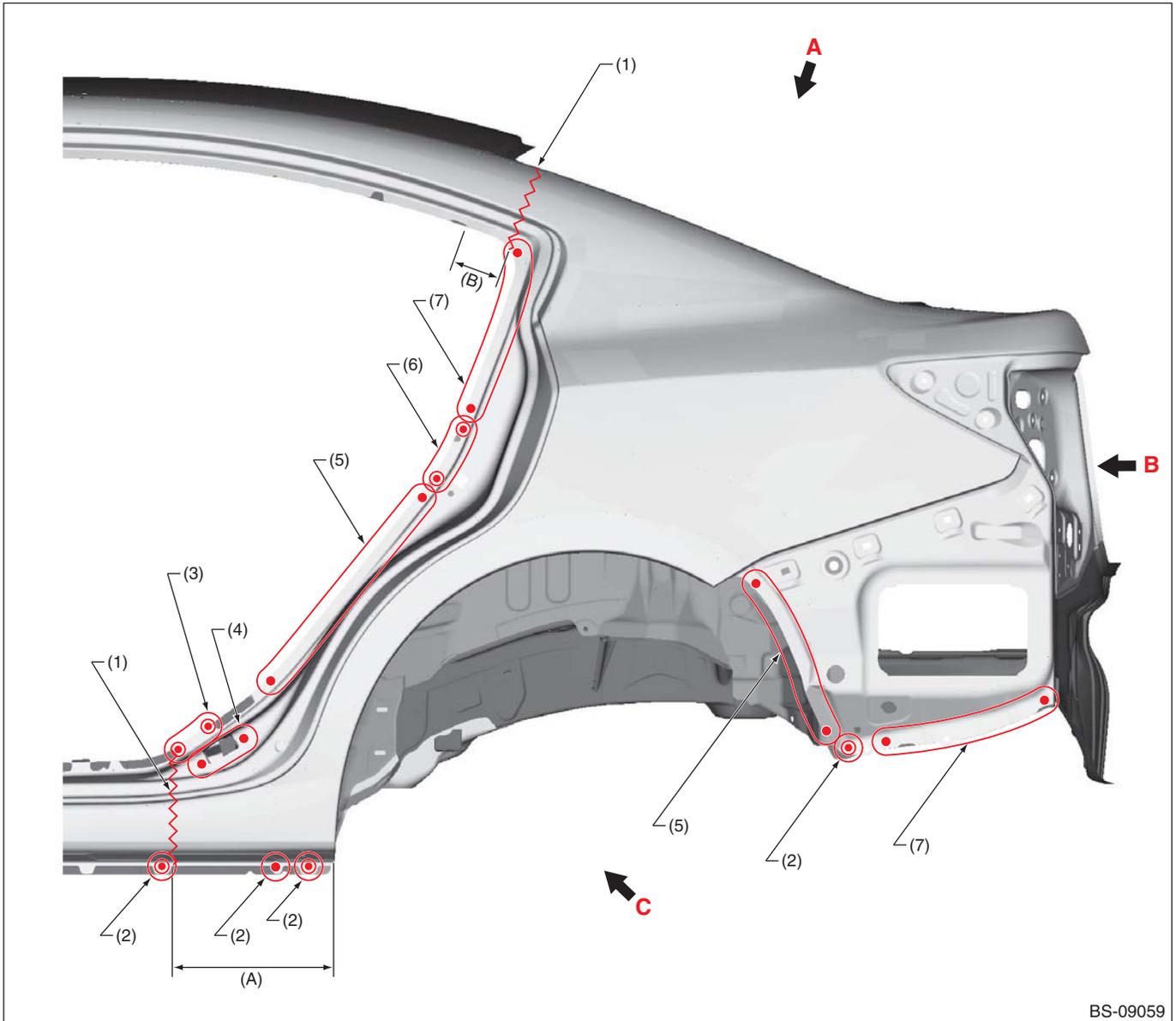
(2) 12 points

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-09059

(A) 260 mm [10.24 in]

(B) 90 mm [3.54 in]

(1) Cut position

(4) 2 points (outside · 1)

(7) 6 points (outside · 1)

(2) 1 point (outside · 1)

(5) 7 points (outside · 1)

(3) 3 points (outside · 1)

(6) 2 points (outside · 2)

# Panel Replacement

## • Views A



BS-09060

(A) 55 mm [2.17 in]

(1) 2 points (outside · 1)

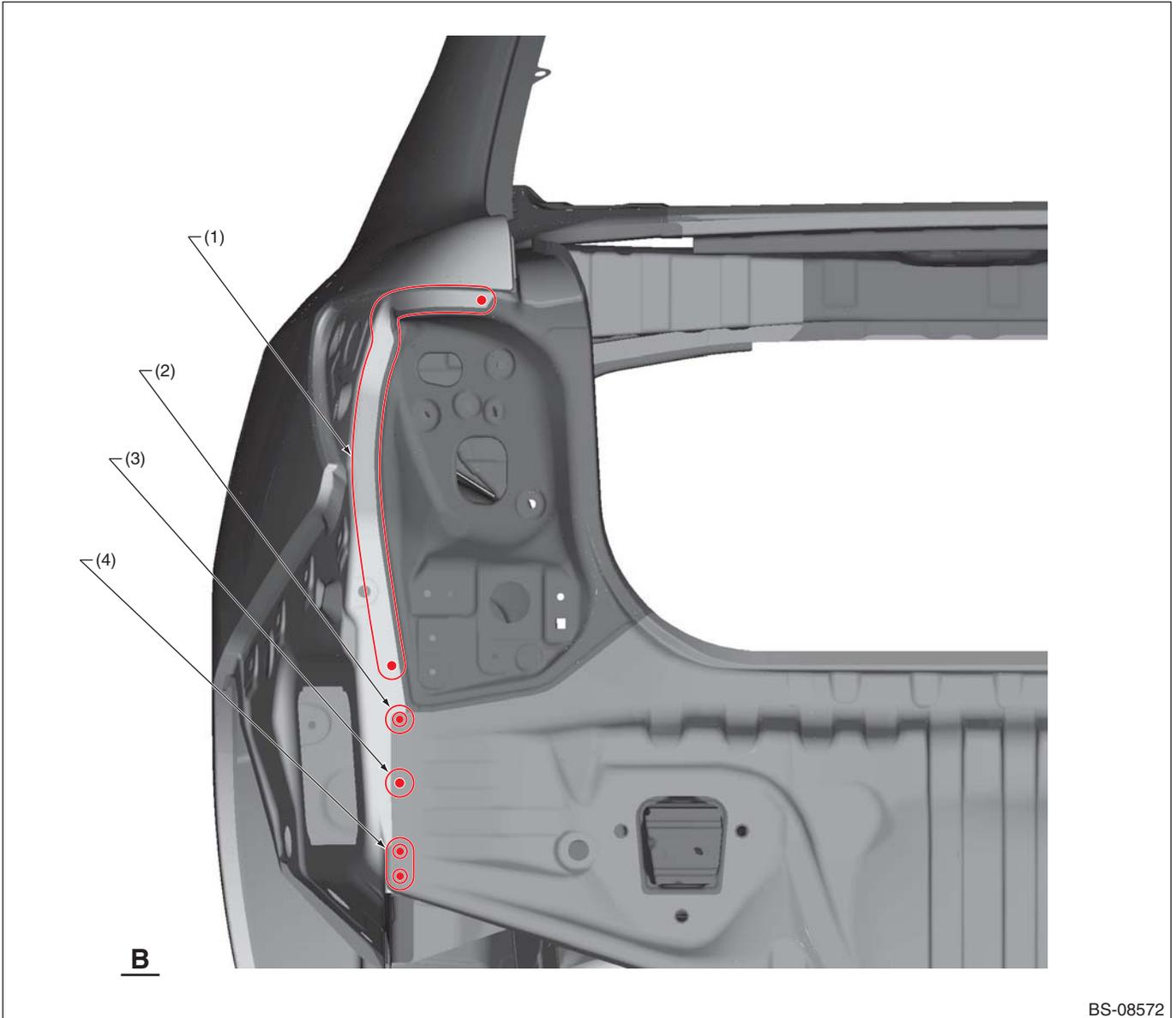
(3) 8 points (outside · 1)

(4) Cut position

(2) 1 point (outside · 1)

# Panel Replacement

## • Views B



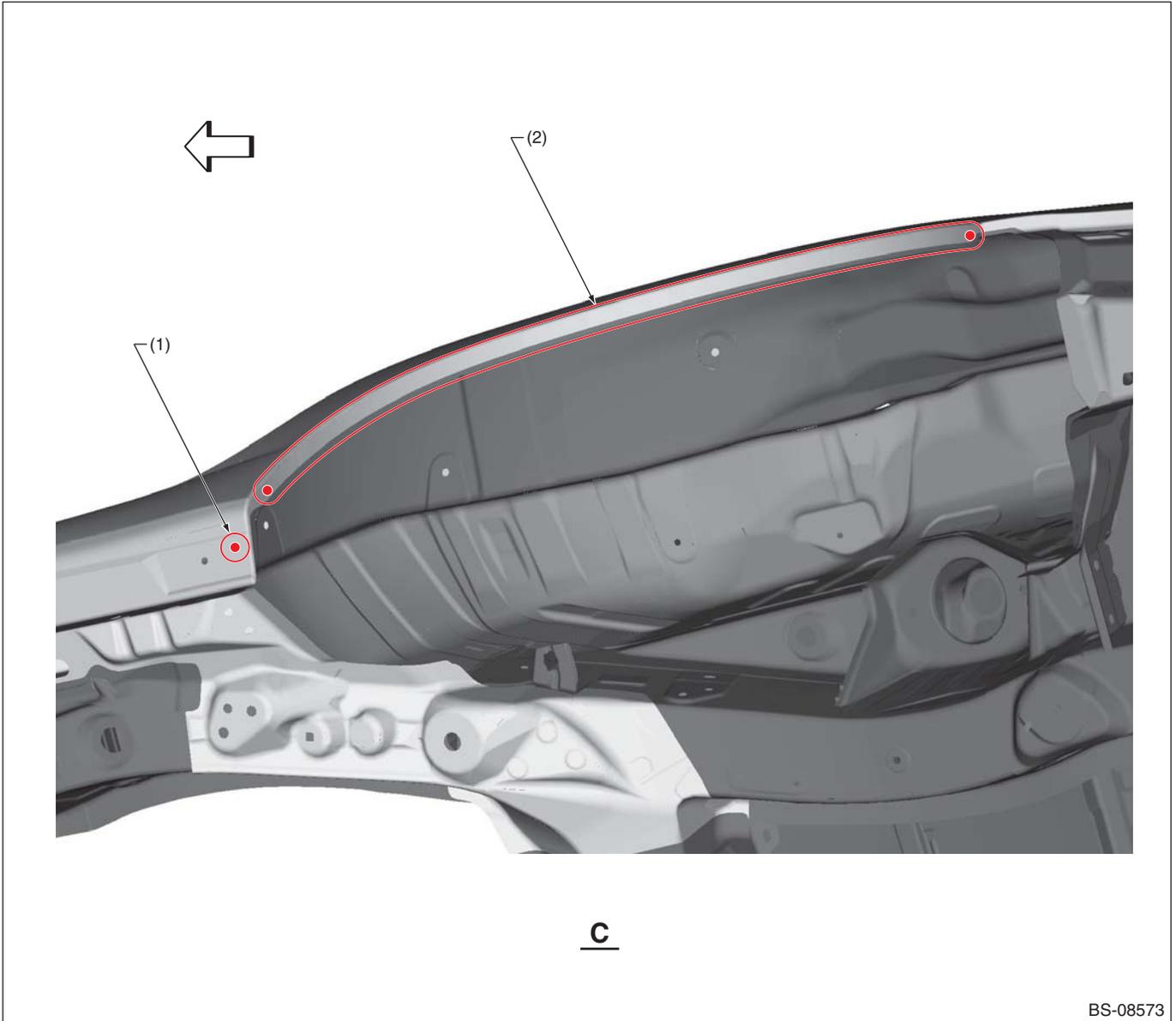
(1) 11 points (outside · 1)  
(2) 1 point (outside · 2)

(3) 1 point (outside · 1)

(4) 2 points (outside · 2)

# Panel Replacement

## • Views C



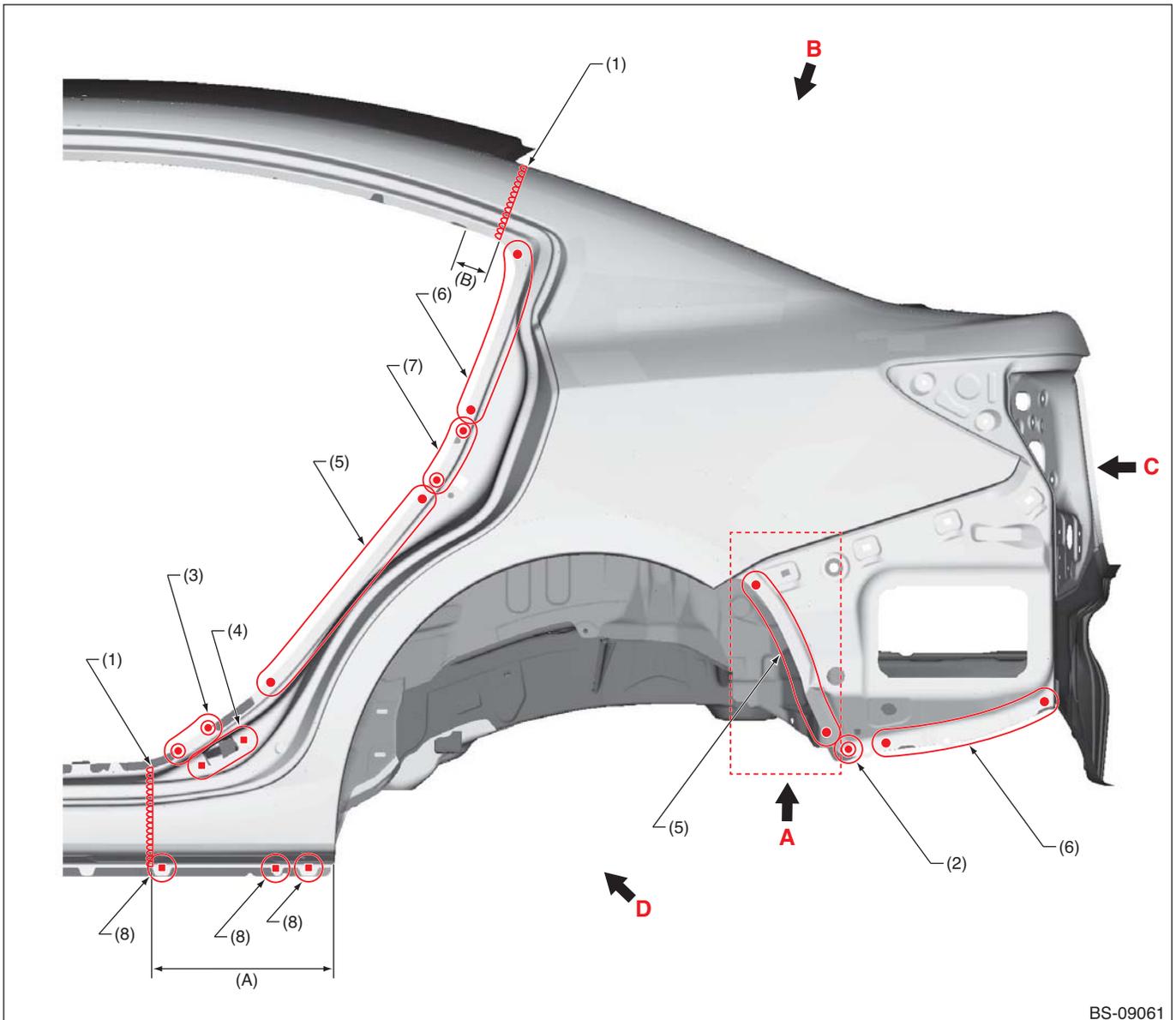
(1) 1 point (bottom · 1)

(2) 14 points (outside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09061

(A) 289 mm [11.38 in]

(B) 60 mm [2.36 in]

(1) 1 point (Continuous welding)

(4) 2 points (service)

(7) 2 points

(2) 1 point

(5) 7 points

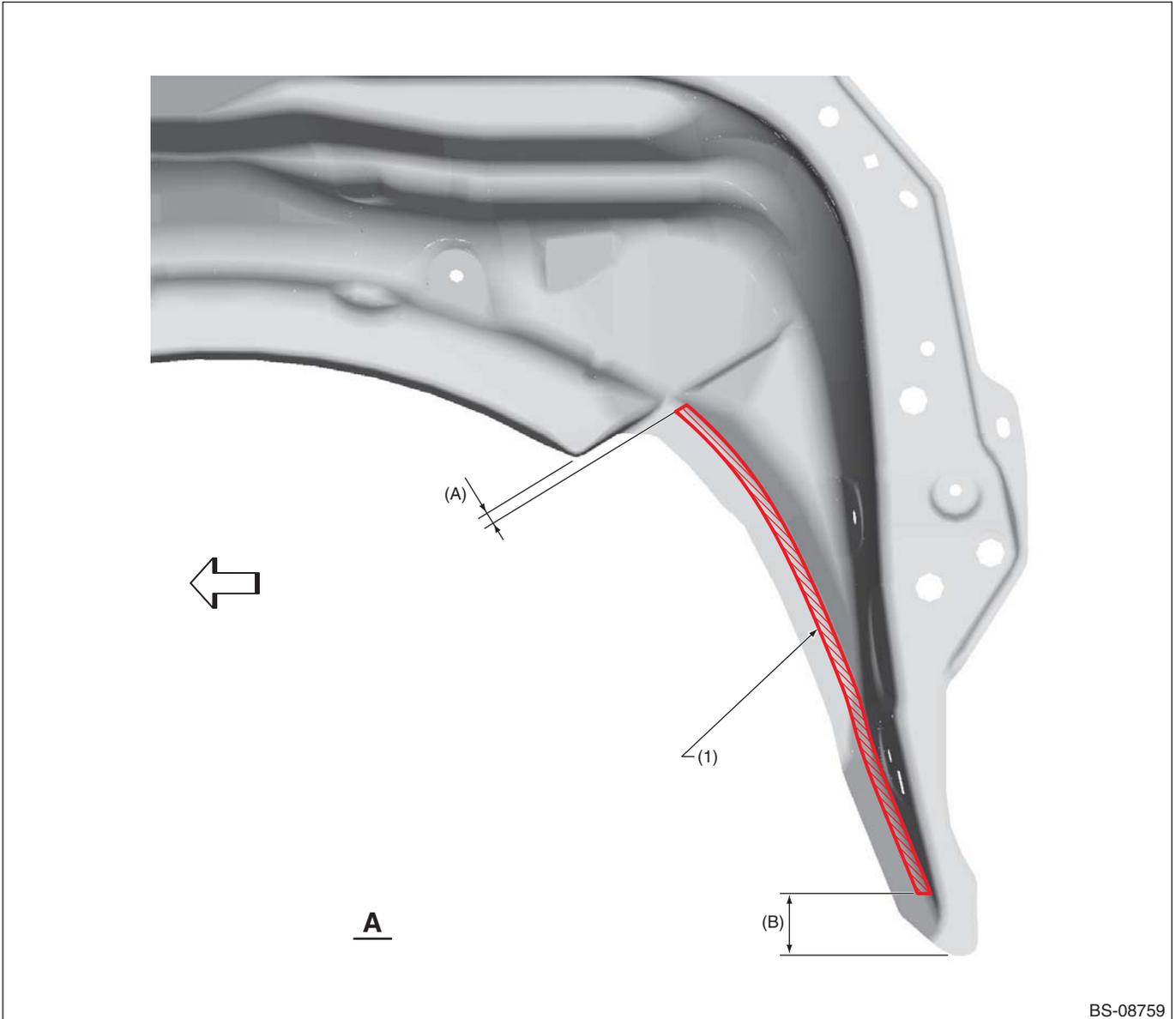
(8) 1 point (service)

(3) 3 points

(6) 6 points

# Panel Replacement

## • Views A



(A) 5 mm [0.02 in]

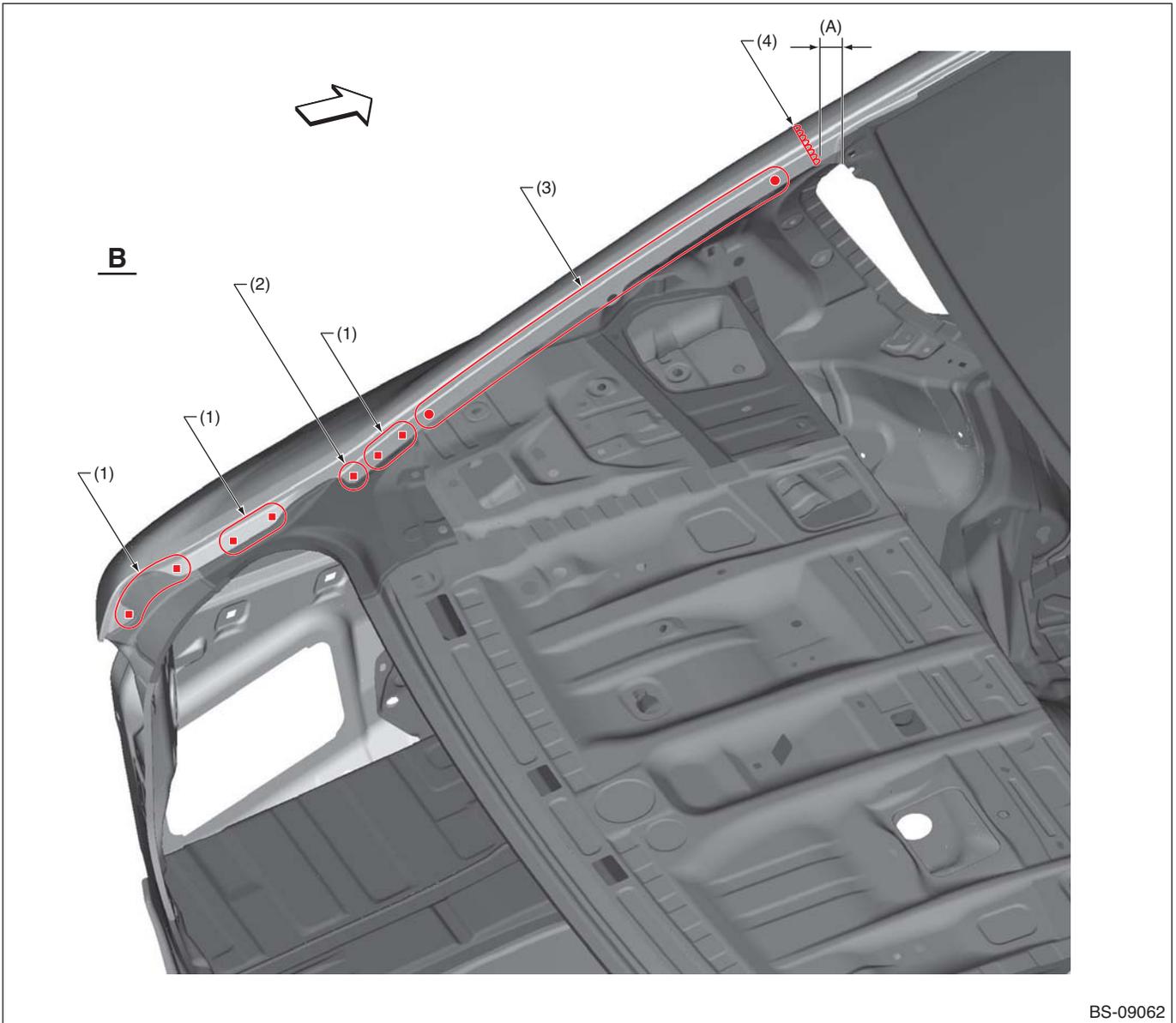
(B) 34 mm [1.34 in]

(1) Spotting sealer

 : Spotting sealer application location (Spotting sealer or sealing [Three Bond 4101 (004403063)])  
Note: Fill spotting sealer between the panel side out and arch rear inner.

# Panel Replacement

## • Views B



BS-09062

(A) 25 mm [0.98 in]

(1) 2 points (service)

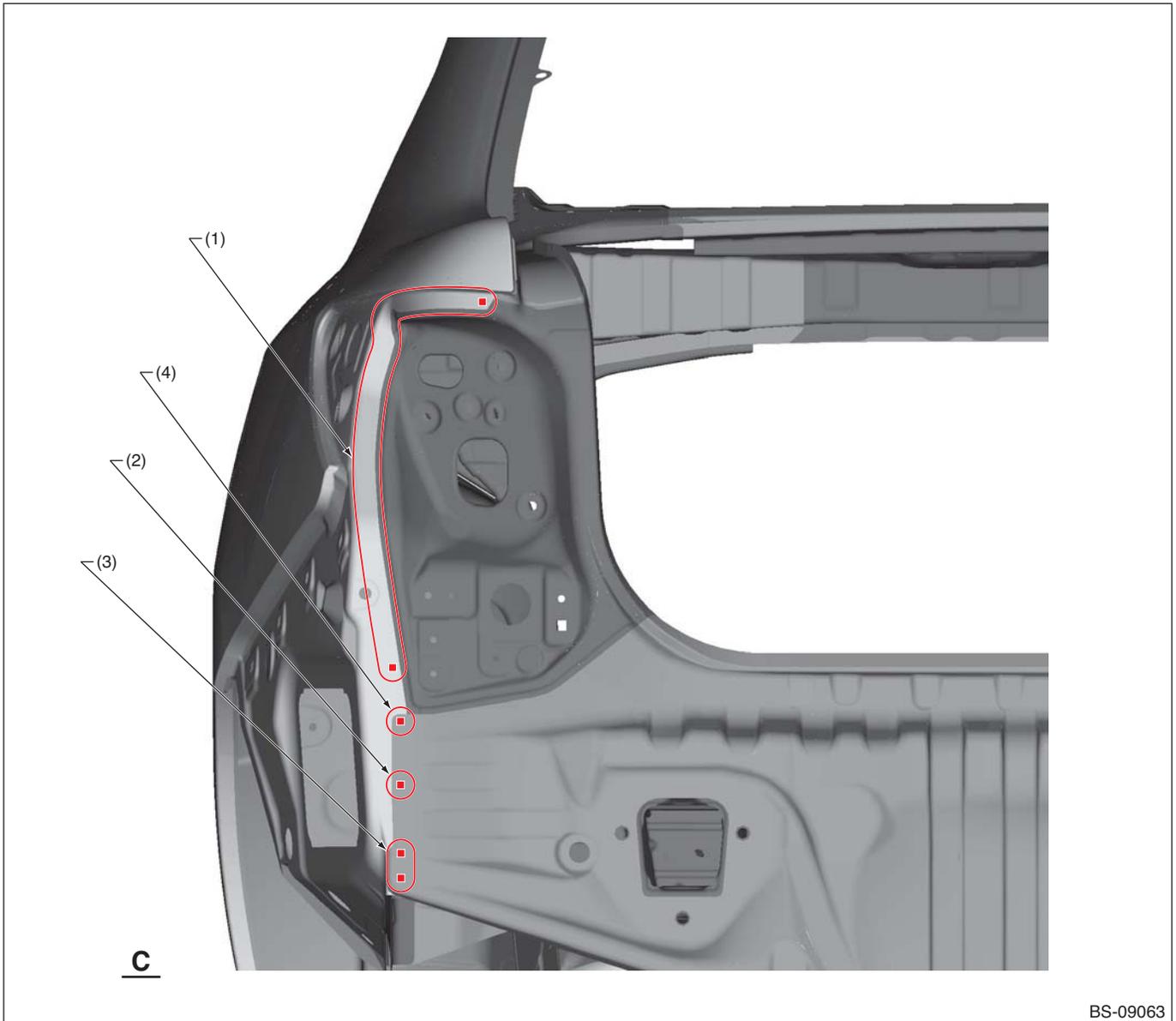
(3) 8 points

(4) 1 point (Continuous welding)

(2) 1 point (service)

# Panel Replacement

## • Views C



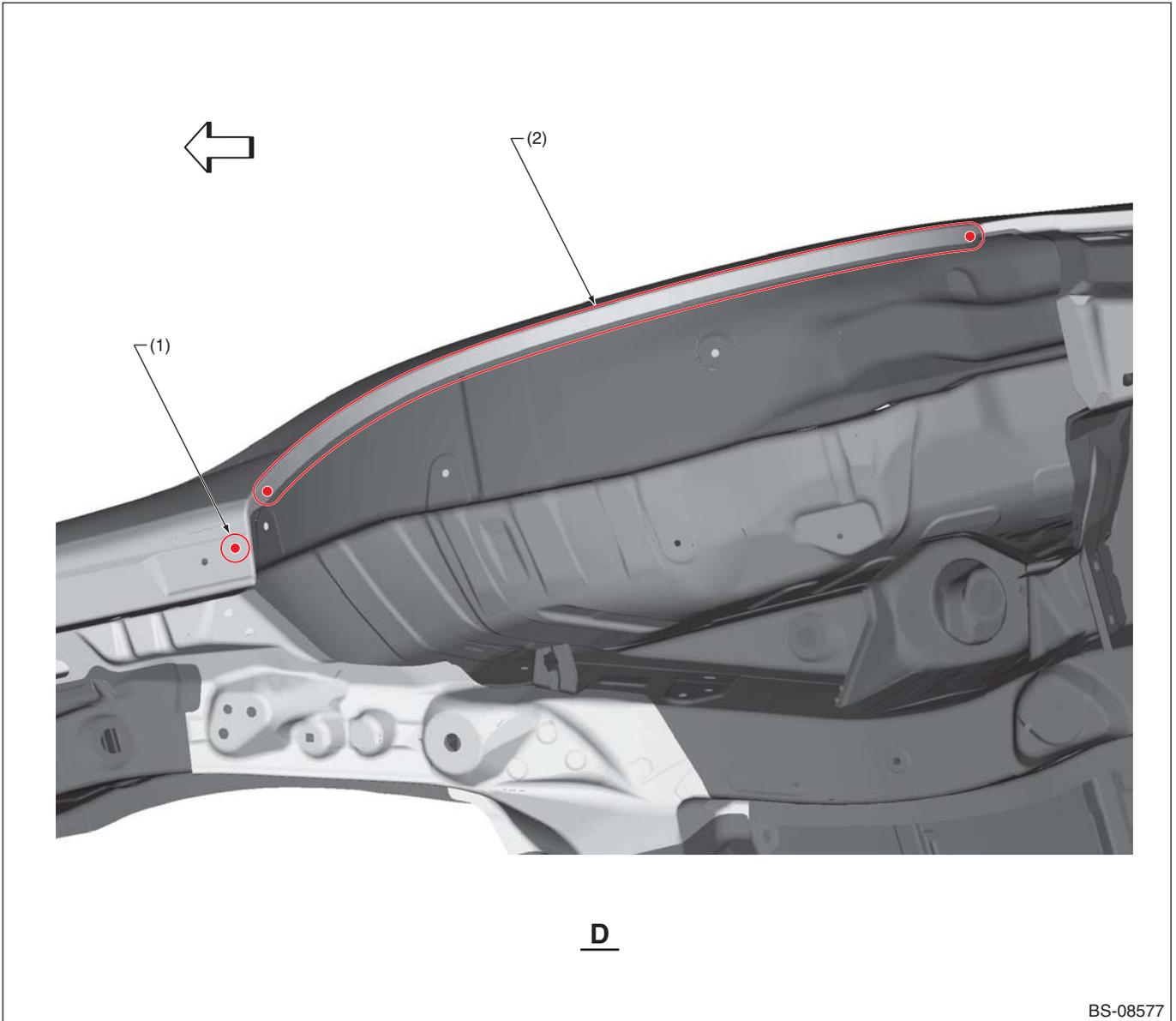
(1) 11 points (service)  
(2) 1 point

(3) 2 points (service · matching)

(4) 1 point (service · matching)

# Panel Replacement

## • Views D



(1) 1 point

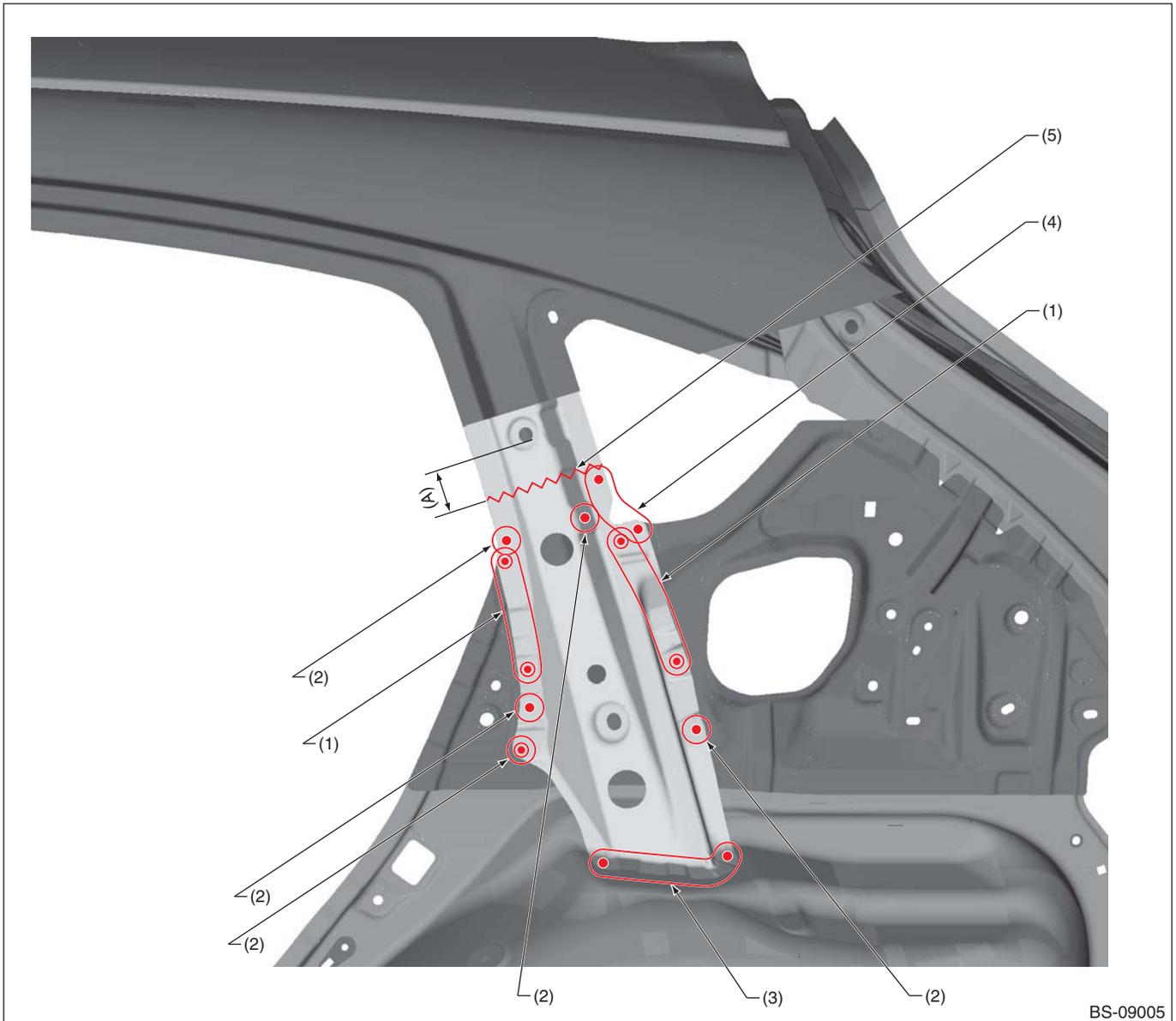
(2) 14 points

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



(A) 55 mm [2.17 in]

(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

(3) 4 points (top · 1)

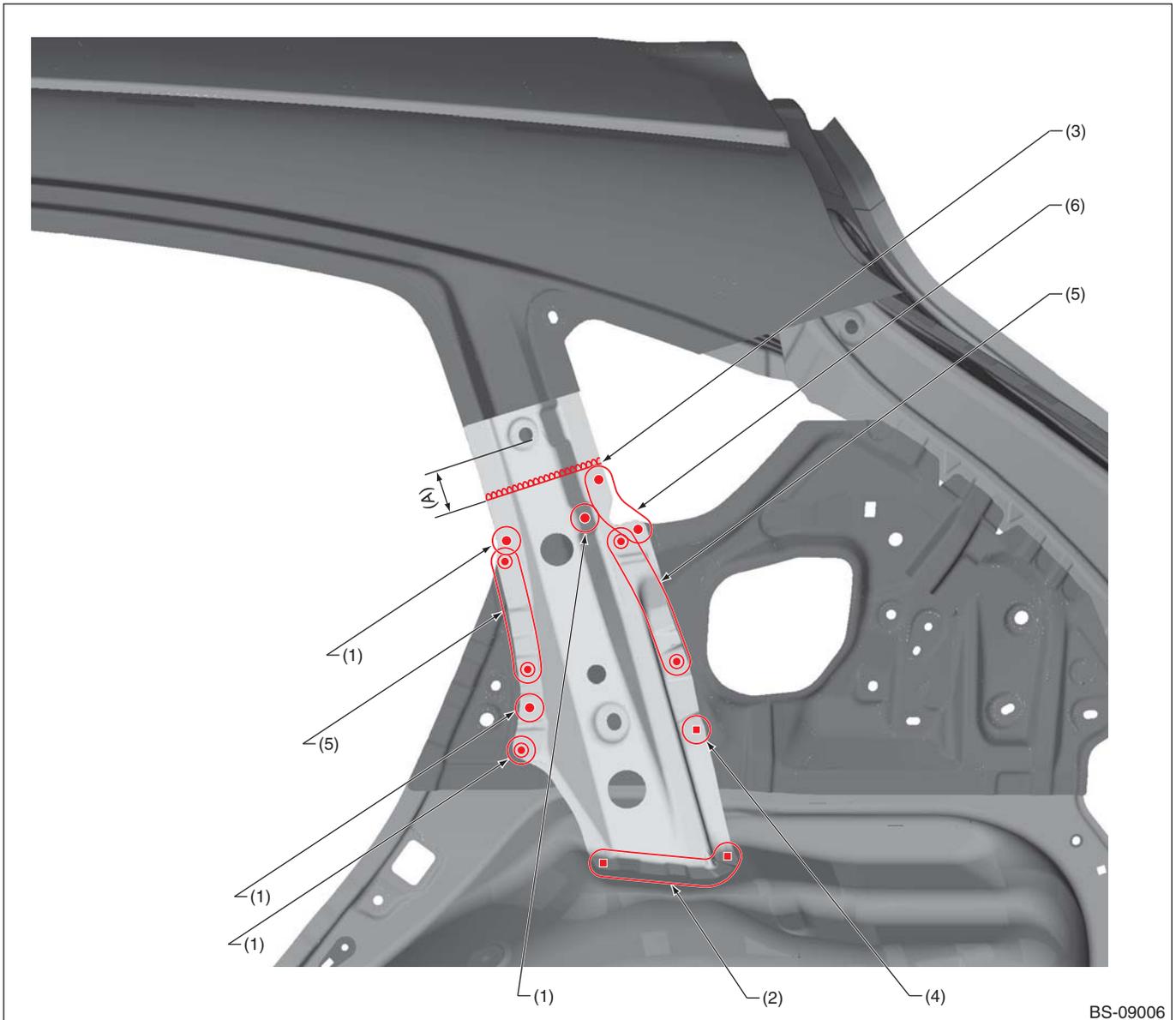
(4) 2 points (outside · 1)

(5) Cut position

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09006

(A) 40 mm [1.57 in]

(1) 1 point

(2) 4 points (service)

(3) 1 point (Continuous welding)

(4) 1 point (service)

(5) 3 points

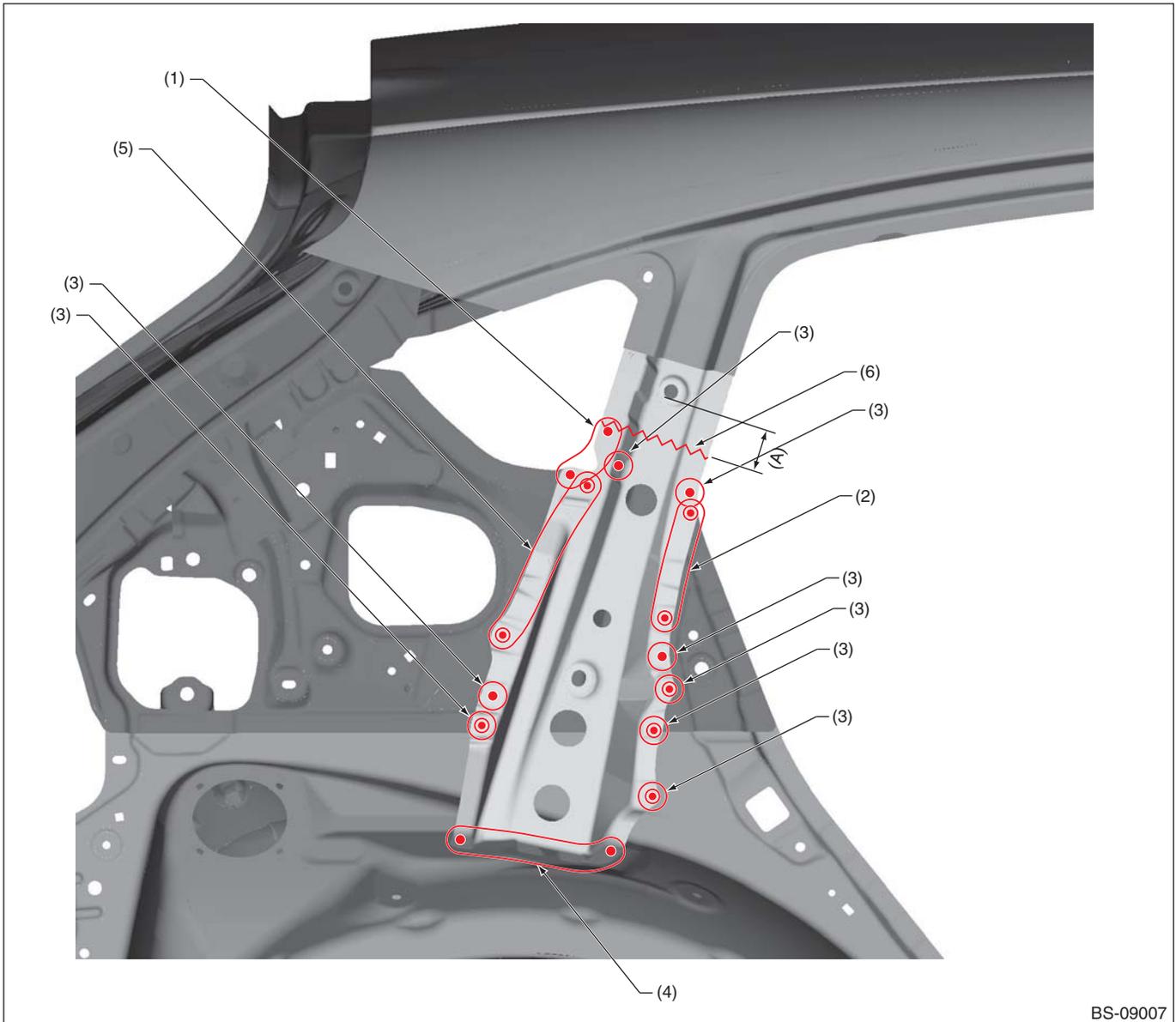
(6) 2 points

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-09007

(A) 55 mm [2.17 in]

(1) 2 points (outside · 1)

(2) 3 points (outside · 1)

(3) 1 point (outside · 1)

(4) 4 points (top · 1)

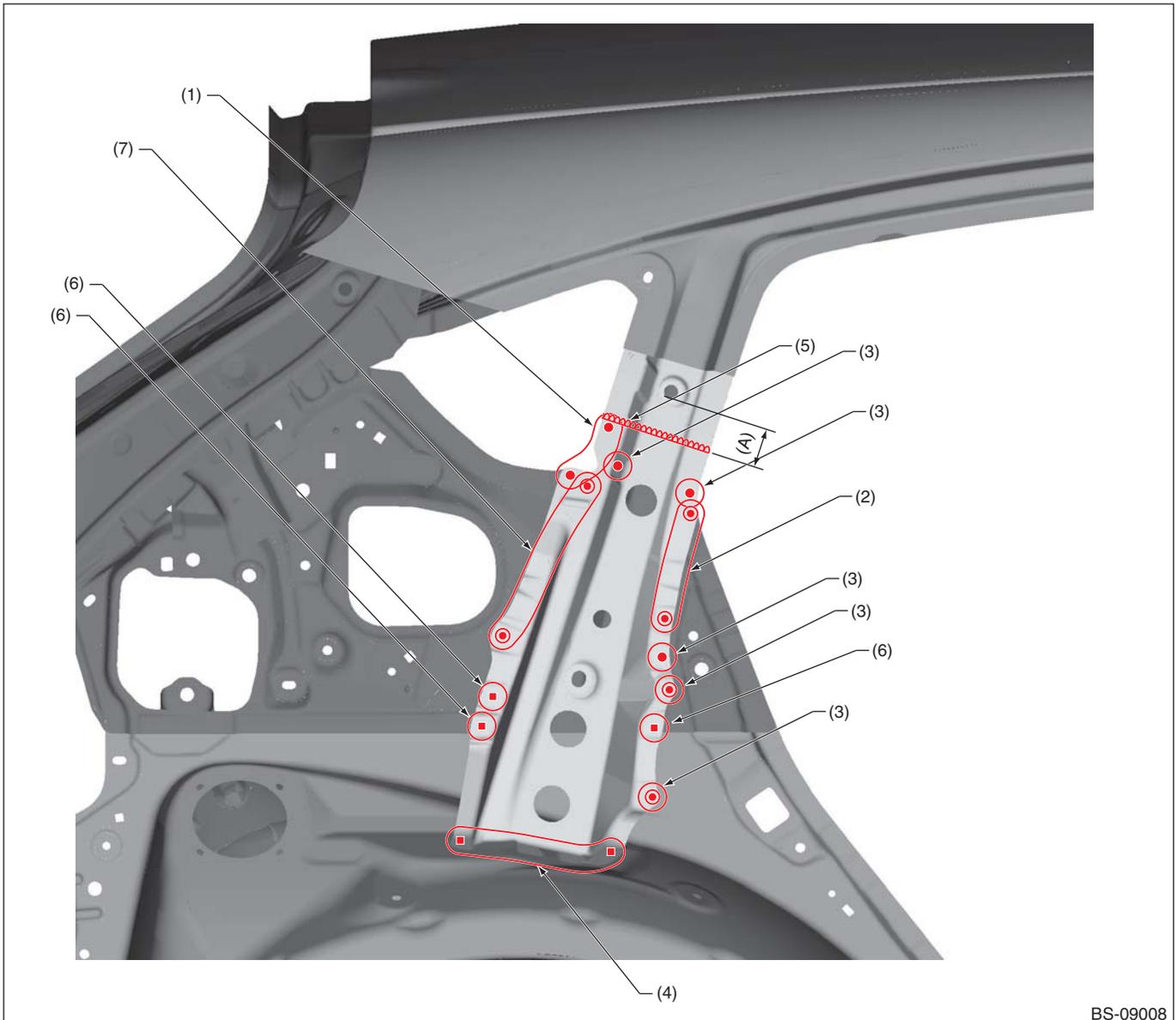
(5) 4 points (outside · 1)

(6) Cut position

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09008

(A) 40 mm [1.57 in]

(1) 2 points

(2) 3 points

(3) 1 point

(4) 4 points (service)

(5) 1 point (Continuous welding)

(6) 1 point (service)

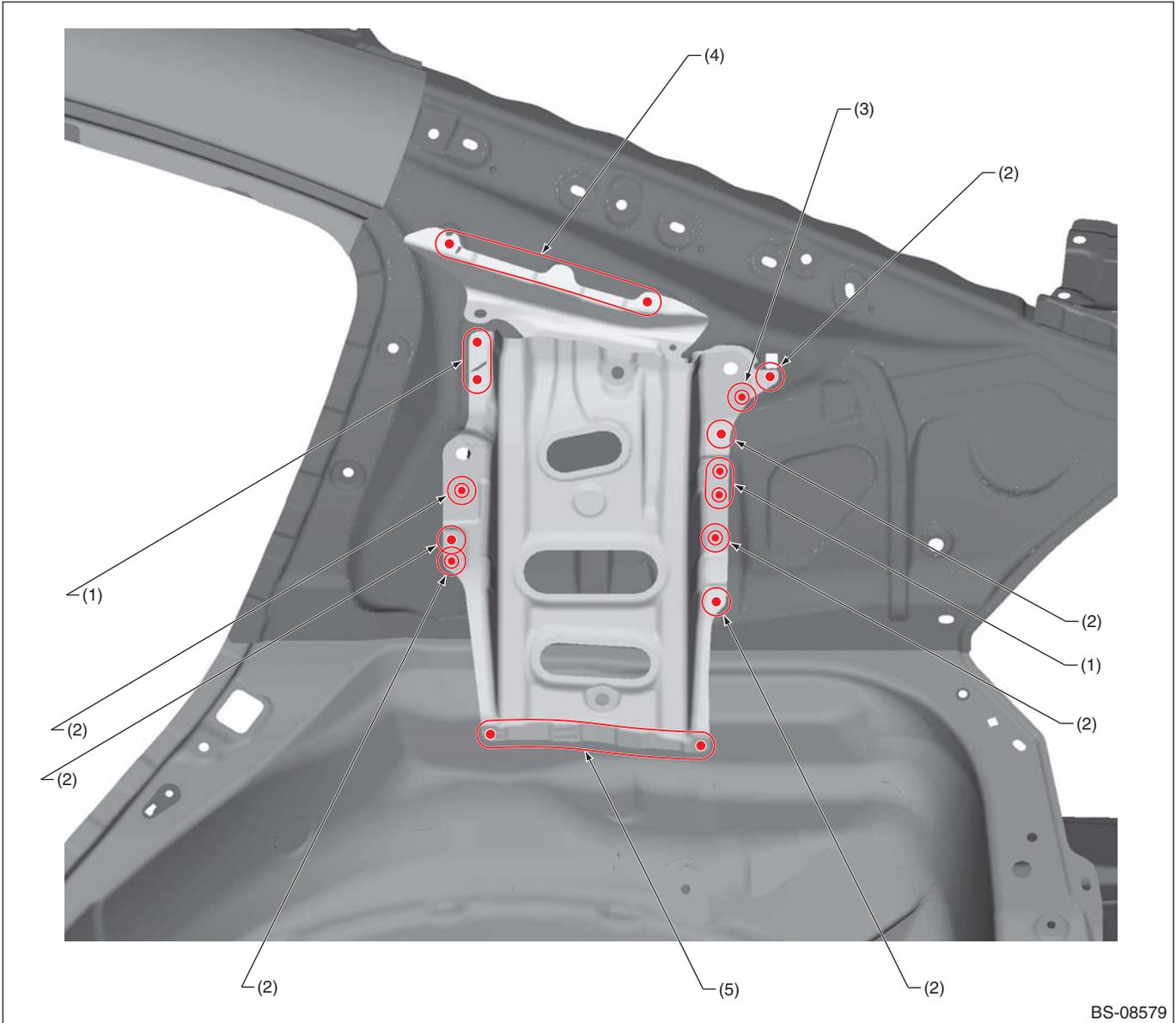
(7) 4 points

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-08579

(1) 2 points (outside · 1)

(2) 1 point (outside · 1)

(3) 1 point (outside · 2)

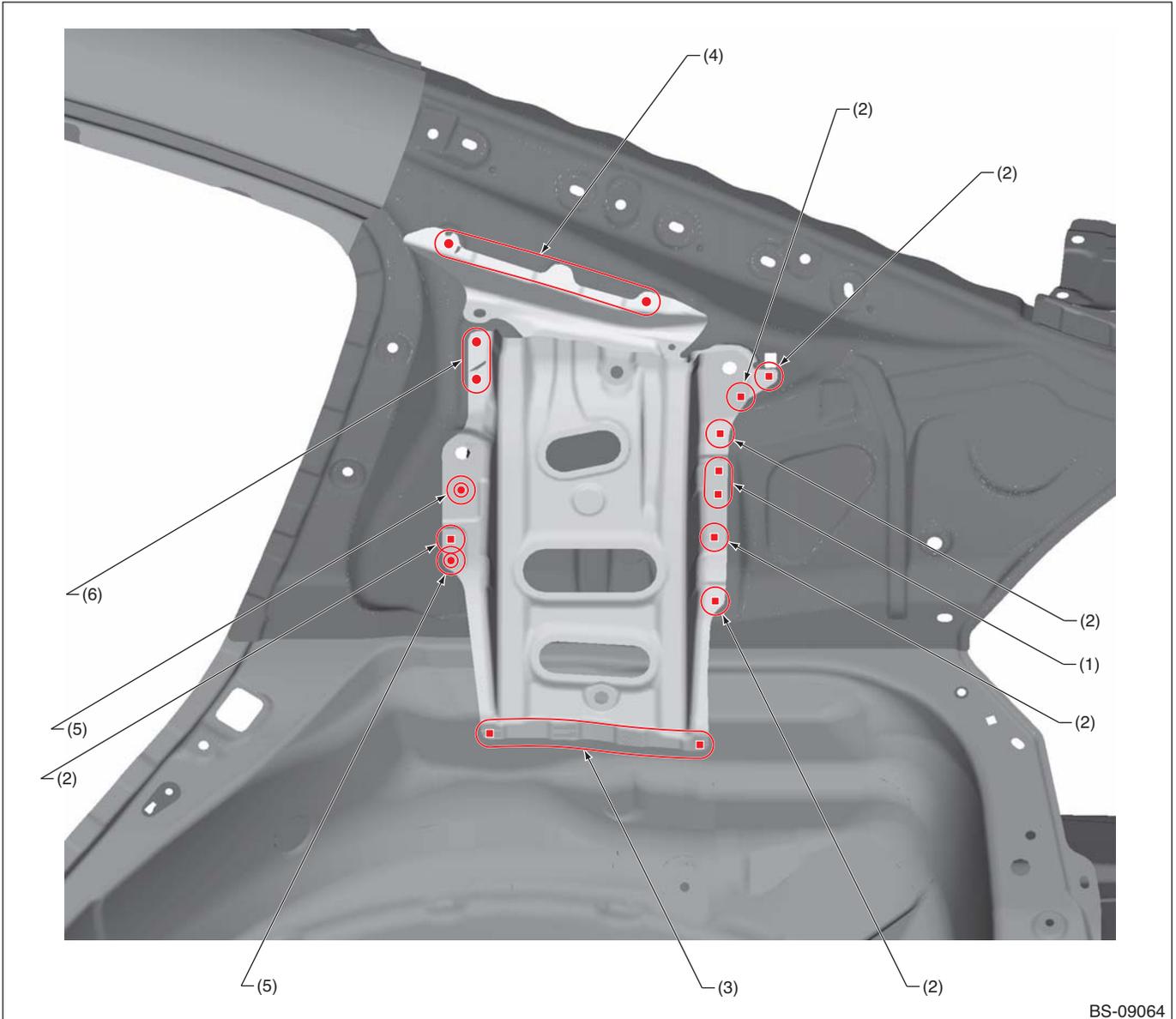
(4) 3 points (outside · 1)

(5) 4 points (top · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



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

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

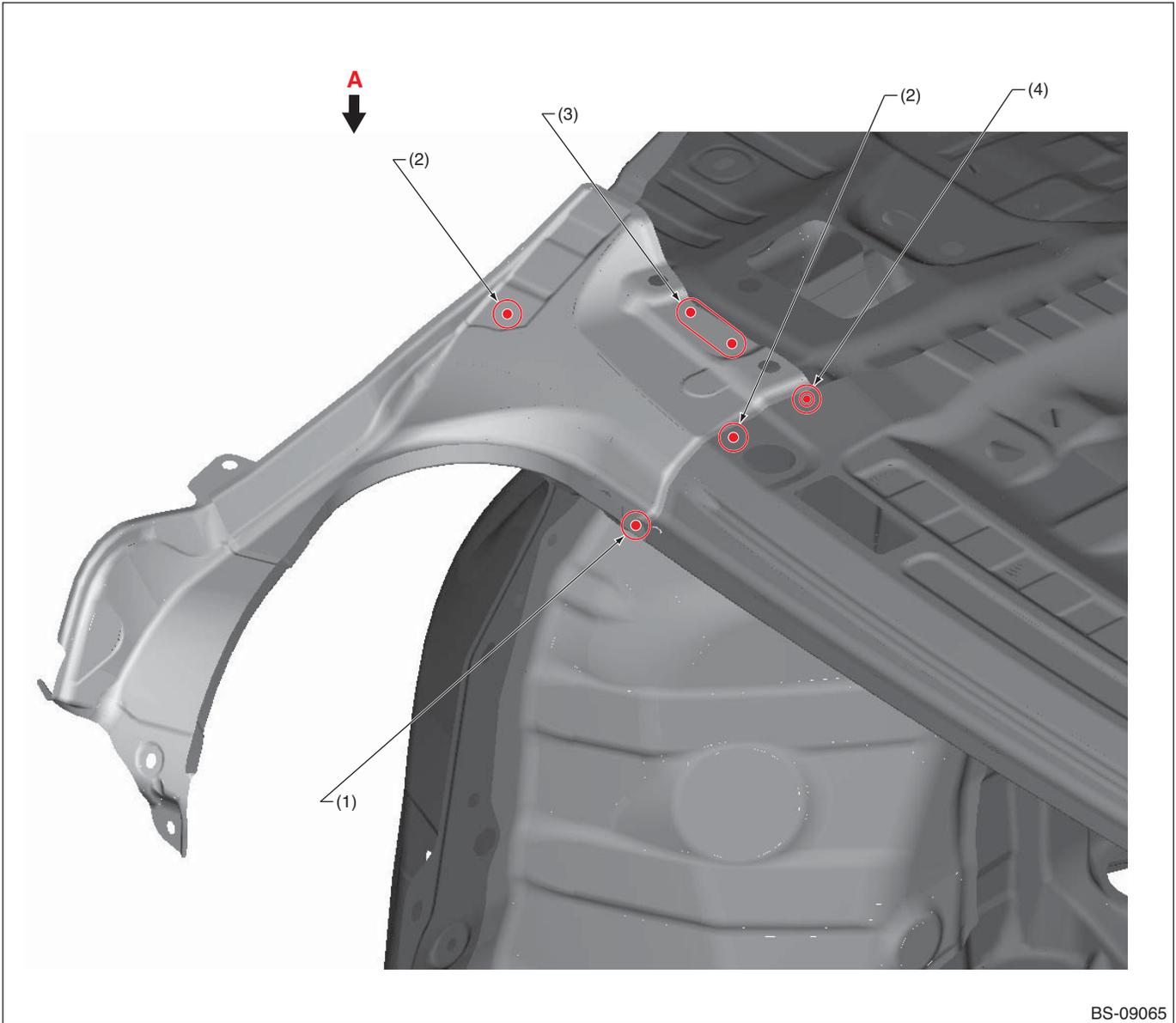
(5) 1 point  
(6) 2 points

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-09065

(1) 1 point (outside - 1)

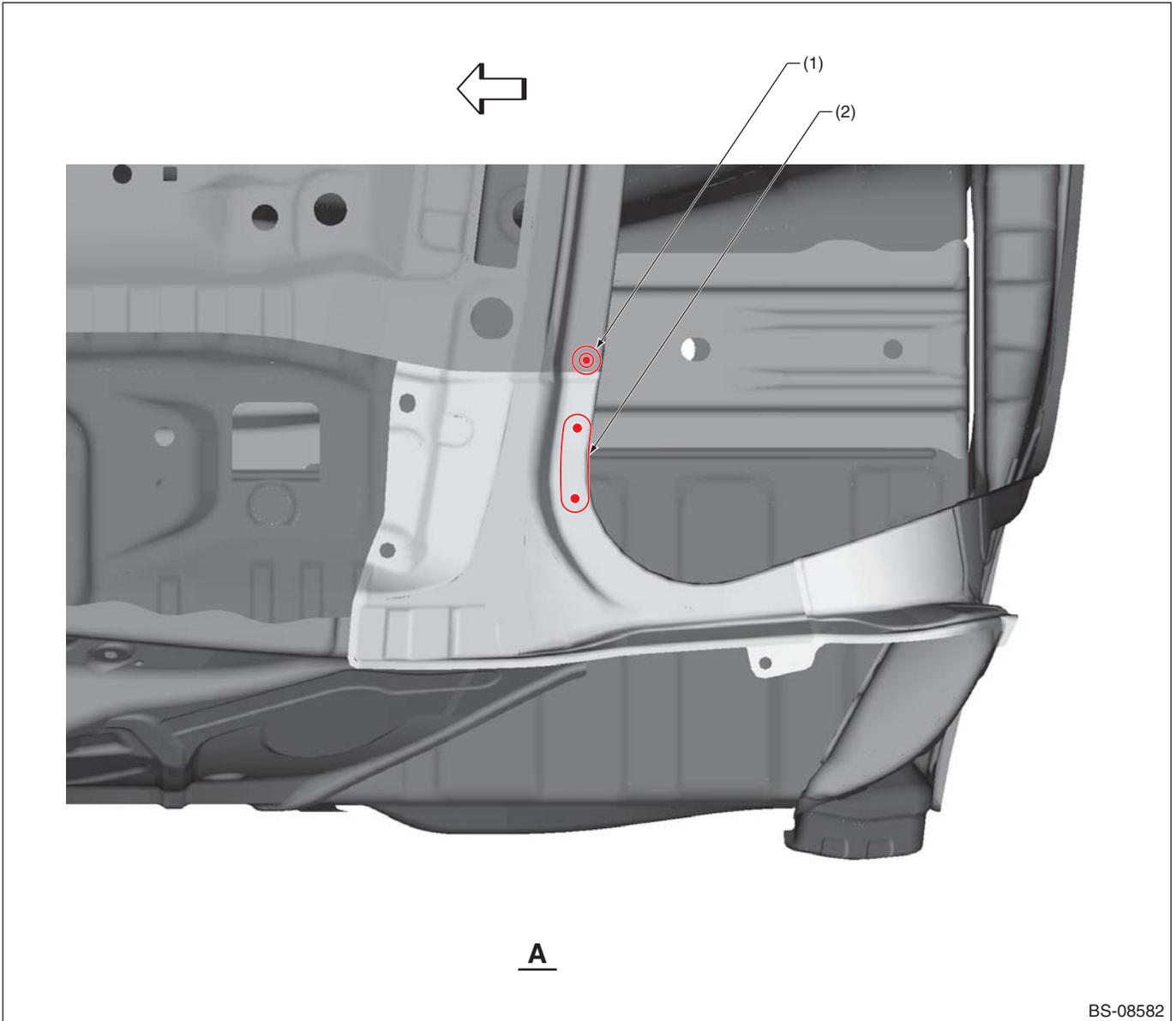
(3) 2 points (top - 1)

(4) 1 point (top - 2)

(2) 1 point (top - 1)

# Panel Replacement

## • Views A



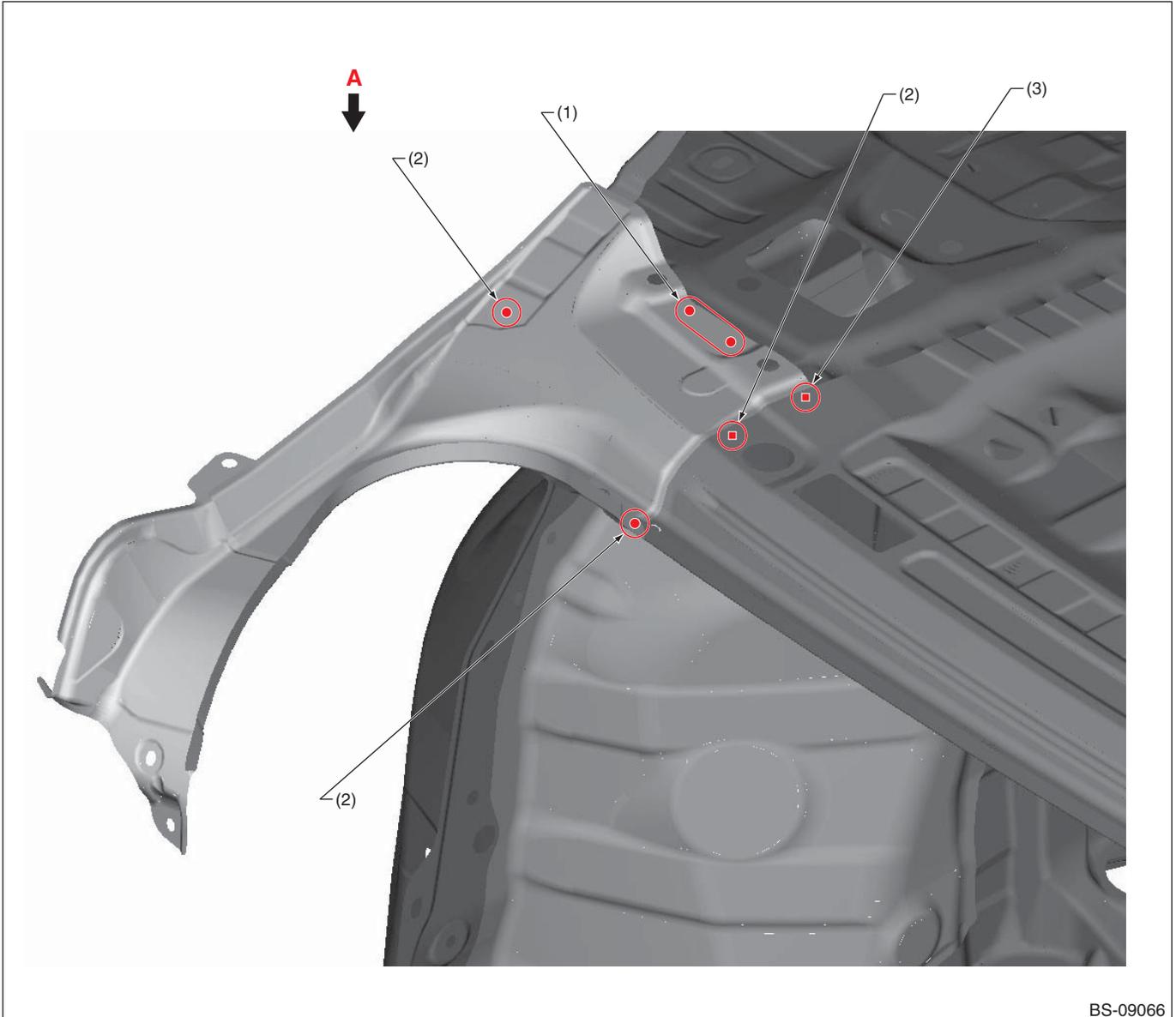
(1) 1 point (top · 2)

(2) 2 points (top · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09066

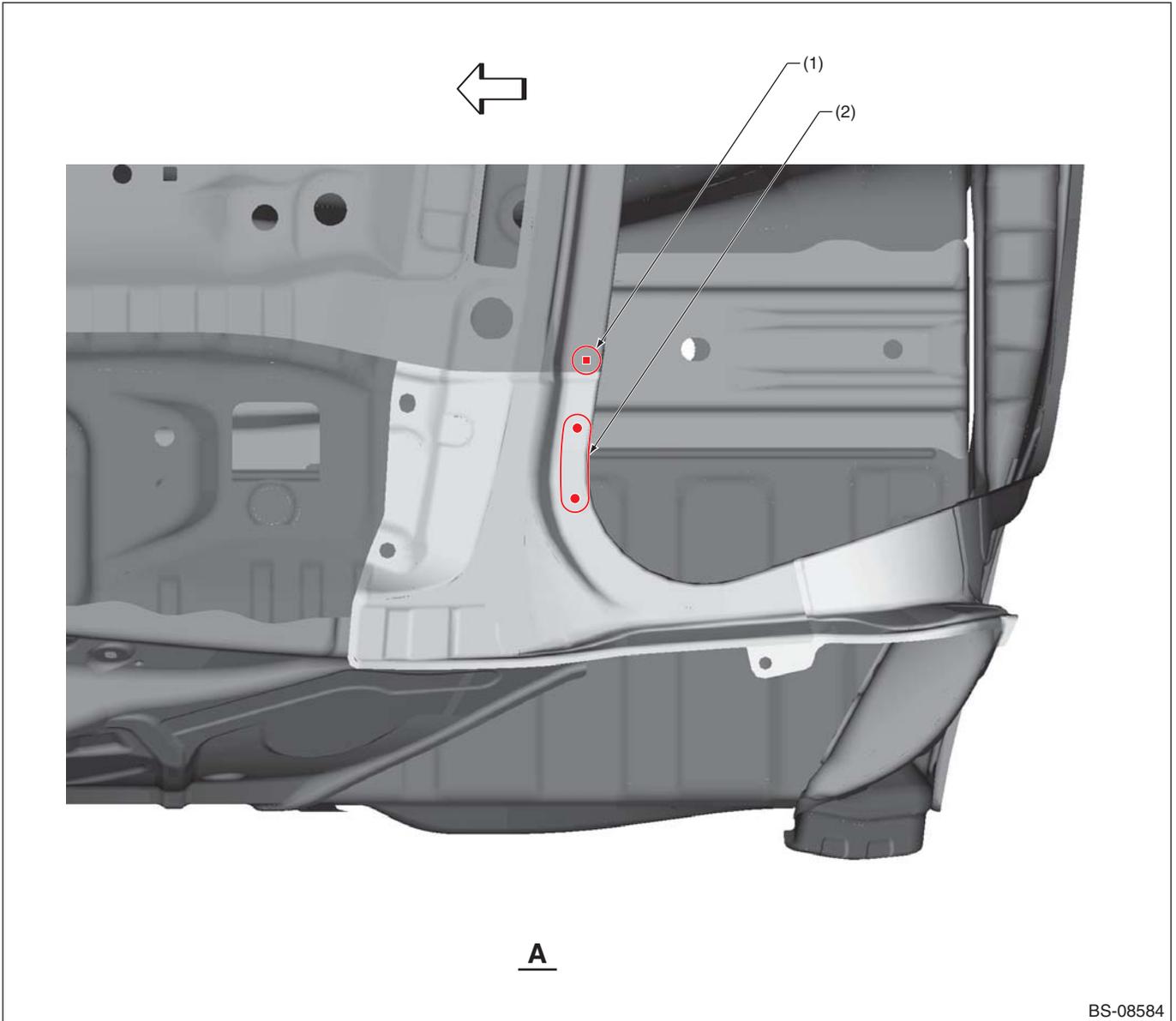
(1) 2 points

(2) 1 point

(3) 1 point (service - matching)

# Panel Replacement

## • Views A



(1) 1 point (service · matching)

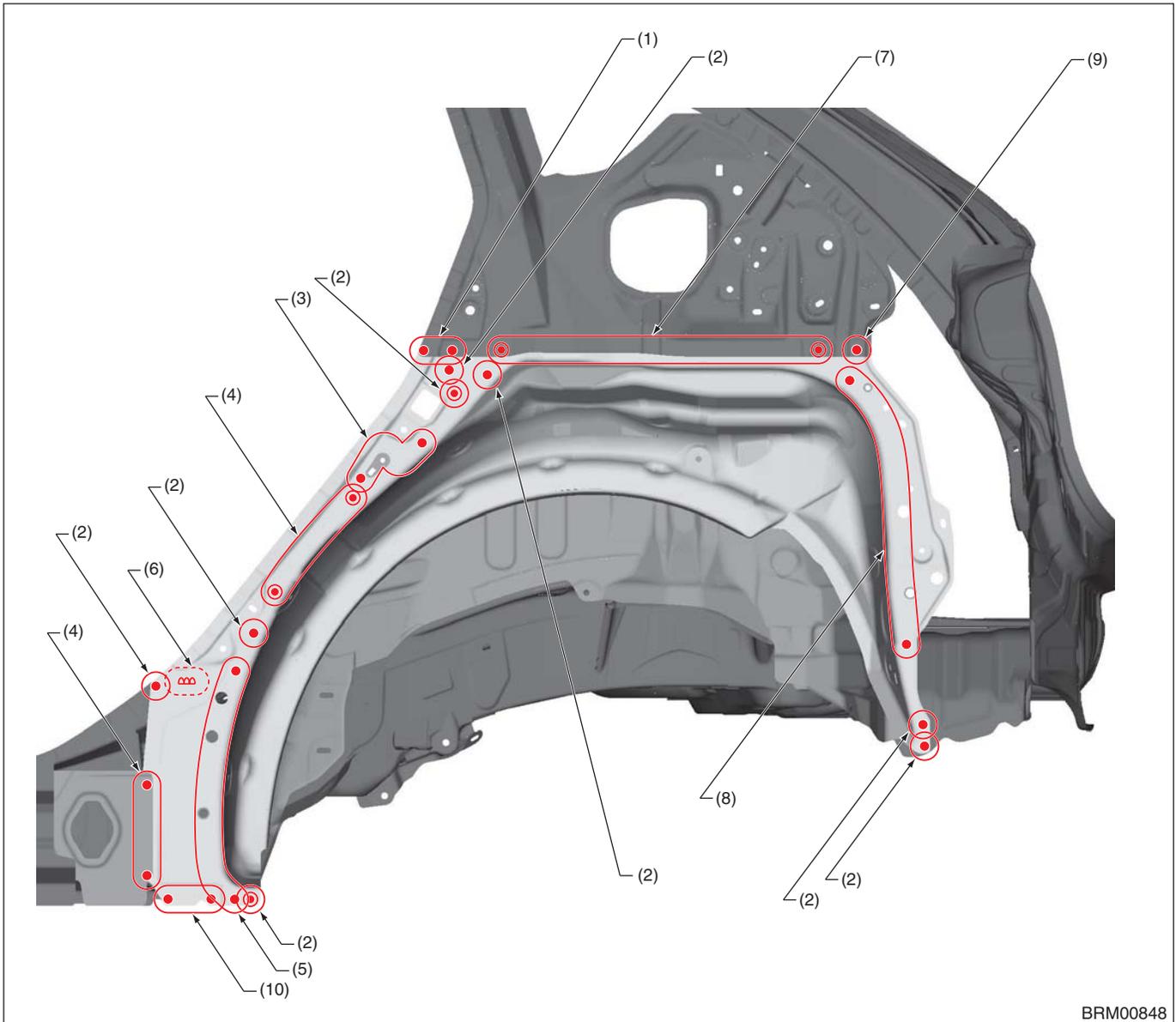
(2) 2 points

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



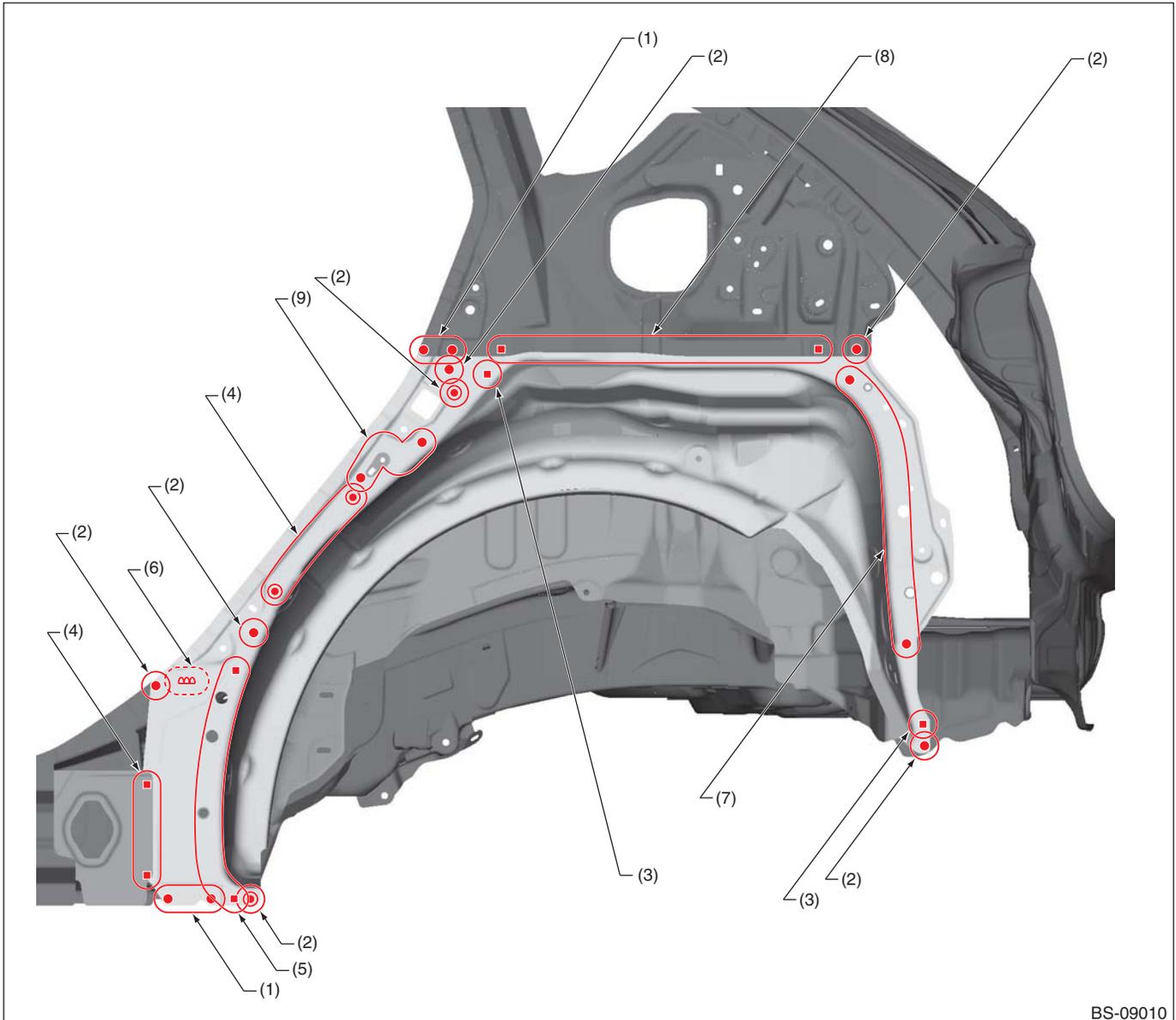
BRM00848

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

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09010

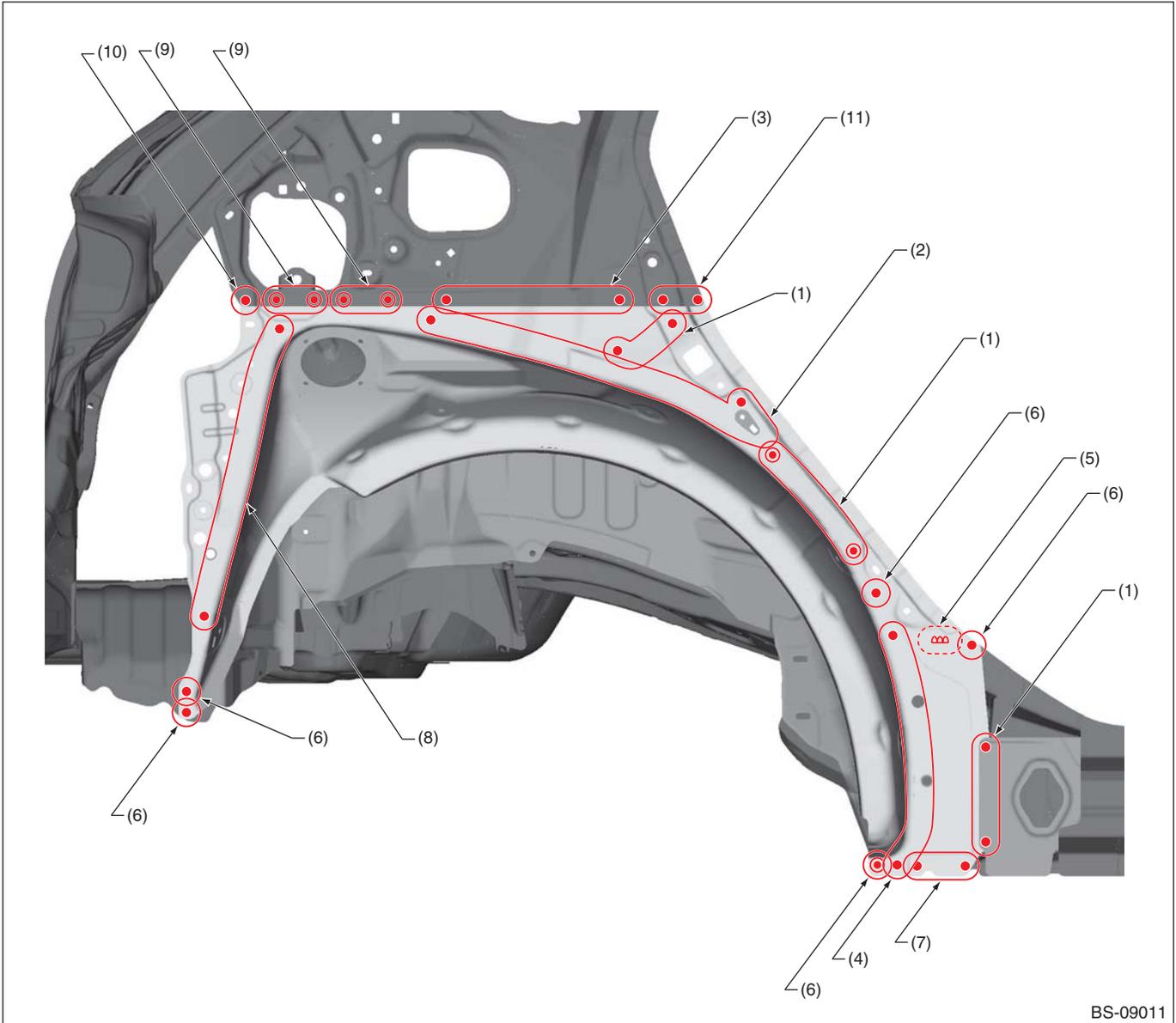
- |                       |   |                                   |
|-----------------------|---|-----------------------------------|
| (1) 2 points          | (4) 3 points  | (7) 7 points                      |
| (2) 1 point           | (5) 6 points (service)                                | (8) 7 points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

# Panel Replacement

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

### A: REMOVAL

#### • Overall view

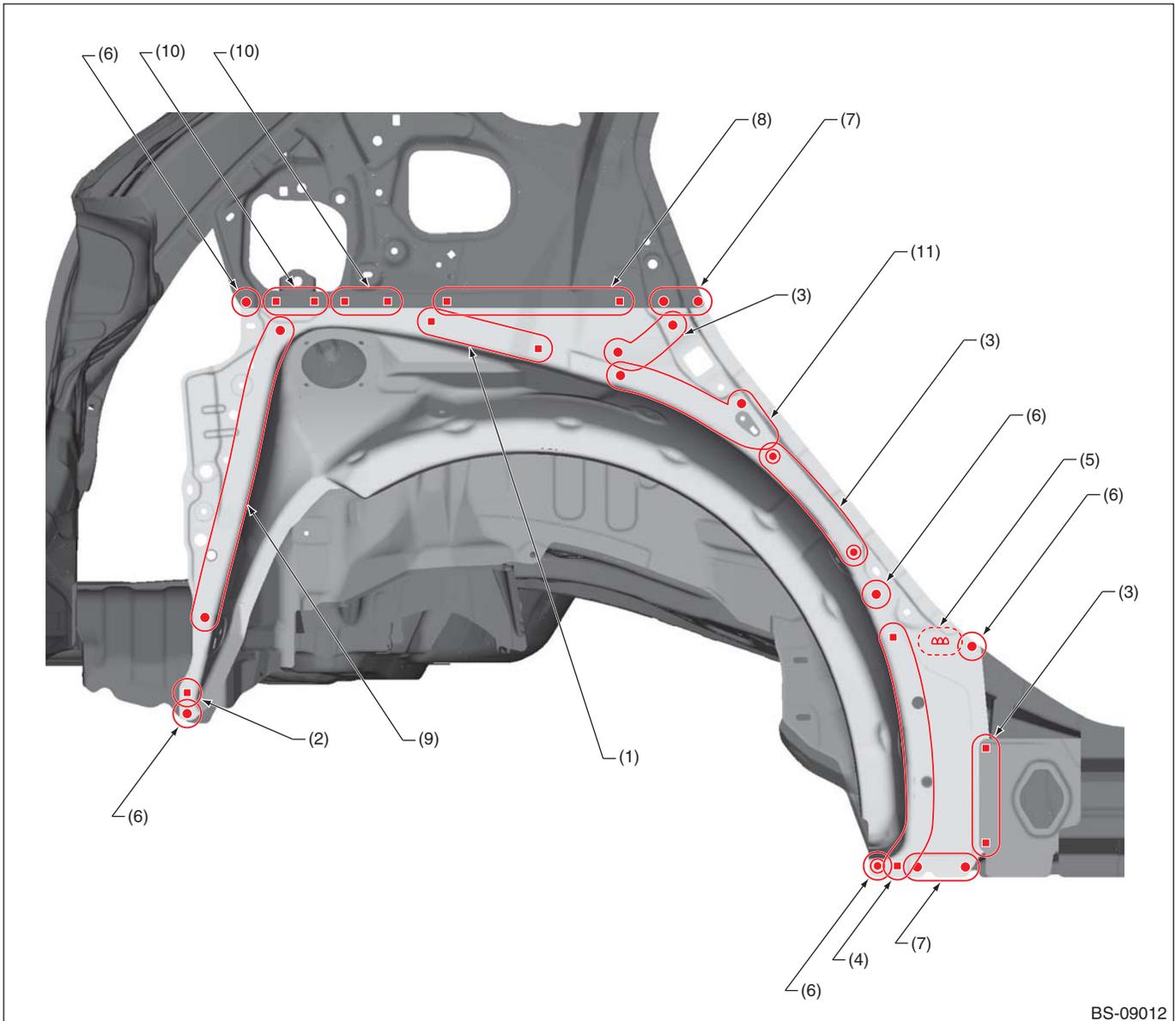


- |                            |                                      |                            |
|----------------------------|--------------------------------------|----------------------------|
| (1) 3 points (outside · 1) | (5) 1 point (inside · 1 belt sander) | (9) 2 points (outside · 2) |
|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

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09012

(1) 3 points (service)

(2) 1 point (service)

(3) 3 points

(4) 6 points (service)

(5) 1 point (Continuous welding)  
[22 mm (0.87 in)]

(6) 1 point

(7) 2 points

(8) 4 points

(9) 7 points

(10) 2 points (service · matching)

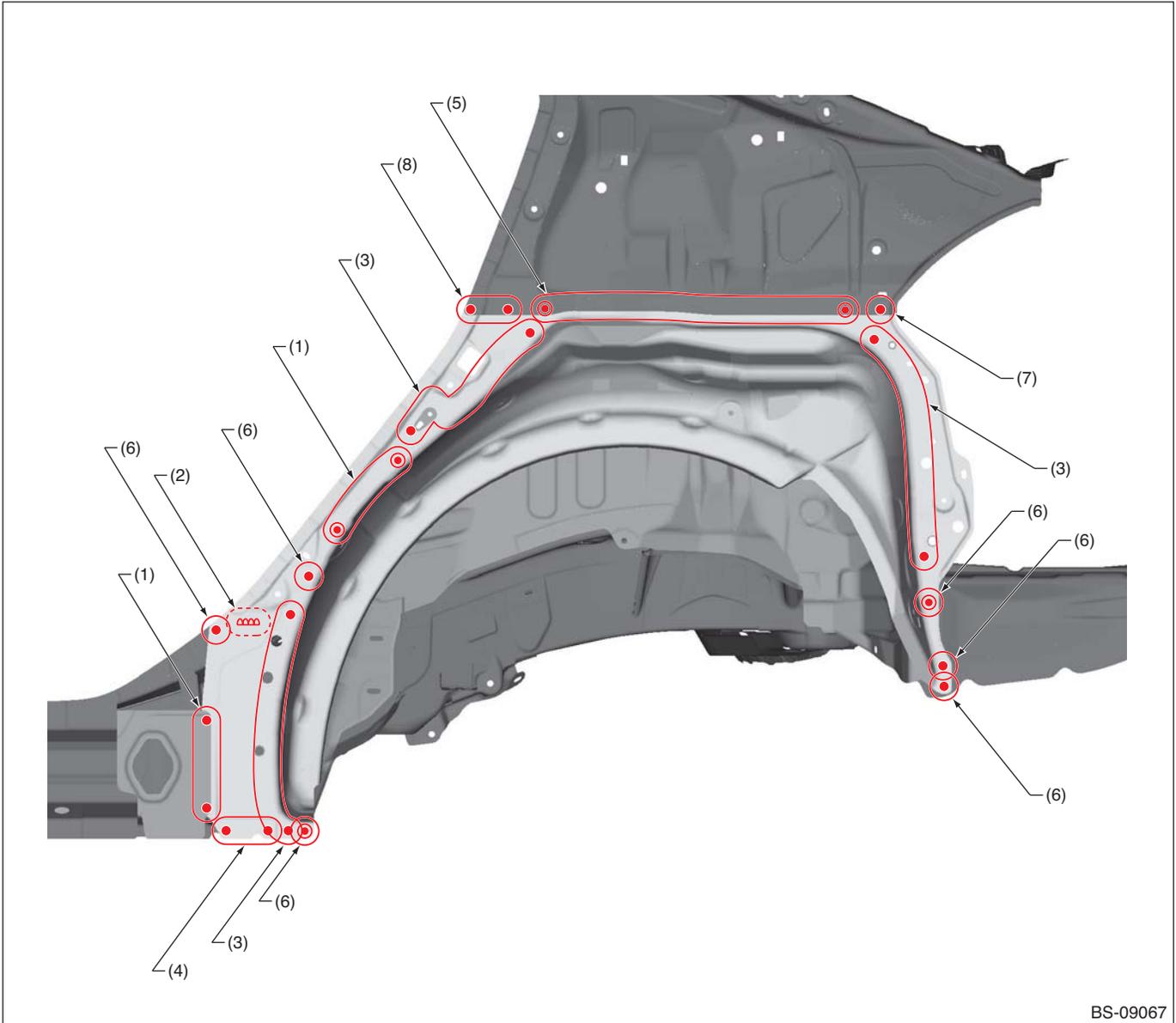
(11) 5 points

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-09067

- (1) 3 points (outside - 1)
- (2) 1 point (inside - 1 belt sander)
- (3) 6 points (outside - 1)

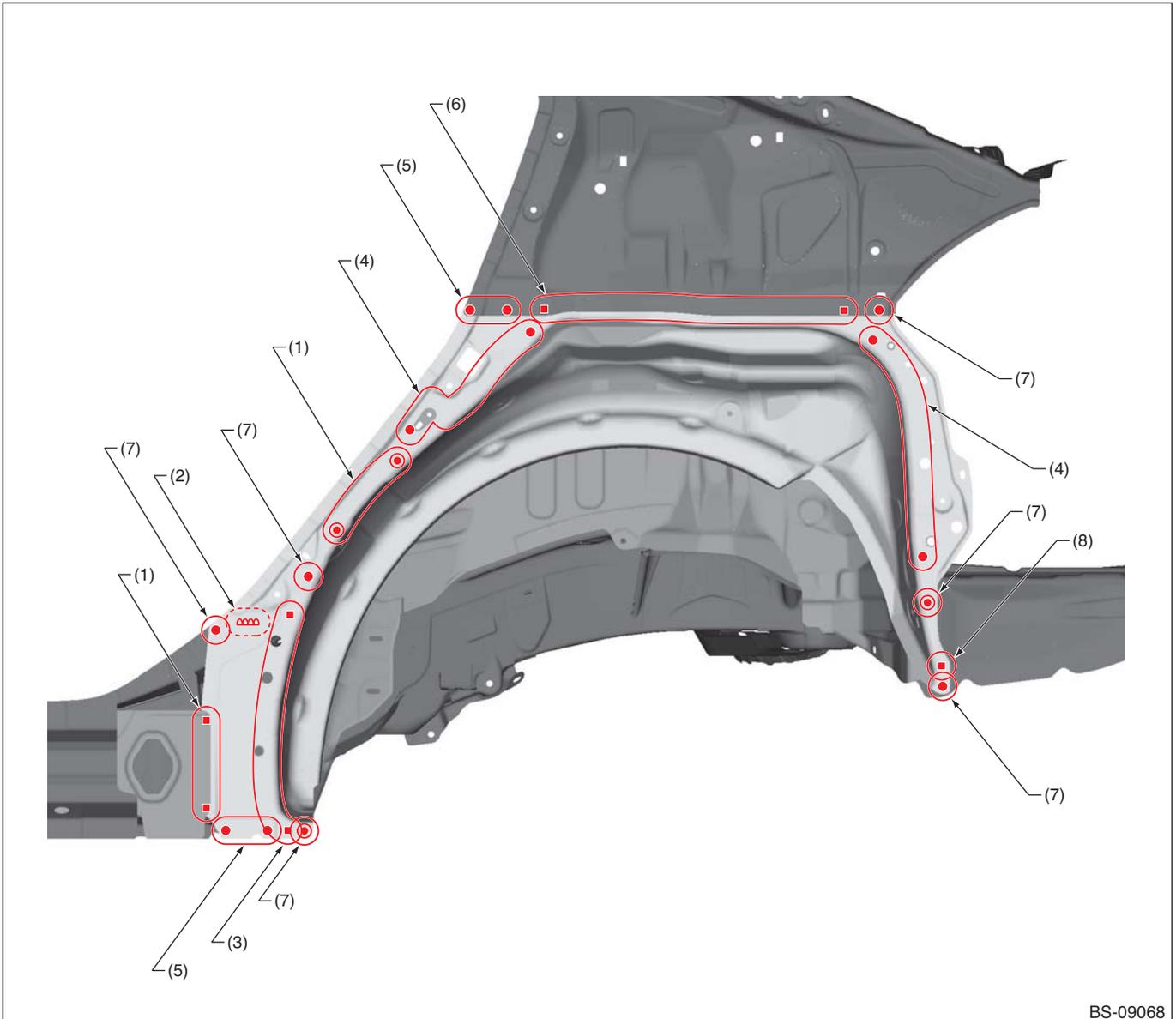
- (4) 2 points (outside - 1)
- (5) 7 points (outside - 2)
- (6) 1 point (outside - 1)

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

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09068

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

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

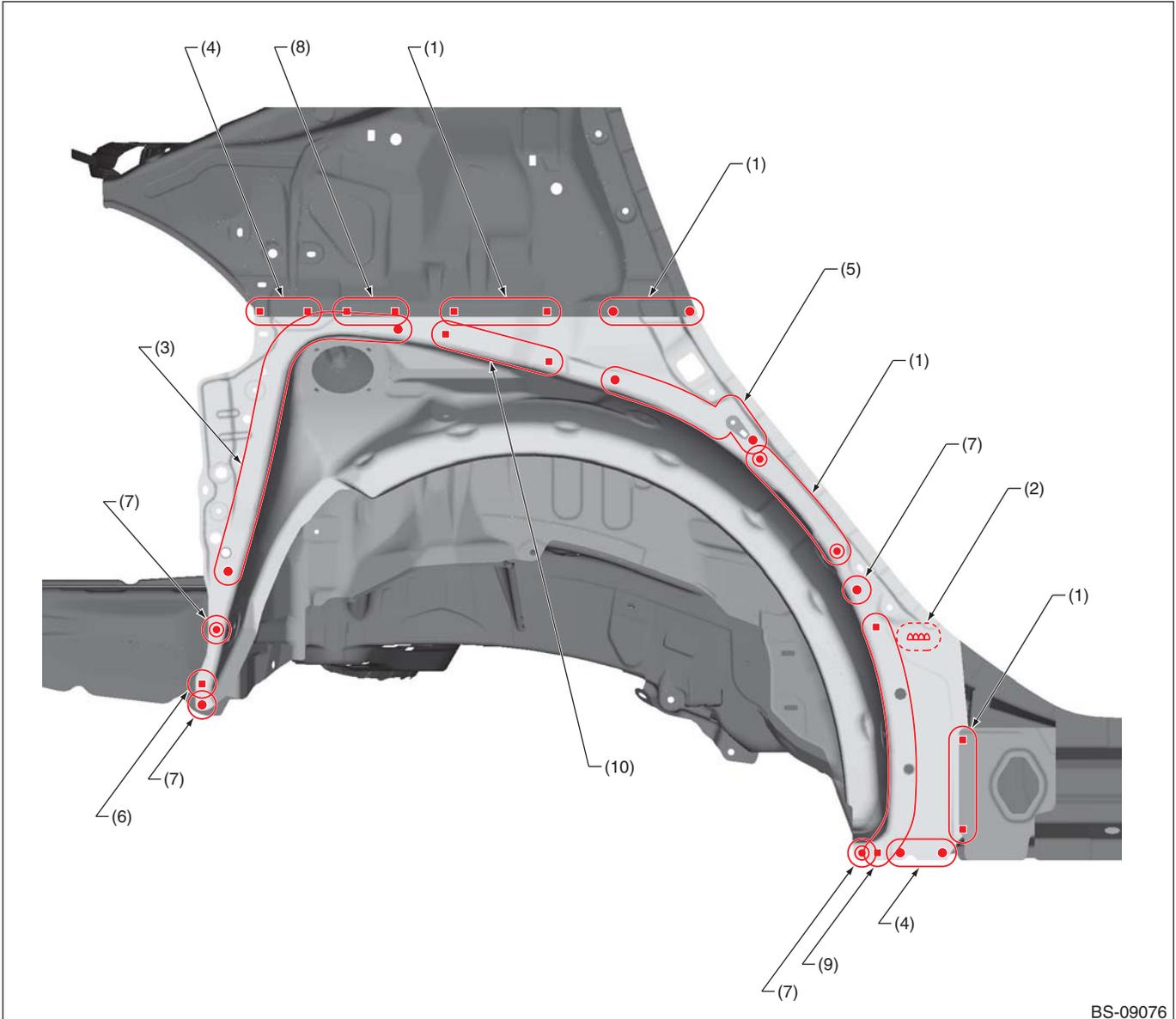
- (7) 1 point
- (8) 1 point (service)



# Panel Replacement

## B: INSTALLATION

### • Overall view



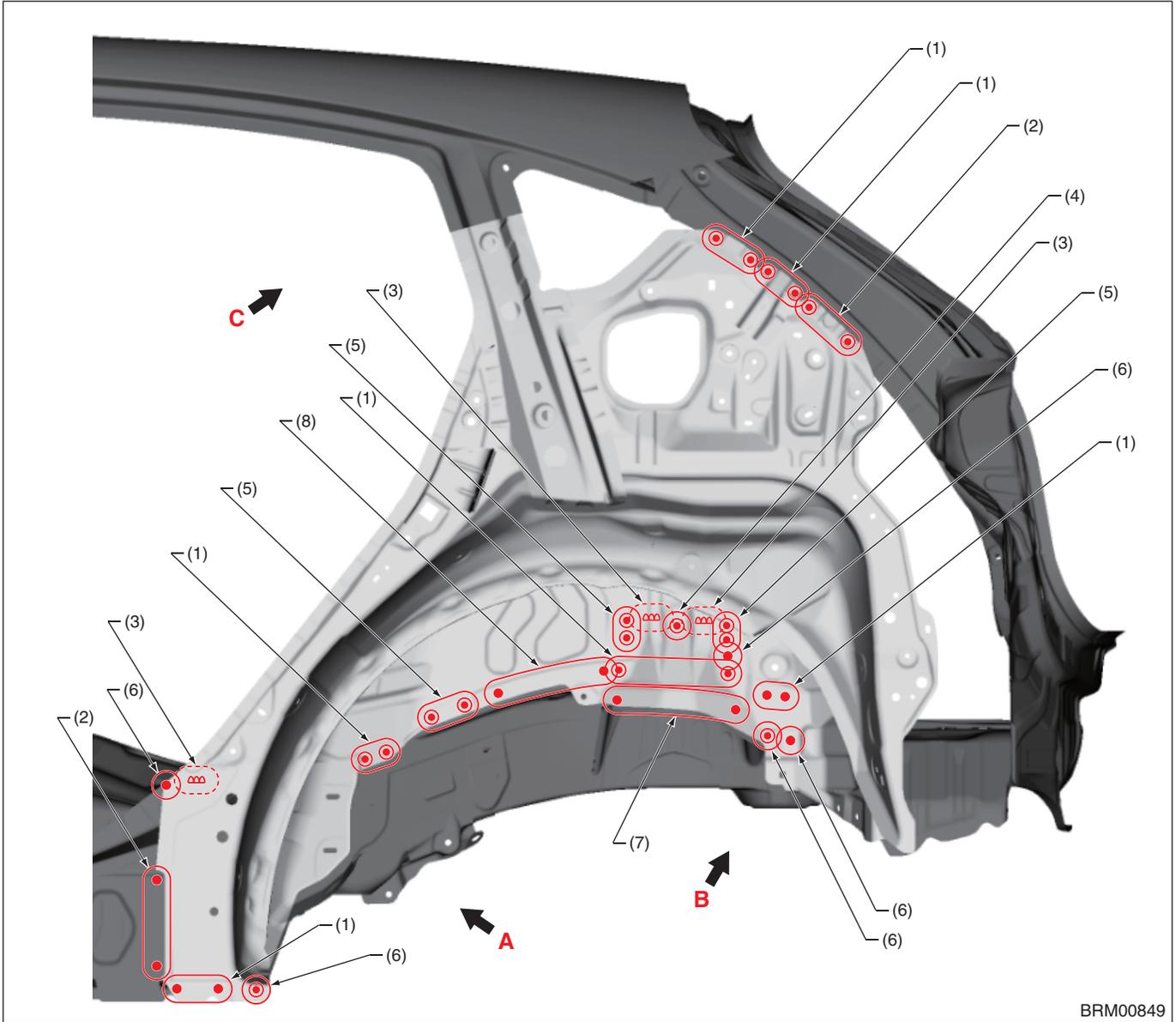
- |   |                                   |                         |
|---|-----------------------------------|-------------------------|
| (1) 3 points  | (5) 5 points                      | (9) 6 points (service)  |
| (2) 1 point (Continuous welding)<br>(30 mm [1.18 in]) | (6) 1 point (service)   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

# Panel Replacement

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

### A: REMOVAL

#### • Overall view

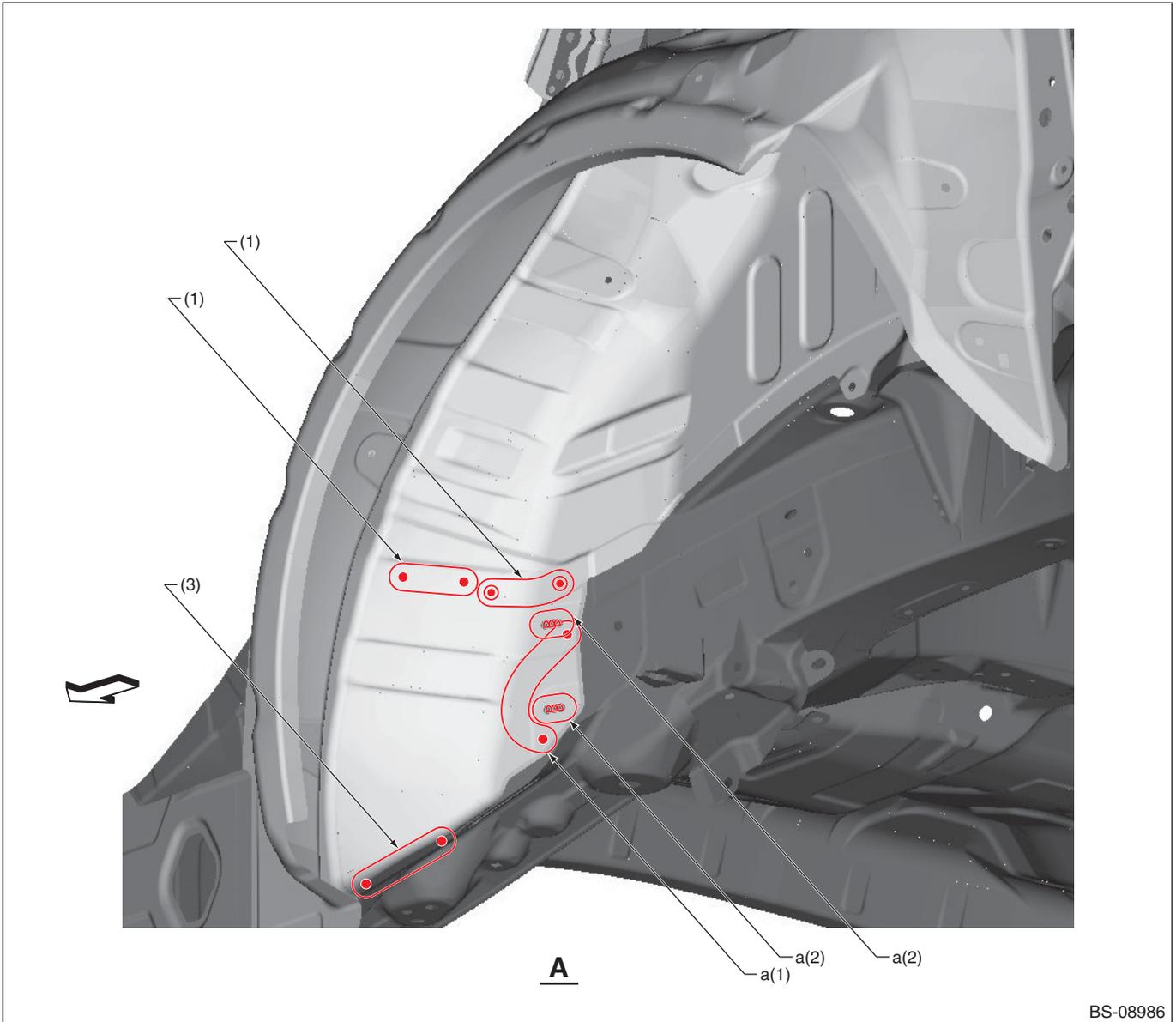


BRM00849

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

# Panel Replacement

## • Views A



(1) 2 points (outside · 1)

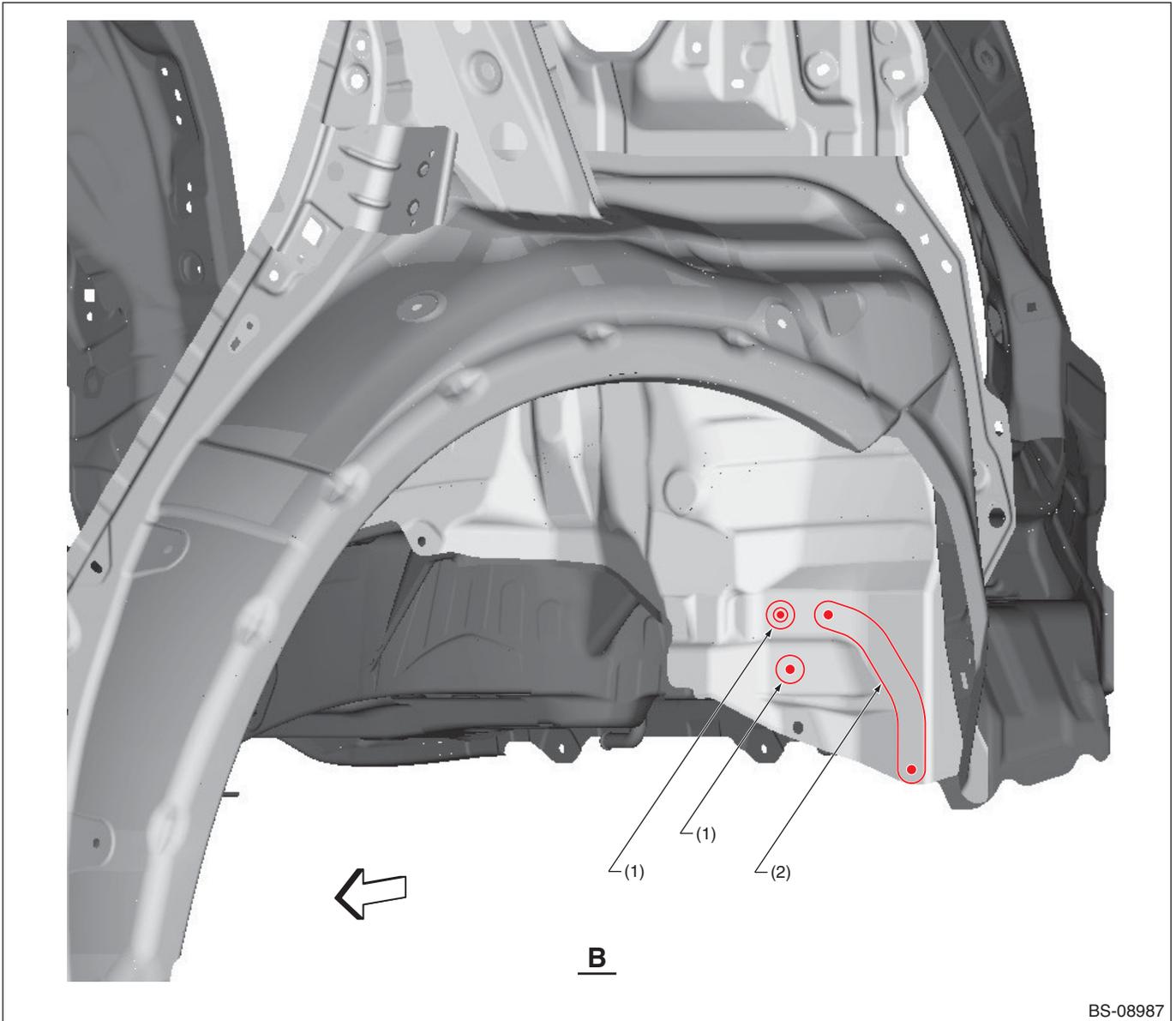
(2) 1 point (outside · 1 belt sander)

(3) 2 points (top · 1)

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

# Panel Replacement

## • Views B

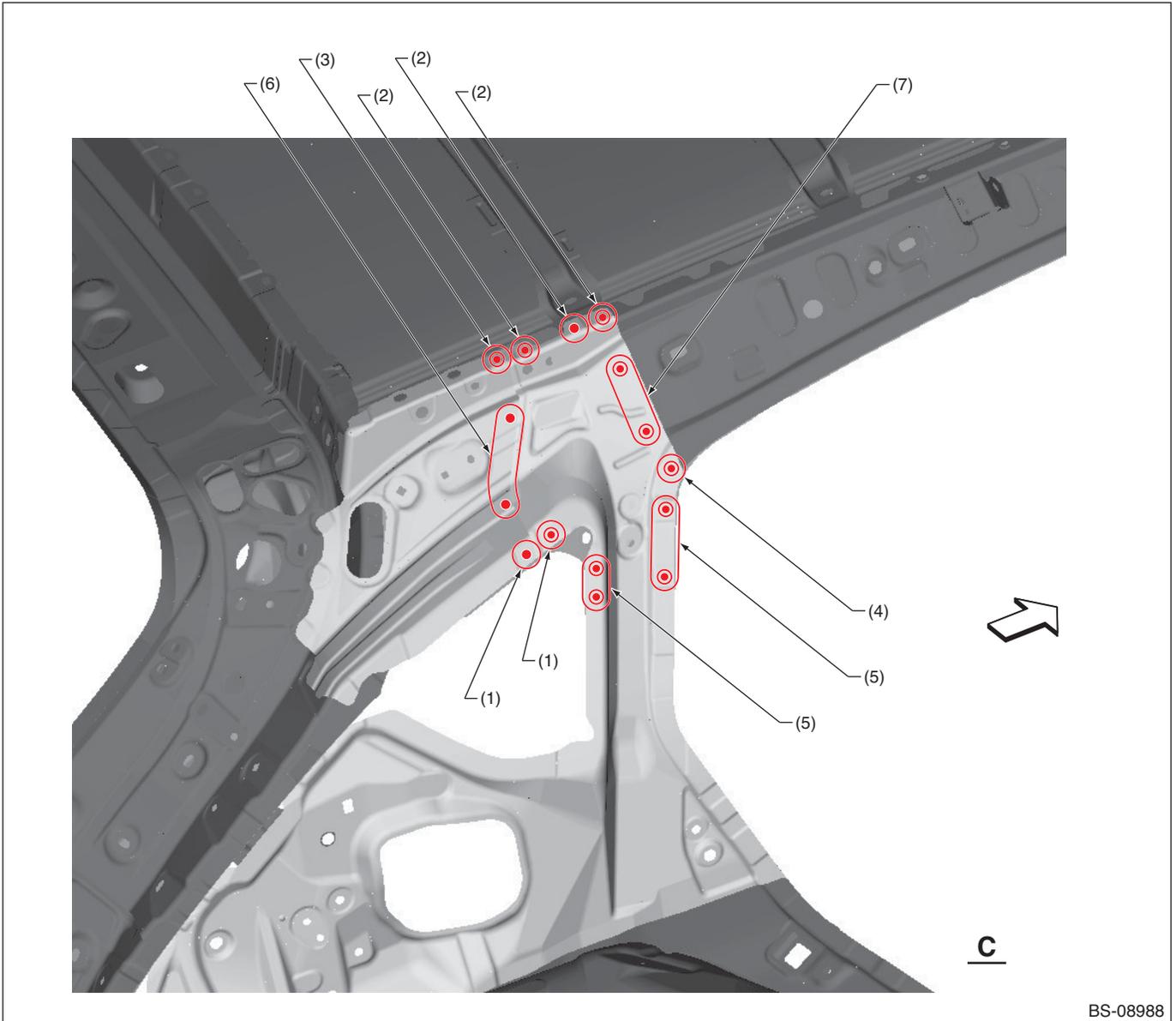


(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

# Panel Replacement

## • Views C



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

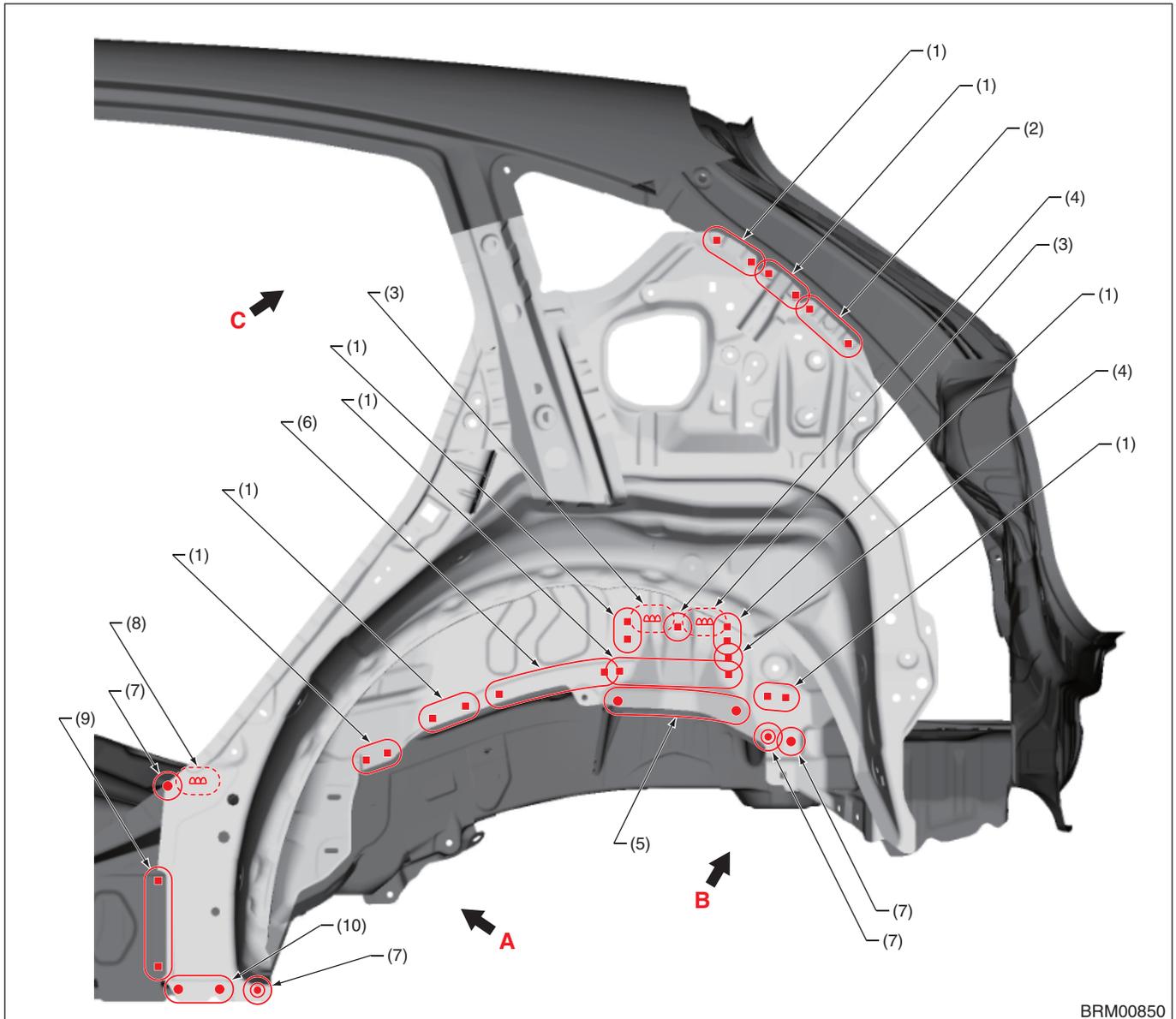
- (4) 1 point (inside · 2)
- (5) 2 points (inside · 2)
- (6) 3 points (inside · 1)

- (7) 3 points (inside · 2)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BRM00850

(1) 2 points (service)

(2) 3 points (service)

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

(4) 1 point (service)

(5) 5 points

(6) 4 points (service)

(7) 1 point

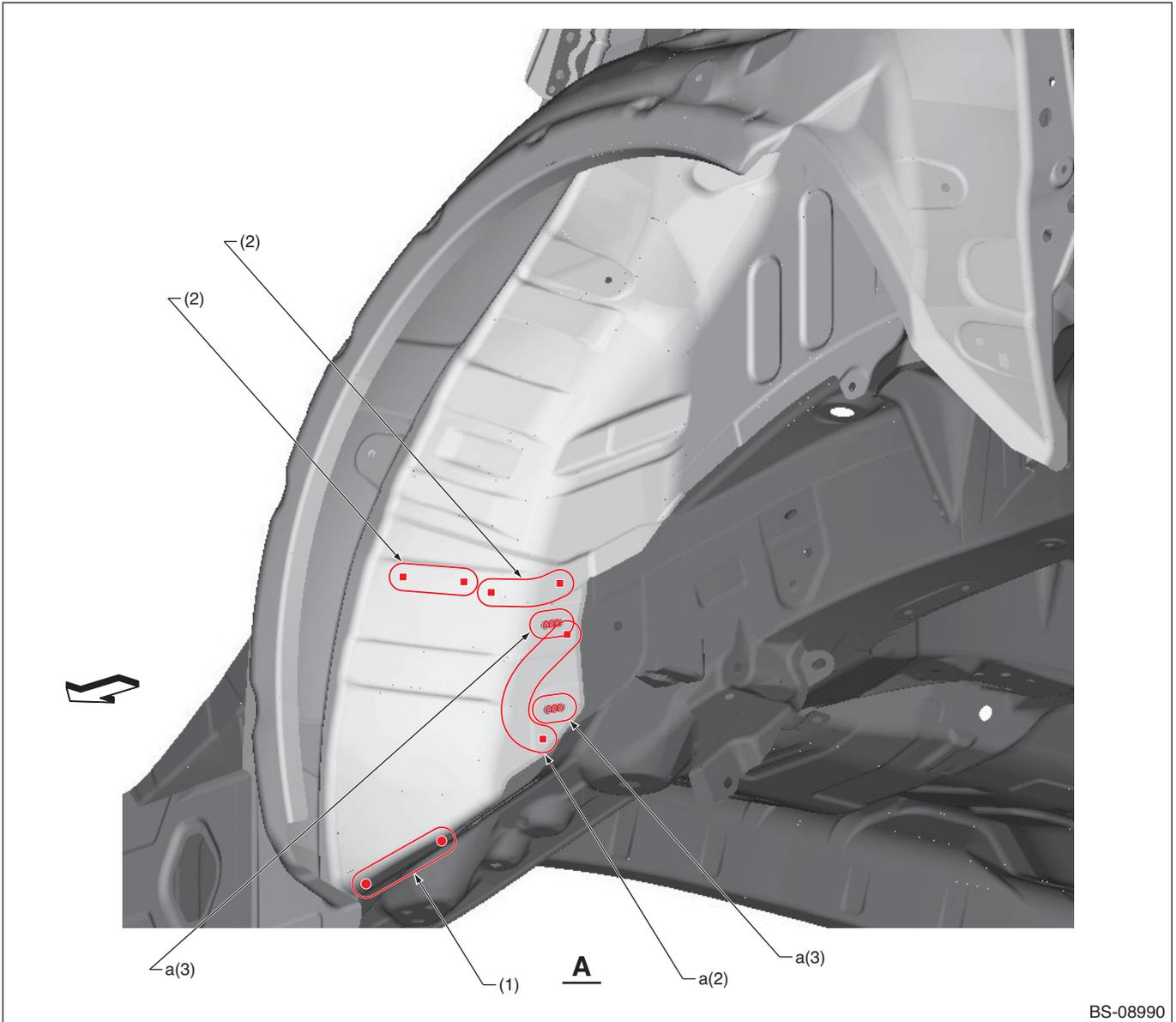
(8) 1 point (Continuous welding)  
(30 mm [1.18 in])

(9) 3 points

(10) 2 points

# Panel Replacement

## • Views A



(1) 2 points

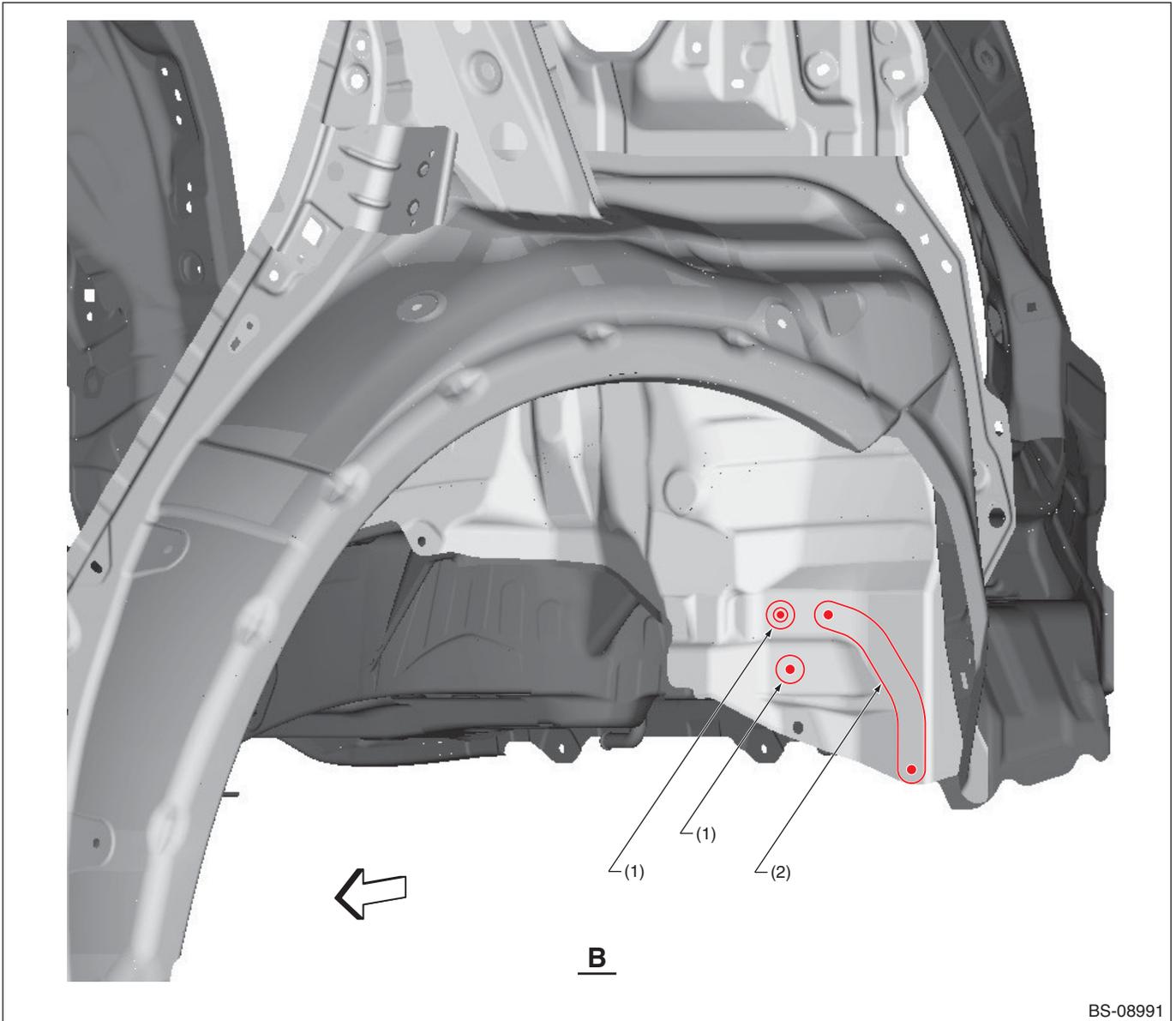
(2) 2 points (service)

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

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

# Panel Replacement

## • Views B

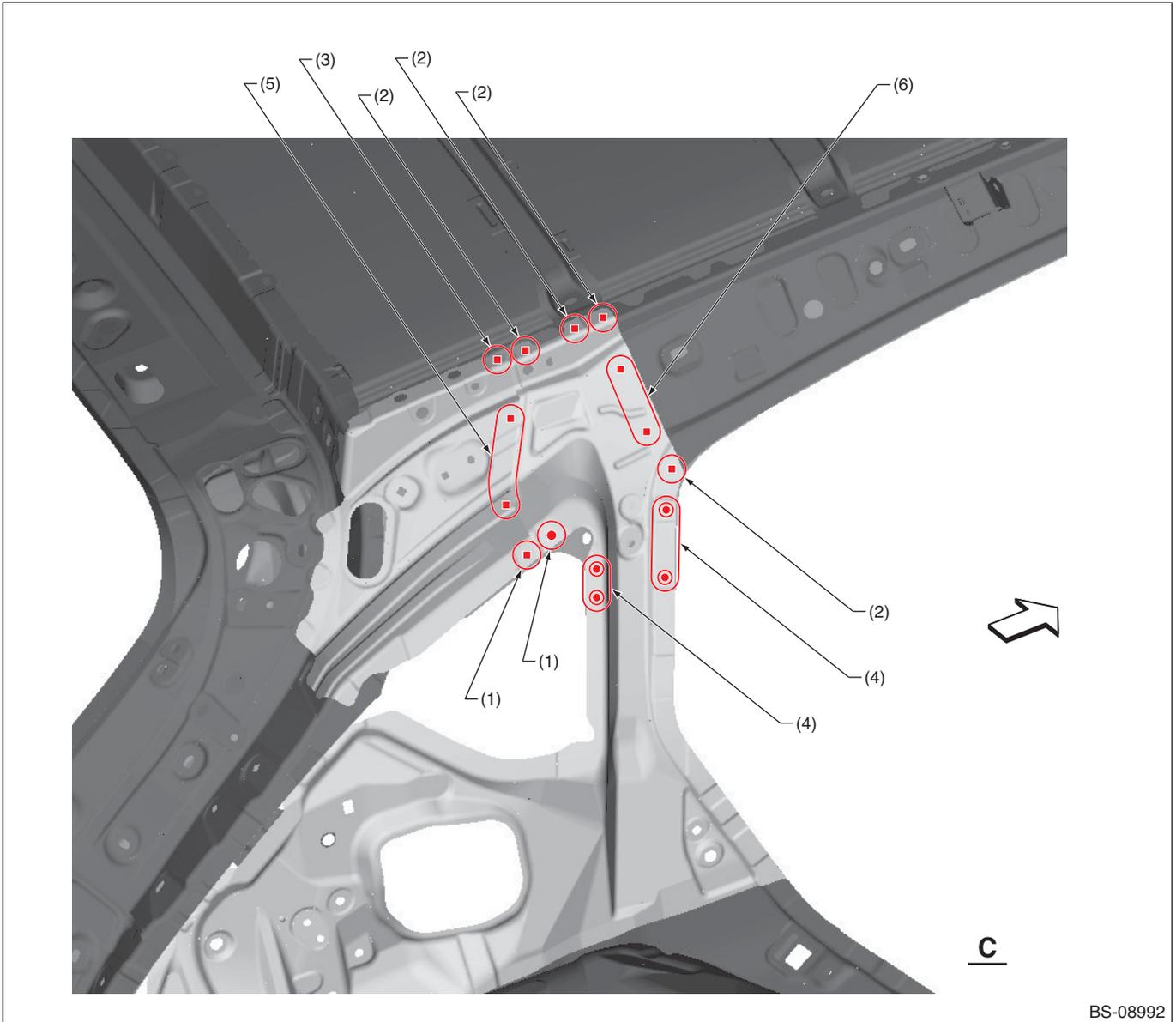


(1) 1 point

(2) 5 points

# Panel Replacement

## • Views C



(1) 1 point

(2) 1 point (service)

(3) 1 point (service · matching)

(4) 2 points

(5) 3 points

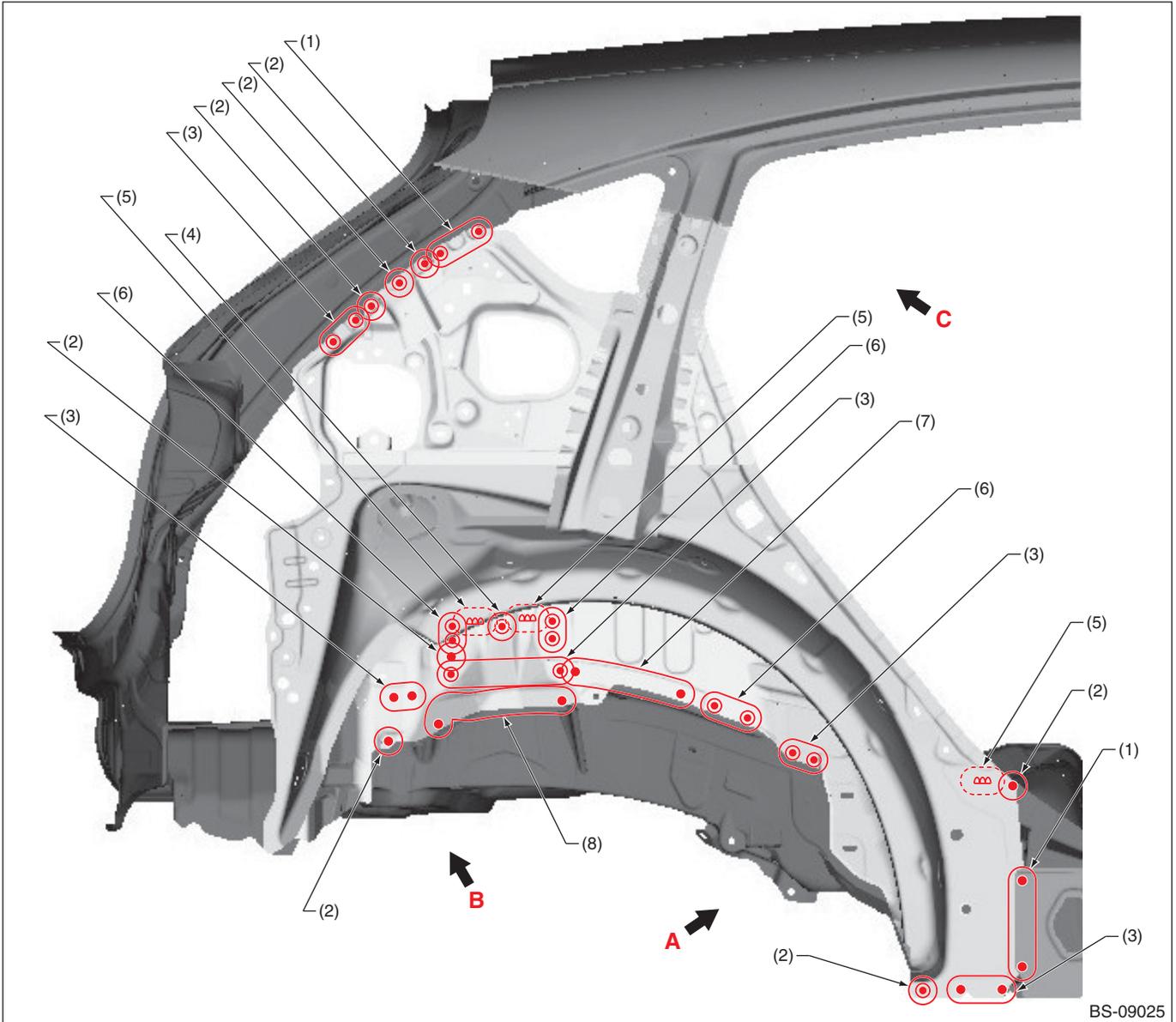
(6) 3 points (service)

# Panel Replacement

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

### A: REMOVAL

• Overall view



BS-09025

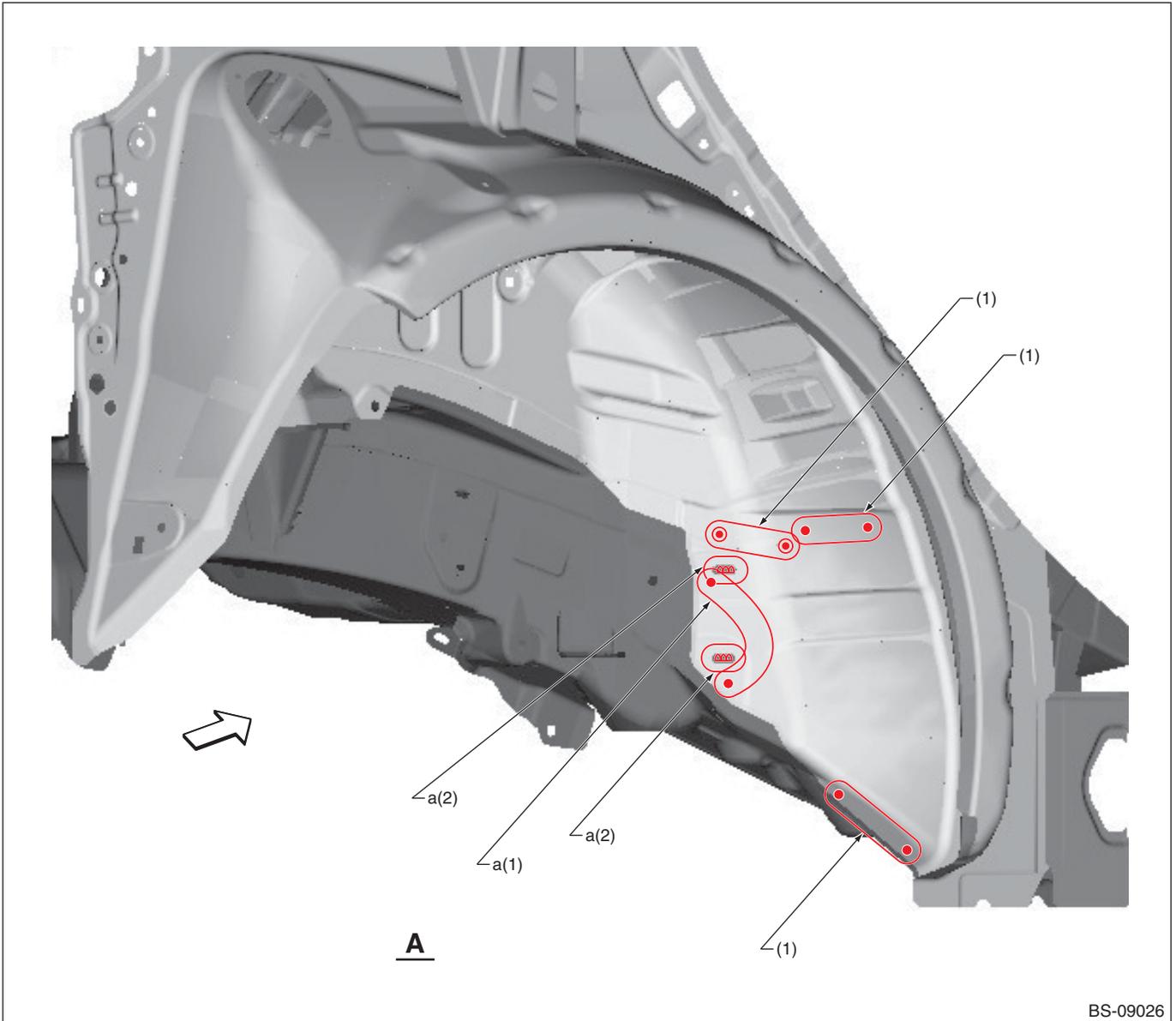
- (1) 3 points (outside · 1)
- (2) 1 point (outside · 1)
- (3) 2 points (outside · 1)

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

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

# Panel Replacement

## • Views A



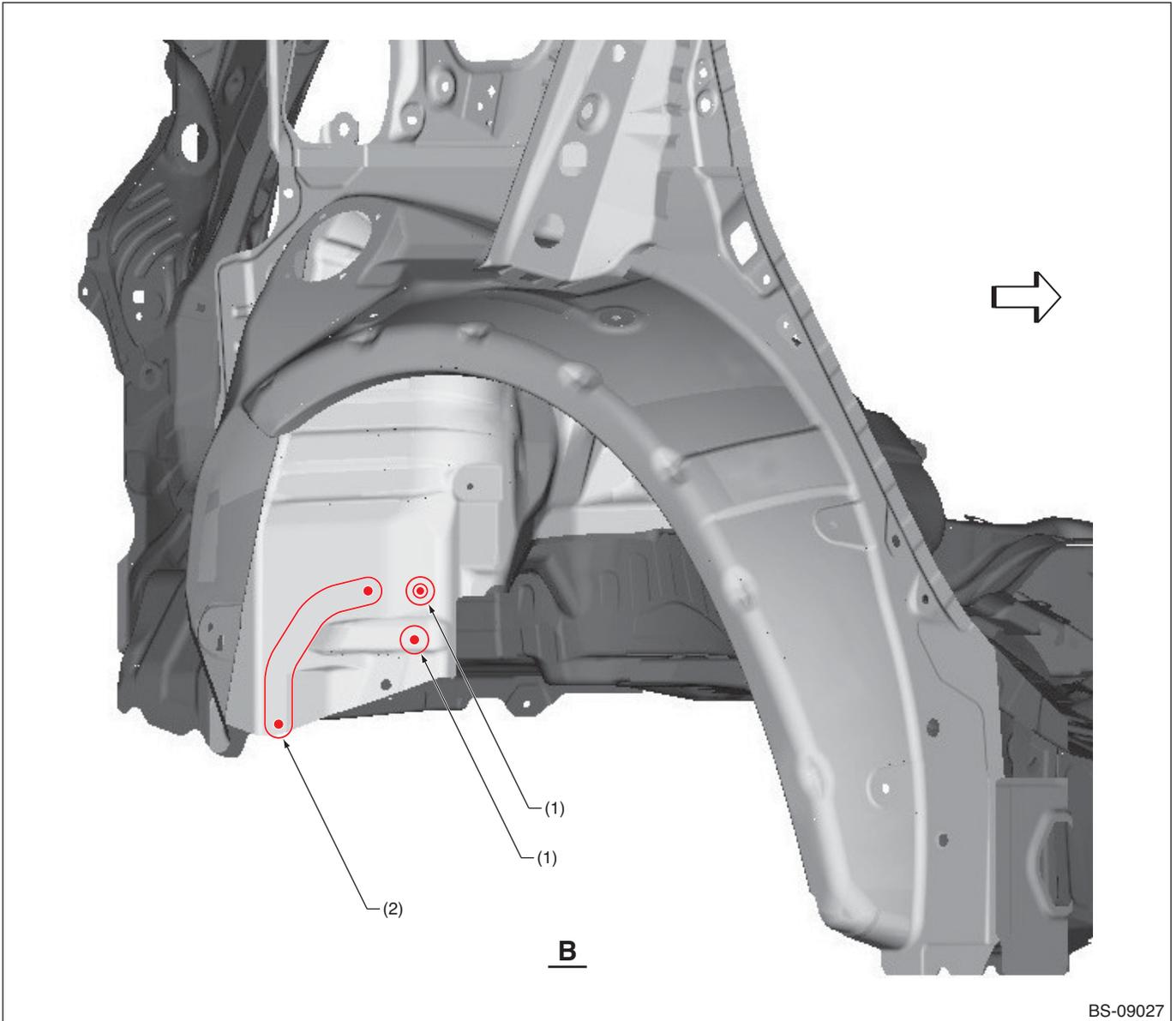
(1) 2 points (outside · 1)

(2) 1 point (outside · 1 belt sander)

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

# Panel Replacement

## • Views B

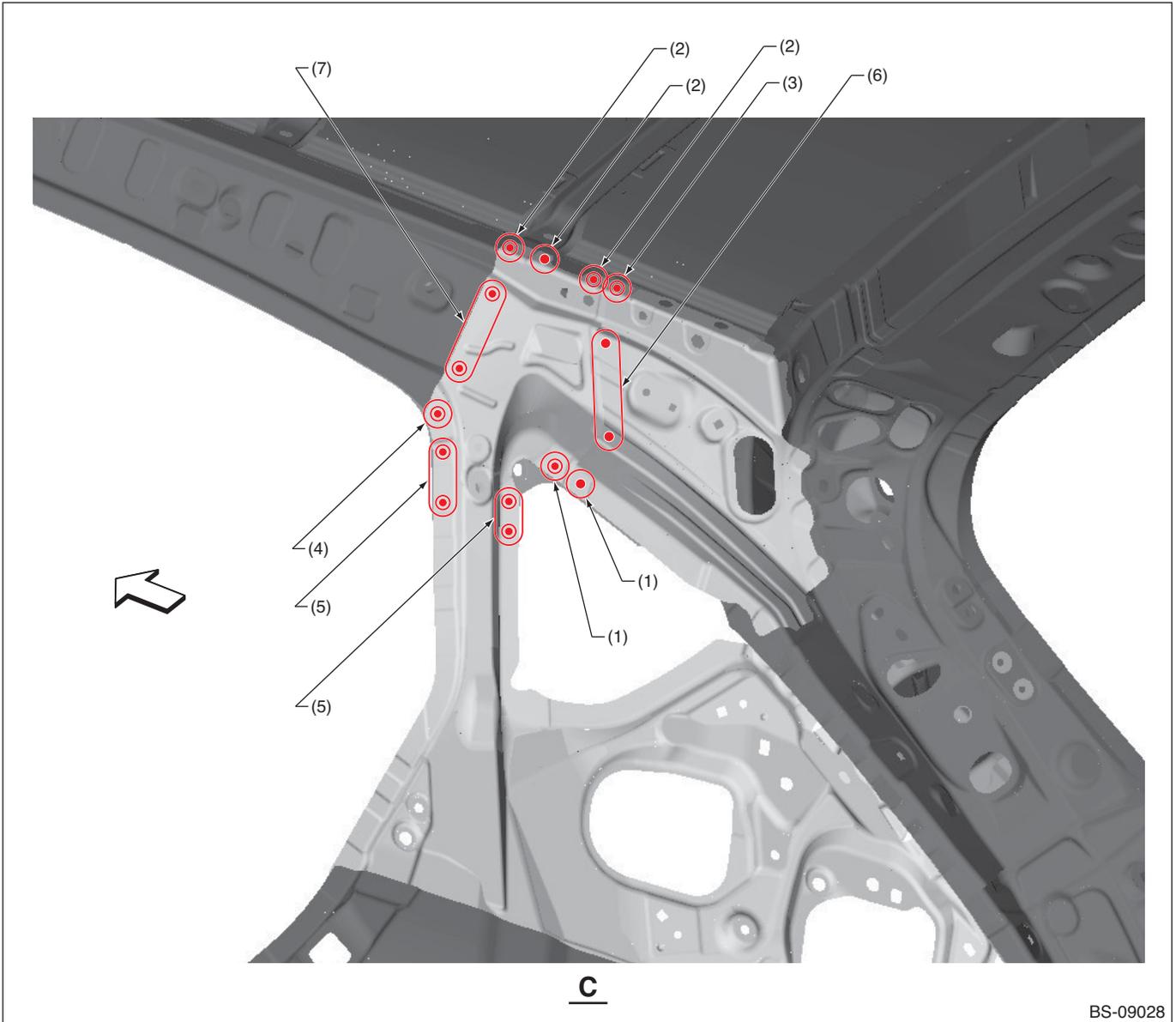


(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

# Panel Replacement

## • Views C



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

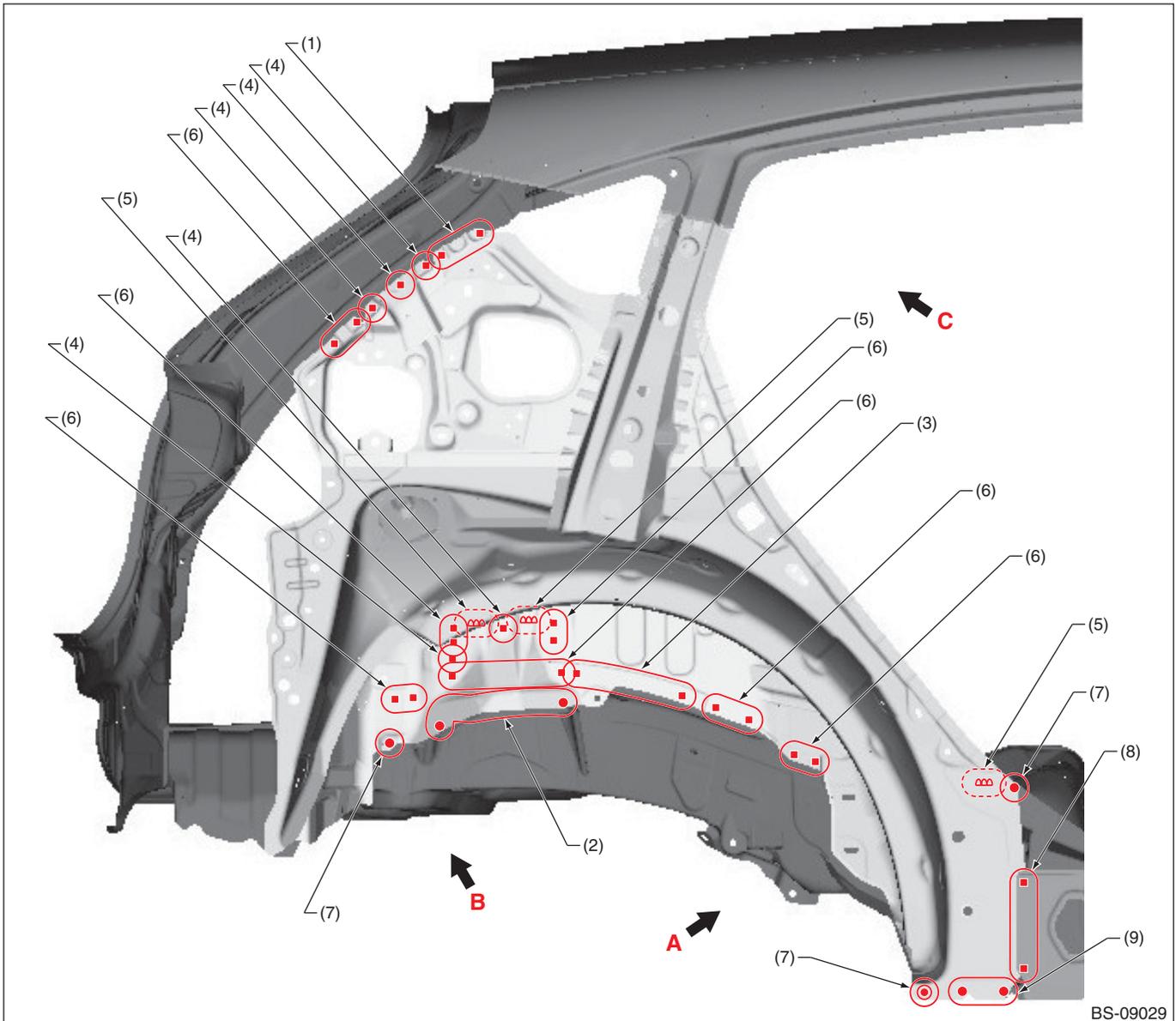
- (4) 1 point (inside · 2)
- (5) 2 points (inside · 2)
- (6) 3 points (inside · 1)

- (7) 3 points (inside · 2)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09029

(1) 3 points (service)

(2) 6 points

(3) 4 points (service)

(4) 1 point (service)

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

(6) 2 points (service)

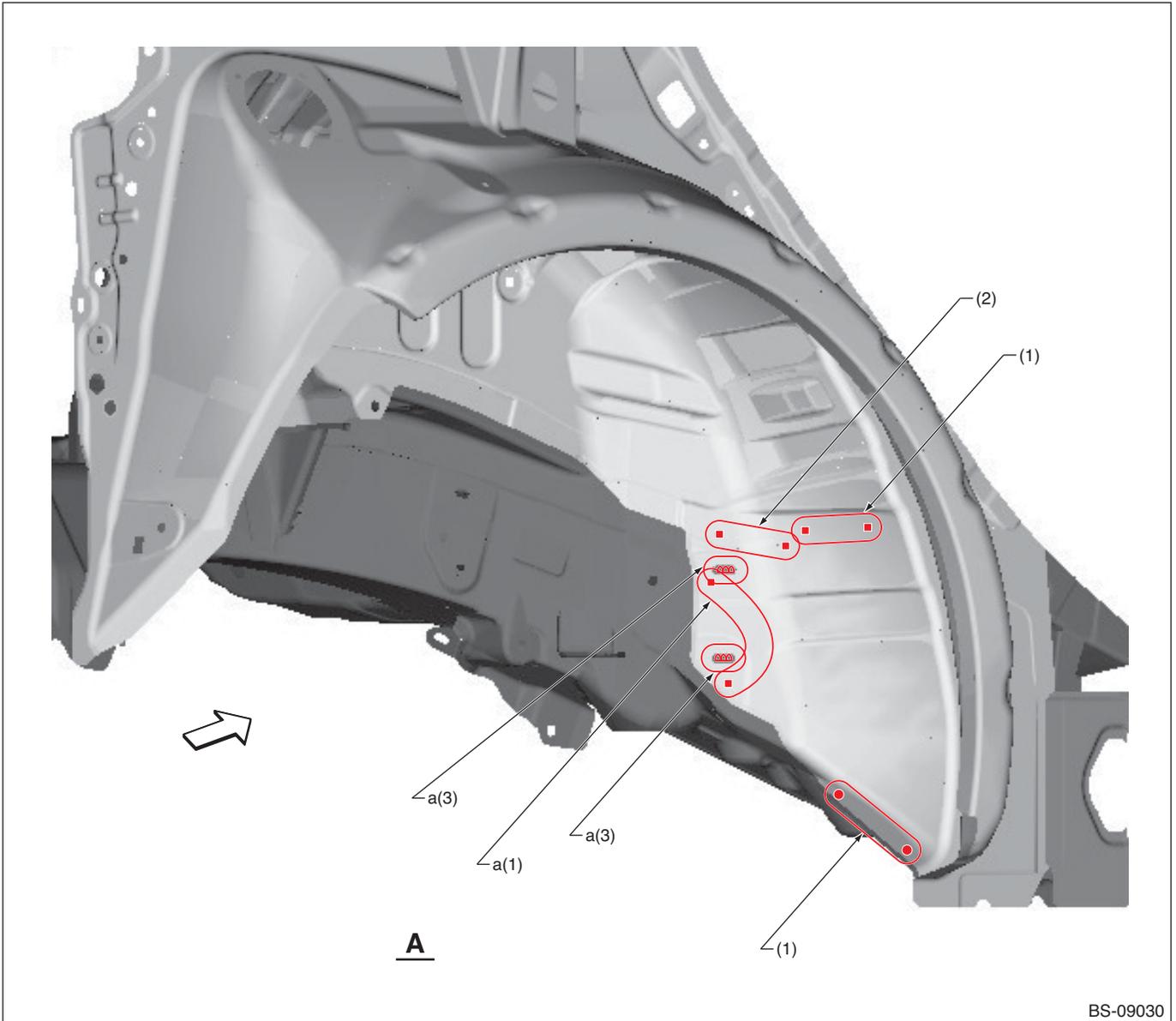
(7) 1 point

(8) 3 points

(9) 2 points

# Panel Replacement

## • Views A



(1) 2 points

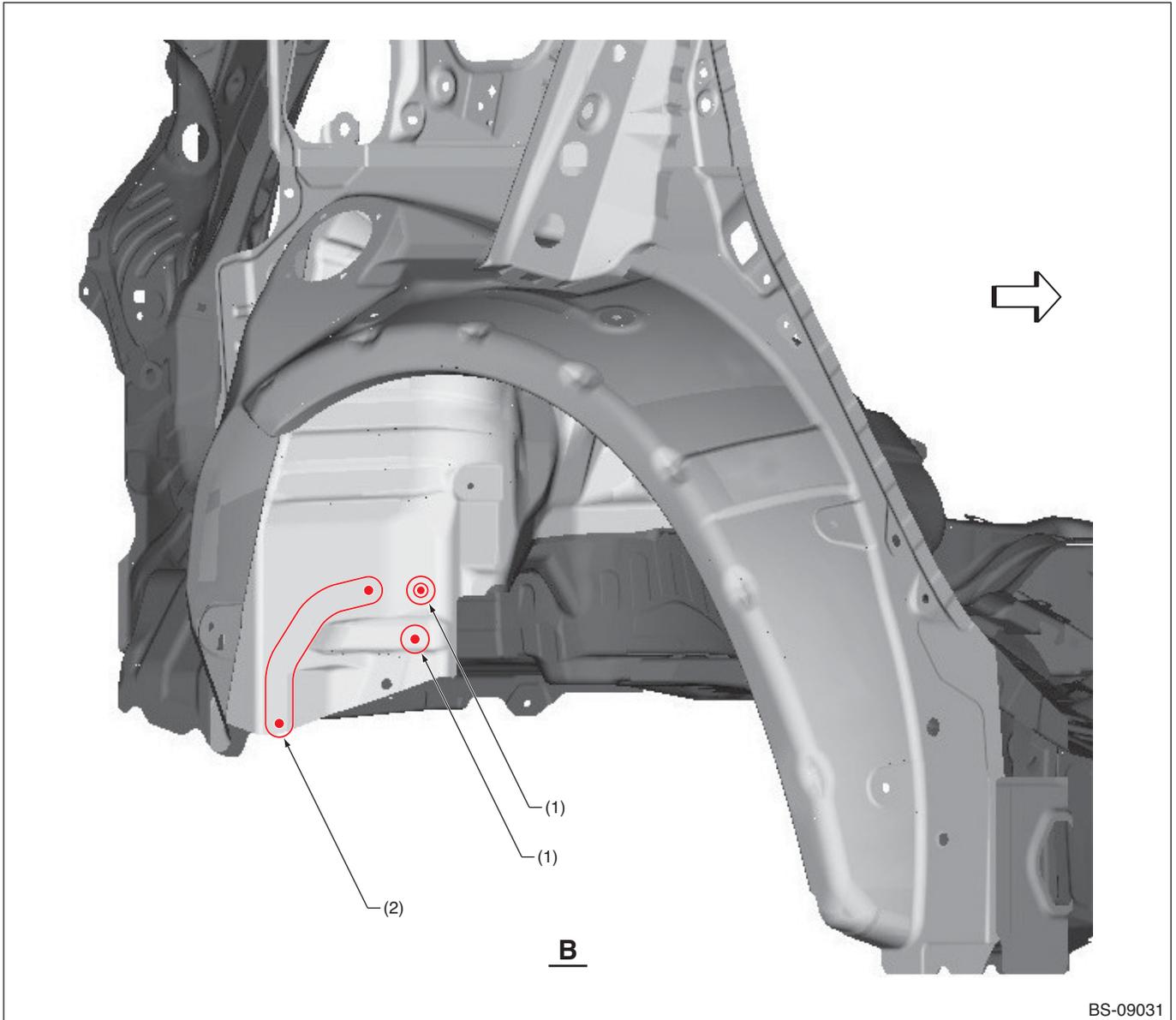
(2) 2 points (service)

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

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

# Panel Replacement

## • Views B

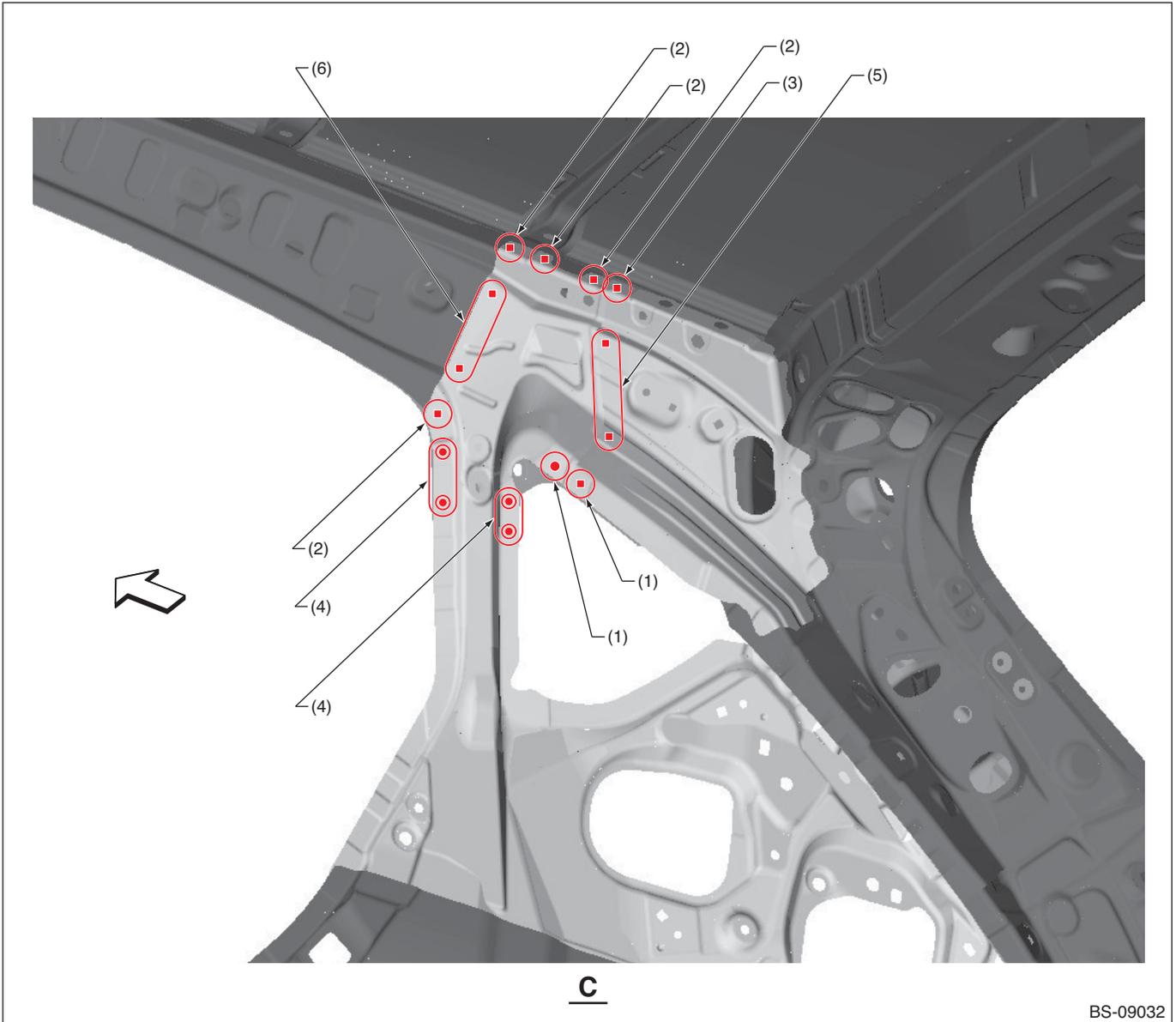


(1) 1 point

(2) 5 points

# Panel Replacement

## • Views C



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

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

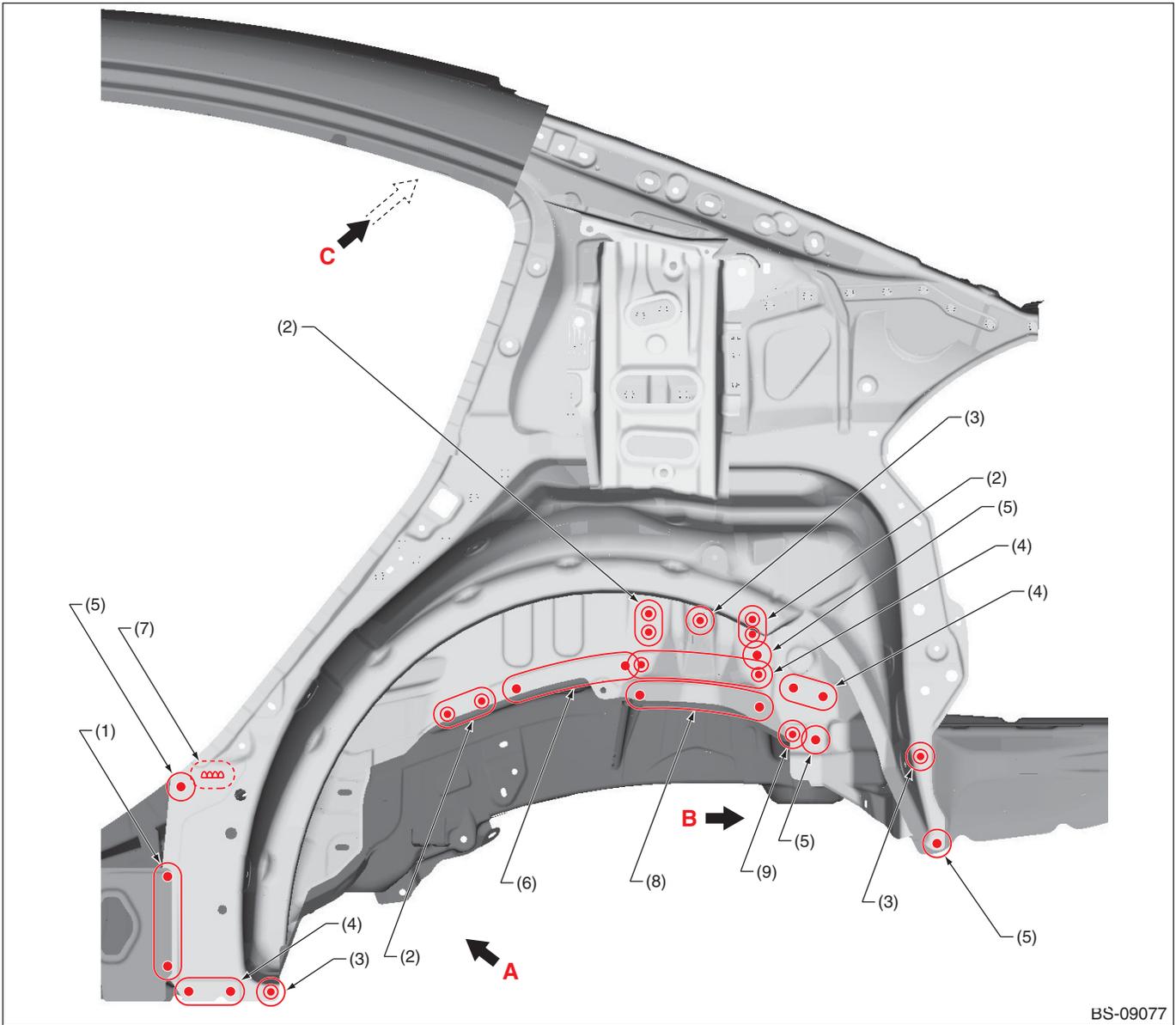
(5) 3 points  
(6) 3 points (service)

# Panel Replacement

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

### A: REMOVAL

• Overall view



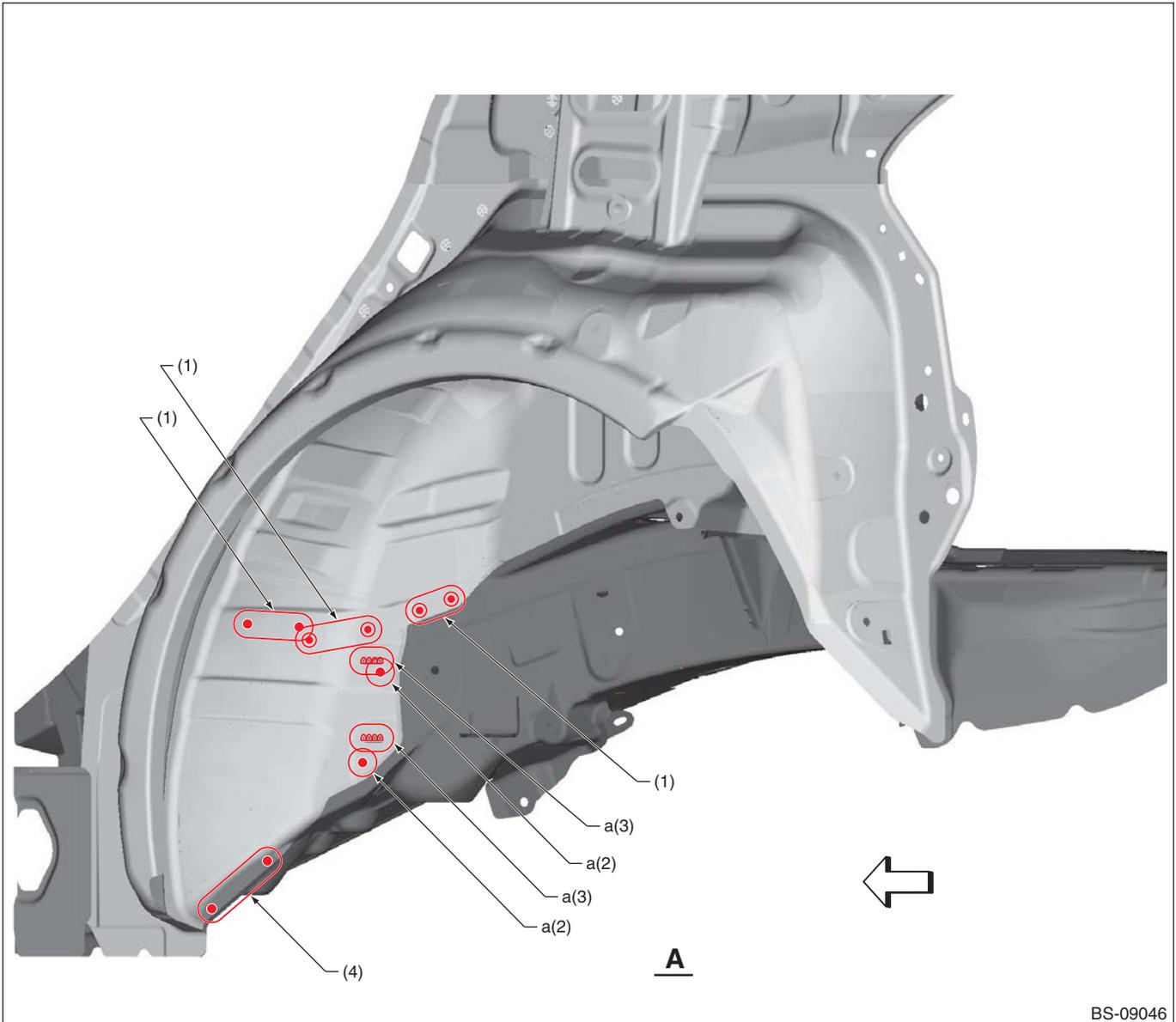
- (1) 3 points (outside · 1)
- (2) 2 points (outside · 2)
- (3) 1 point (outside · 2)
- (4) 2 points (outside · 1)

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

- (8) LH: 5 points (outside · 1)  
RH: 6 points (outside · 1)
- (9) LH only: 1 point (outside · 1)

# Panel Replacement

## • Views A



BS-09046

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

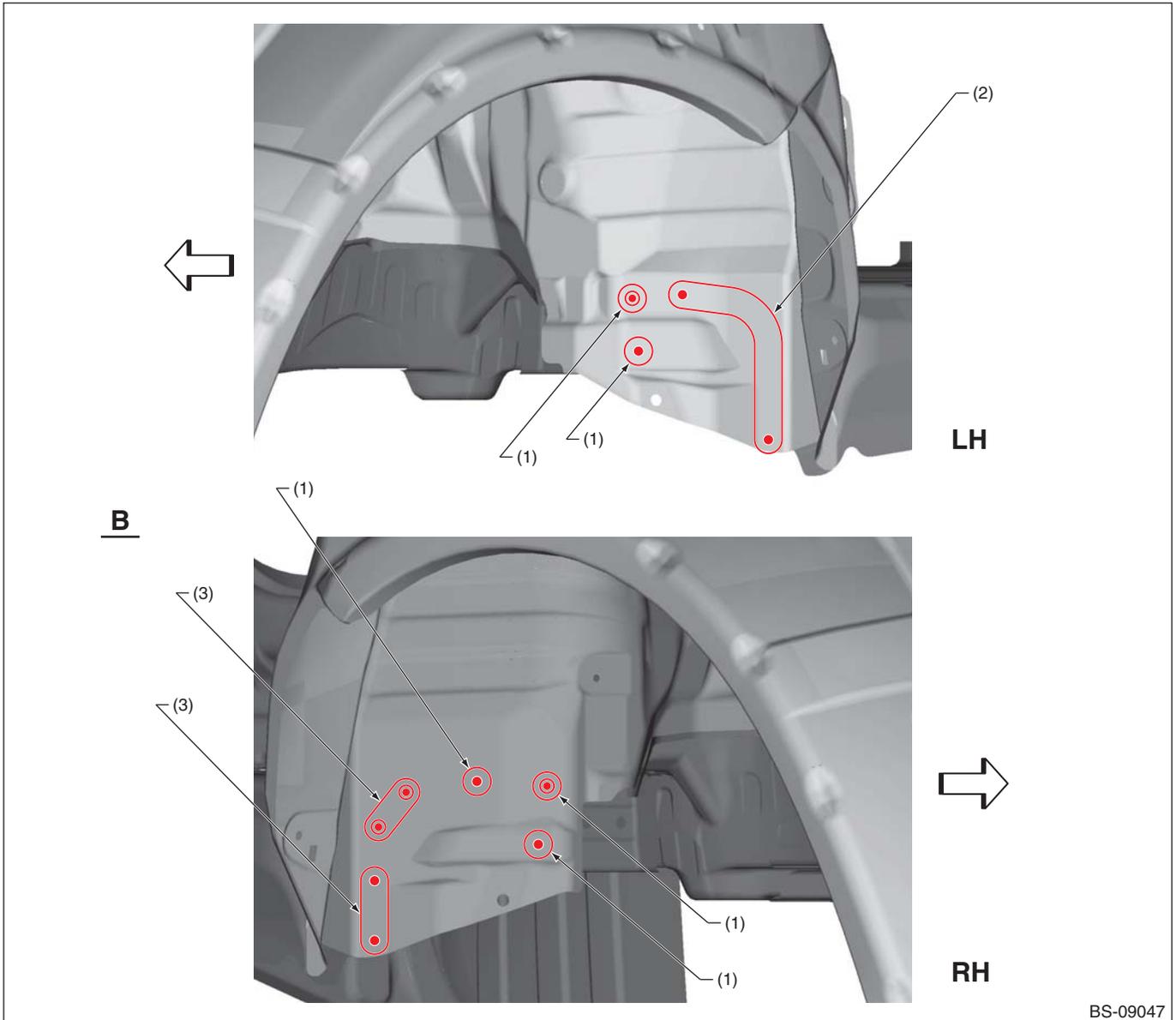
(3) 1 point (outside · 1 belt sander)

(4) 2 points (outside · 1)

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

# Panel Replacement

## • Views B



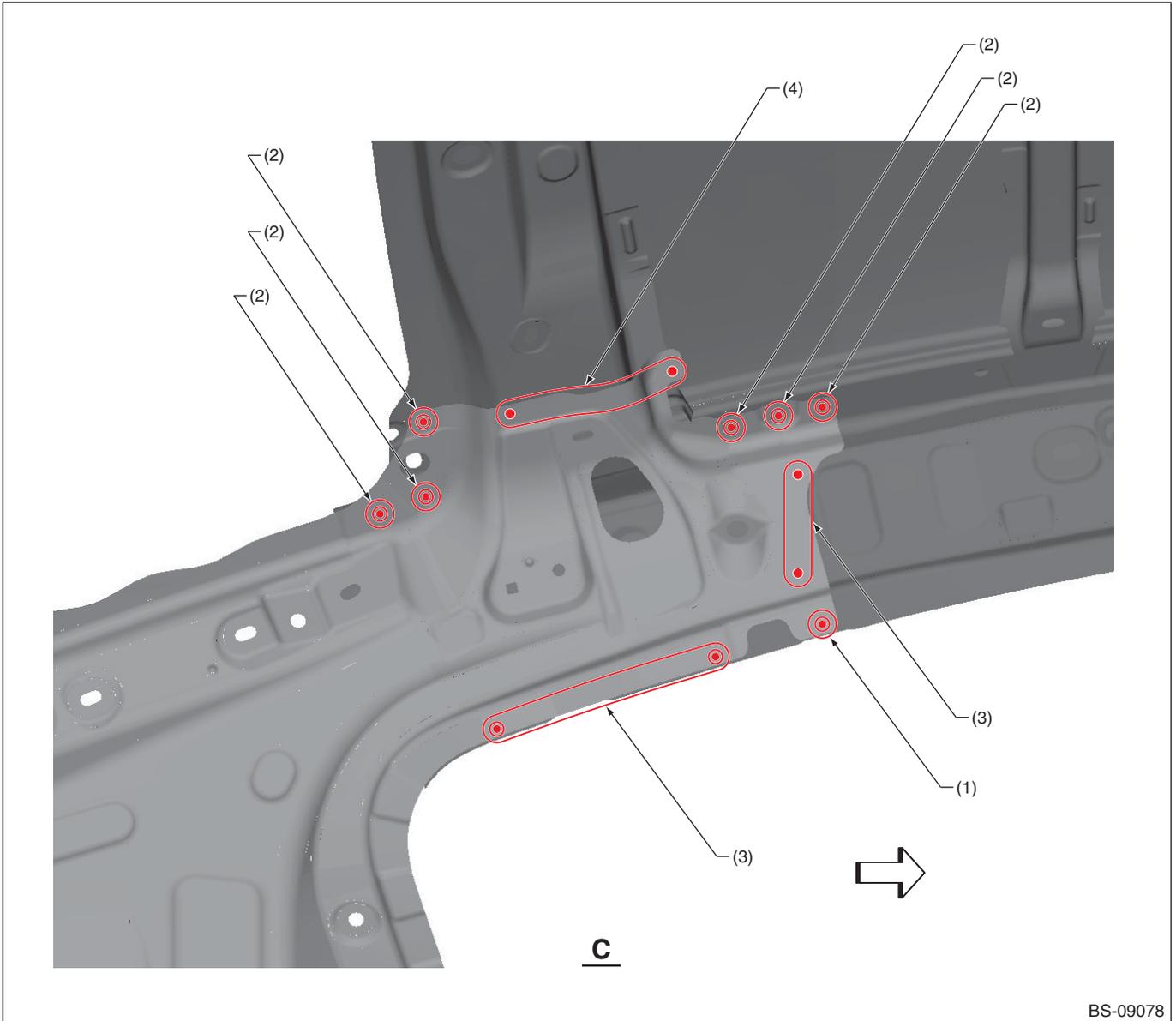
(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

(3) 2 points (outside · 1)

# Panel Replacement

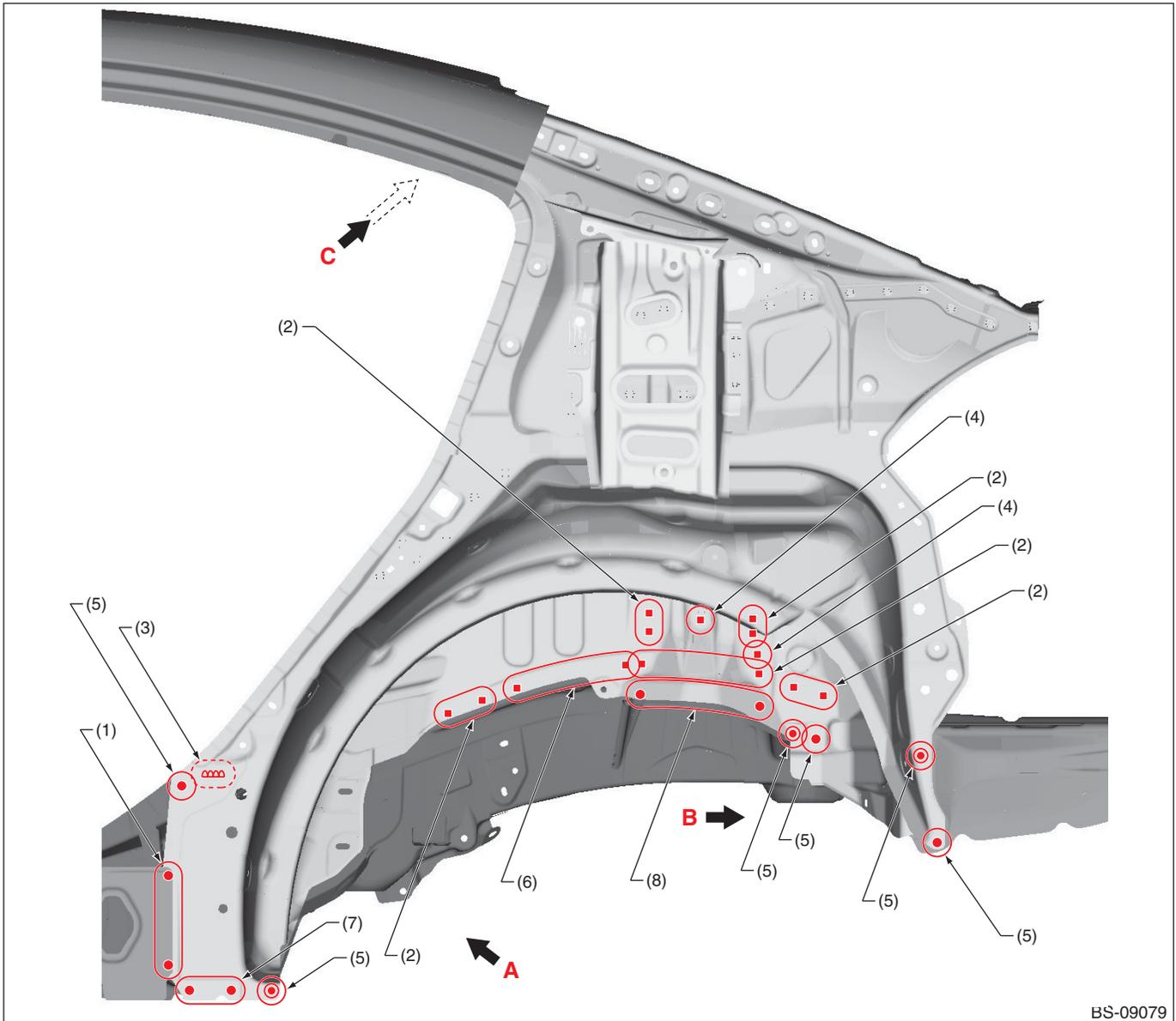
## • Views C



# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09079

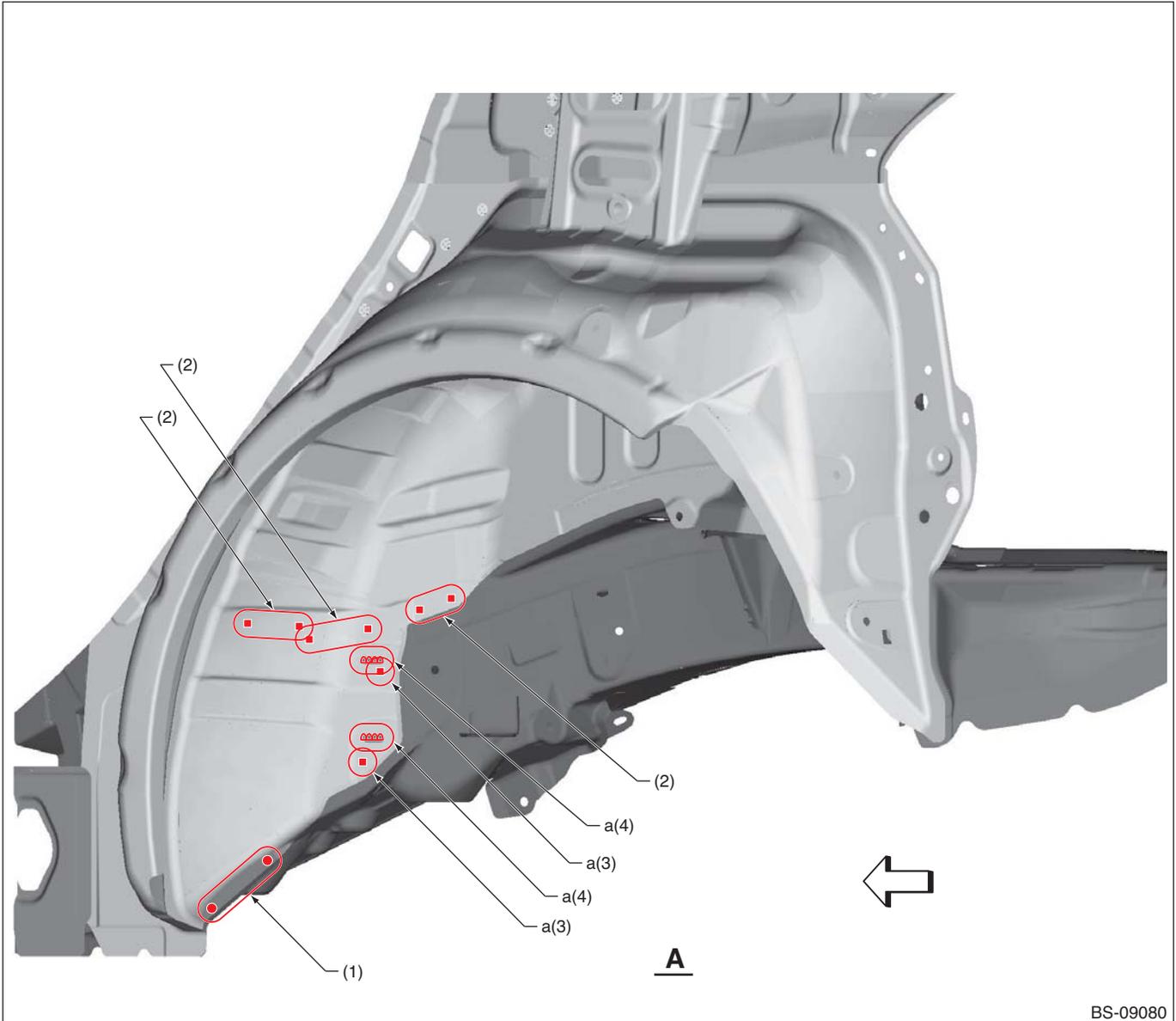
- (1) 3 points
- (2) 2 points (service)
- (3) 1 point (Continuous welding)  
(30 mm [1.18 in])

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

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

# Panel Replacement

## • Views A



BS-09080

(1) 2 points

(3) 1 point (service)

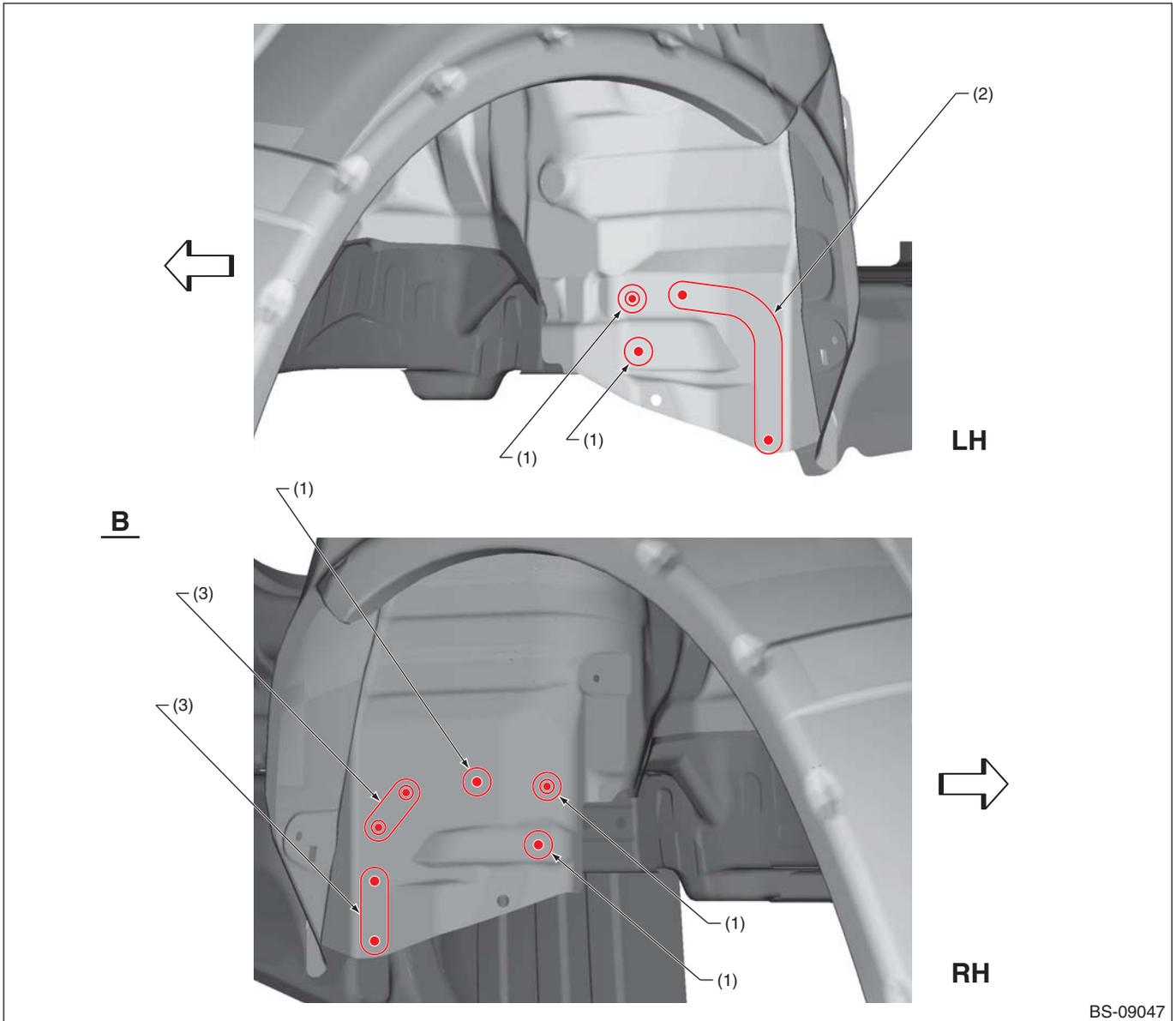
(4) 1 point (Continuous welding)  
(5 mm [0.2 in])

(2) 2 points (service)

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

# Panel Replacement

## • Views B



BS-09047

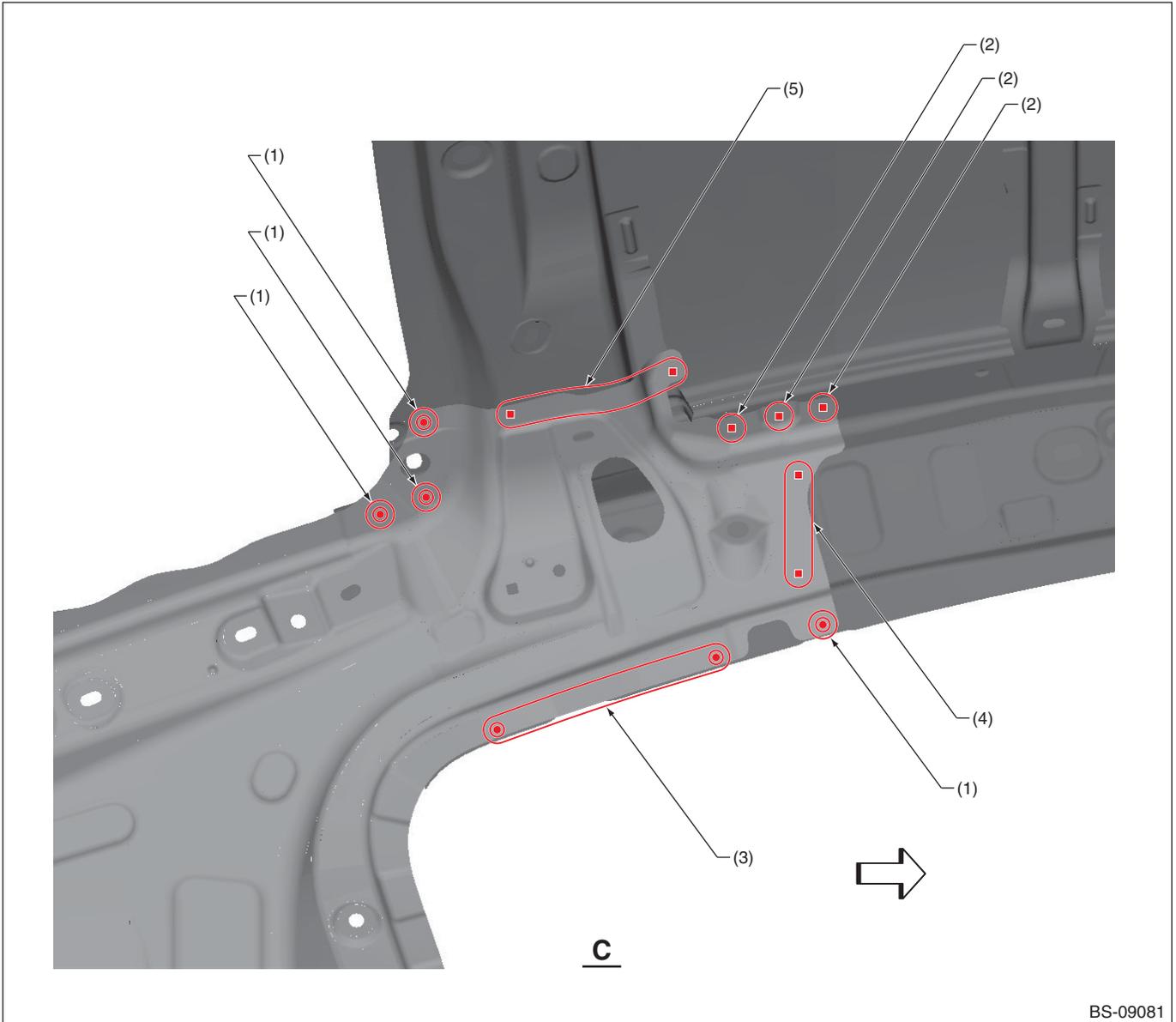
(1) 1 point

(2) 5 points

(3) 2 points

# Panel Replacement

## • Views C



(1) 1 point

(2) 1 point (service)

(3) 3 points

(4) 3 points (service)

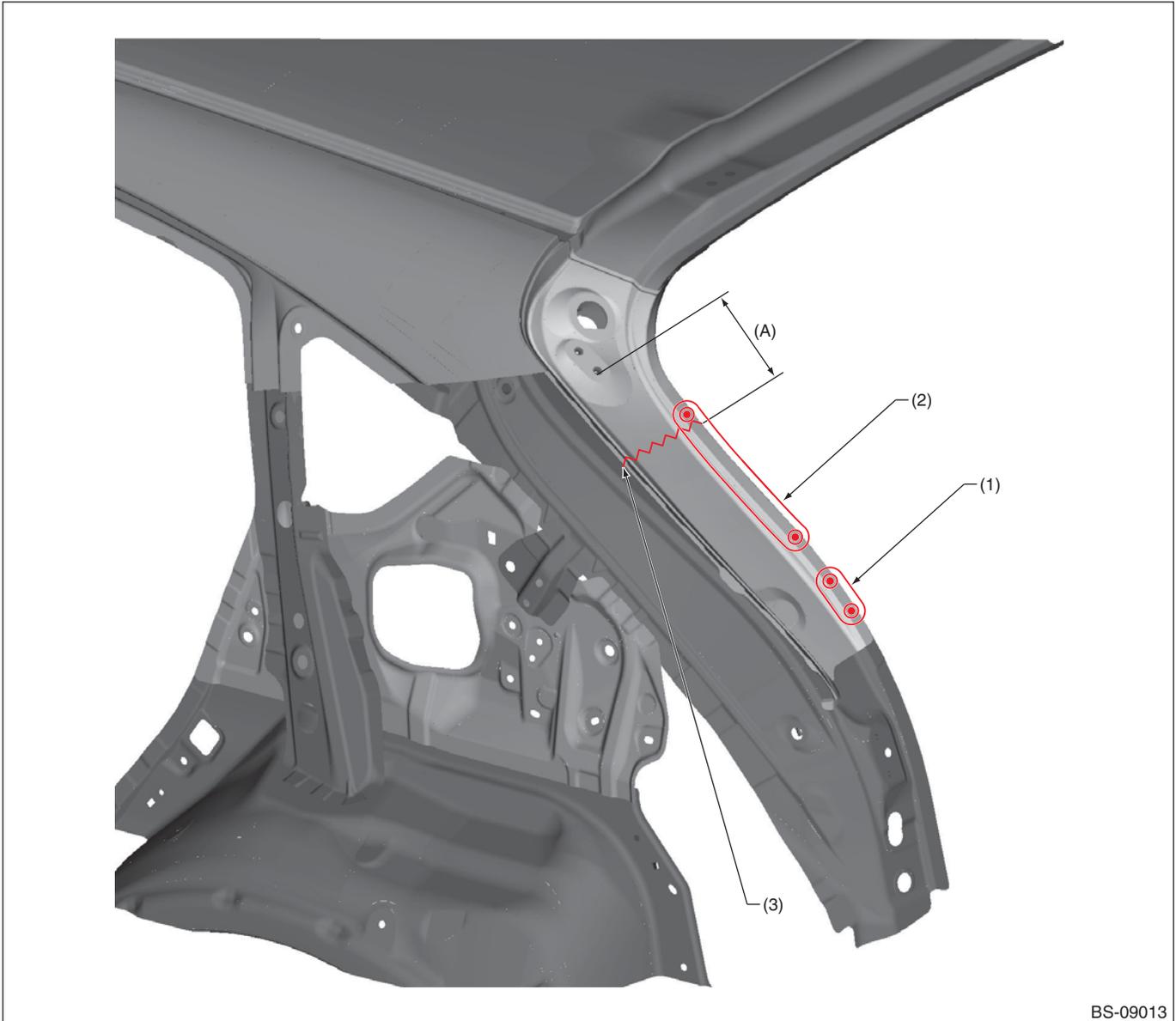
(5) 4 points (service)

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-09013

(A) 90 mm [3.54 in]

(1) 2 points (outside · 1)

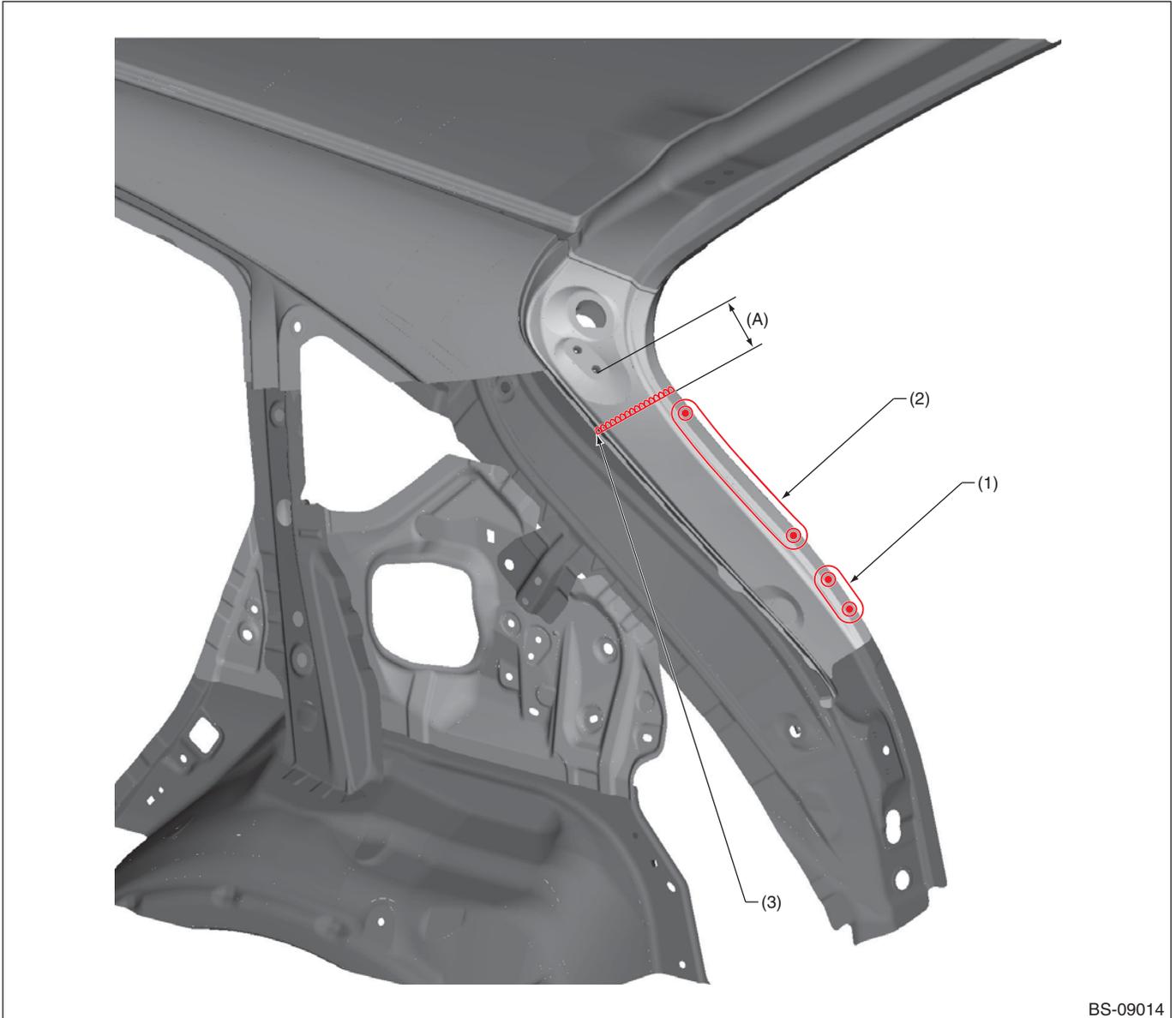
(2) LH: 5 points (outside · 1)  
RH: 4 points (outside · 1)

(3) Cut position

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09014

(A) 70 mm [2.76 in]

(1) 2 points

(2) LH: 5 points  
RH: 4 points

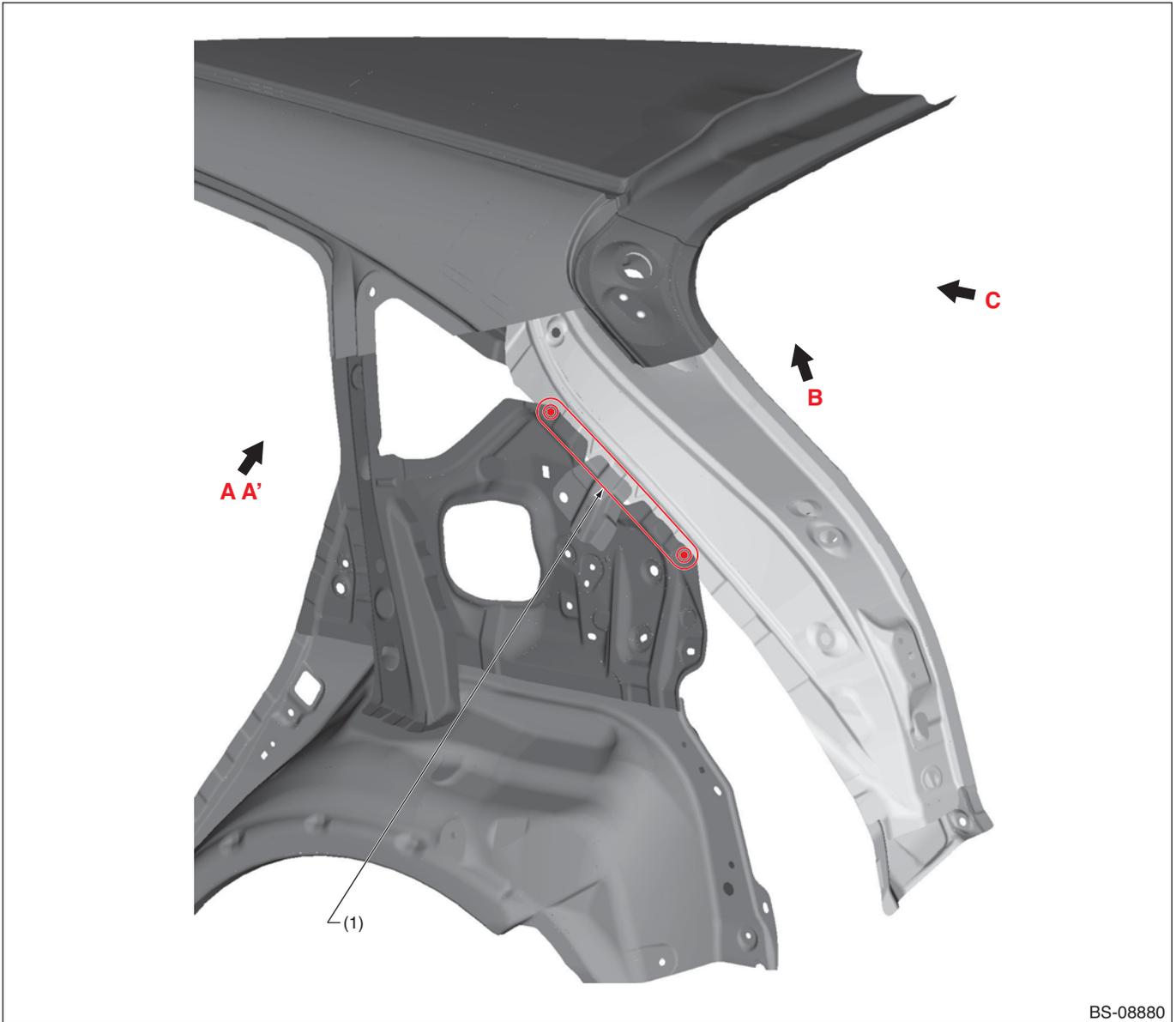
(3) 1 point (Continuous welding)

# Panel Replacement

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

### A: REMOVAL

- Overall view

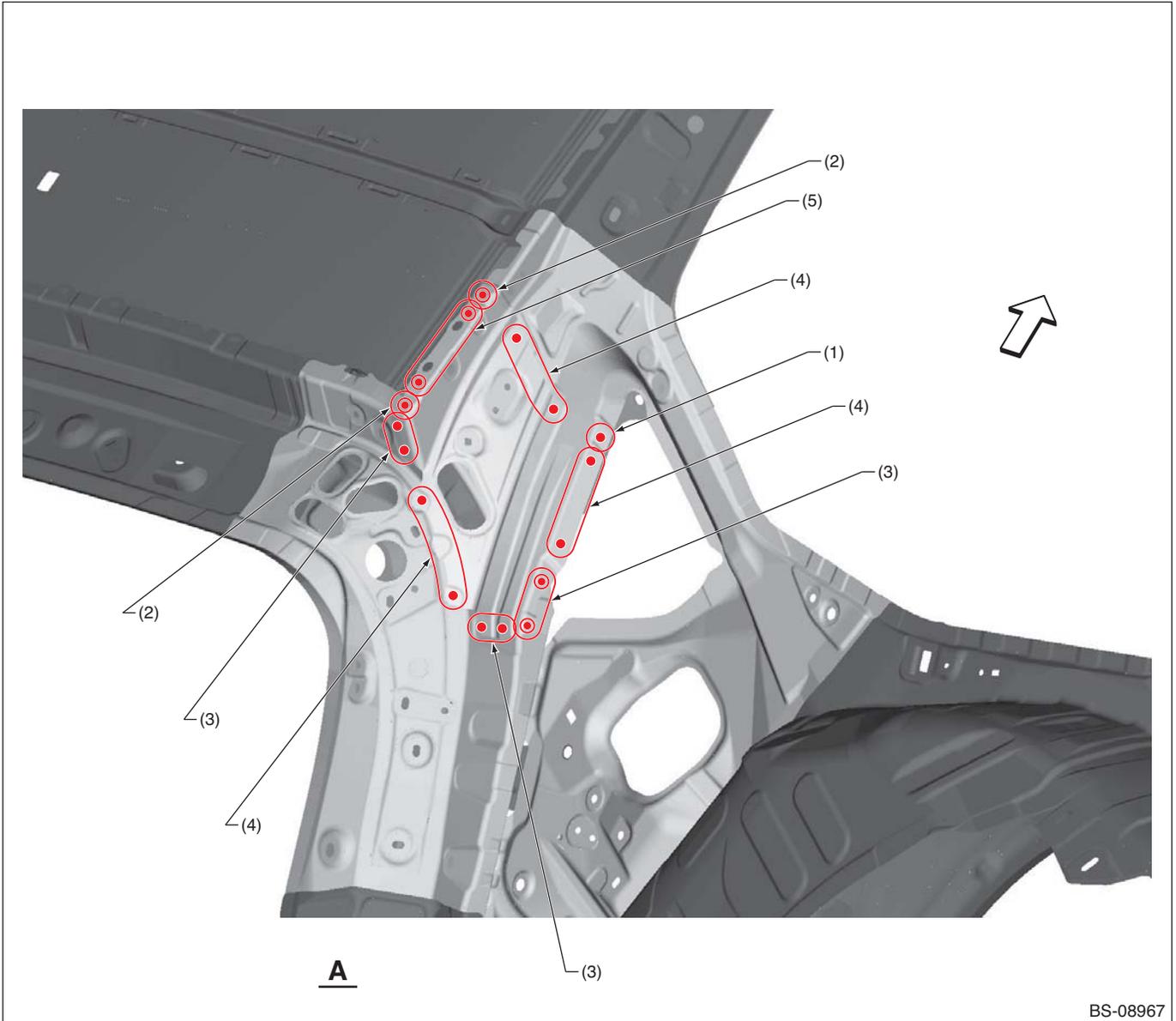


BS-08880

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

# Panel Replacement

## • Views A



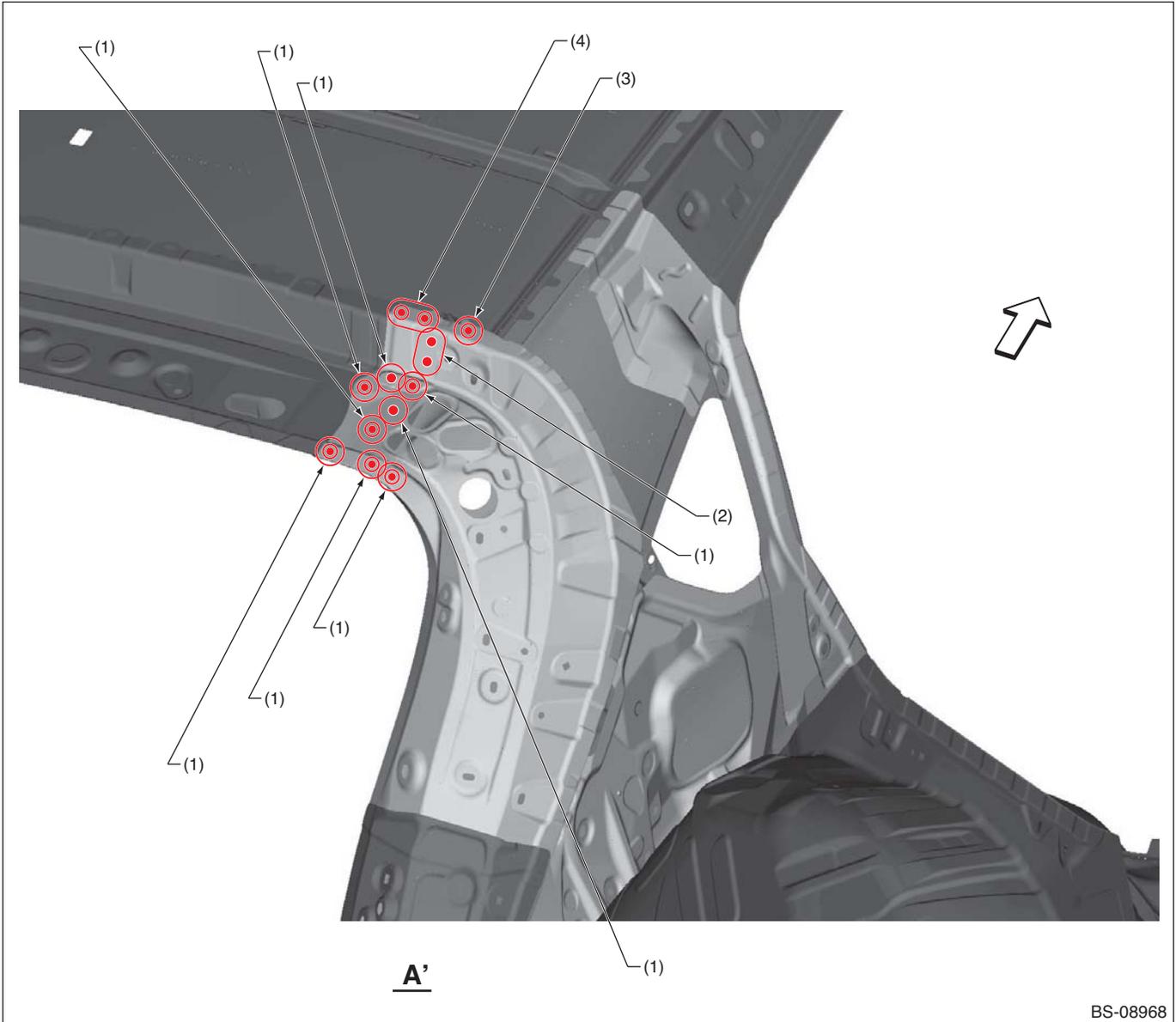
(1) 1 point (inside · 1)  
(2) 1 point (bottom · 1)

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

(5) 3 points (bottom · 1)

# Panel Replacement

## • Views A'



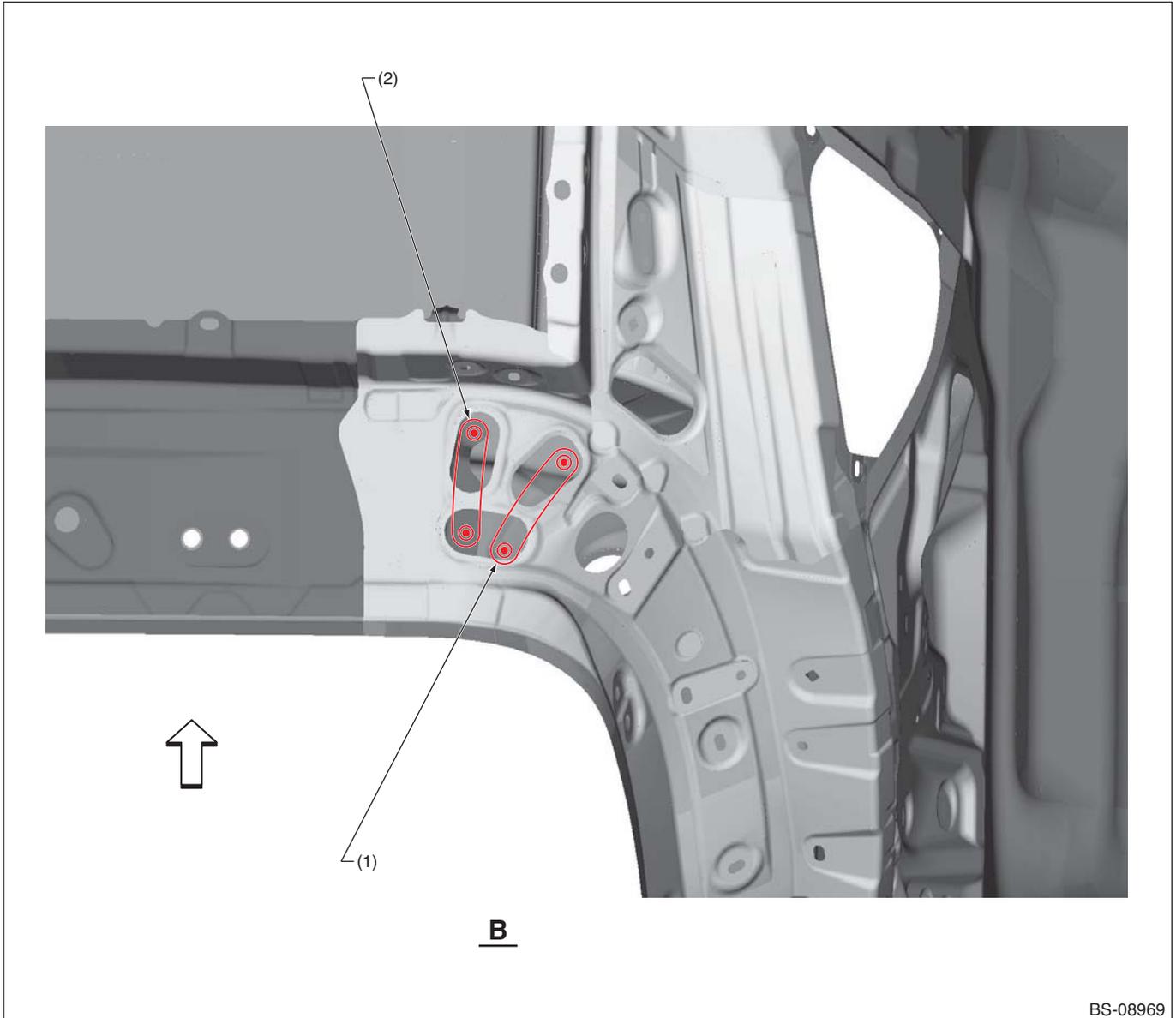
(1) 1 point (bottom · 1)  
(2) 2 points (inside · 1)

(3) 1 point (bottom · 2)

(4) 2 points (bottom · 1)

# Panel Replacement

## • Views B

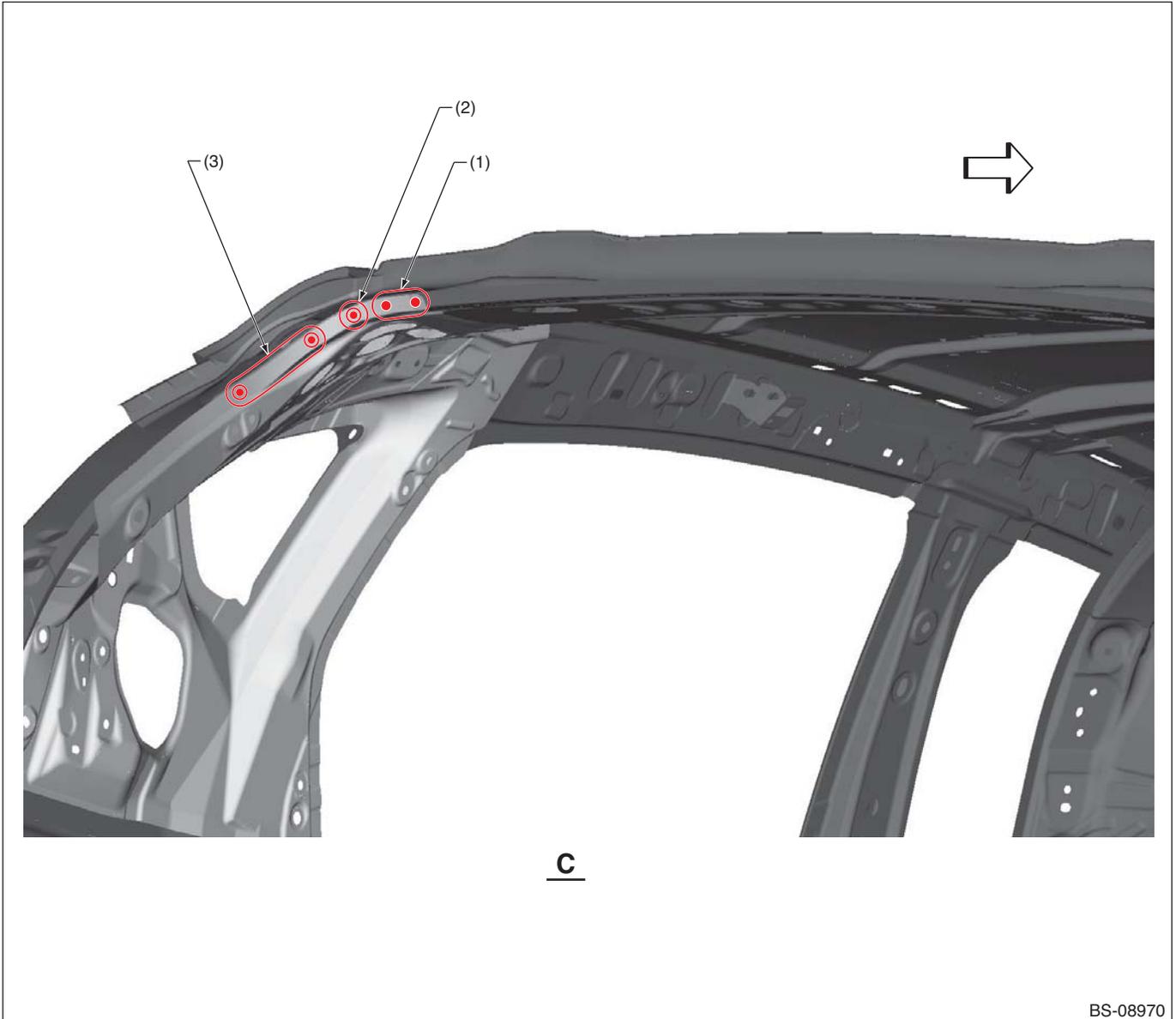


(1) 3 points (bottom · 1)

(2) 3 points (bottom · 2)

# Panel Replacement

## • Views C



BS-08970

(1) 3 points (outside · 1)

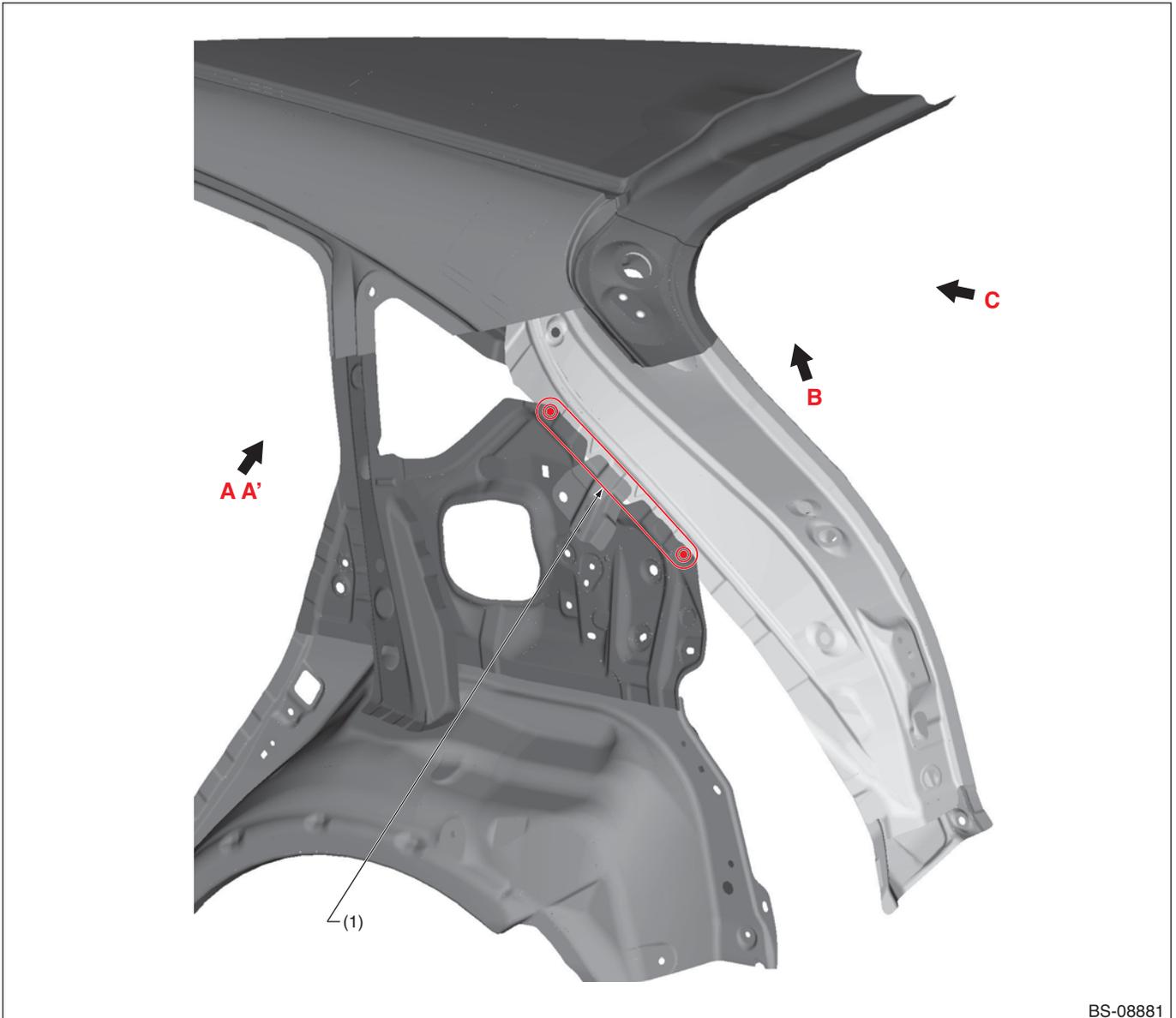
(2) 1 point (outside · 1)

(3) 3 points (inside · 2)

# Panel Replacement

## B: INSTALLATION

### • Overall view

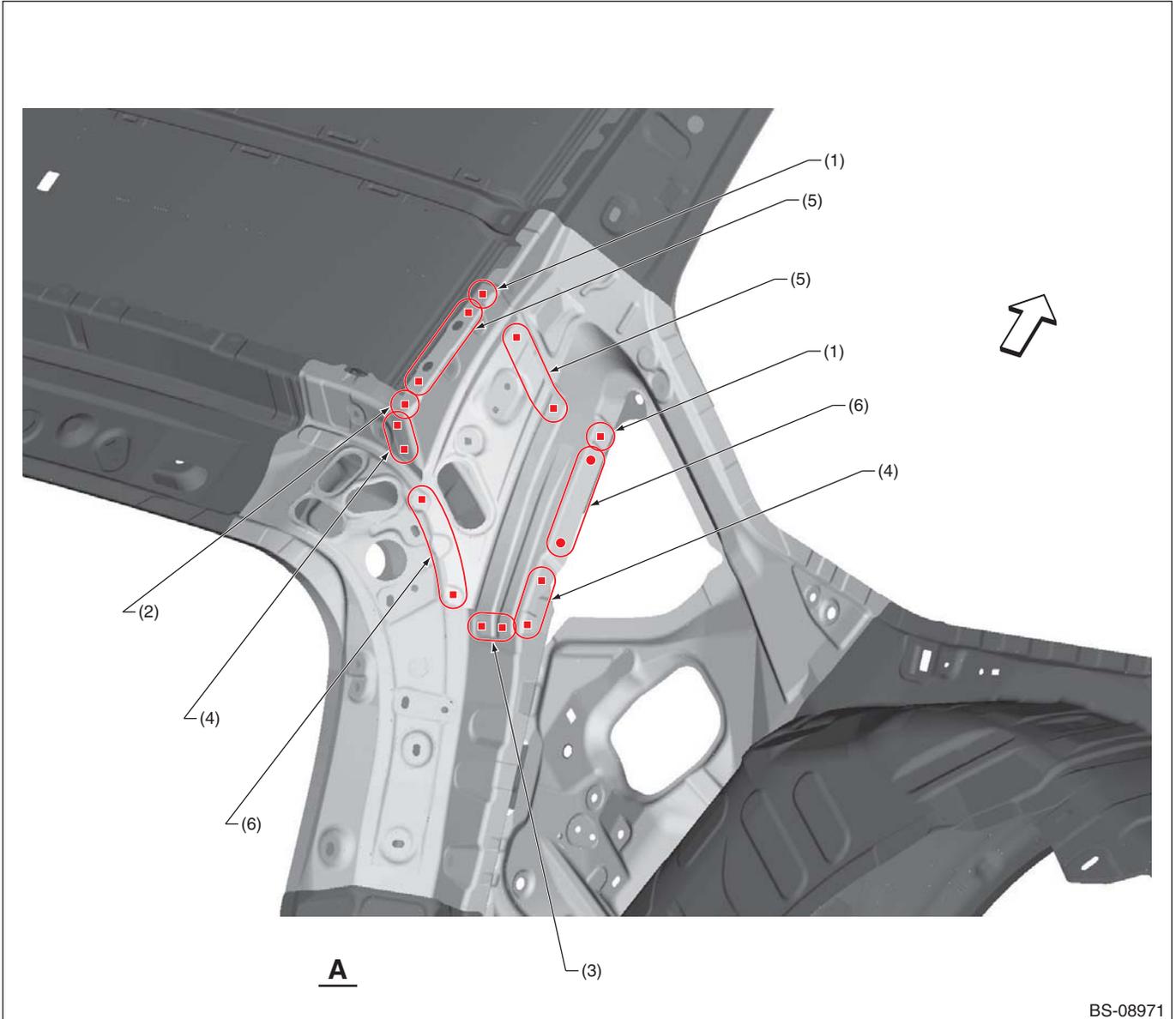


BS-08881

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

# Panel Replacement

## • Views A



BS-08971

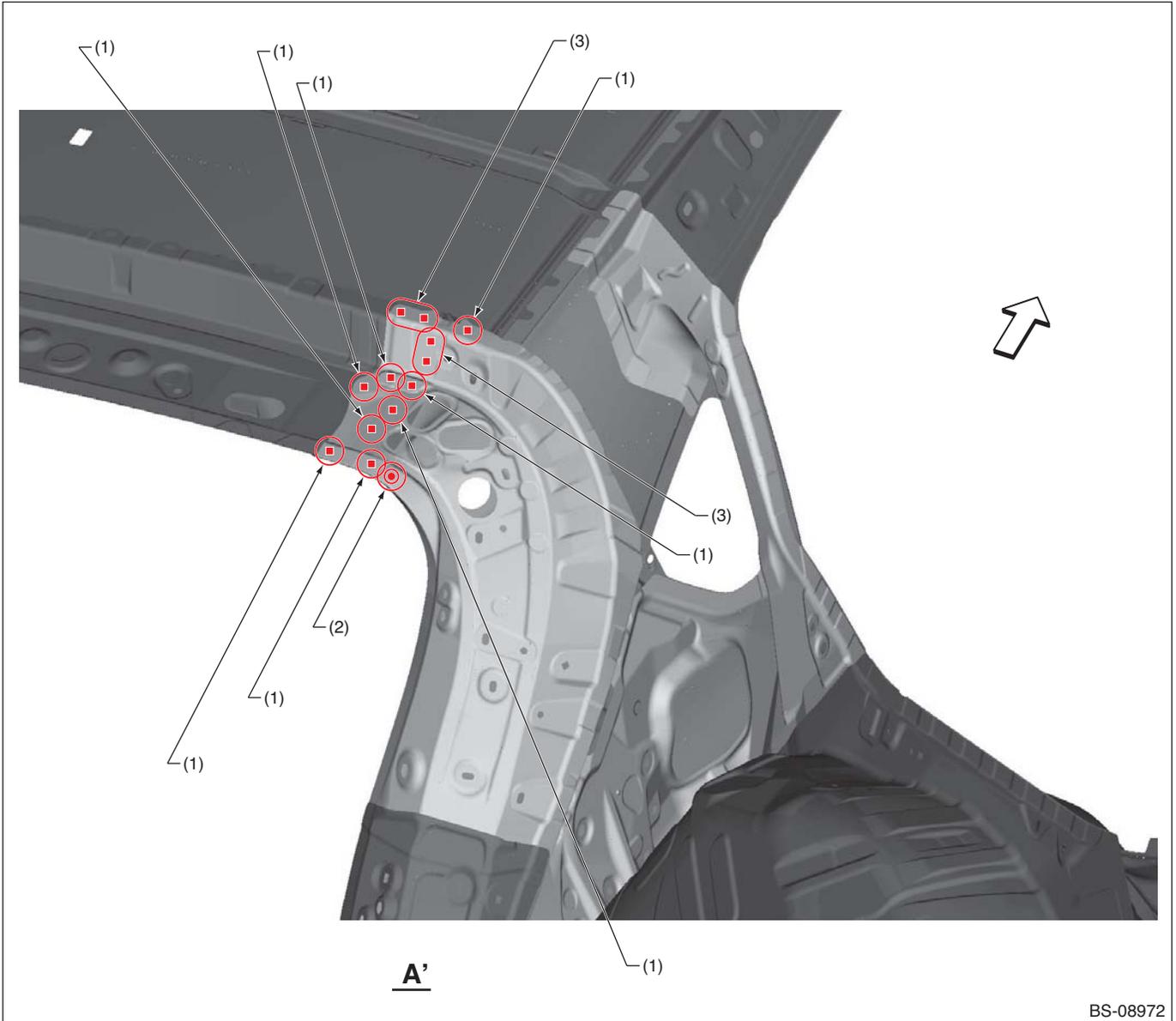
(1) 1 point (service)  
(2) 1 point

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

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

# Panel Replacement

## • Views A'



BS-08972

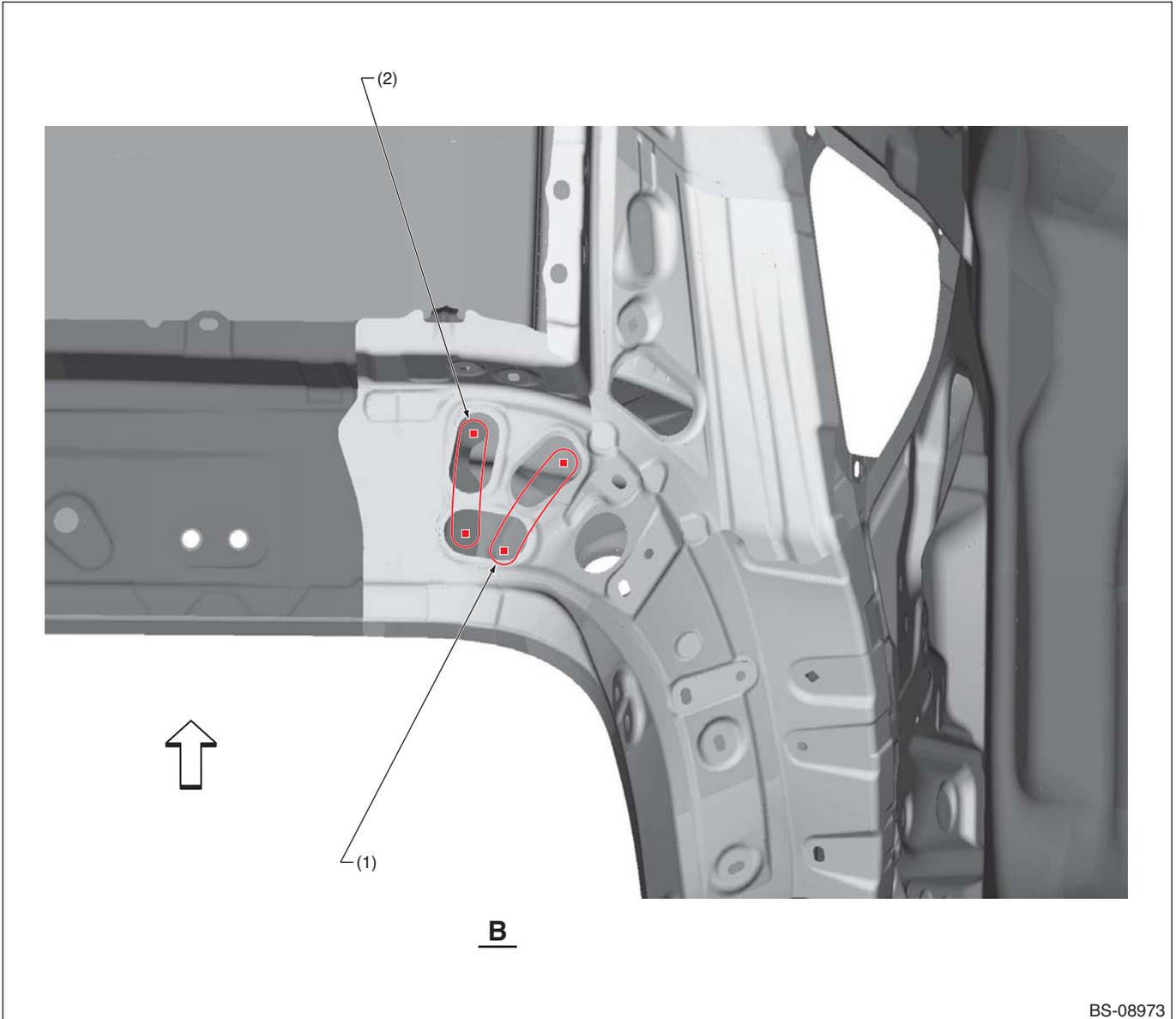
(1) 1 point (service)

(2) 1 point

(3) 2 points (service)

# Panel Replacement

## • Views B

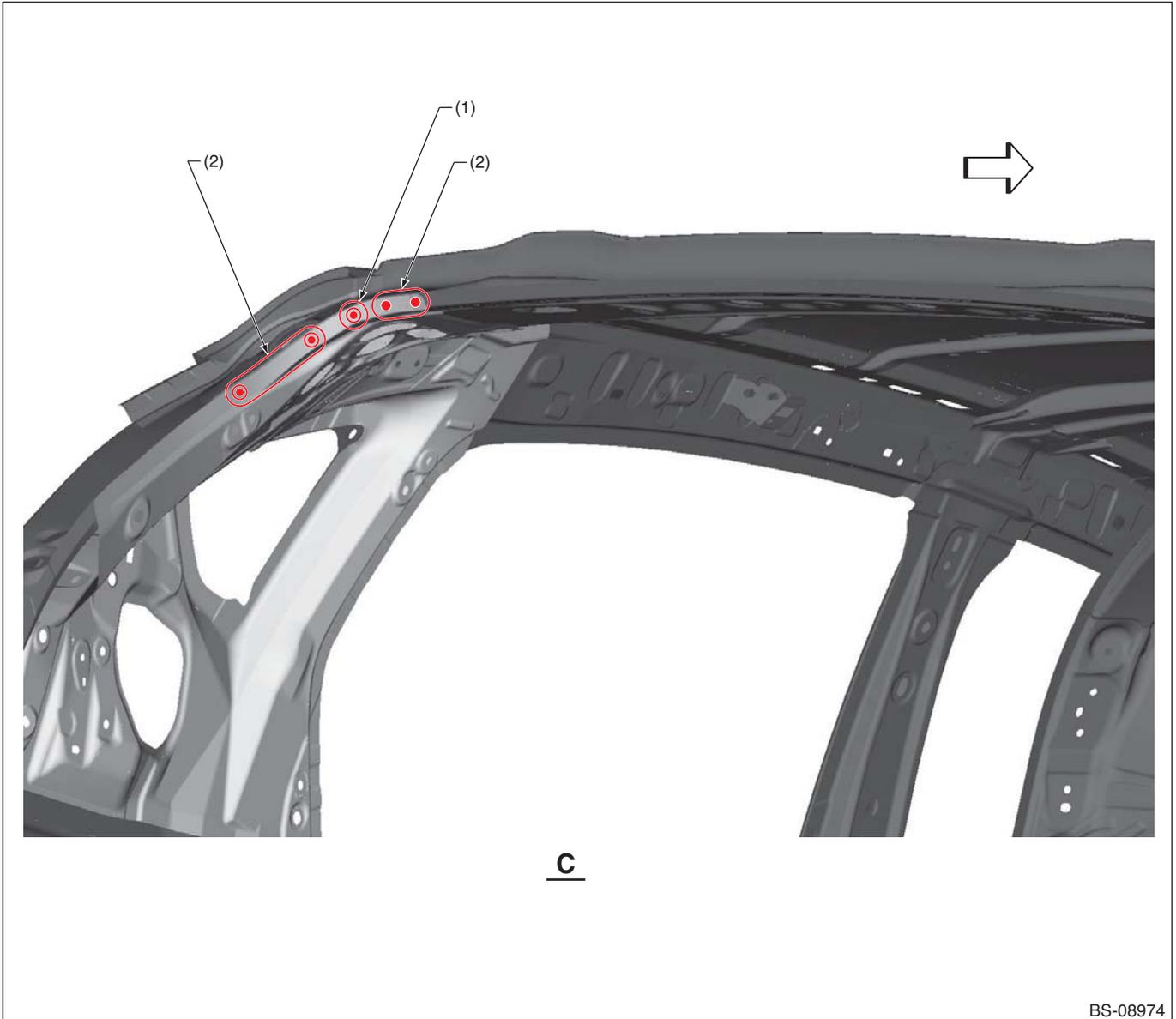


(1) 3 points (service)

(2) 3 points (service · matching)

# Panel Replacement

## • Views C



BS-08974

(1) 1 point

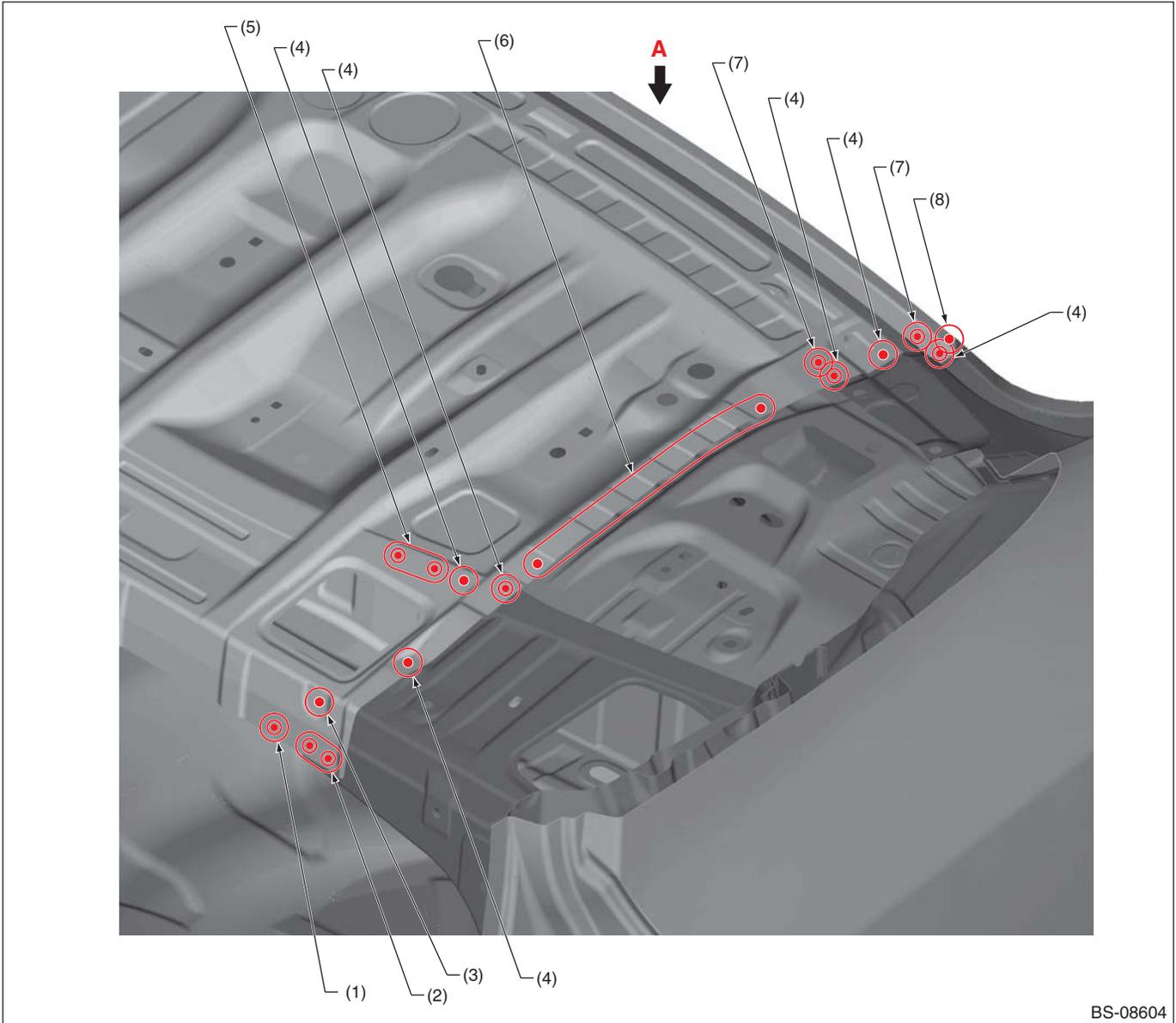
(2) 3 points

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-08604

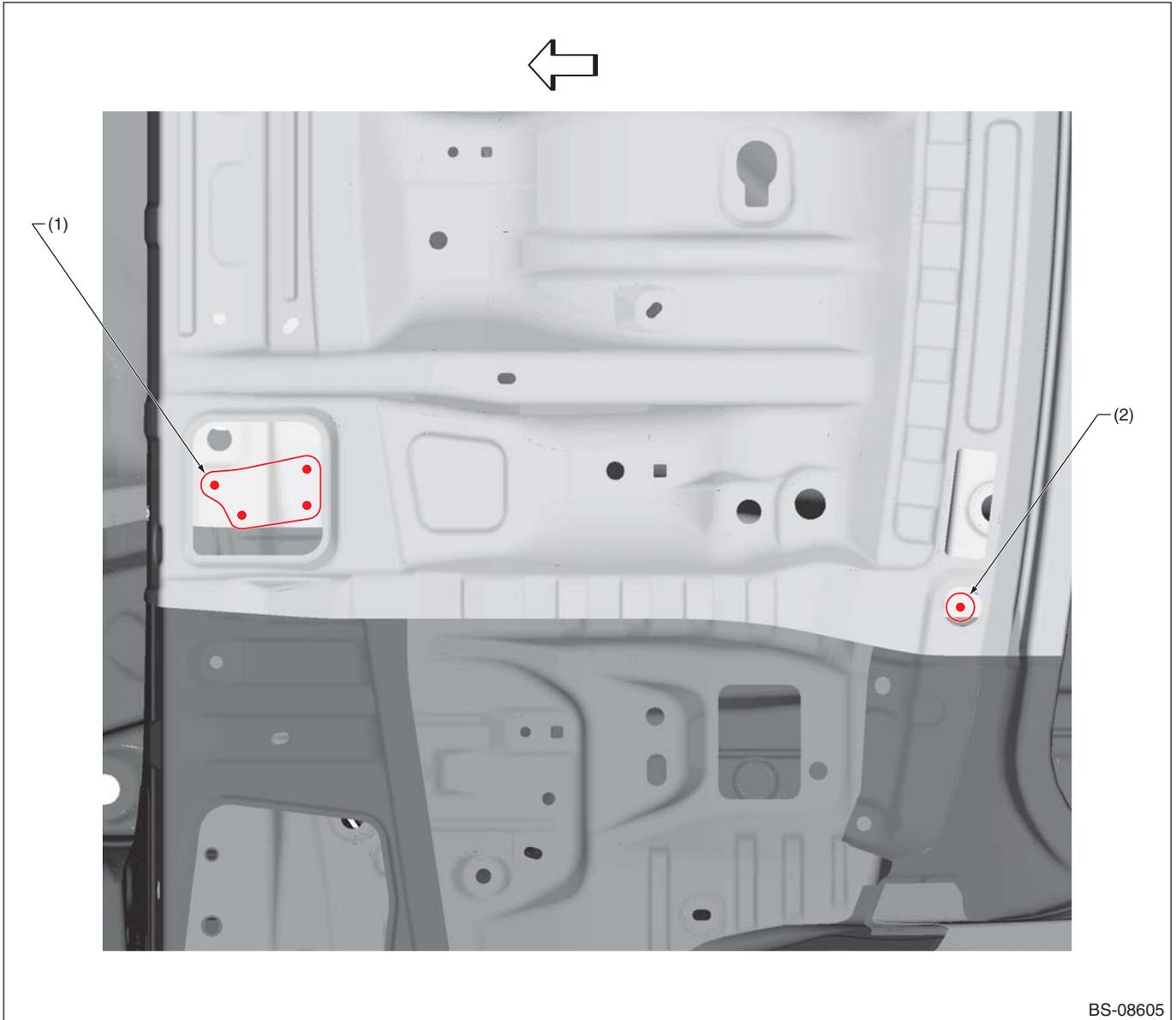
- (1) 1 point (inside · 2)
- (2) 2 points (inside · 1)
- (3) 1 point (inside · 1)

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

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

# Panel Replacement

## • Views A



BS-08605

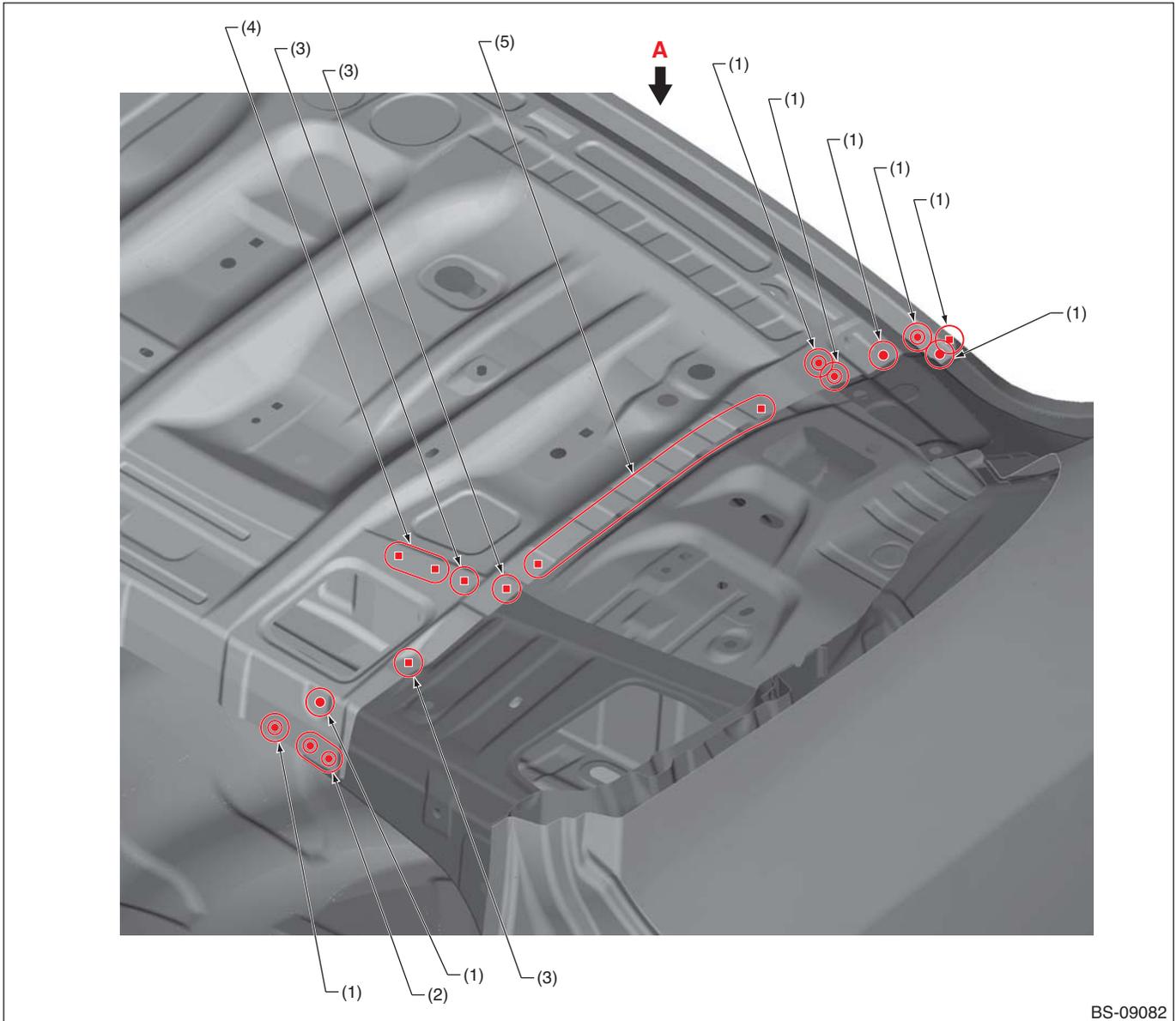
(1) 5 points (top · 1)

(2) 1 point (top · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09082

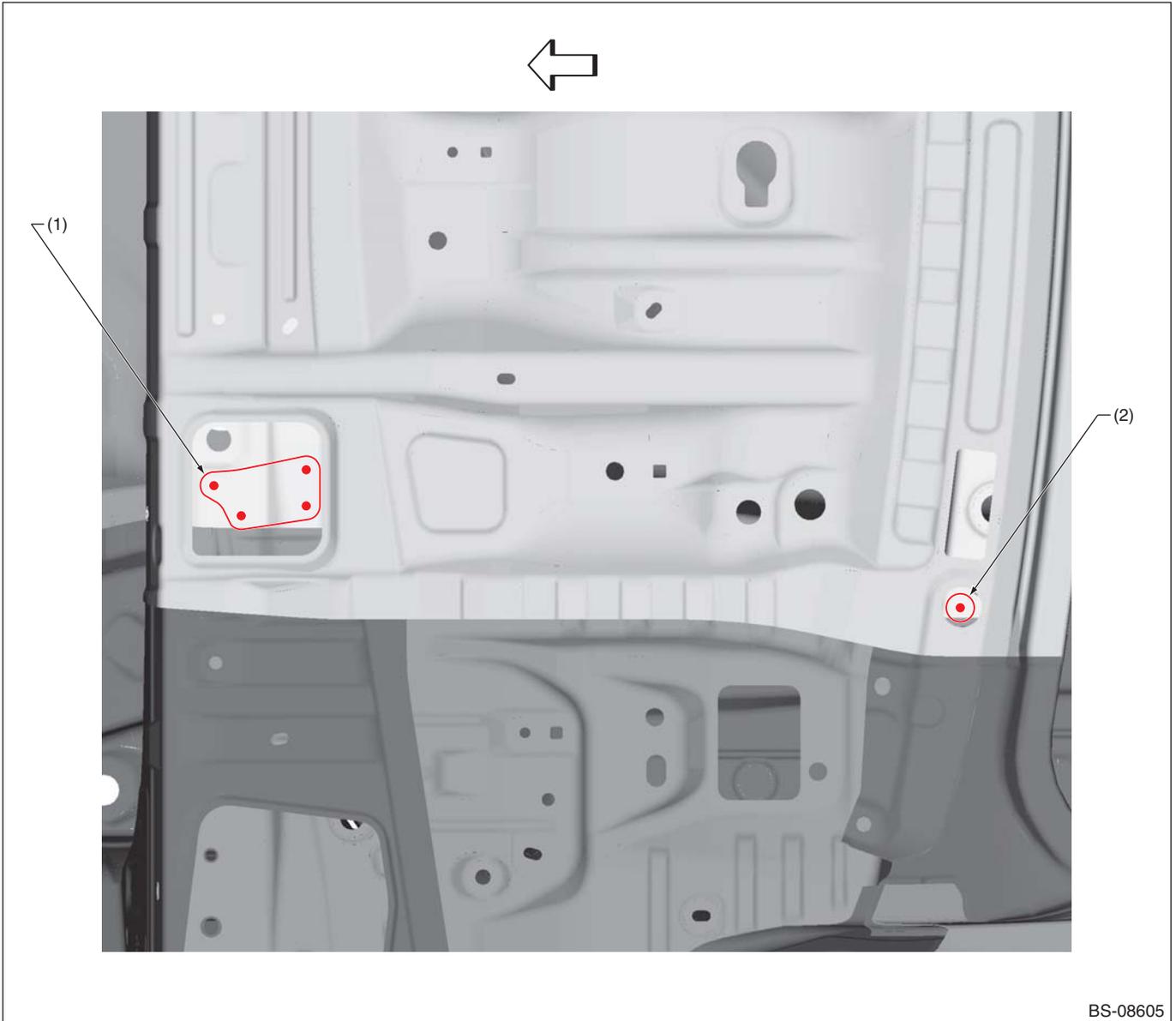
- (1) 1 point
- (2) 2 points

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

- (5) 6 points (service)

# Panel Replacement

## • Views A



(1) 5 points

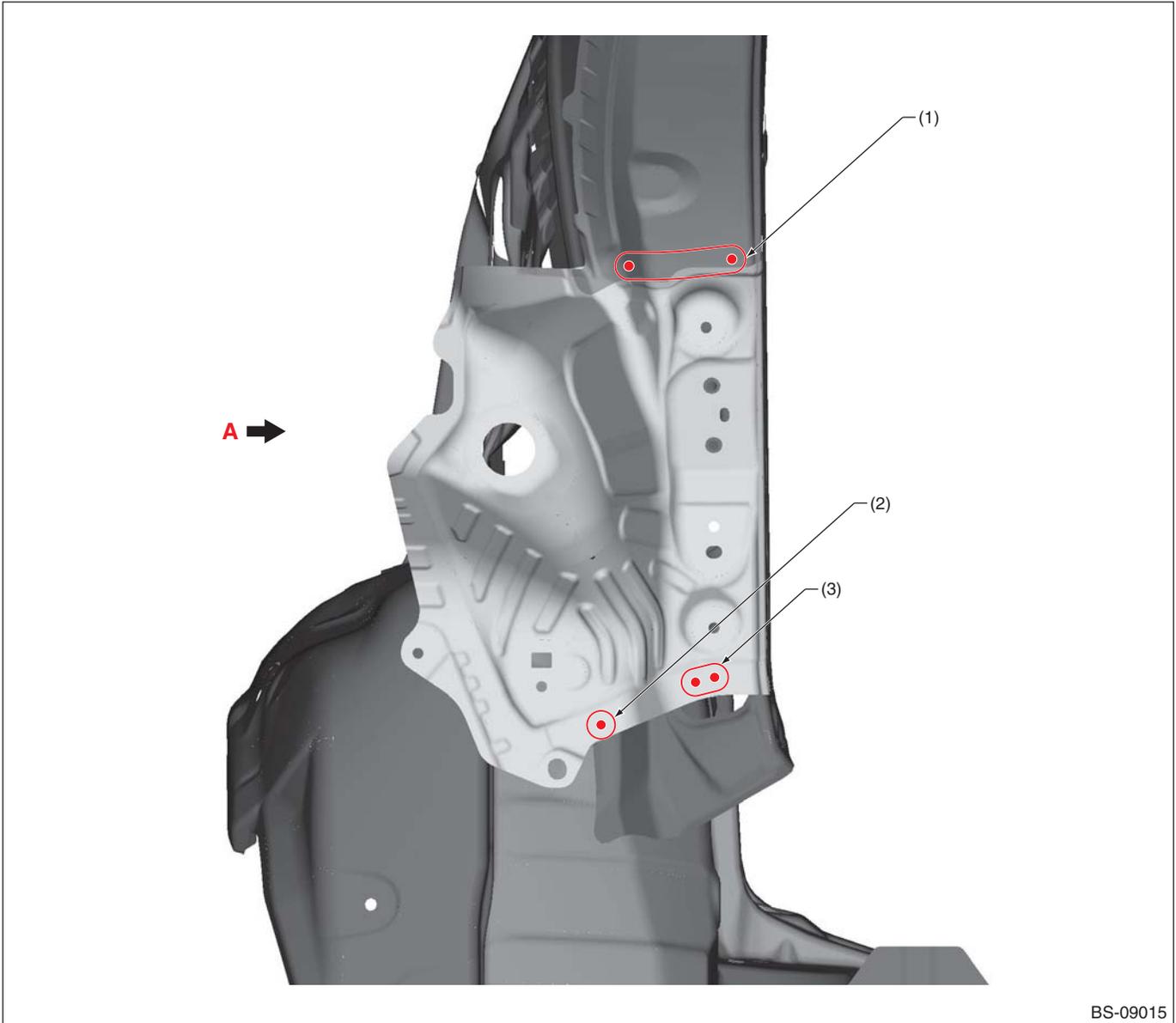
(2) 1 point

# Panel Replacement

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

### A: REMOVAL

- Overall view



BS-09015

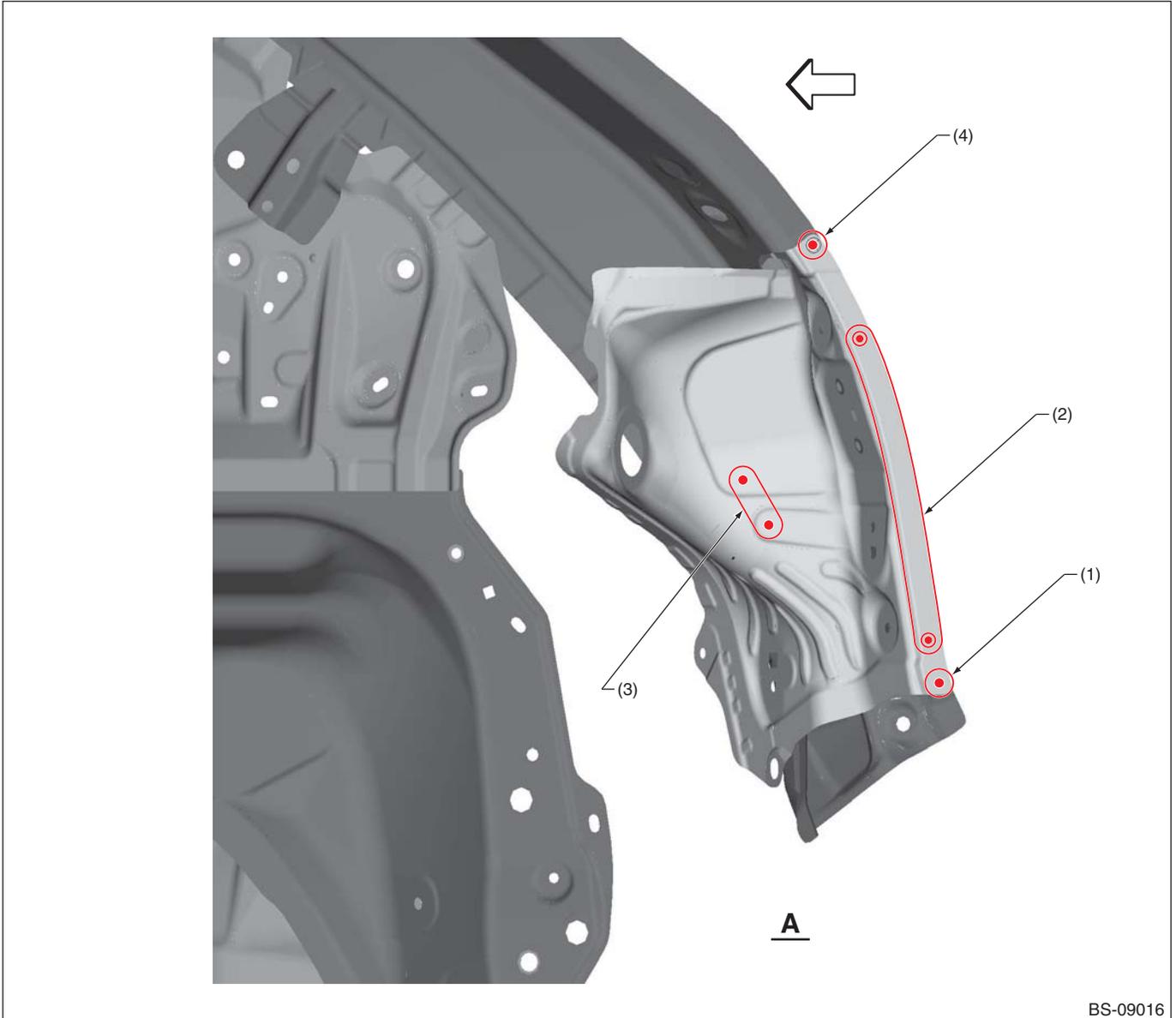
(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

(3) 2 points (outside · 1)

# Panel Replacement

## • Views A



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

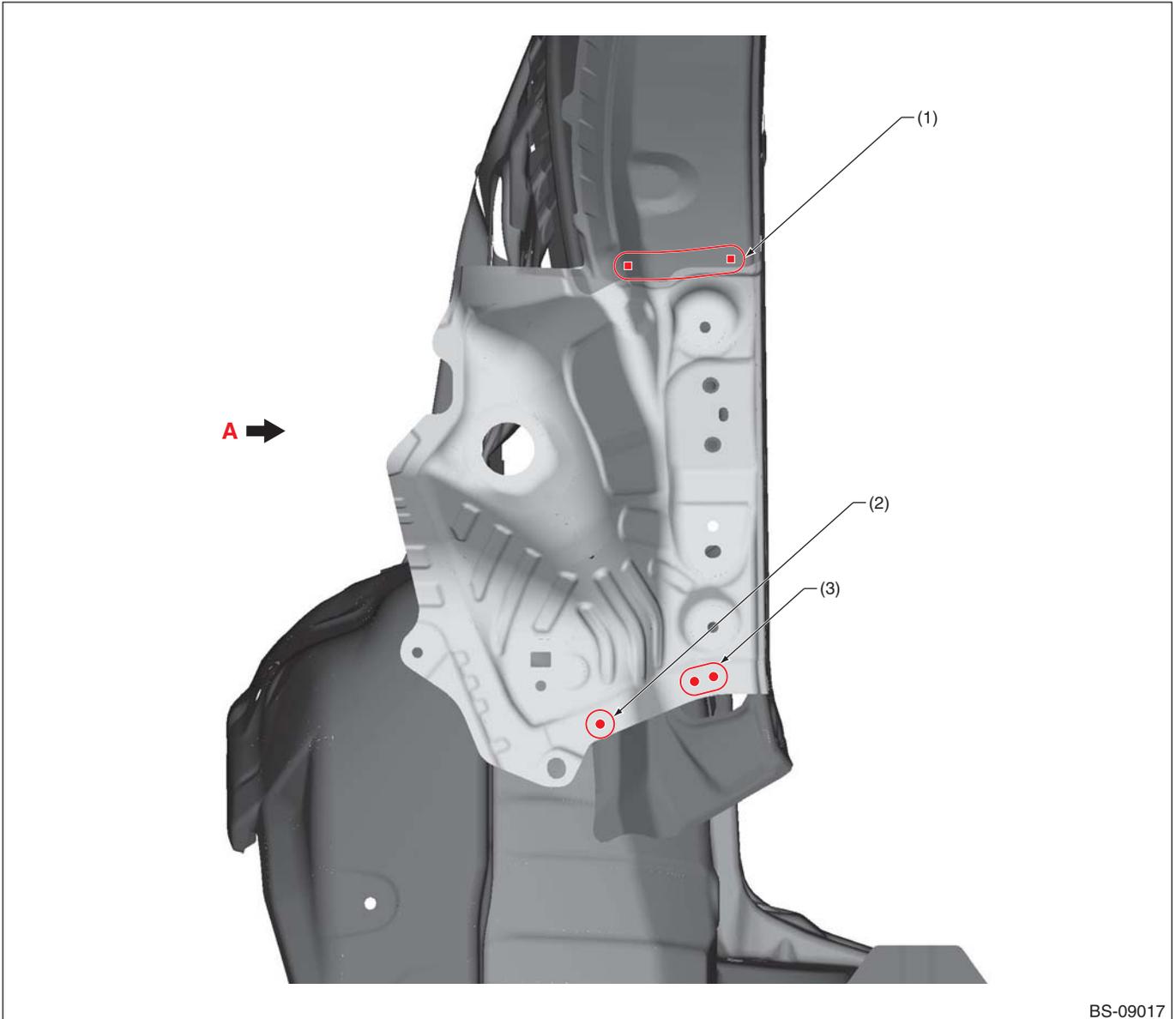
(3) 2 points (outside · 1)

(4) 1 point (outside · 1 belt sander)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09017

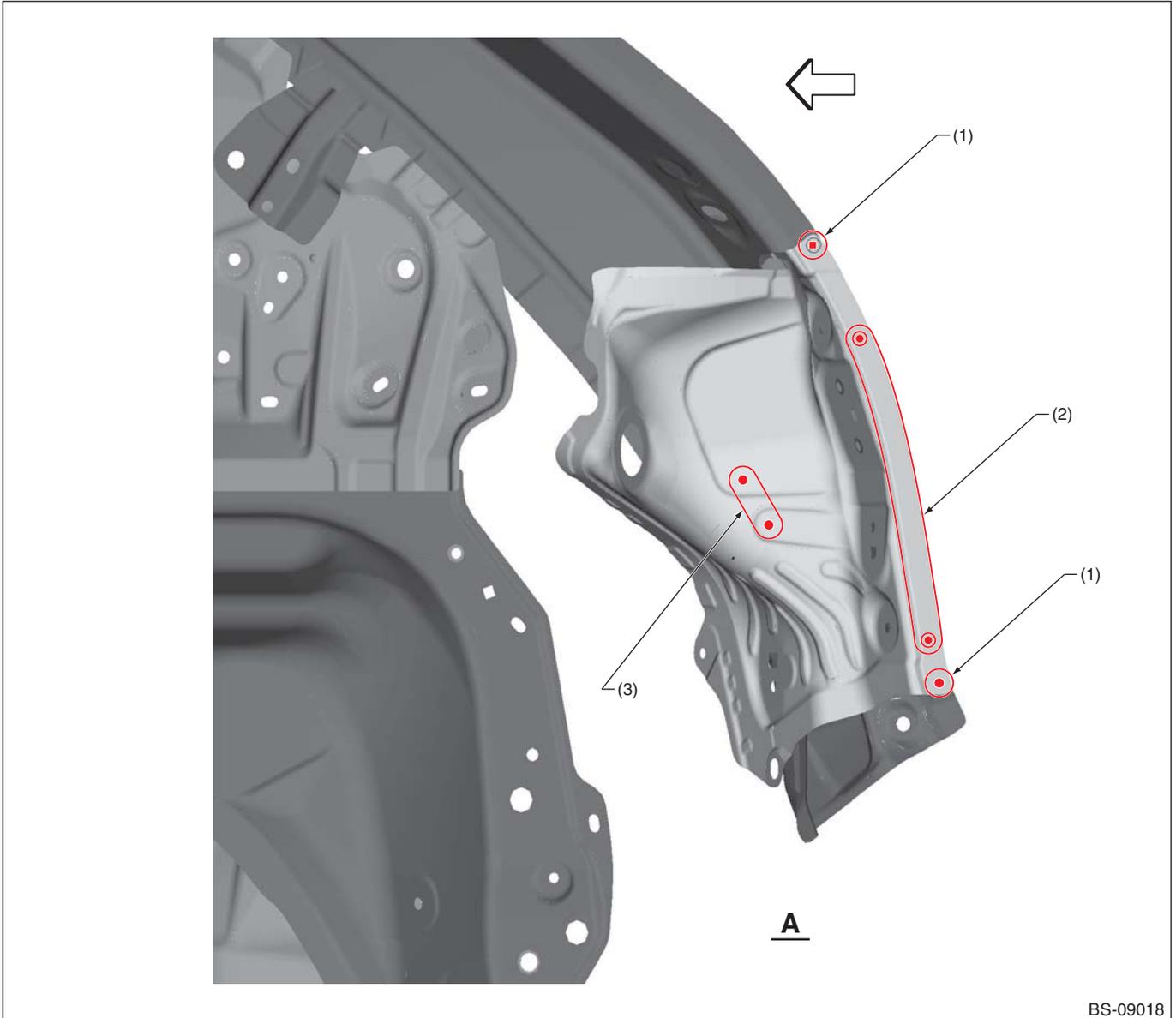
(1) 3 points

(2) 1 point

(3) 2 points

# Panel Replacement

## • Views A



BS-09018

(1) 1 point

(2) 5 points

(3) 2 points

# Panel Replacement

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

### A: REMOVAL

- Overall view



BS-08602

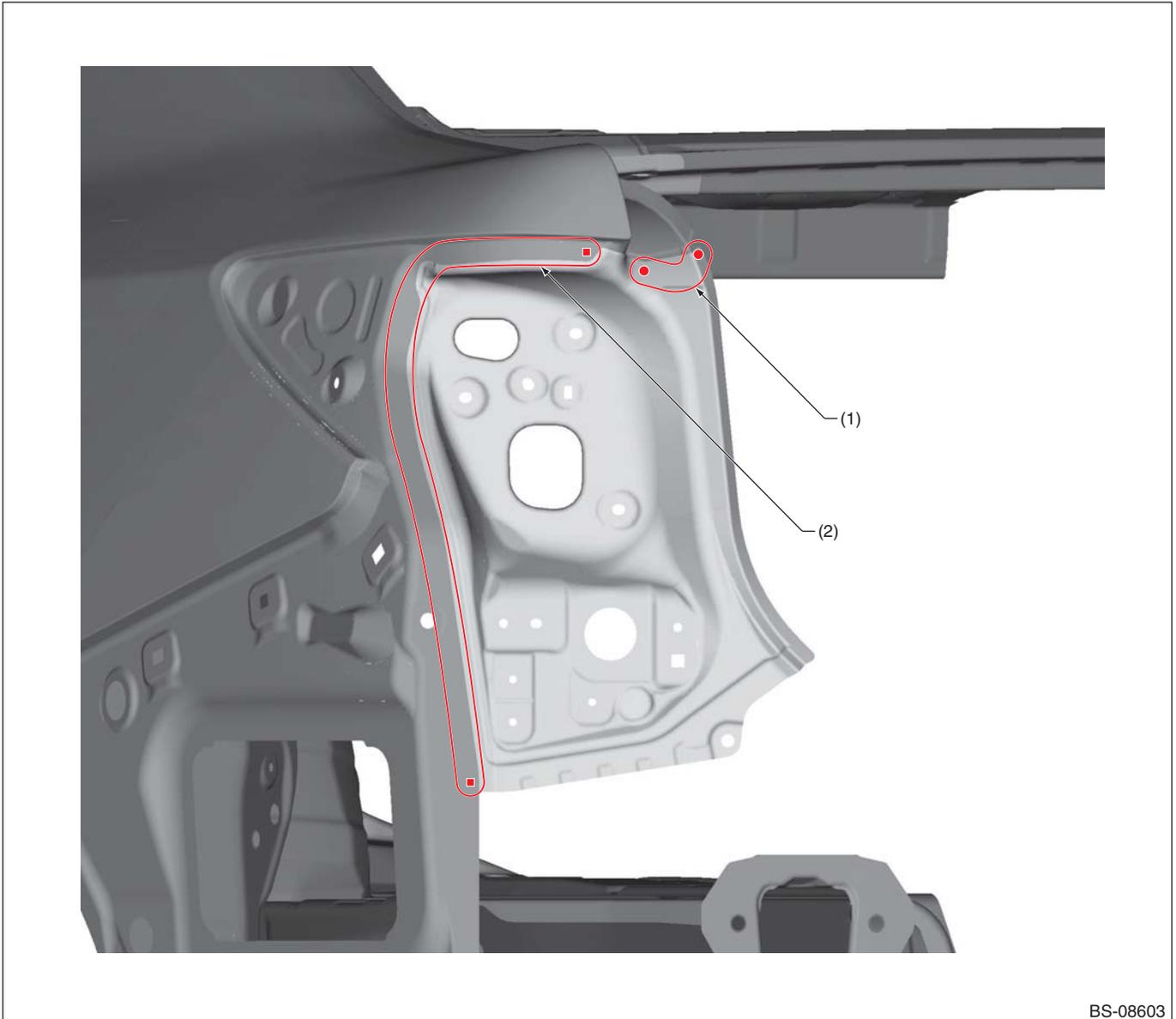
(1) 3 points (outside · 1)

(2) 12 points (outside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-08603

(1) 3 points

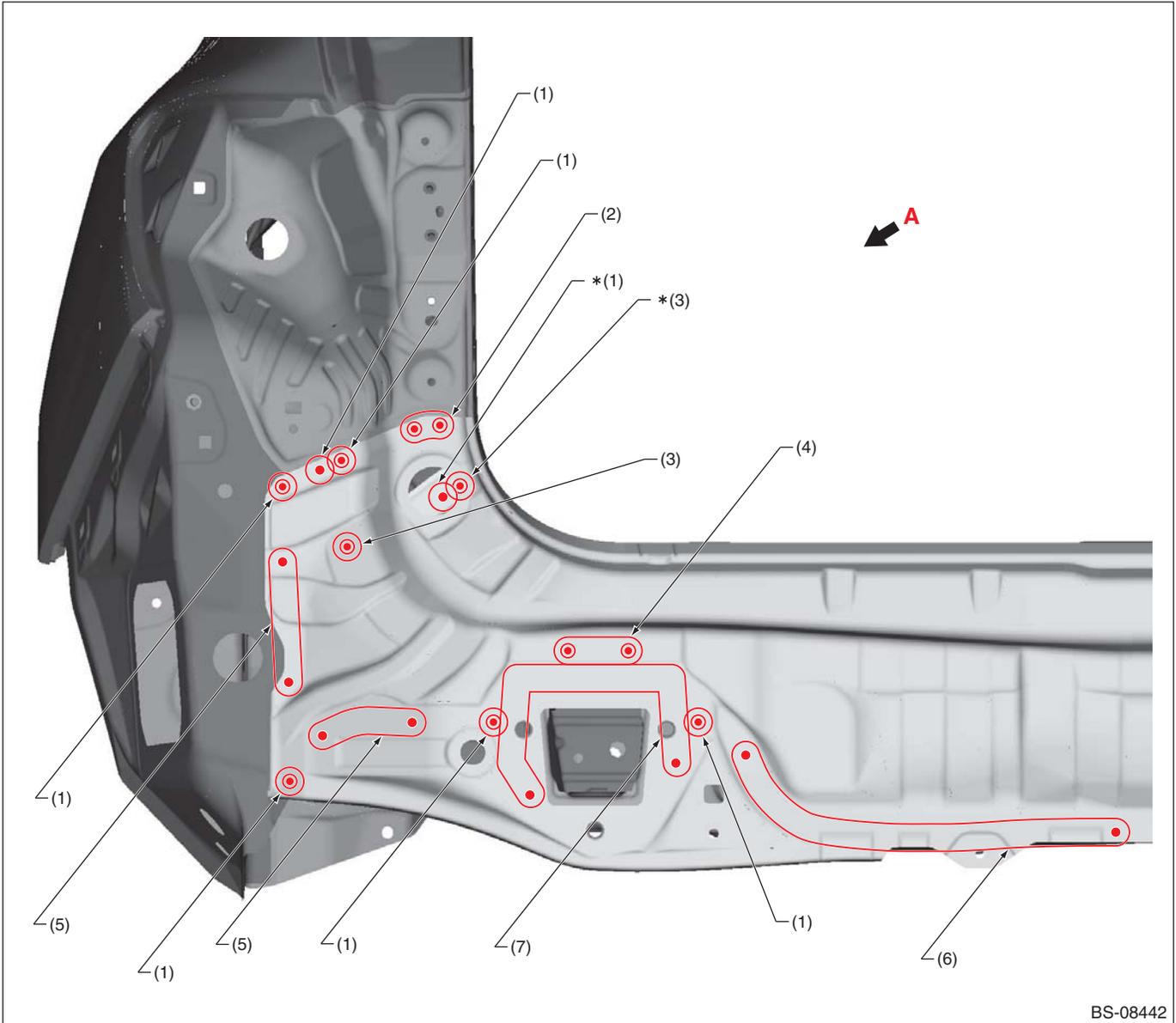
(2) 12 points

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-08442

(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

(3) 1 point (outside · 2)

(4) 2 points (outside · 2)

(5) 3 points (outside · 1)

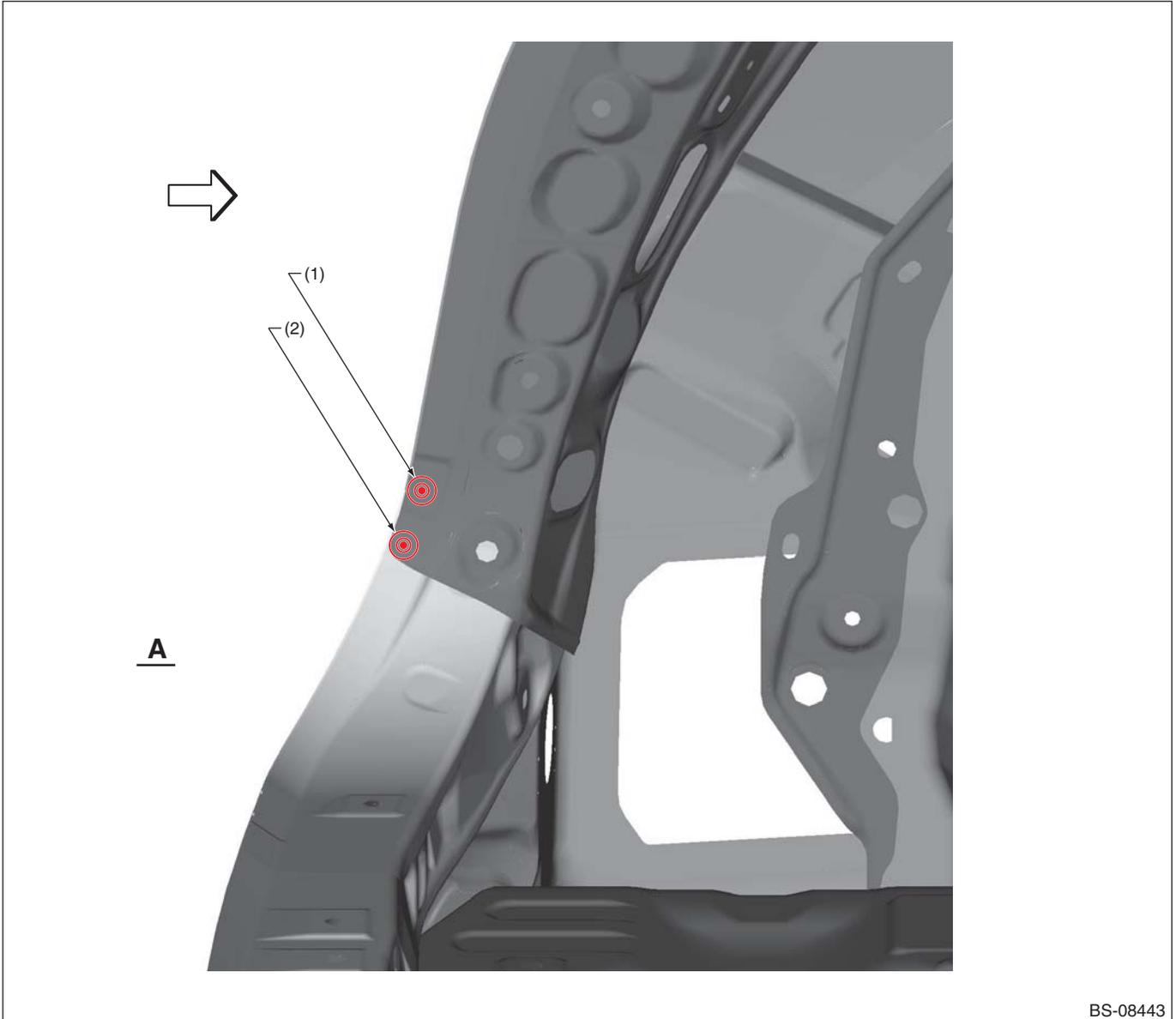
(6) 7 points (outside · 1)

(7) 5 points (outside · 1)

\* : Spots are provided in the back.

# Panel Replacement

## • Views A



BS-08443

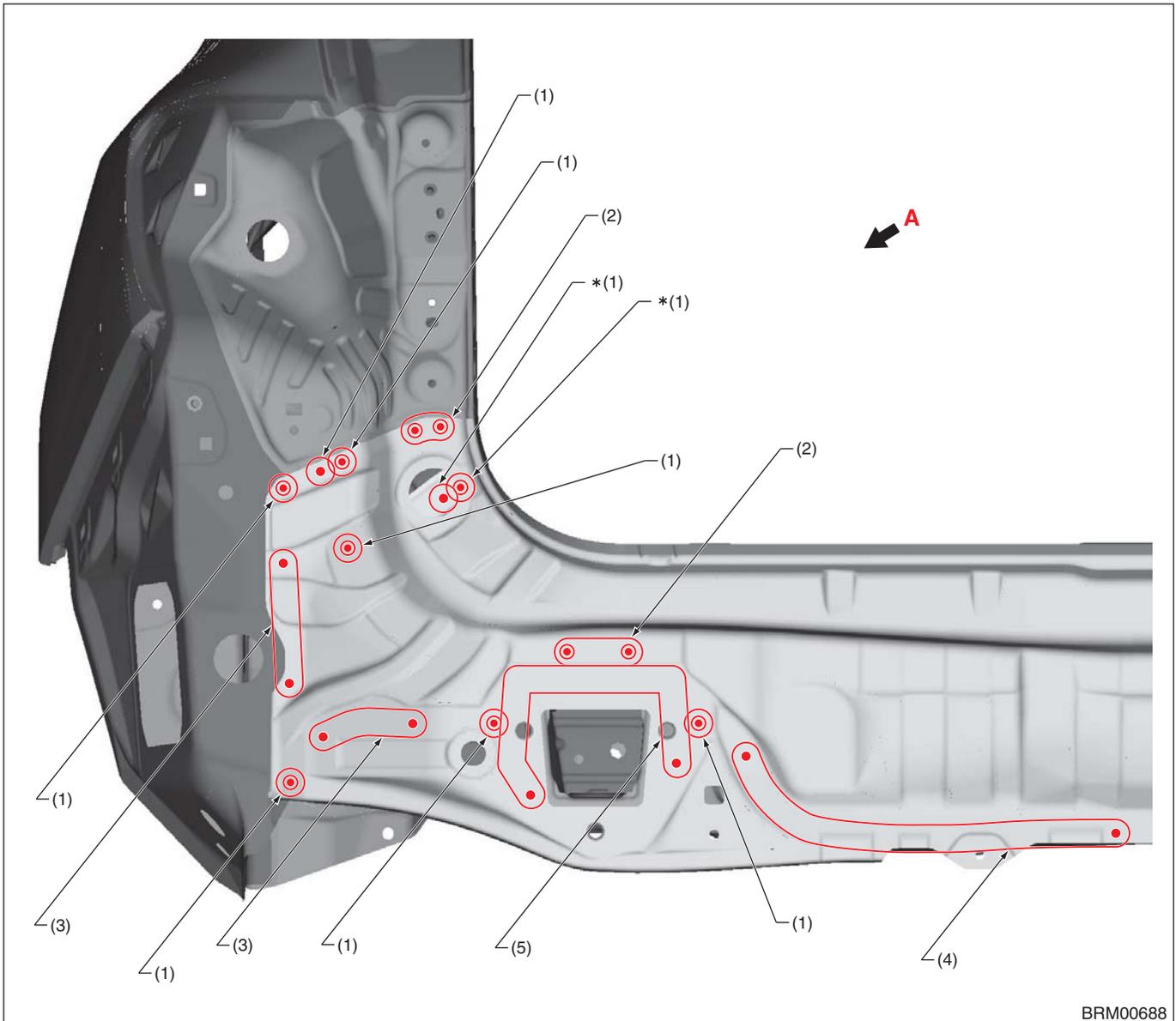
(1) 1 point (outside · 1)

(2) 1 point (outside · 2)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BRM00688

(1) 1 point  
(2) 2 points

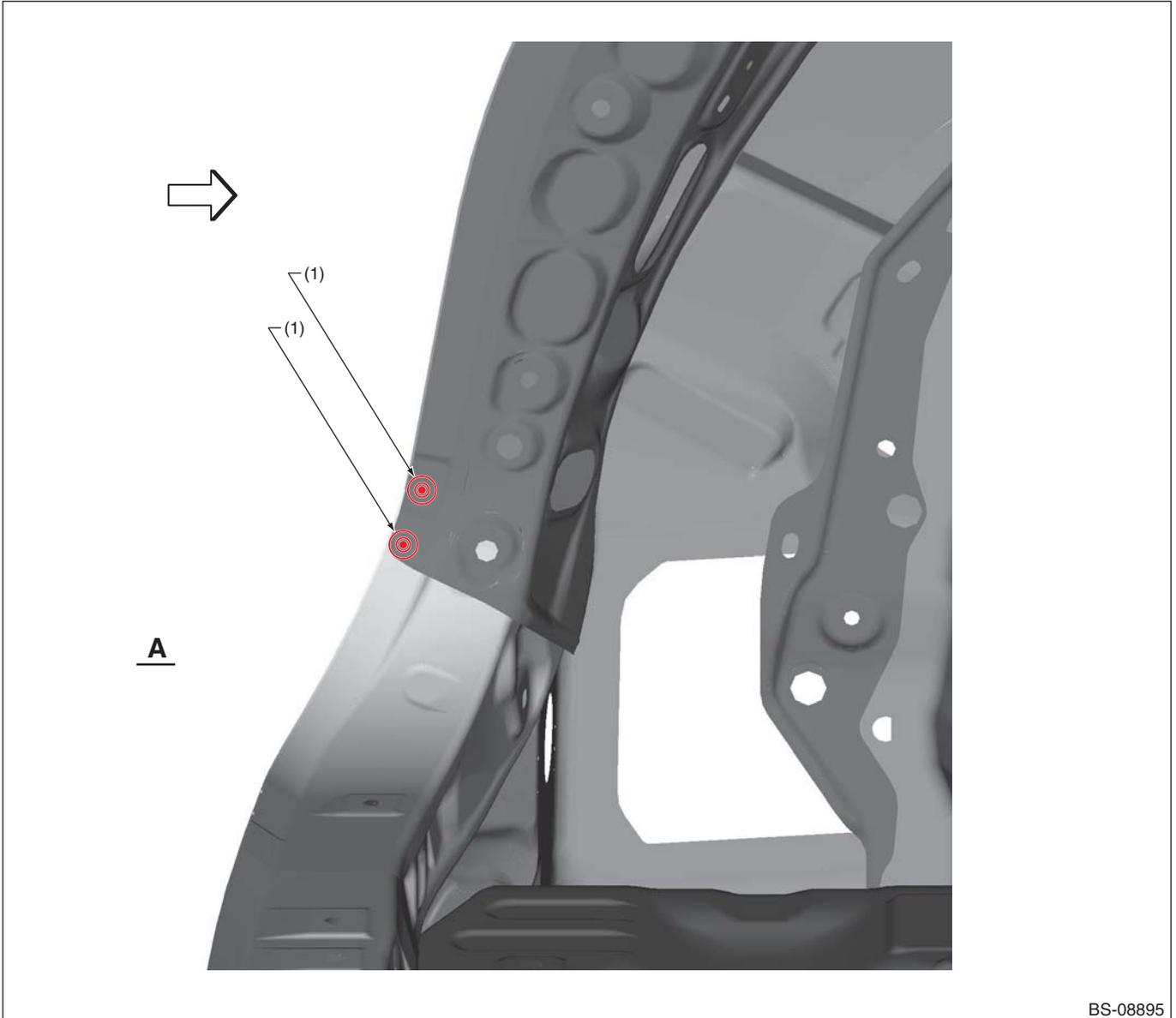
(3) 3 points  
(4) 7 points

(5) 5 points

\* : Spots are provided in the back.

# Panel Replacement

## • Views A



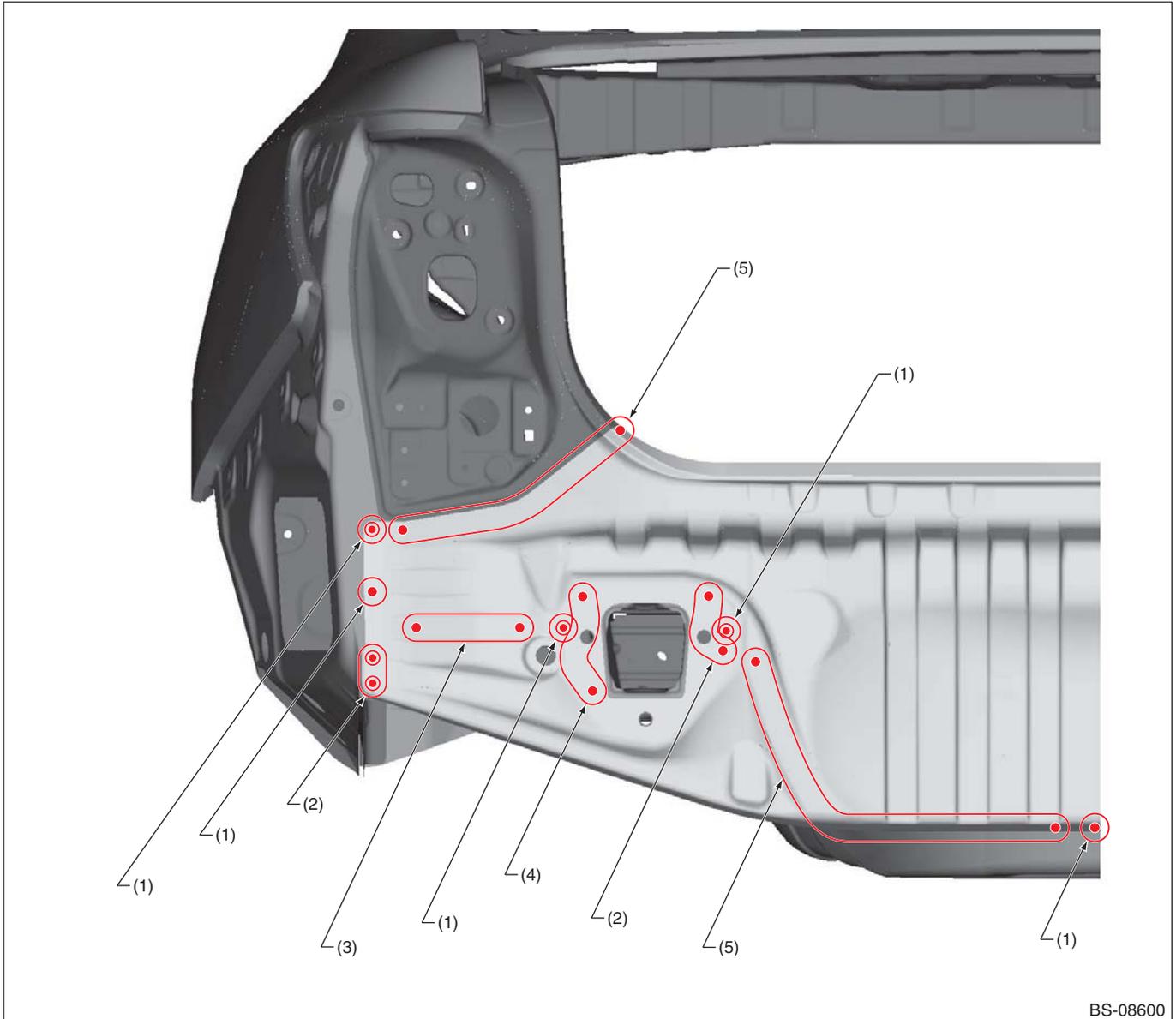
(1) 1 point

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-08600

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

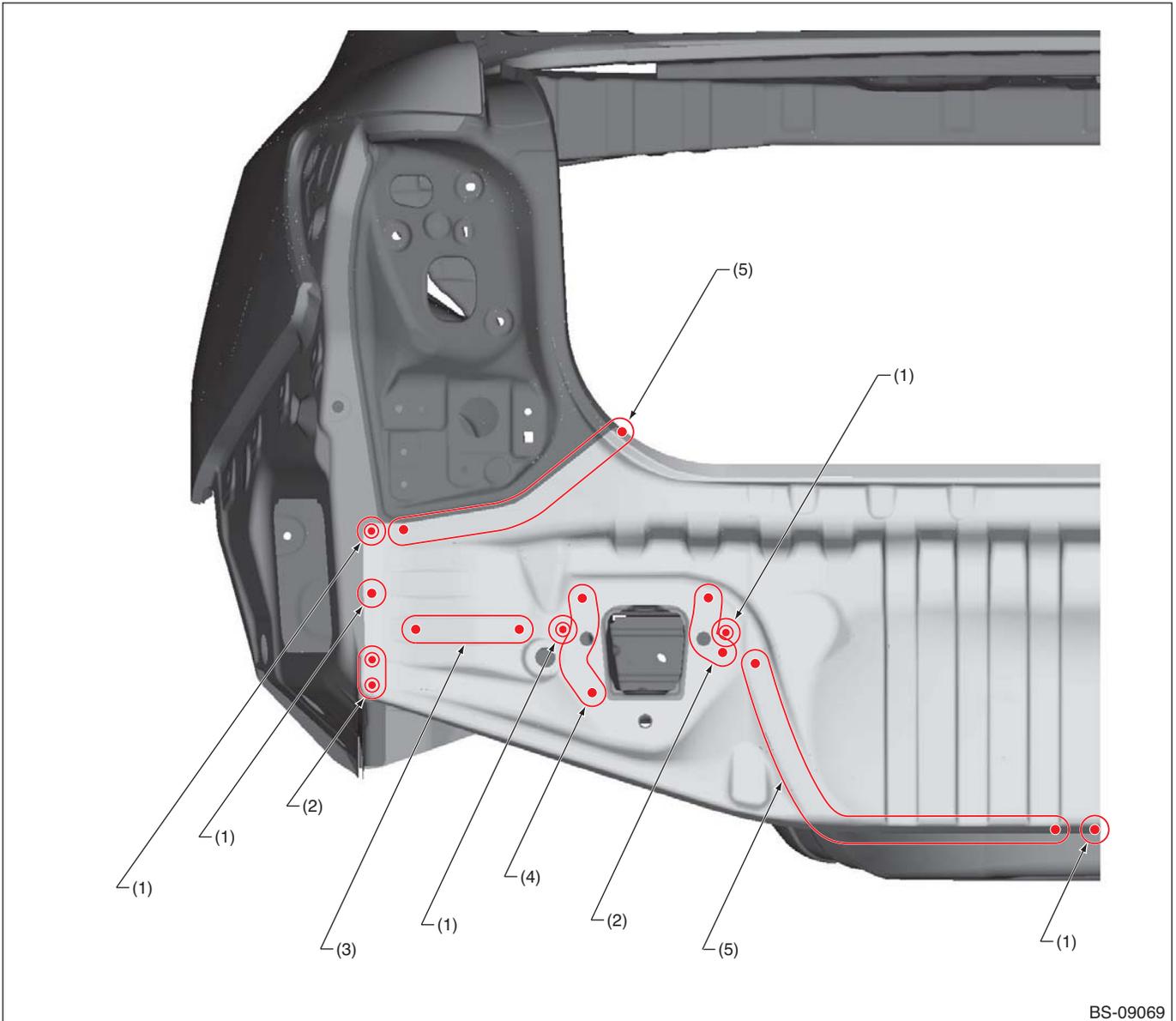
(3) 4 points (outside · 1)  
(4) 3 points (outside · 1)

(5) 9 points (outside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09069

(1) 1 point  
(2) 2 points

(3) 4 points  
(4) 3 points

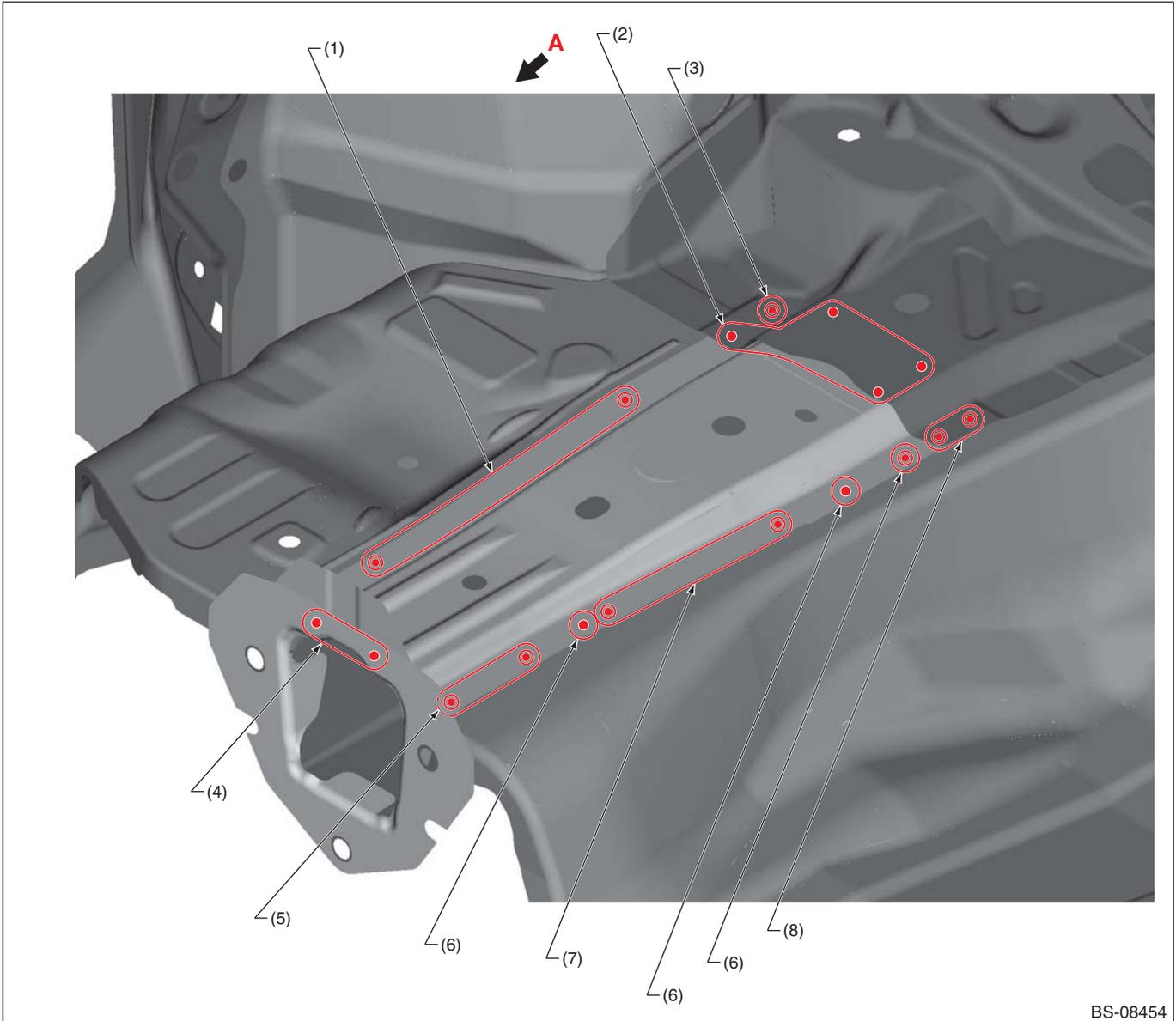
(5) 9 points

# Panel Replacement

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

### A: REMOVAL

- Overall view (Gasoline model)



BS-08454

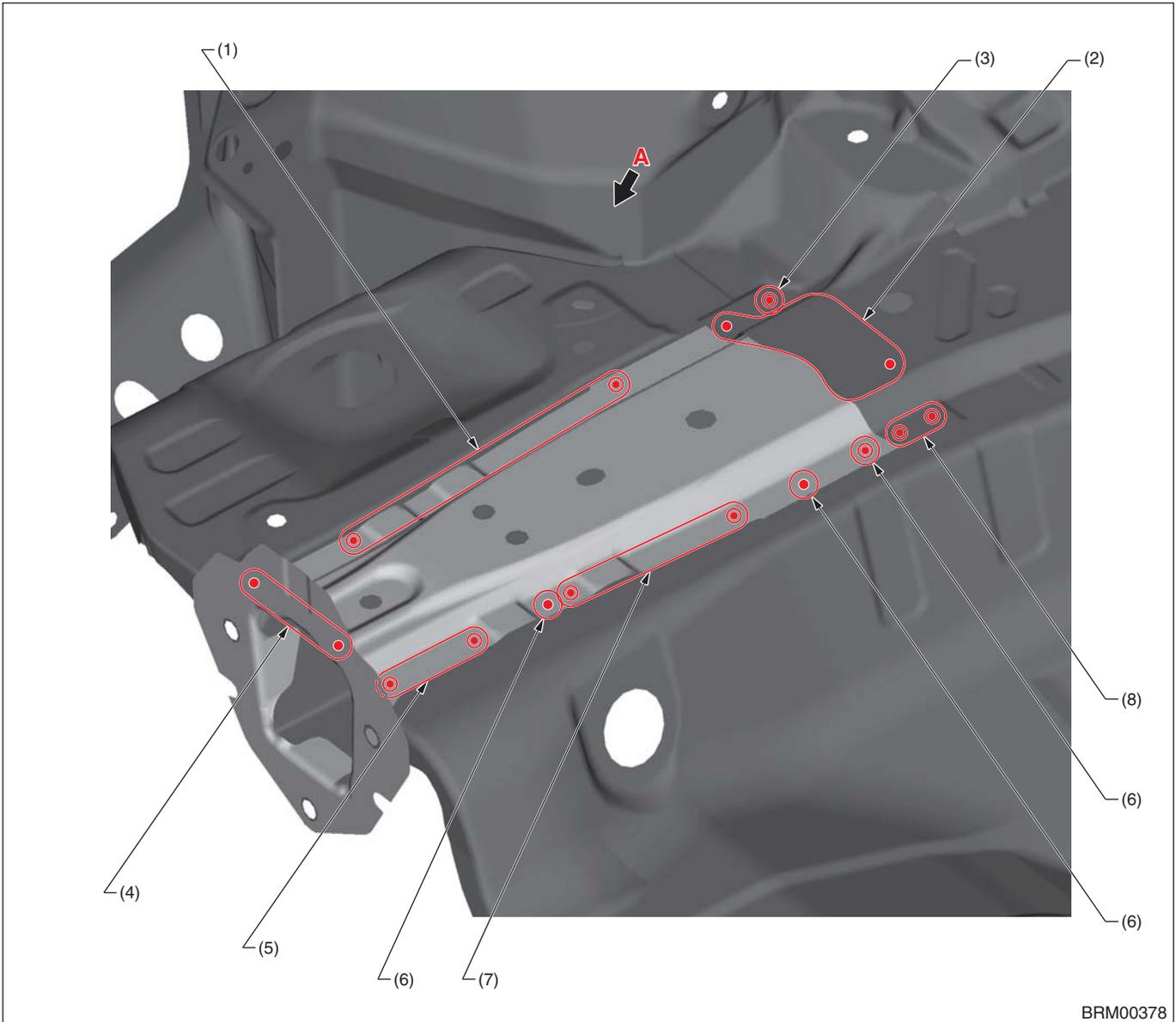
- (1) 5 points (top · 1)
- (2) 6 points (top · 1)
- (3) 1 point (top · 2)

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

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

# Panel Replacement

## • Overall view (Hybrid model)



BRM00378

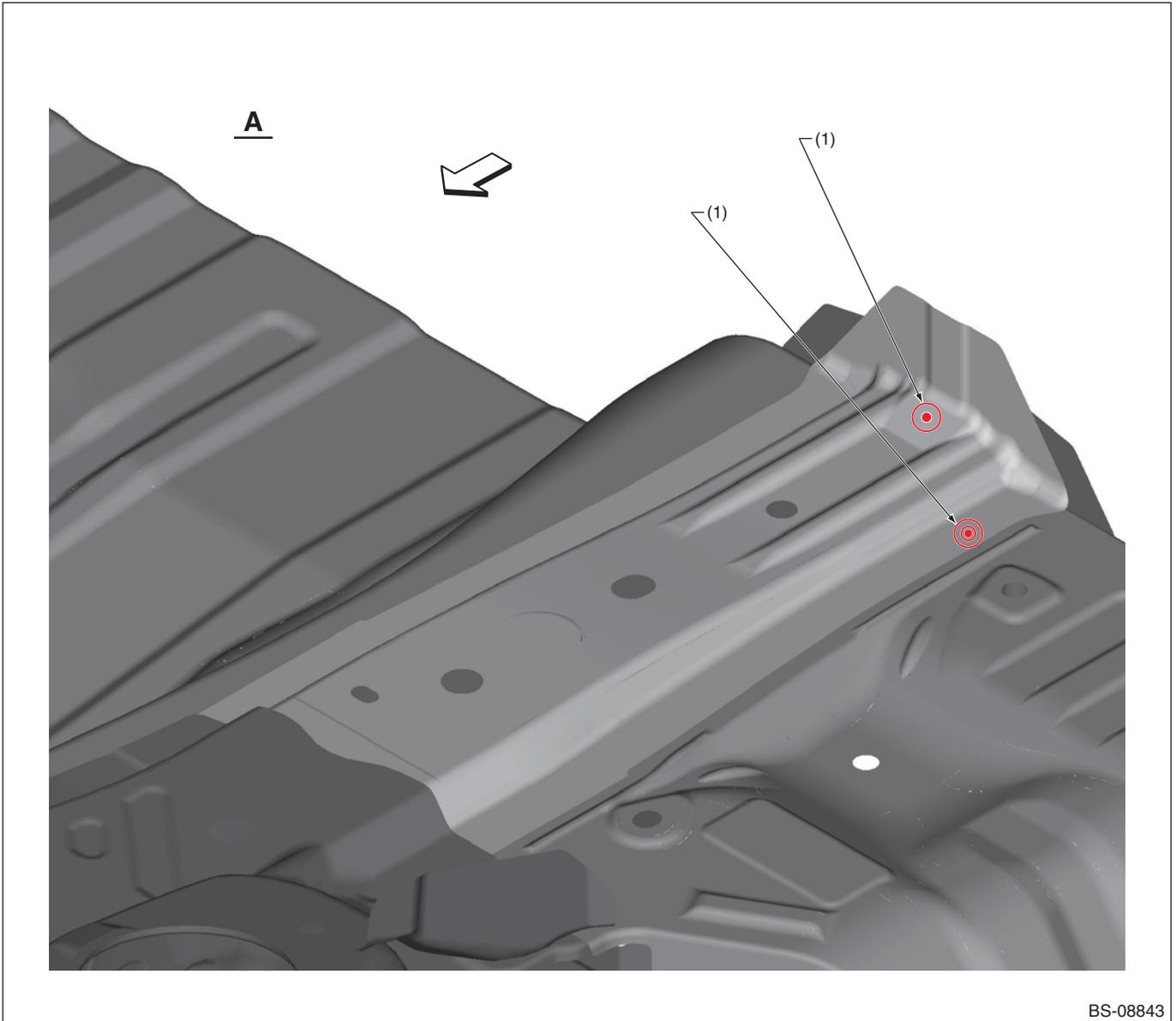
(1) 5 points (top · 1)  
(2) 6 points (top · 1)  
(3) 1 point (top · 2)

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

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

# Panel Replacement

- Views A (Gasoline model)

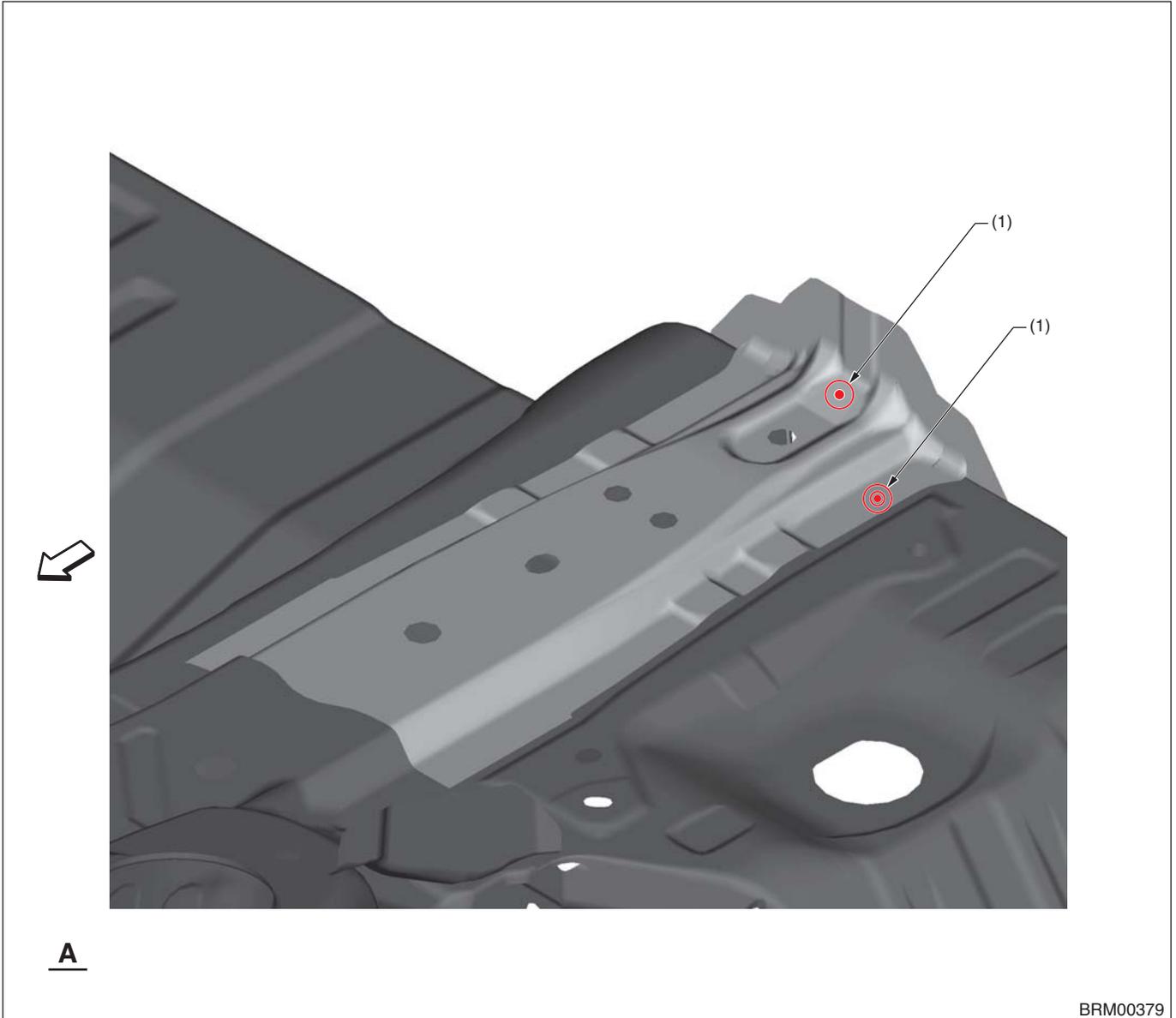


BS-08843

(1) 1 point (top · 1)

# Panel Replacement

- Views A (Hybrid model)

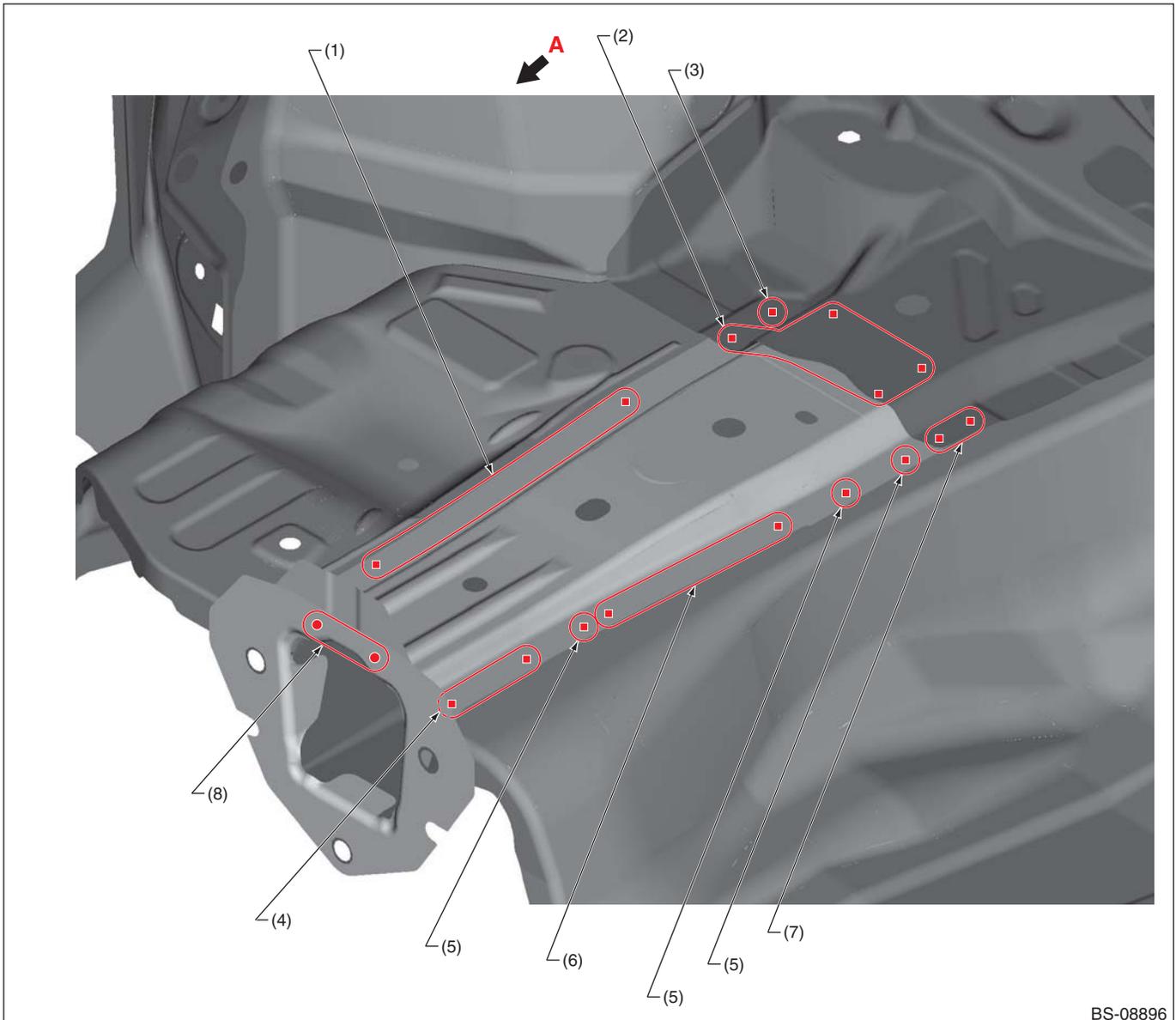


(1) 1 point (top · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view (Gasoline model)



BS-08896

(1) 5 points (service)

(2) 6 points

(3) 1 point (service · matching)

(4) 2 points (service)

(5) 1 point (service)

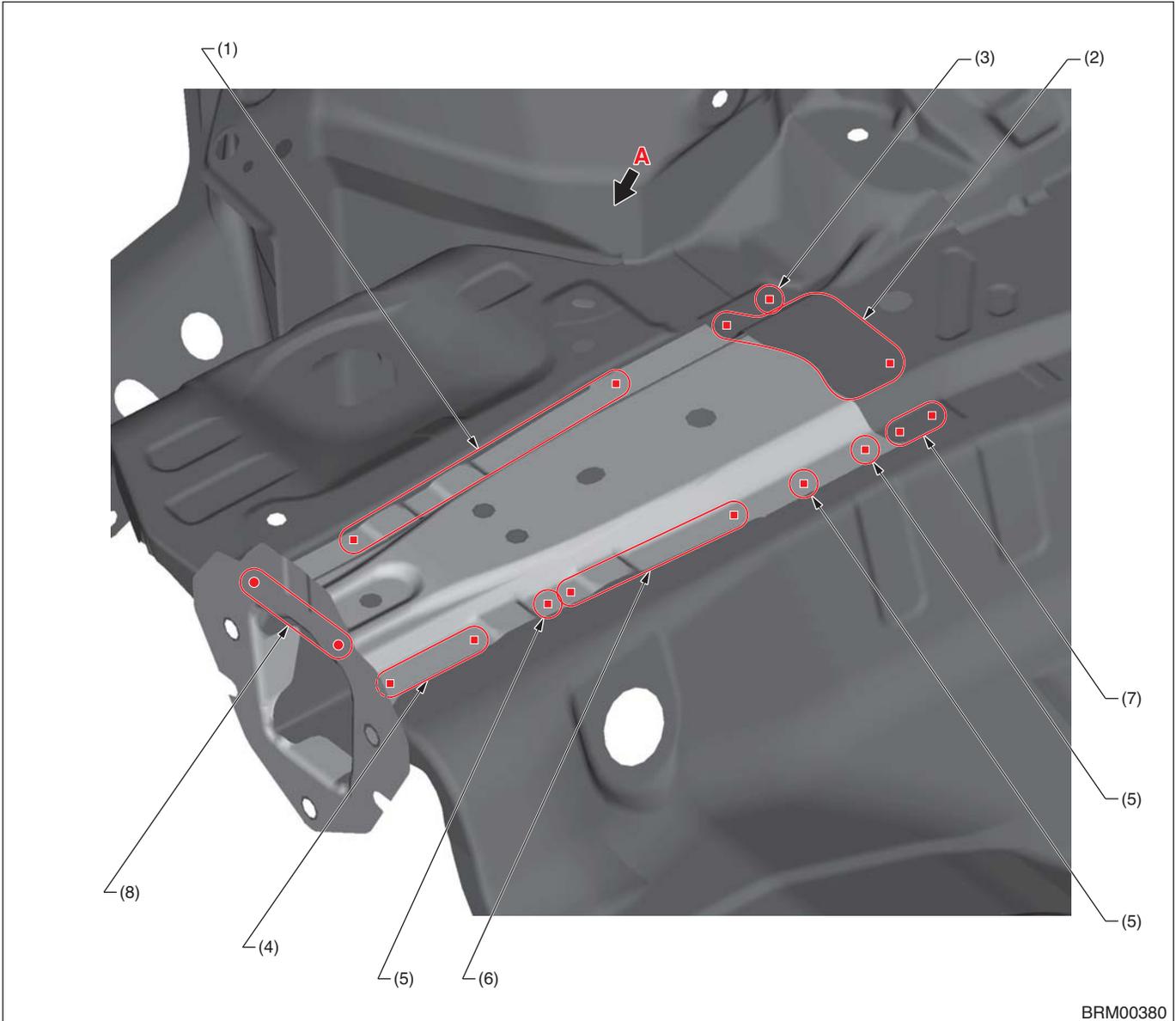
(6) 3 points (service)

(7) 2 points (service · matching)

(8) 2 points

# Panel Replacement

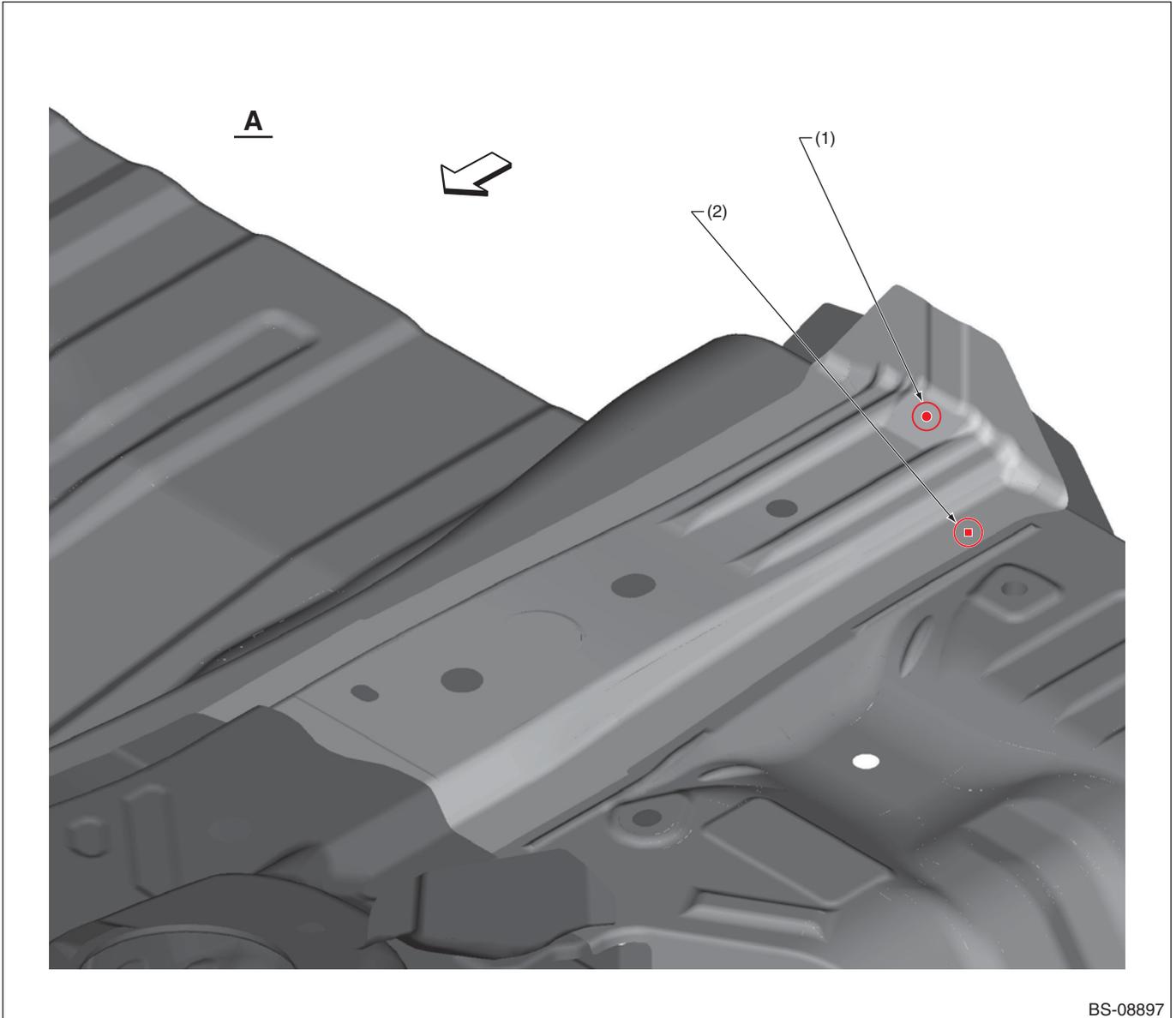
- (Hybrid model)



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

# Panel Replacement

## • Views A (Gasoline model)



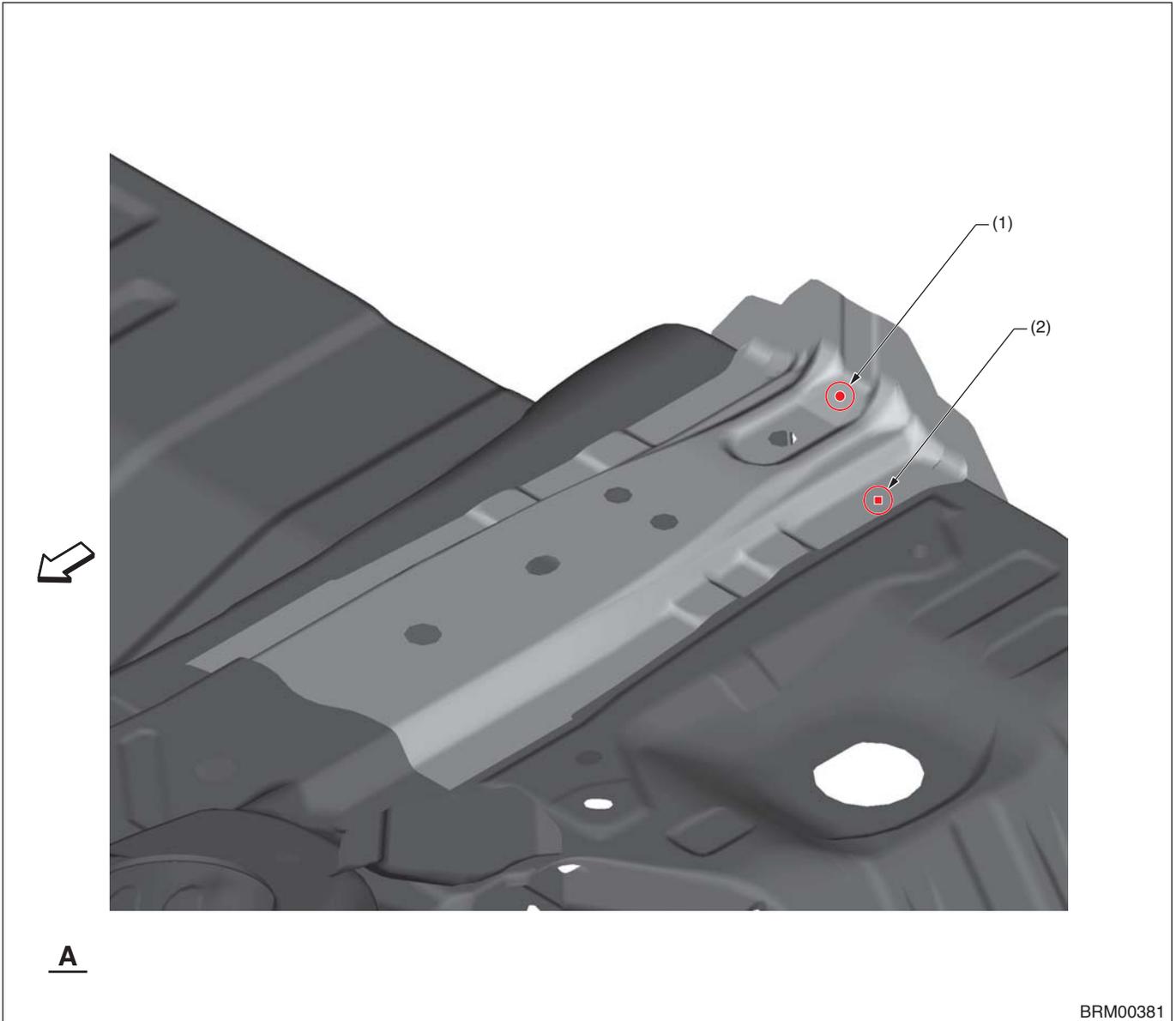
BS-08897

(1) 1 point

(2) 1 point (service)

# Panel Replacement

- Views A (Hybrid model)



BRM00381

(1) 1 point

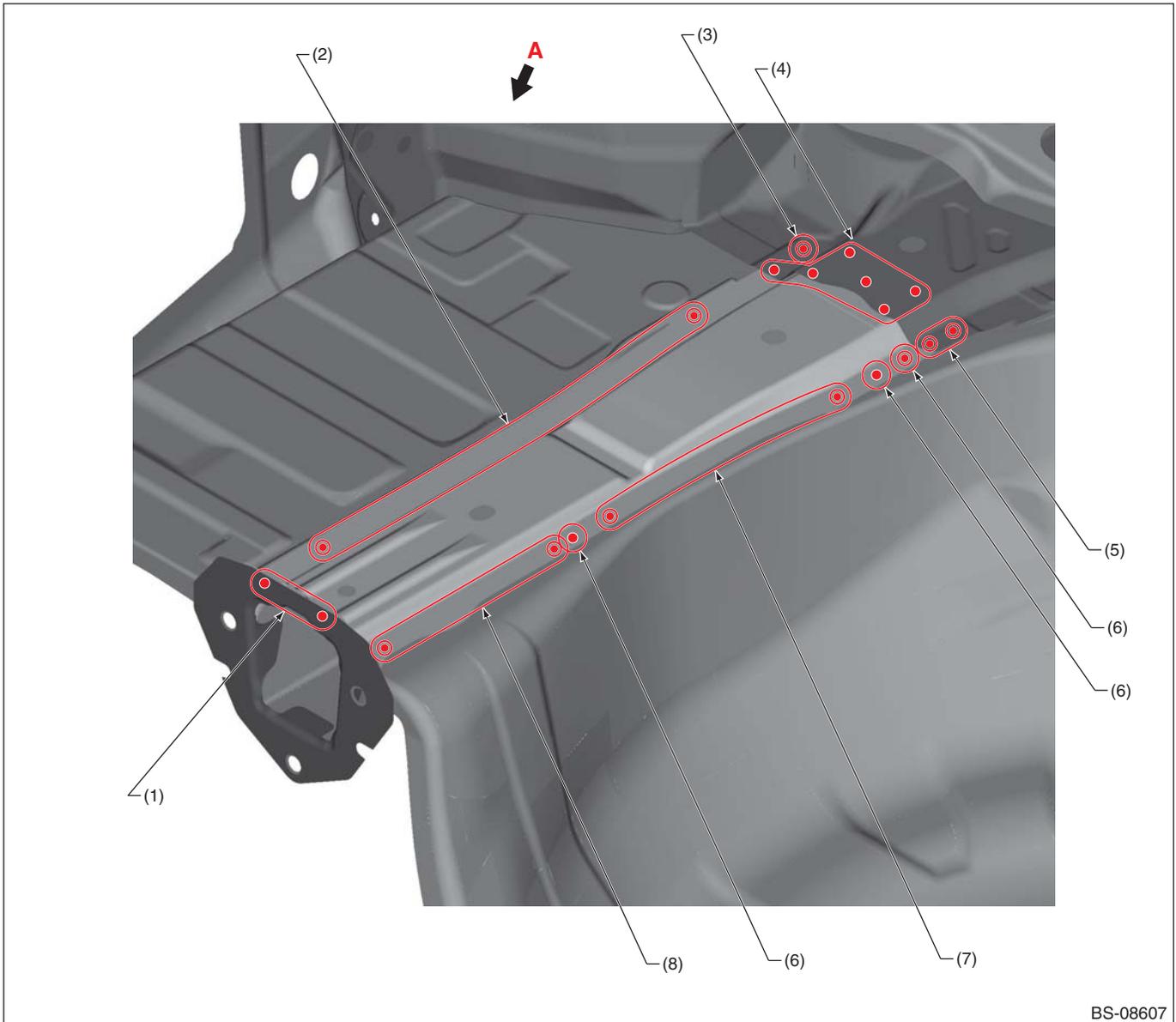
(2) 1 point (service)

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-08607

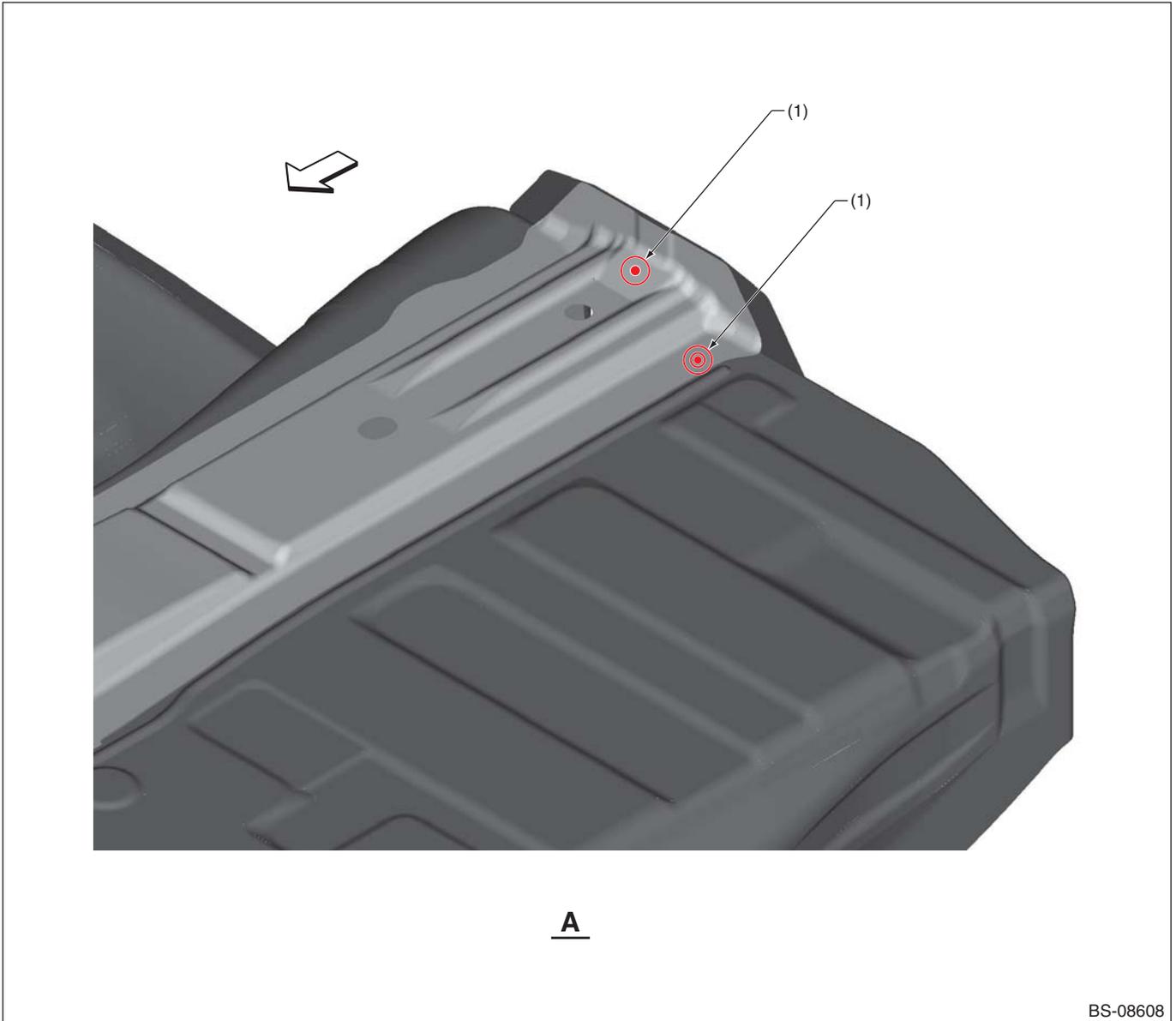
- (1) 2 points (inside · 1)
- (2) 8 points (top · 1)
- (3) 1 point (top · 2)

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

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

# Panel Replacement

## • Views A

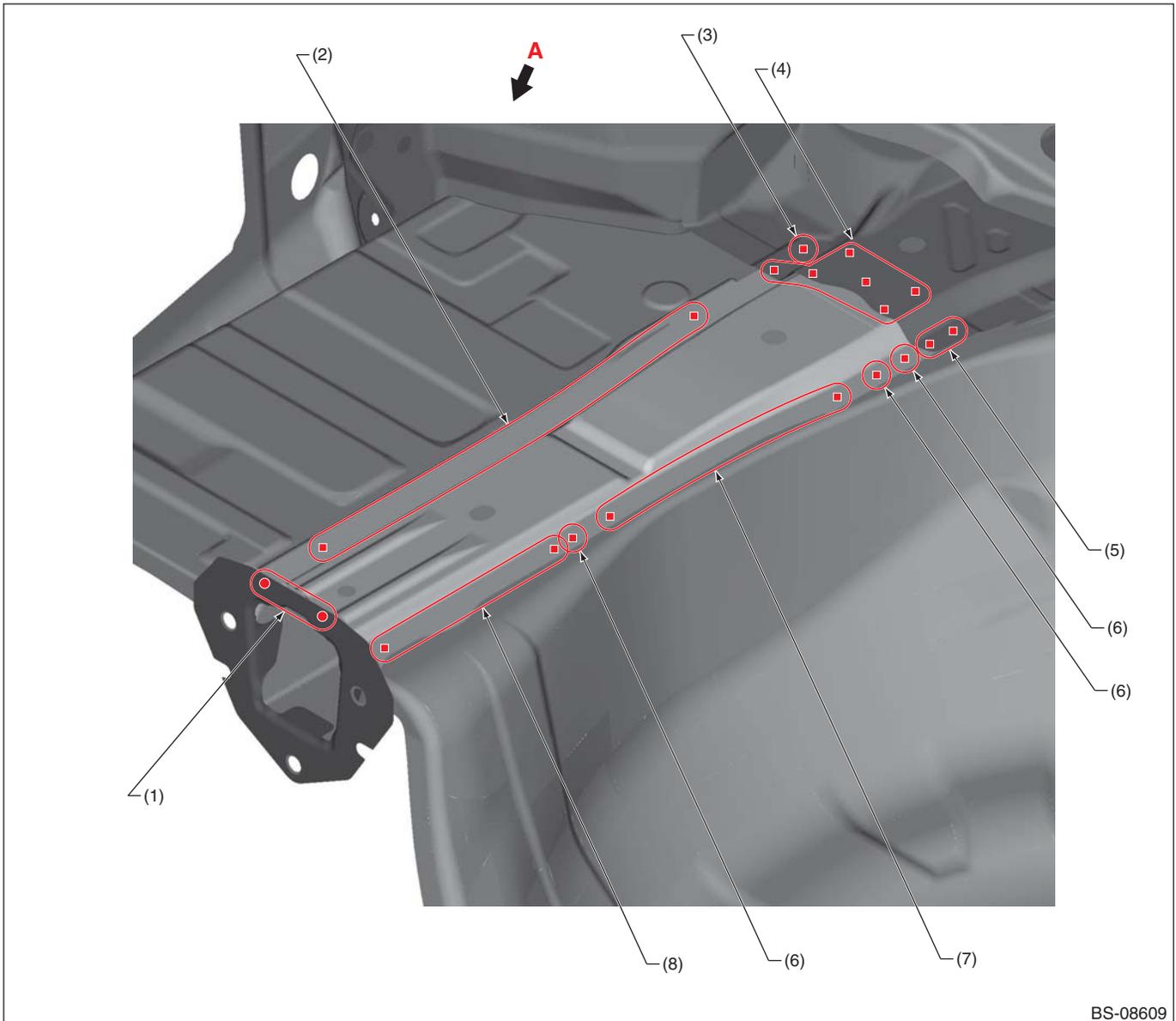


(1) 1 point (top · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view

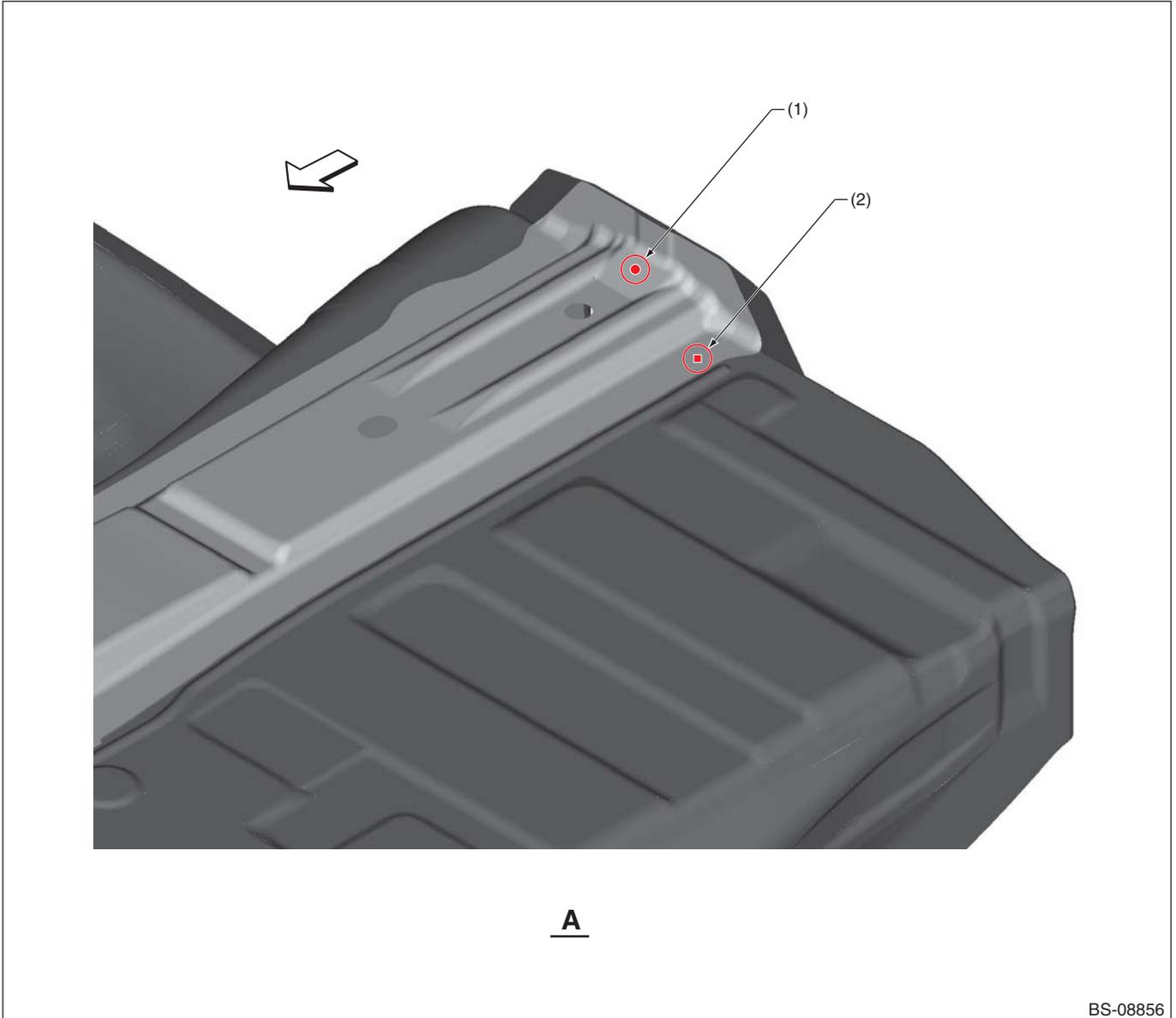


BS-08609

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

# Panel Replacement

## • Views A



(1) 1 point

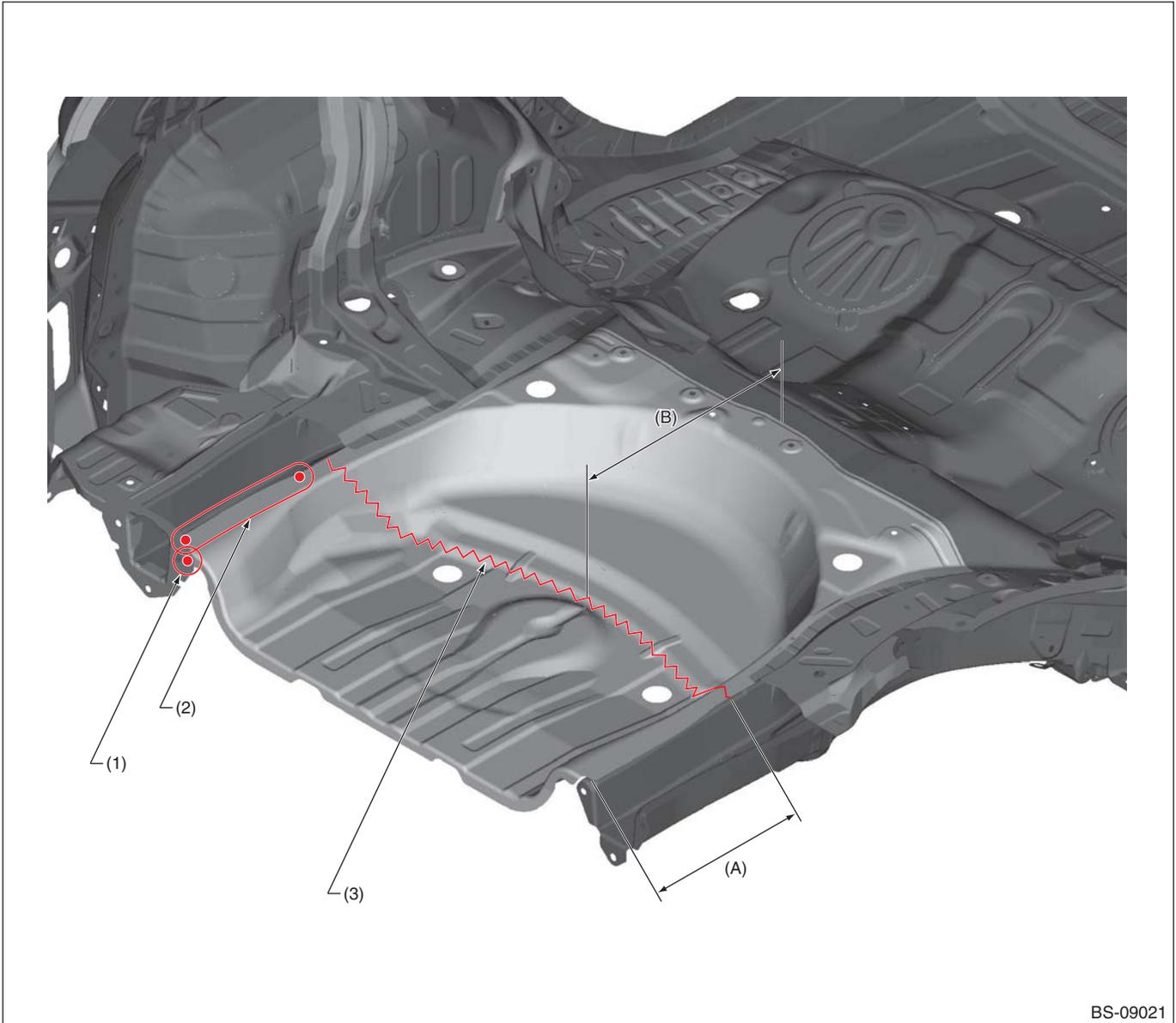
(2) 1 point (service)

# Panel Replacement

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

### A: REMOVAL

- Overall view (Gasoline model)



BS-09021

(A) 290 mm [11.42 in]

(B) 350 mm [13.78 in]

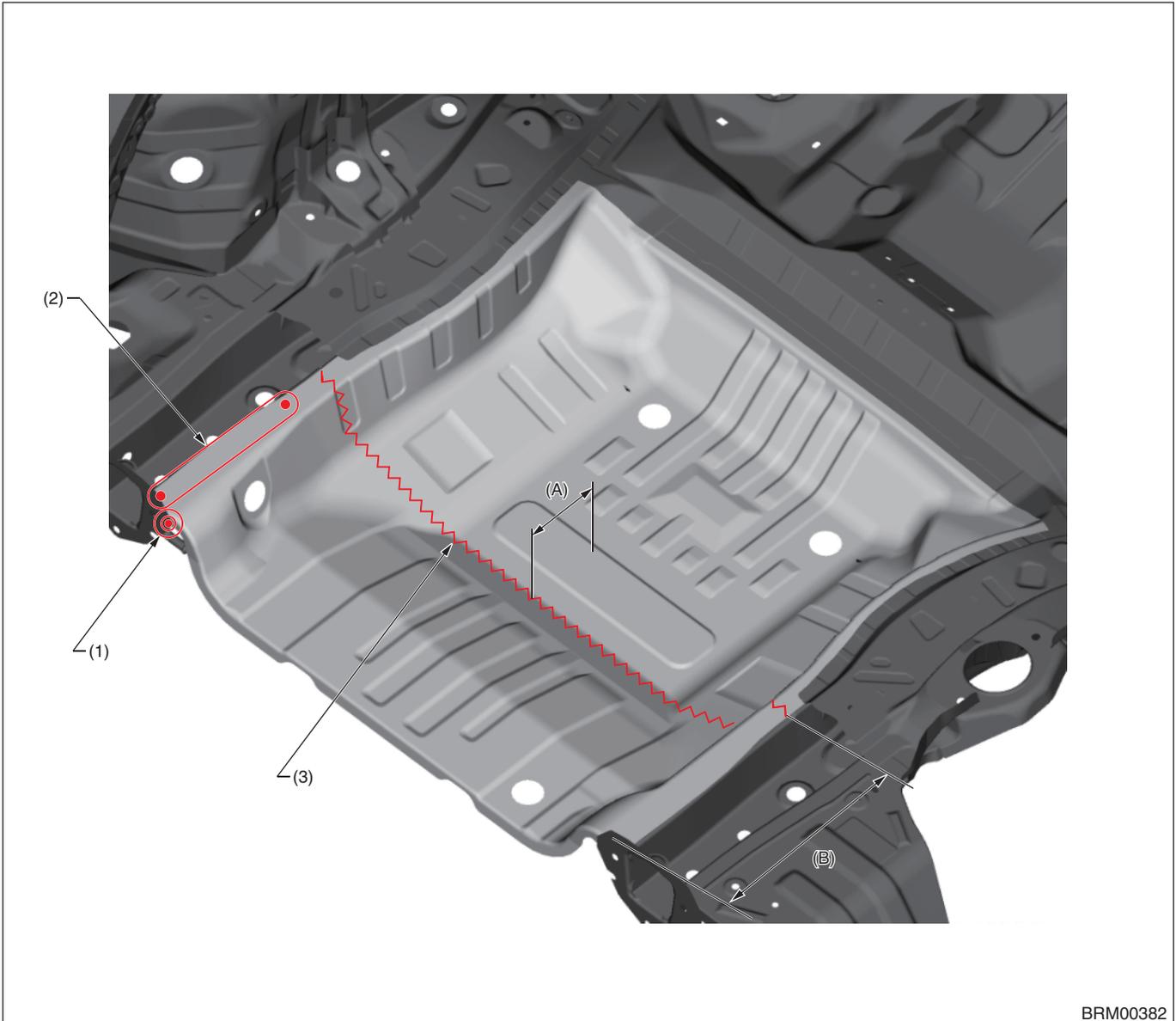
(1) 1 point (inside · 1 belt sander)

(2) 5 points (top · 1)

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

# Panel Replacement

## • Overall view (Hybrid model)



BRM00382

(A) 120 mm [4.72 in]

(B) 288 mm [11.34 in]

(1) 1 point (inside · 1 belt sander)

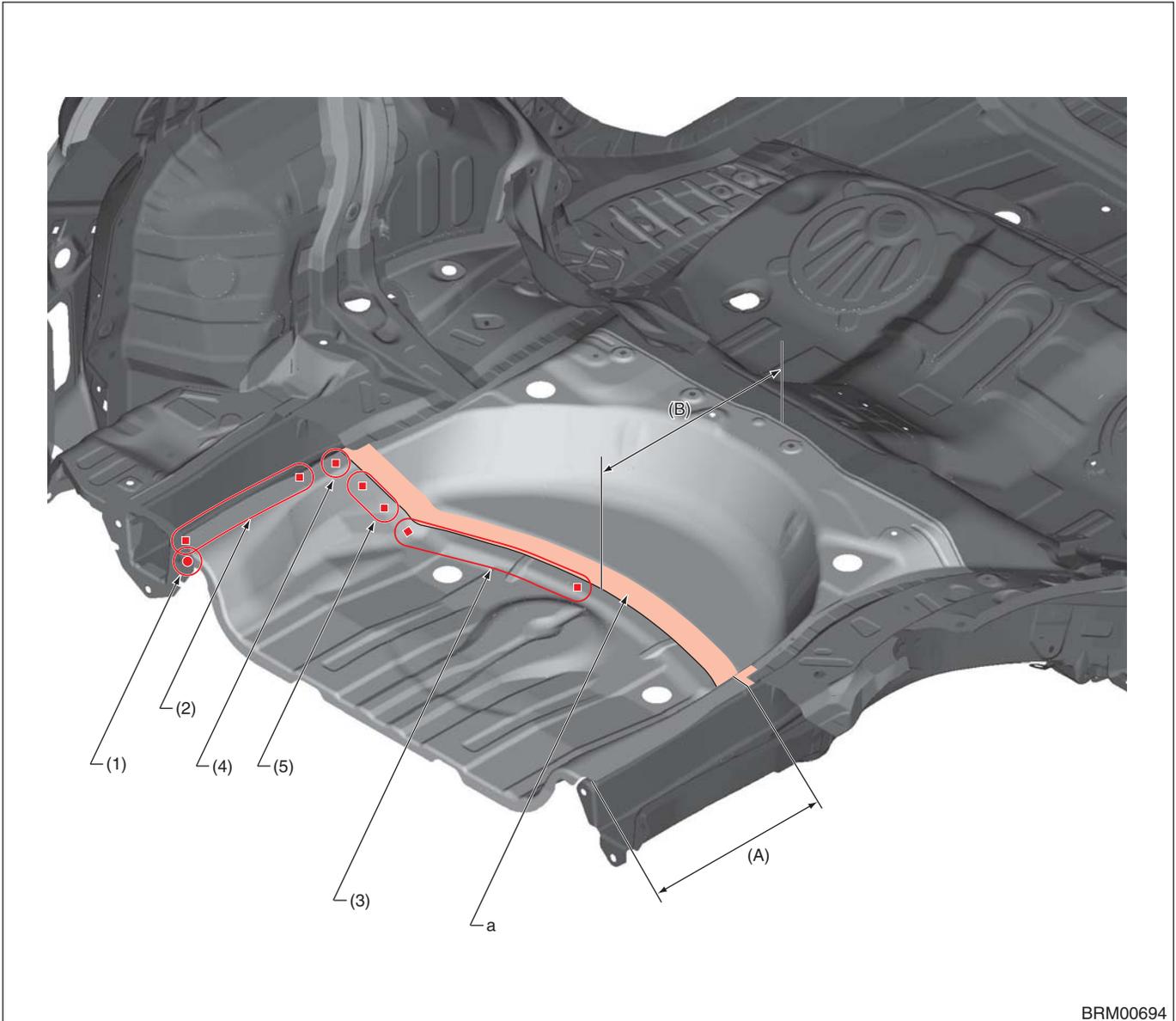
(2) 5 points (top · 1)

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

# Panel Replacement

## B: INSTALLATION

### • Overall view (Gasoline model)



BRM00694

(A) 310 mm [12.20 in]

(B) 325 mm [12.80 in]

(1) 1 point

(3) 6 points (service)

(5) 2 points (service)

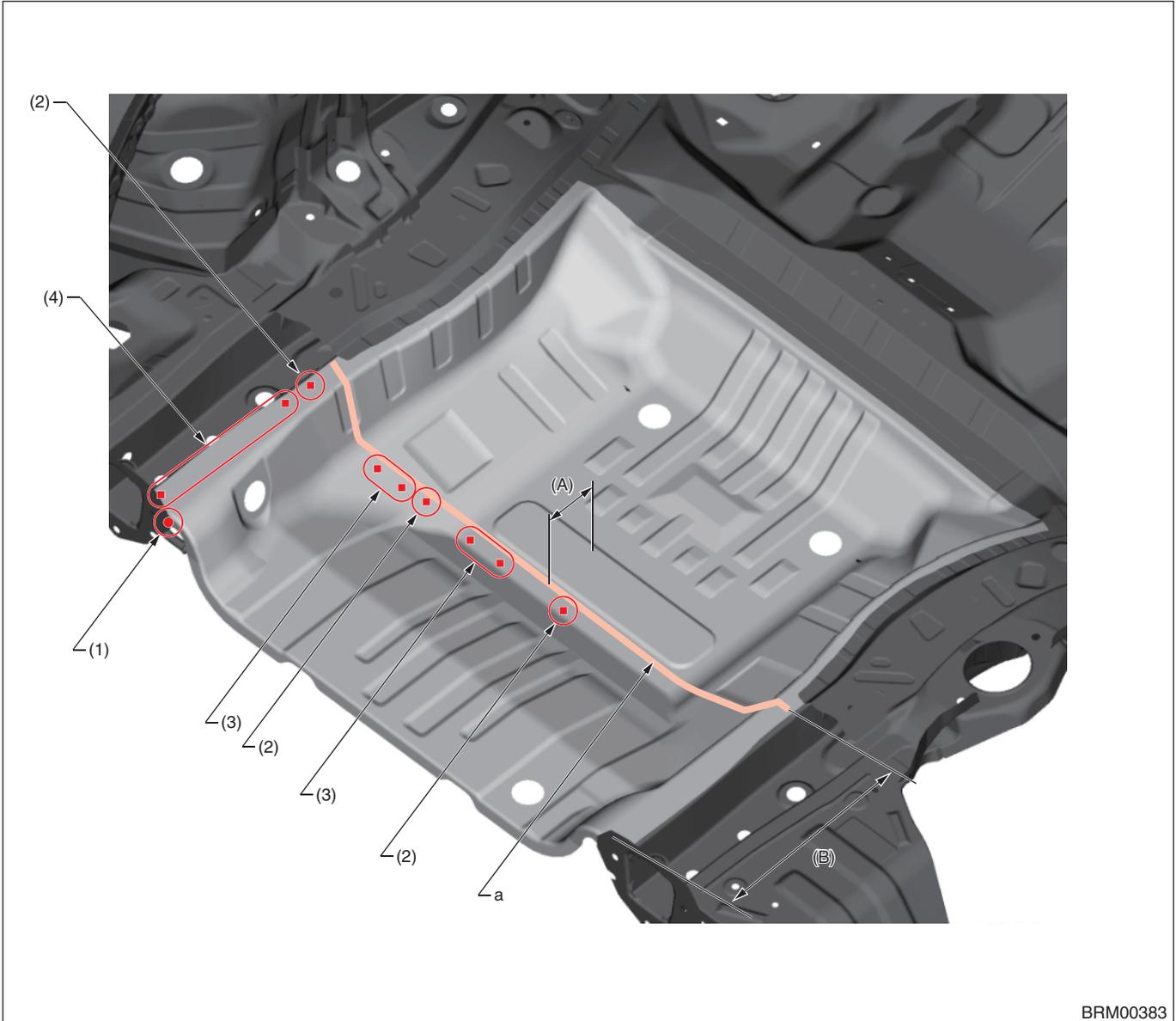
(2) 5 points (service)

(4) 1 point (service)

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

# Panel Replacement

## • Overall view (Hybrid model)



BRM00383

(A) 75 mm [2.95 in]

(B) 315 mm [12.40 in]

(1) 1 point

(3) 2 points (service)

(4) 5 points (service)

(2) 1 point (service)

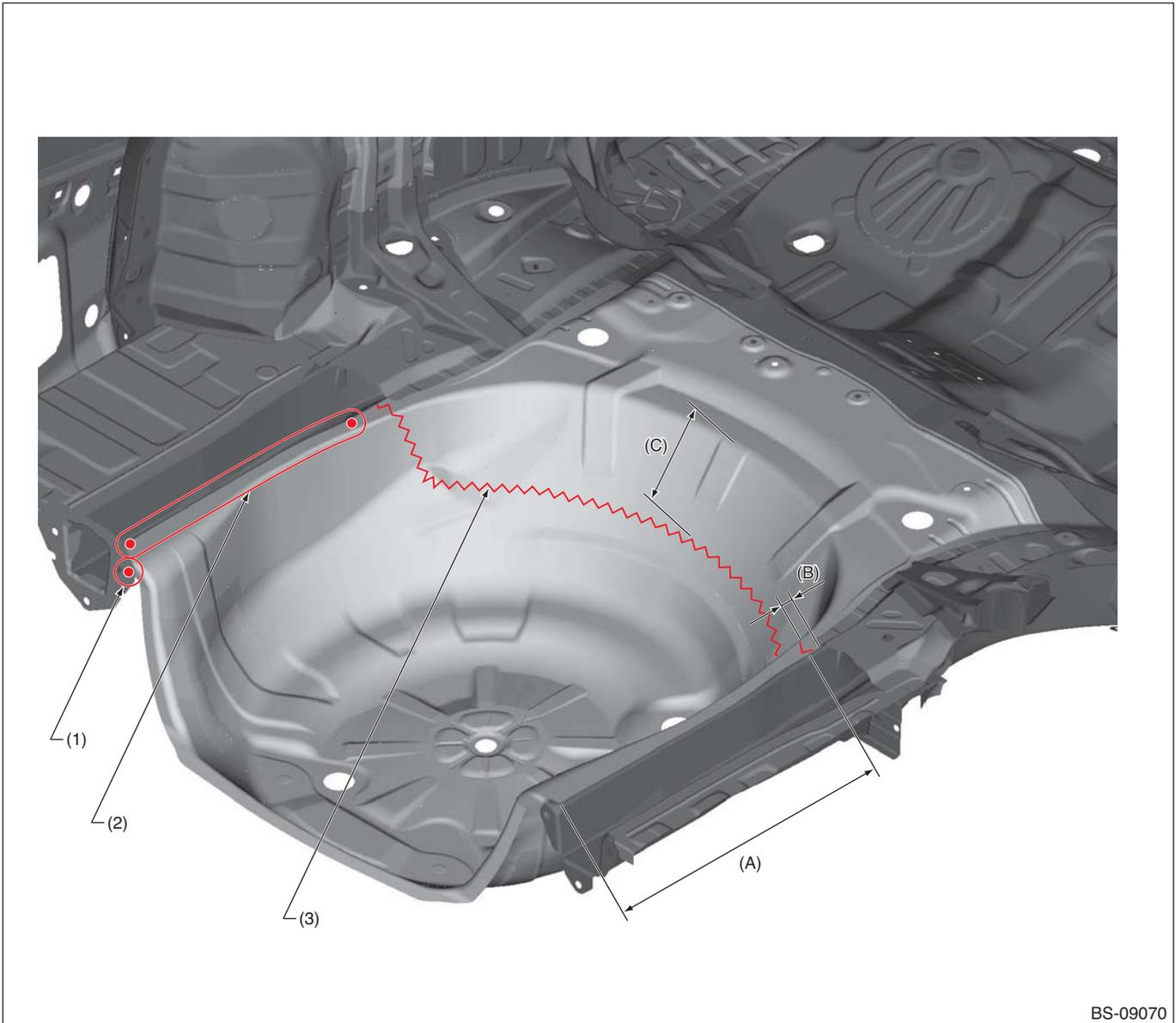
Note: Apply sealing agent to the floor pan fitting parts (front and rear) of section "a".

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-09070

(A) 455 mm [17.91 in]

(B) 25 mm [0.98 in]

(C) 160 mm [6.3 in]

(1) 1 point (inside · 1 belt sander)

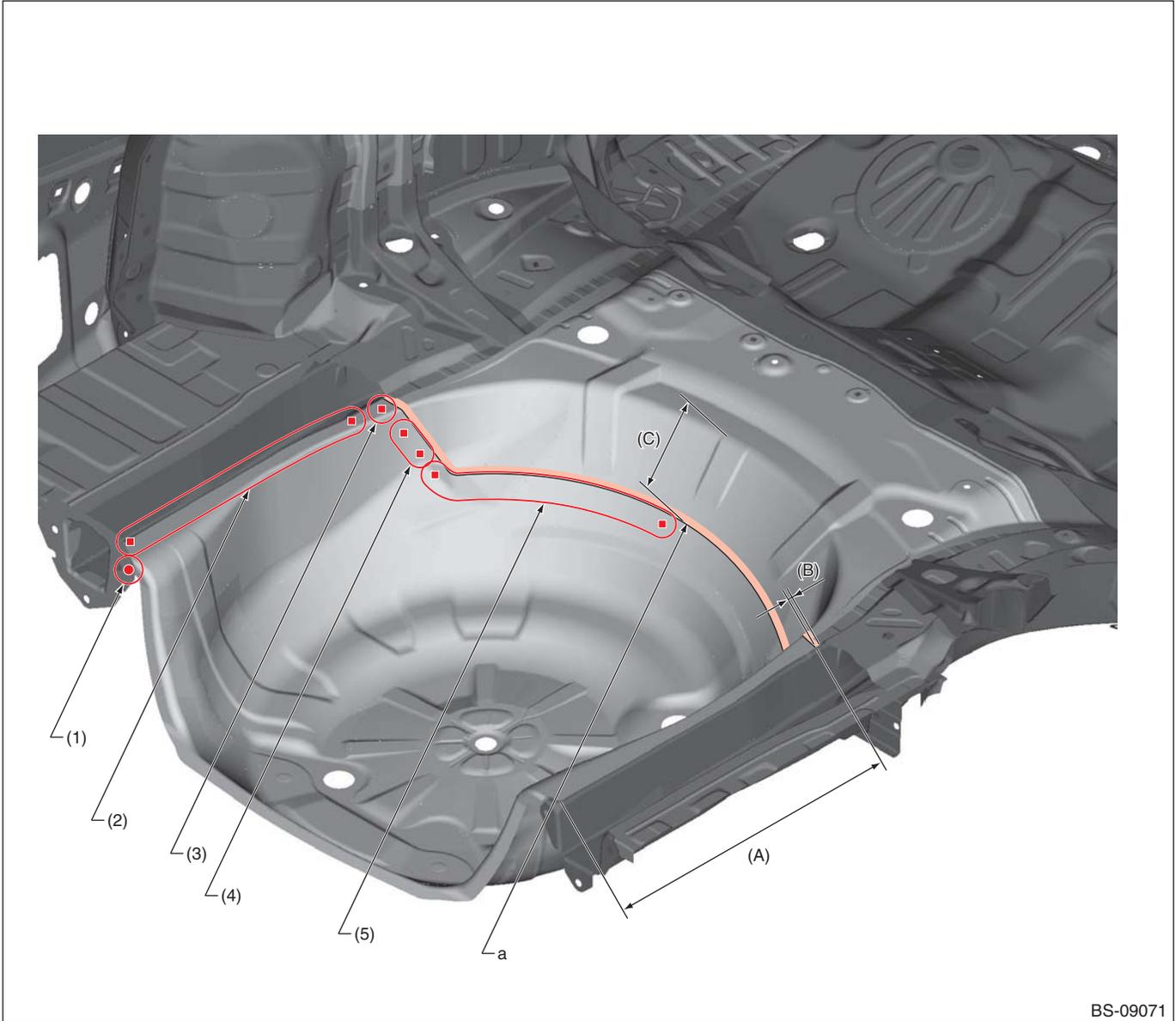
(2) 9 points (top · 1)

(3) Cut position

# Panel Replacement

## B: INSTALLATION

### • Overall view



(A) 475 mm [18.7 in]

(B) 5 mm [0.2 in]

(C) 140 mm [5.51 in]

(1) 1 point

(3) 1 point (service)

(5) 6 points (service)

(2) 9 points (service)

(4) 2 points (service)

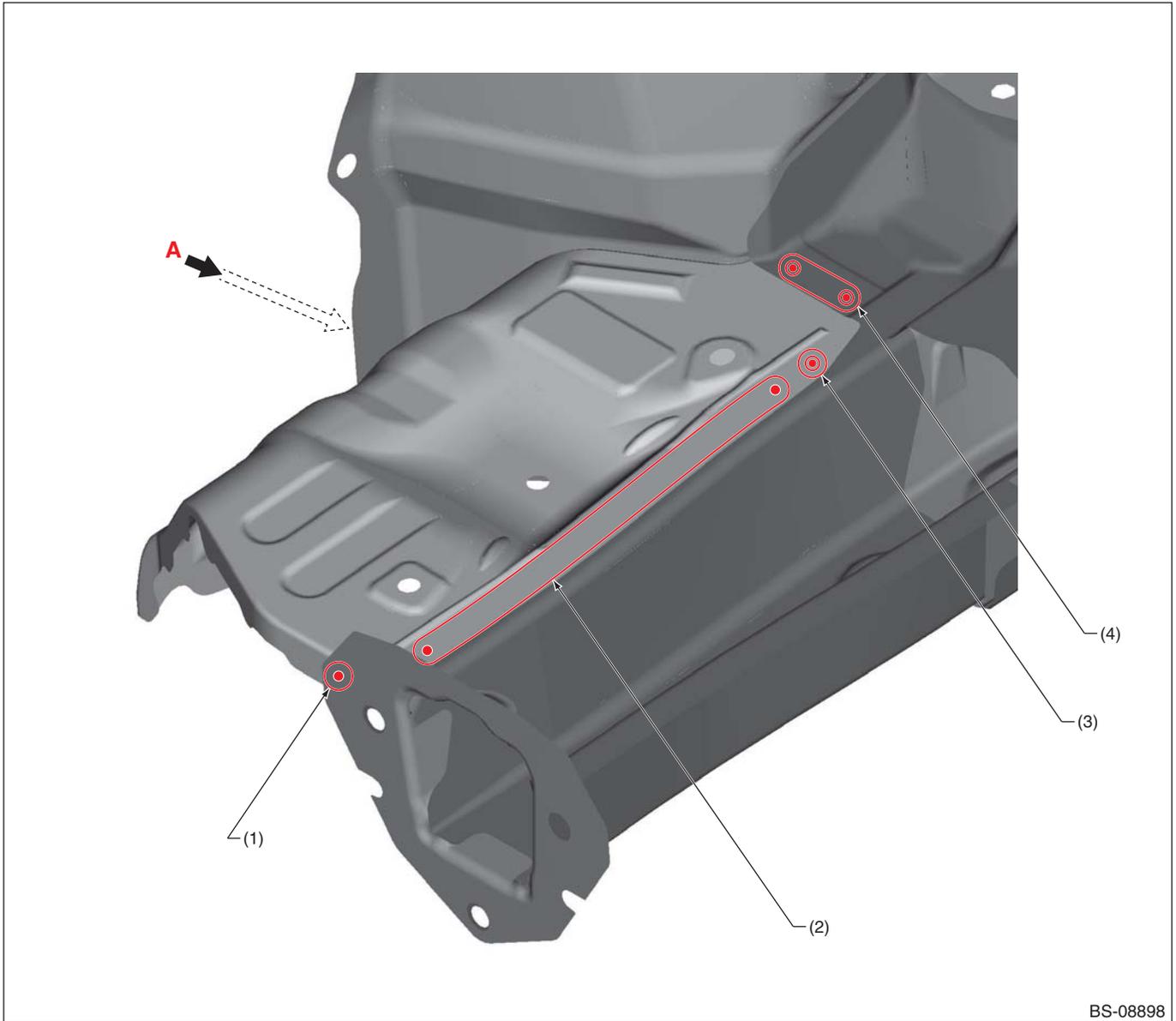
Note: Apply sealing agent to the floor pan fitting parts (front and rear) of section "a".

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-08898

(1) 1 point (inside - 1 belt sander)

(3) 1 point (top - 1)

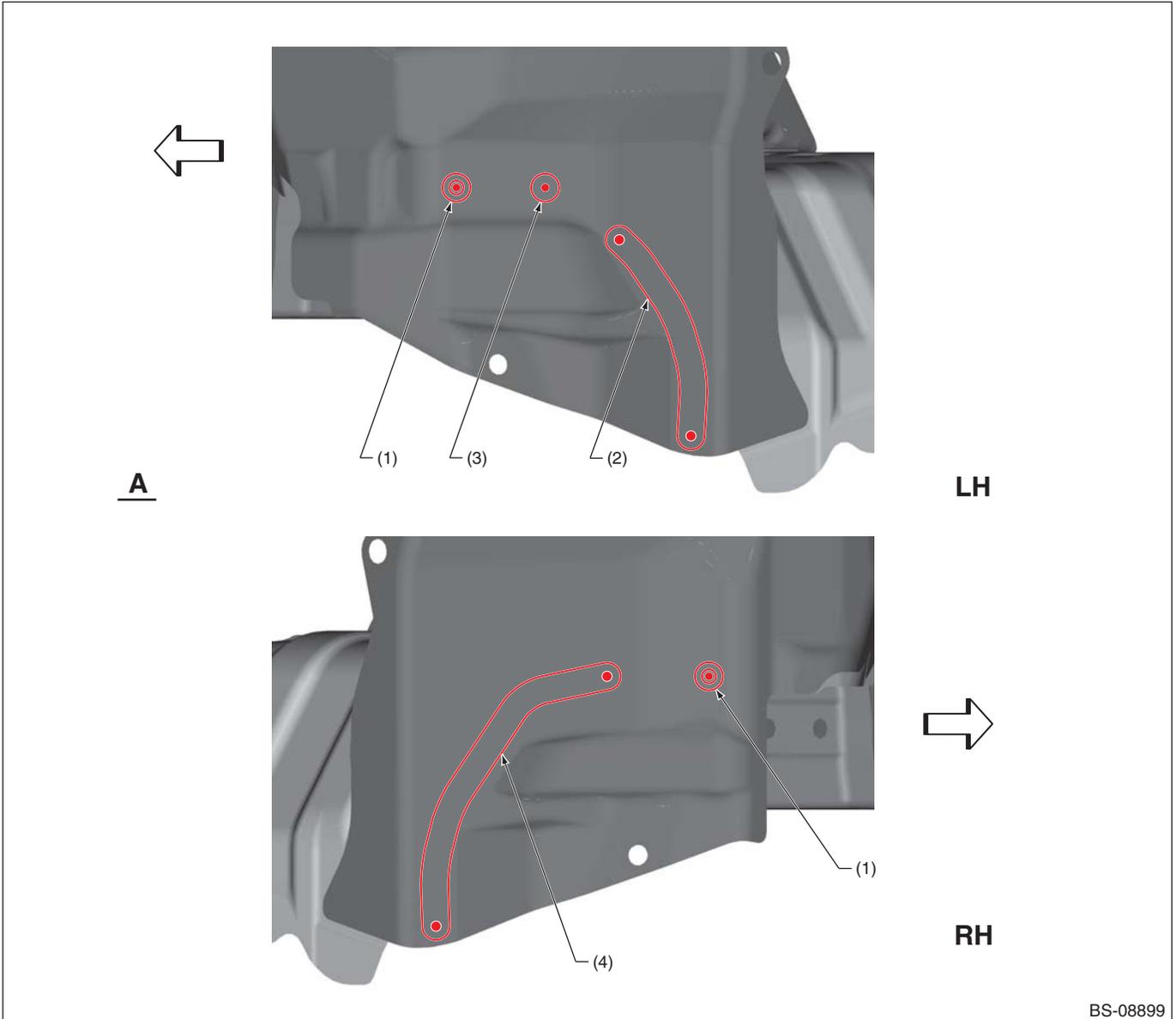
(4) LH: 2 points (top - 2)

(2) 7 points (top - 1)

RH: 1 point (top - 2)

# Panel Replacement

## • Views A



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

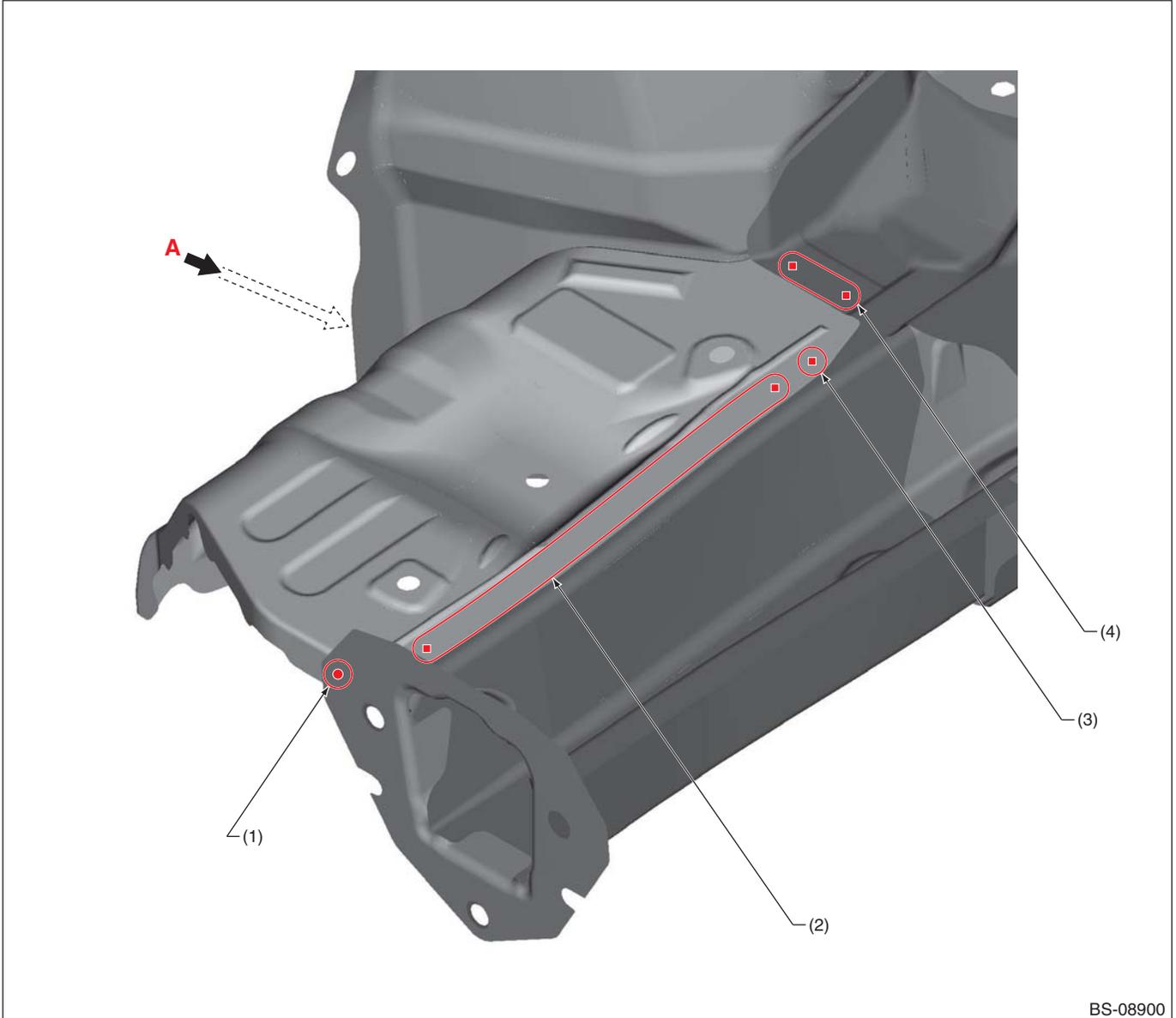
(3) 1 point (outside · 1)

(4) 5 points (inside · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-08900

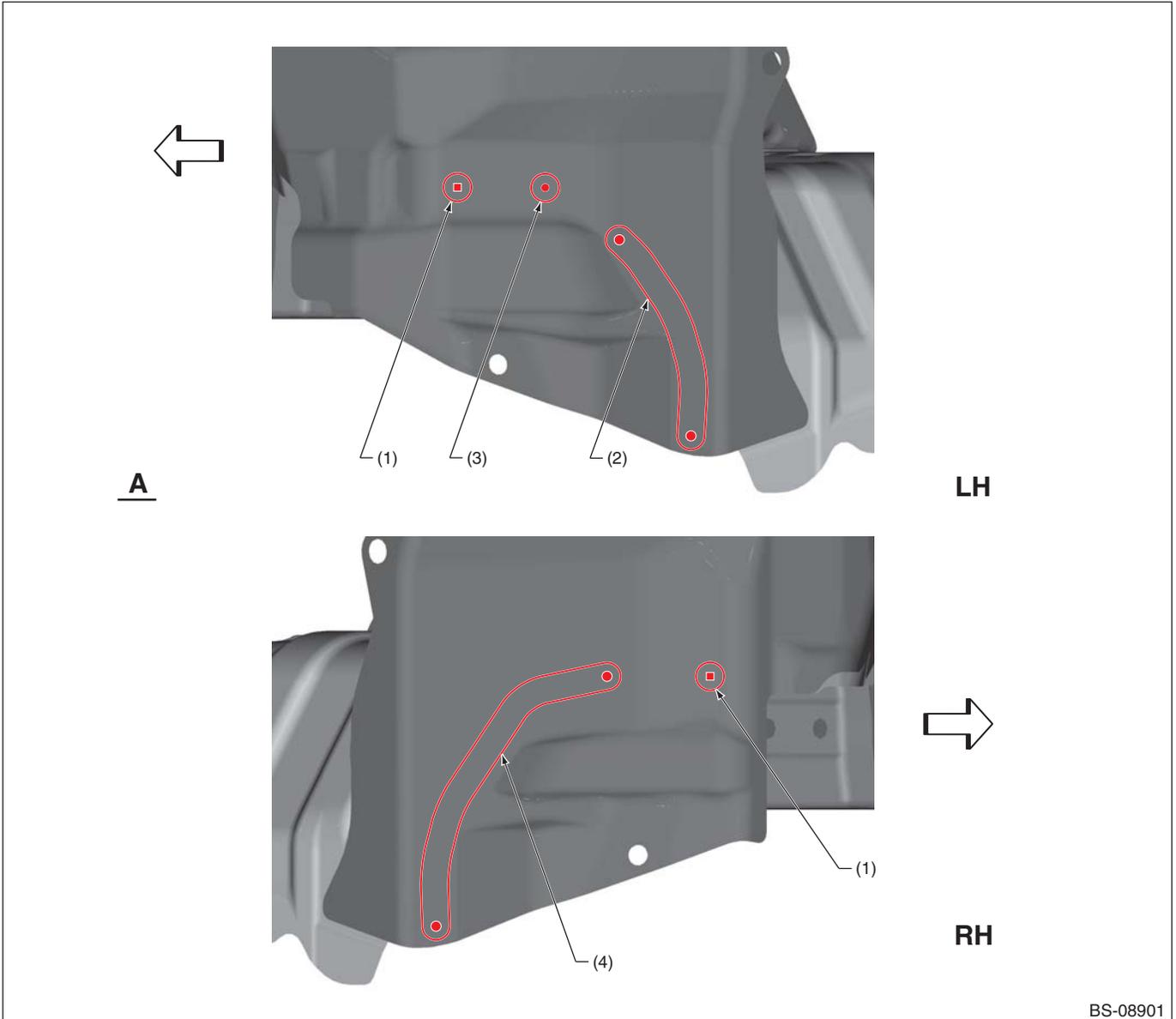
- (1) 1 point
- (2) 7 points (service)

- (3) 1 point (service)

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

# Panel Replacement

## • Views A



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

(3) 1 point

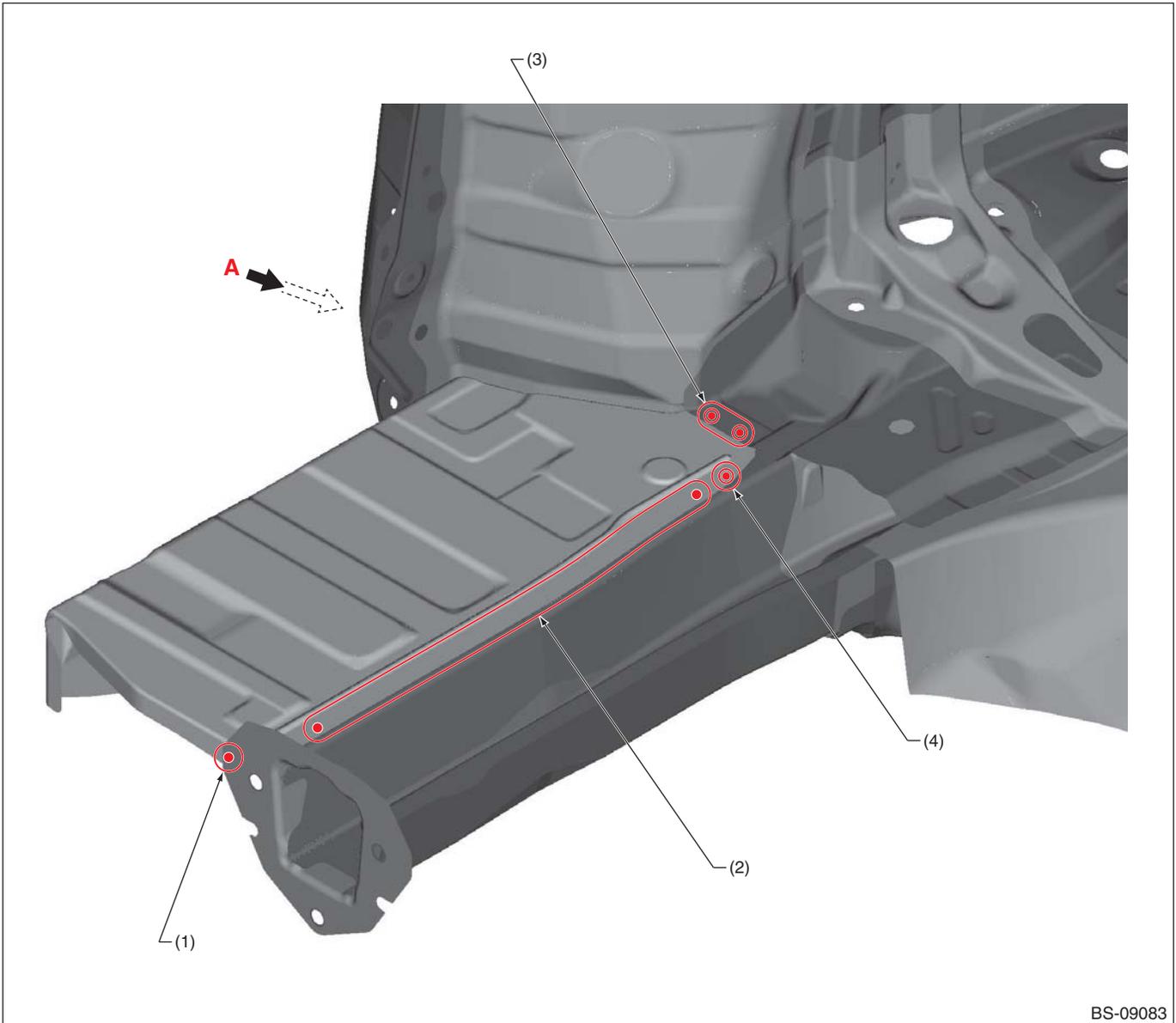
(4) 5 points

# Panel Replacement

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

### A: REMOVAL

- Overall view



BS-09083

(1) 1 point (inside - 1 belt sander)

(2) 10 points (top - 1)

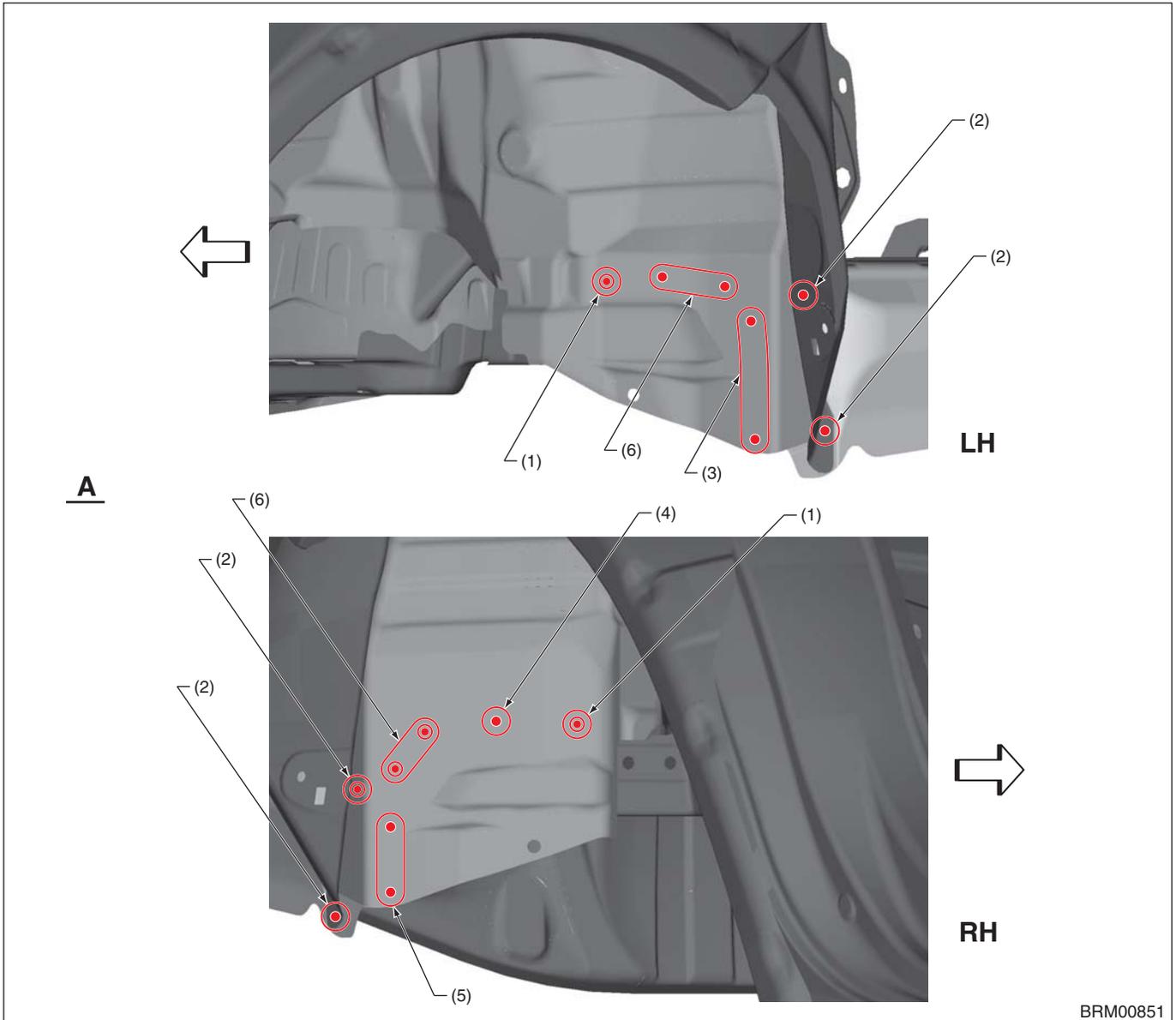
(3) LH: 2 points (top - 2)

RH: 1 point (top - 2)

(4) 1 point (top - 1)

# Panel Replacement

## • Views A



BRM00851

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

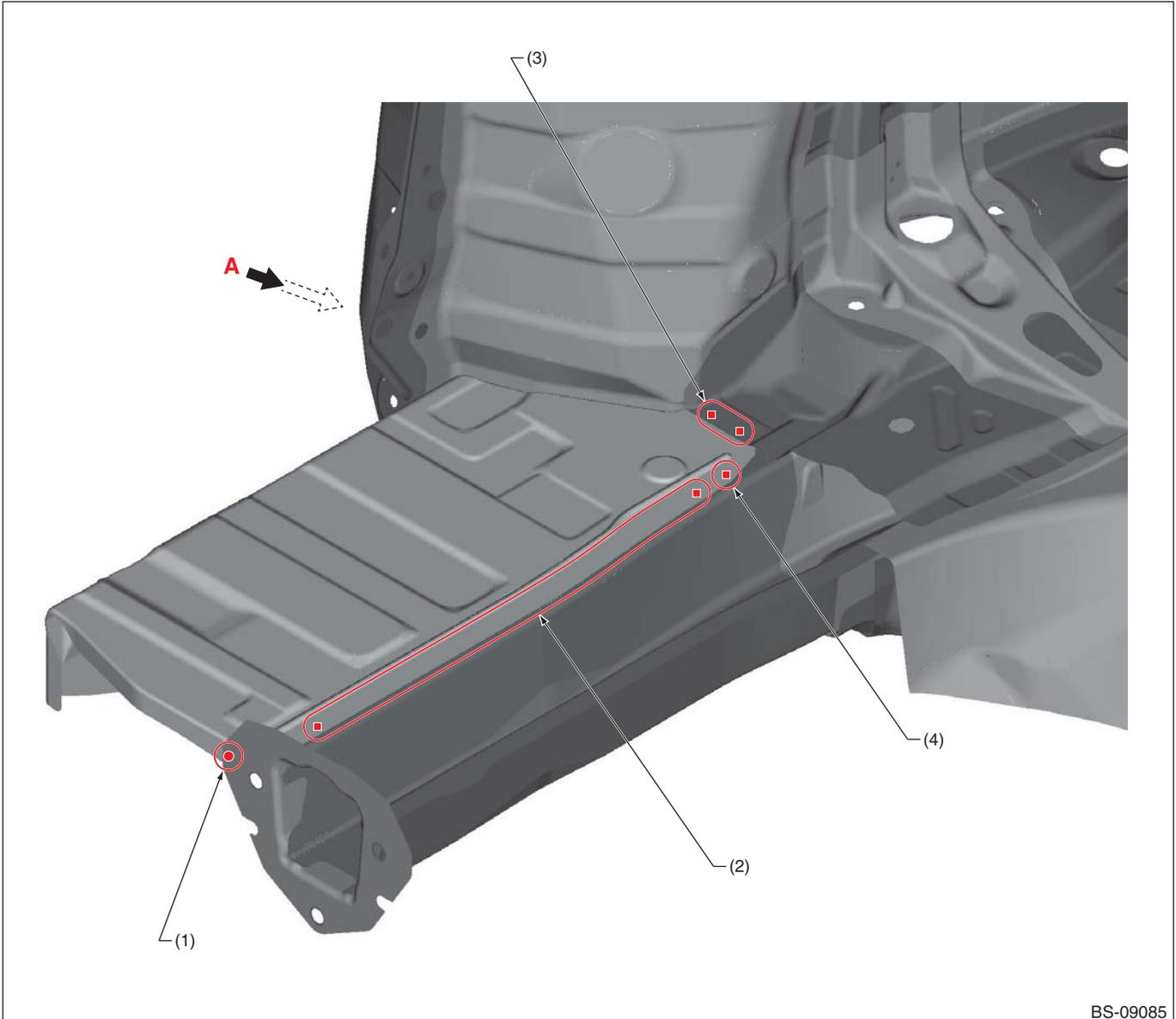
(3) 3 points (inside · 1)  
(4) 1 point (outside · 1)

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

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09085

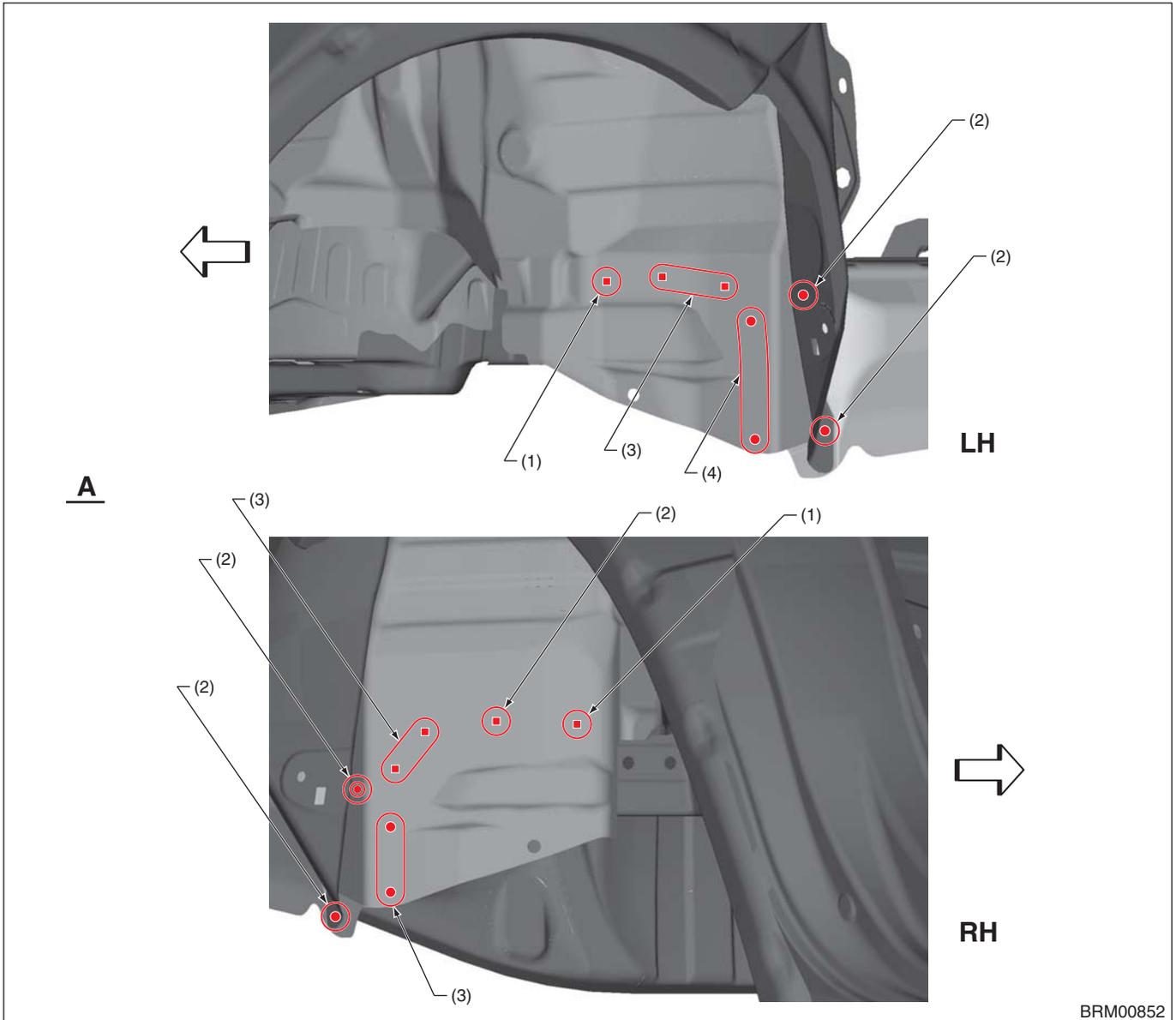
- (1) 1 point
- (2) 10 points (service)

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

- (4) 1 point (service)

# Panel Replacement

## • Views A



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

(3) 2 points

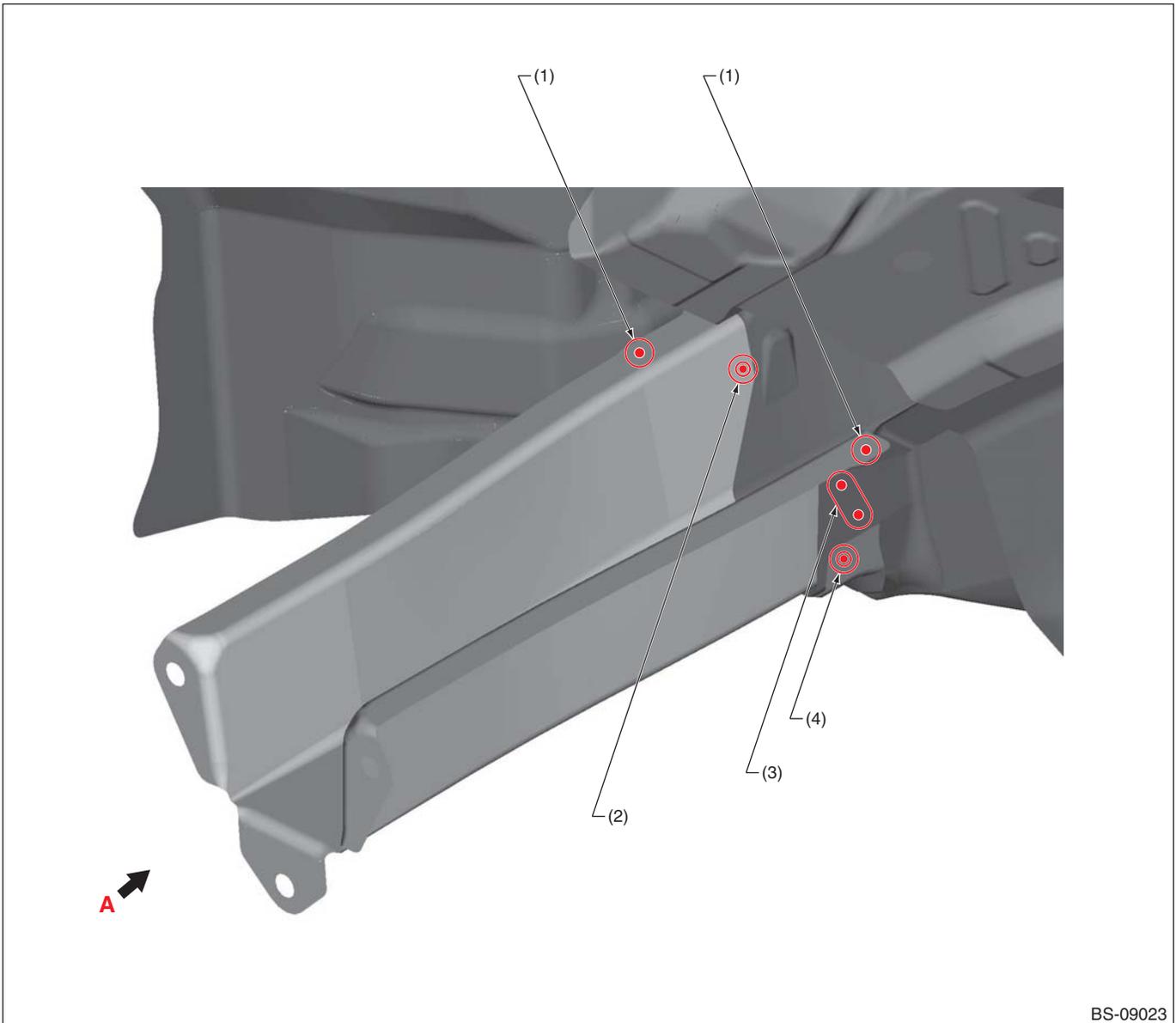
(4) 3 points

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-09023

(1) 1 point (top · 1)

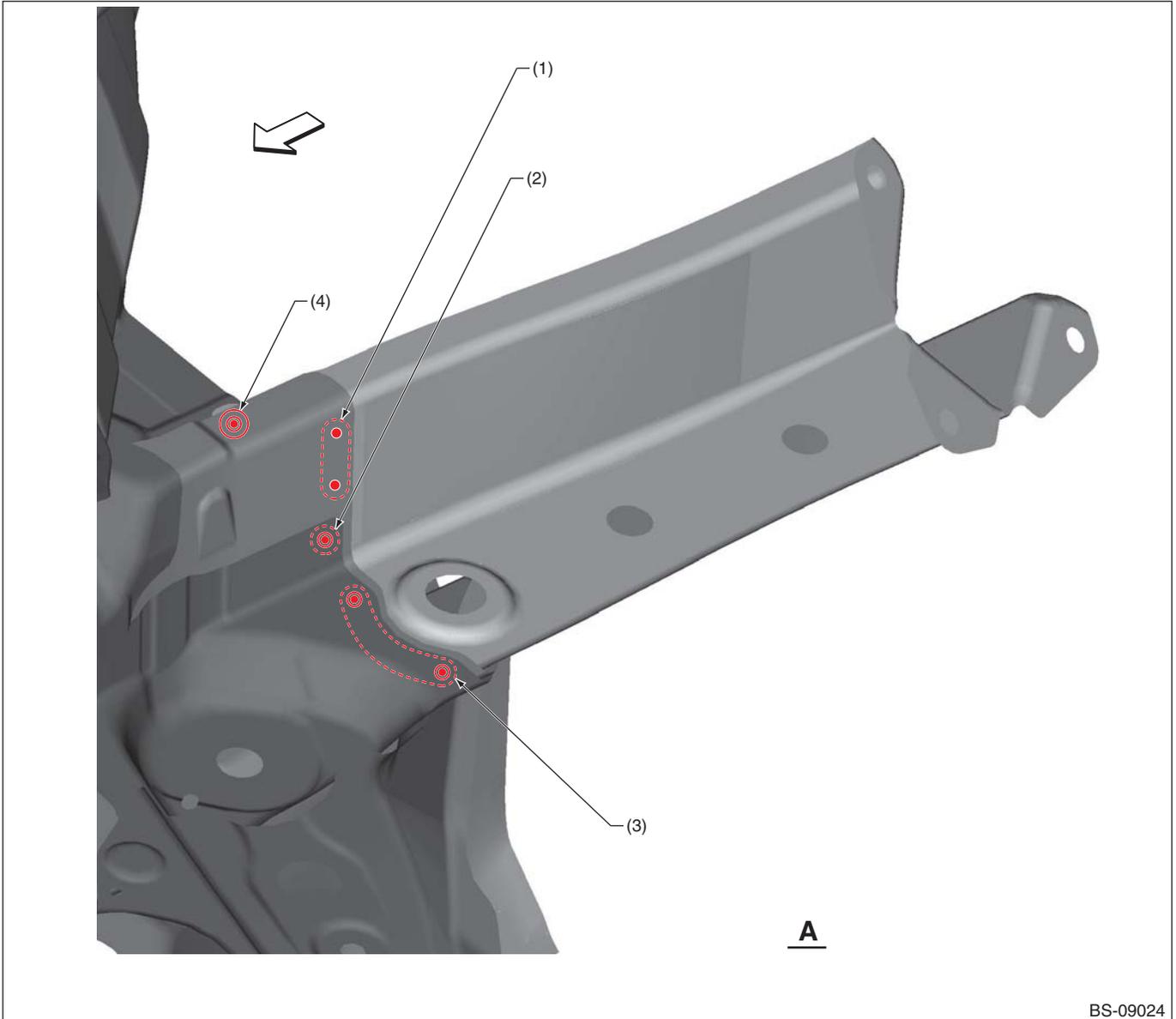
(2) 1 point (inside · 1 belt sander)

(3) 2 points (inside · 1)

(4) 1 point (inside · 2)

# Panel Replacement

## • Views A



BS-09024

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

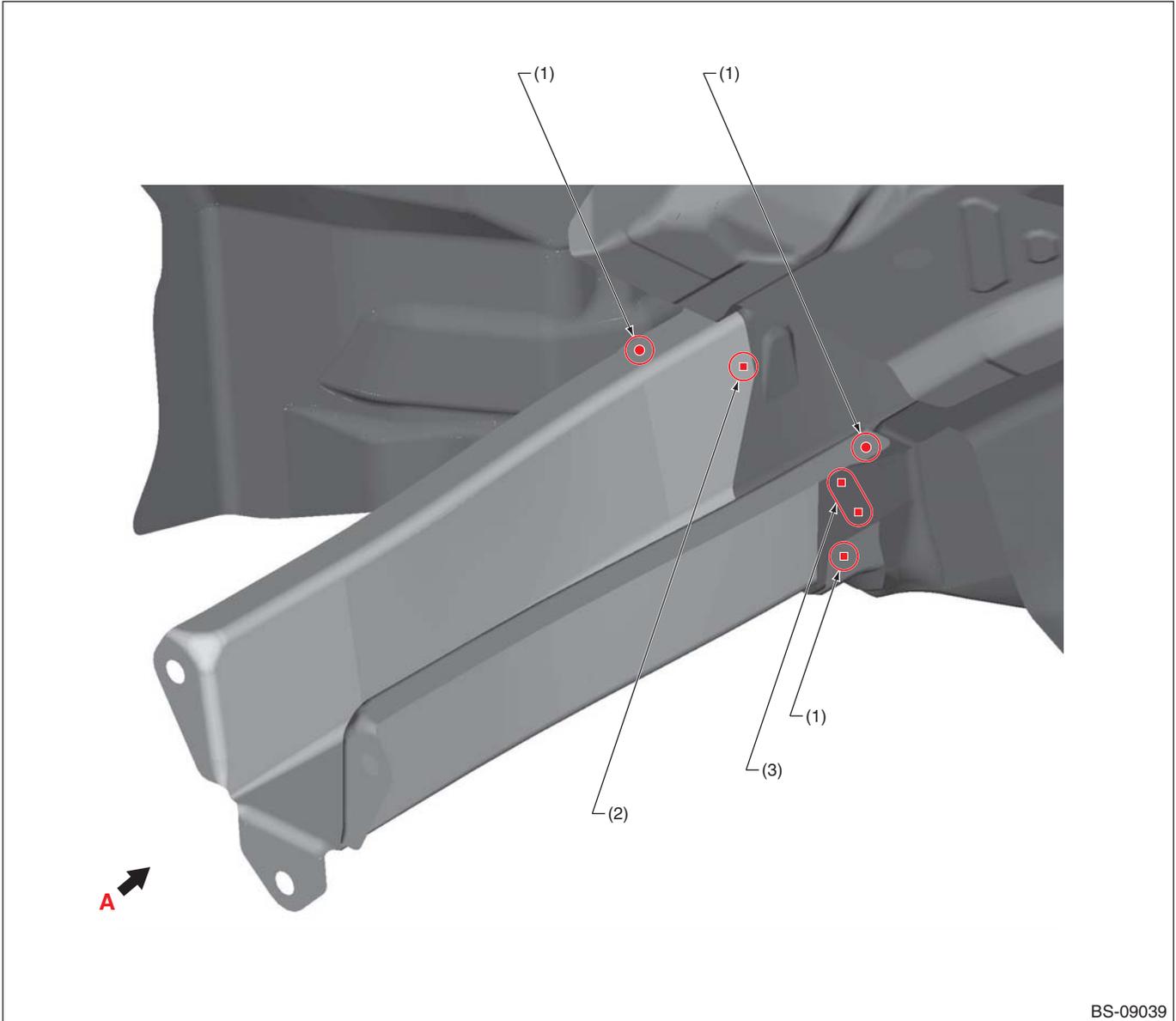
(3) 3 points (top · 1)

(4) 1 point (bottom · 2)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09039

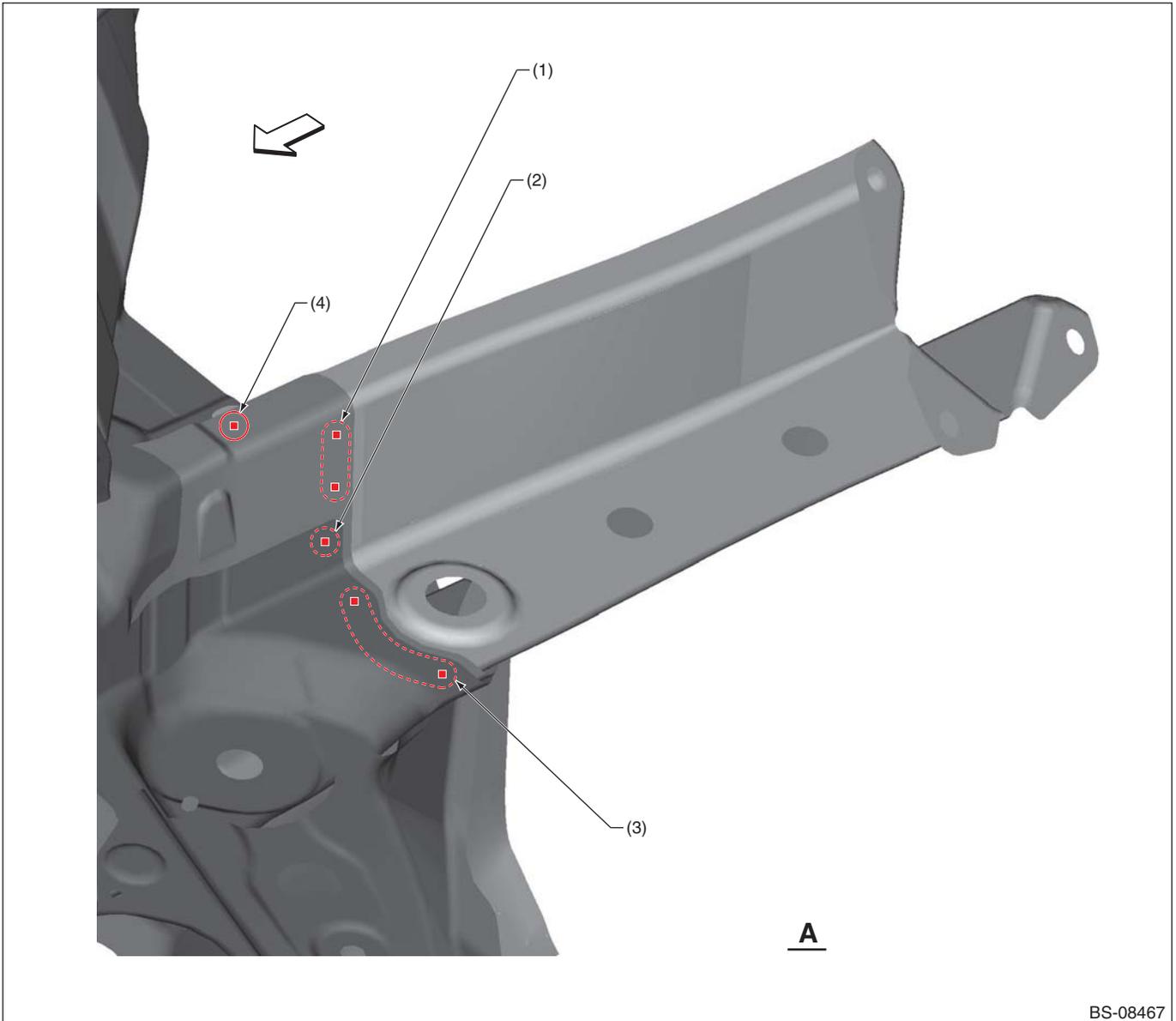
(1) 1 point

(2) 1 point (service)

(3) 2 points

# Panel Replacement

## • Views A



BS-08467

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

(3) 3 points (service)

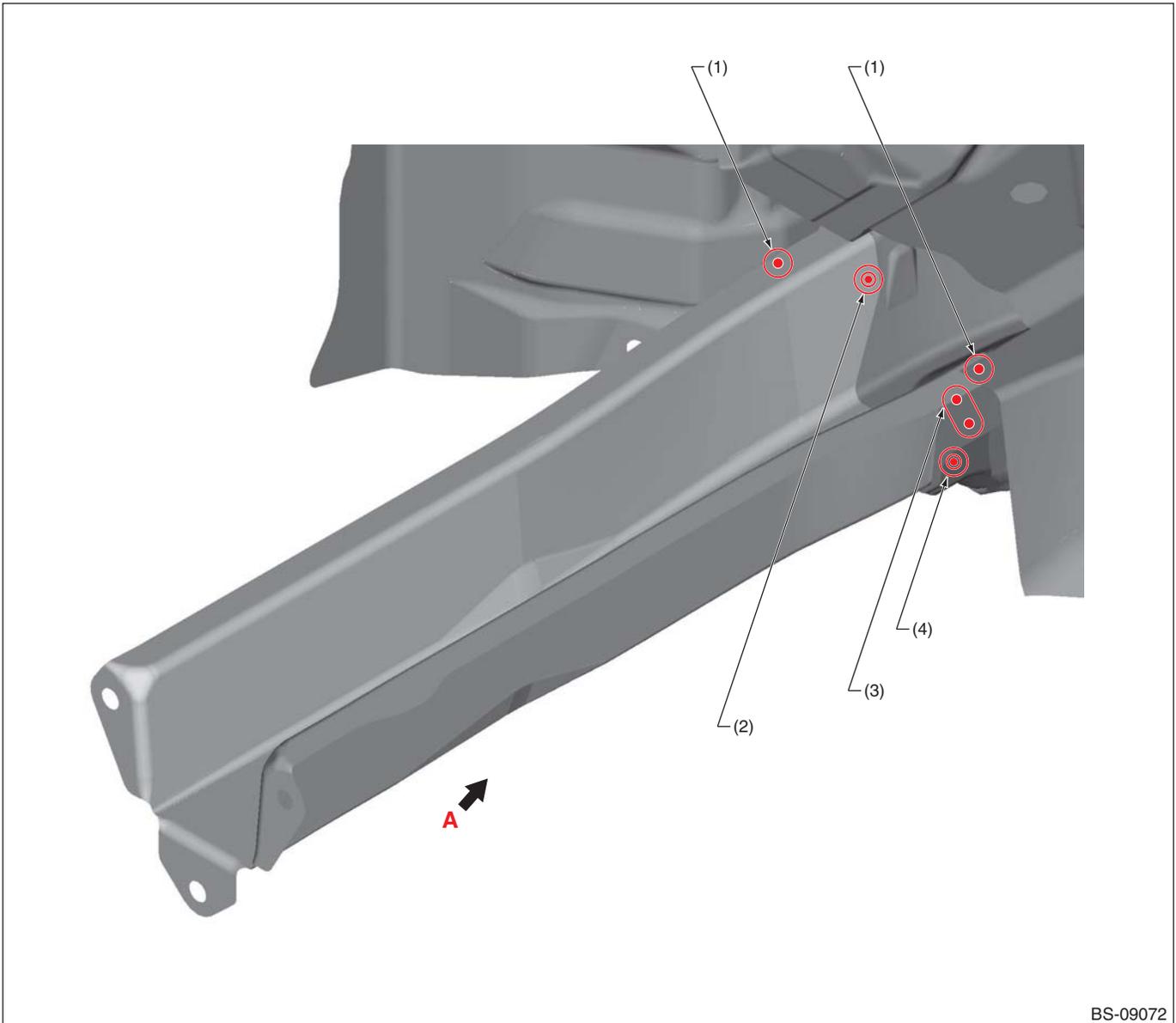
(4) 1 point

# Panel Replacement

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

### A: REMOVAL

#### • Overall view



BS-09072

(1) 1 point (top · 1)

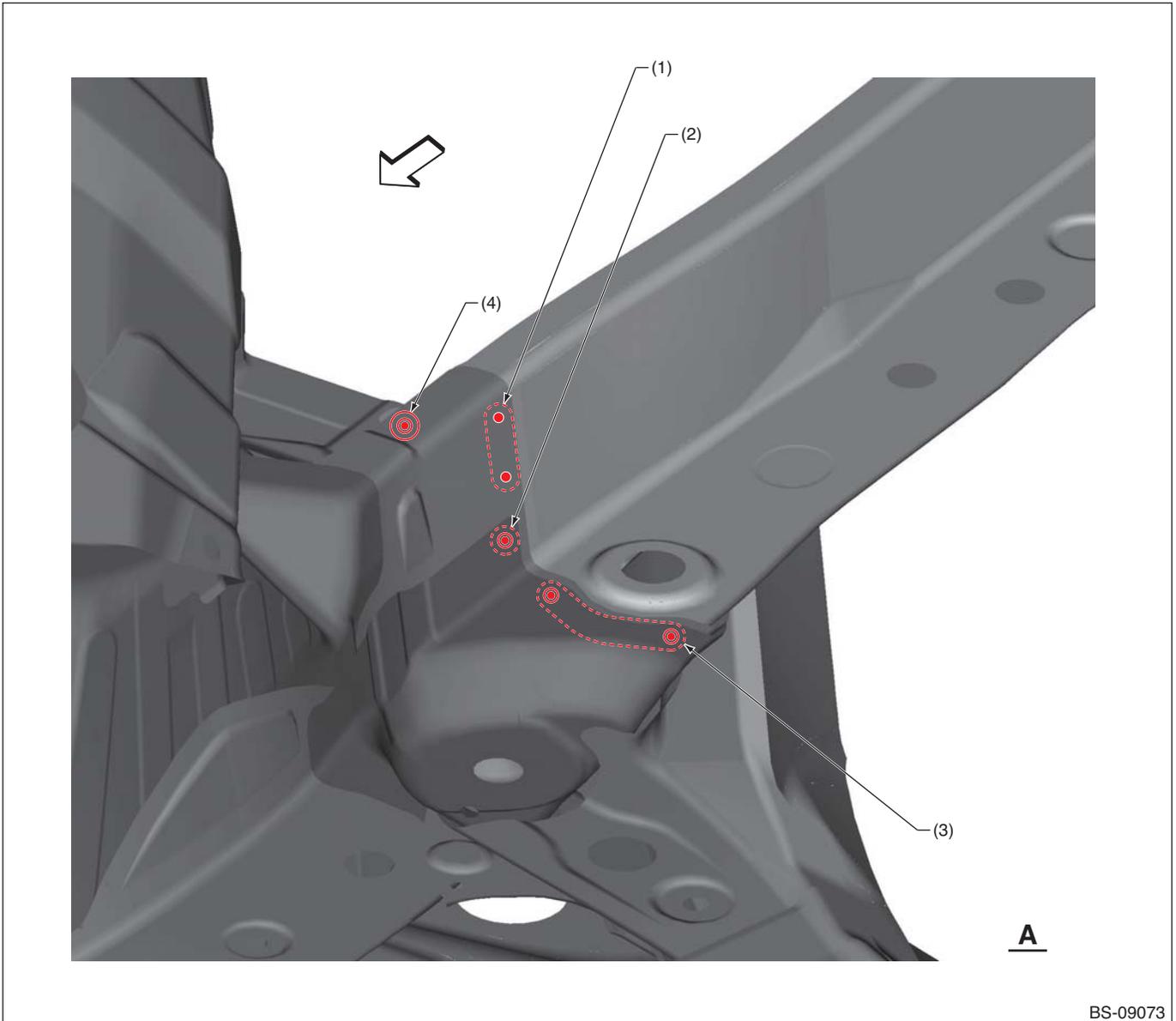
(3) 2 points (inside · 1)

(4) 1 point (inside · 2)

(2) 1 point (inside · 1 belt sander)

# Panel Replacement

## • Views A



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

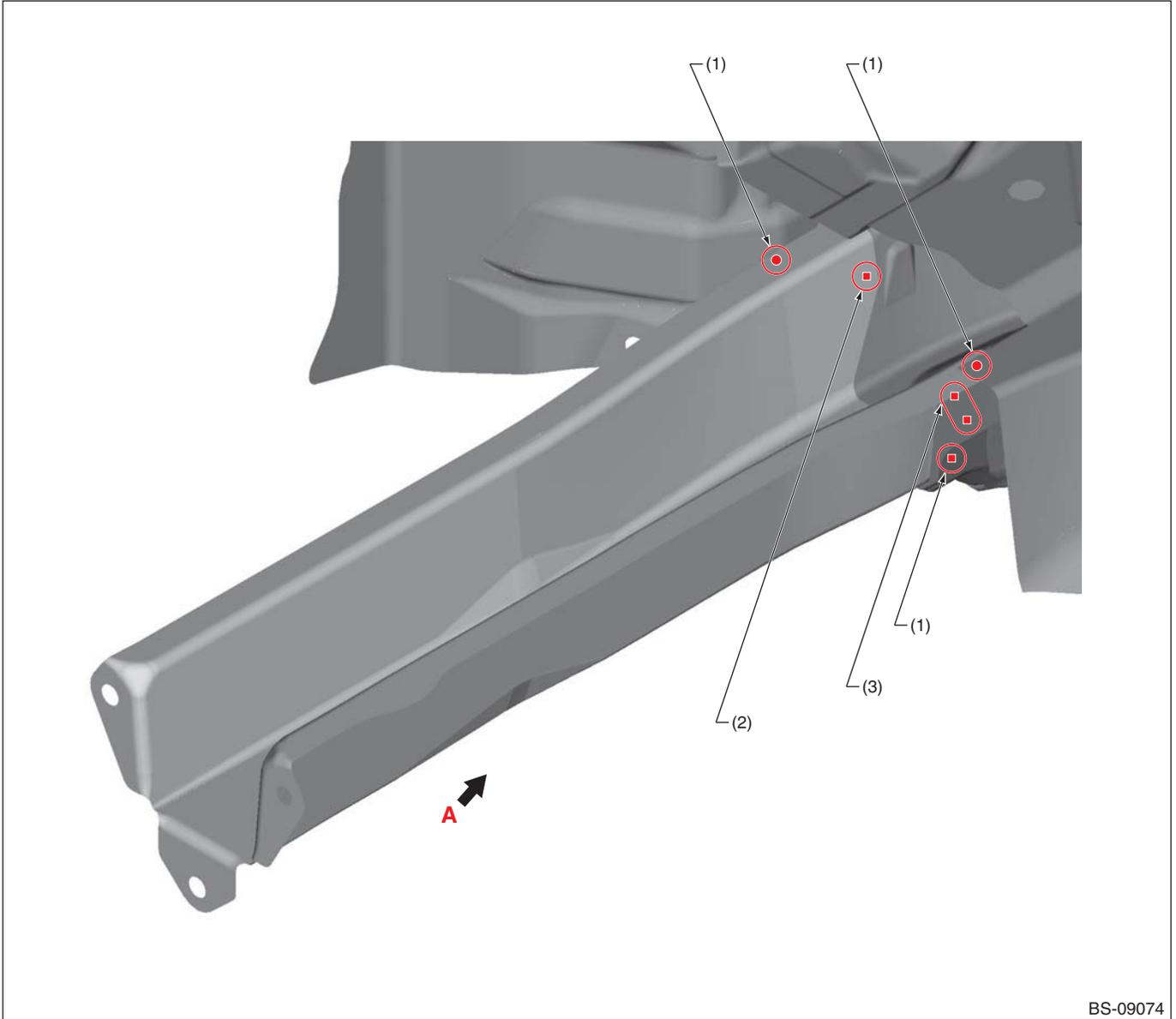
(3) 3 points (top · 1)

(4) 1 point (bottom · 2)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-09074

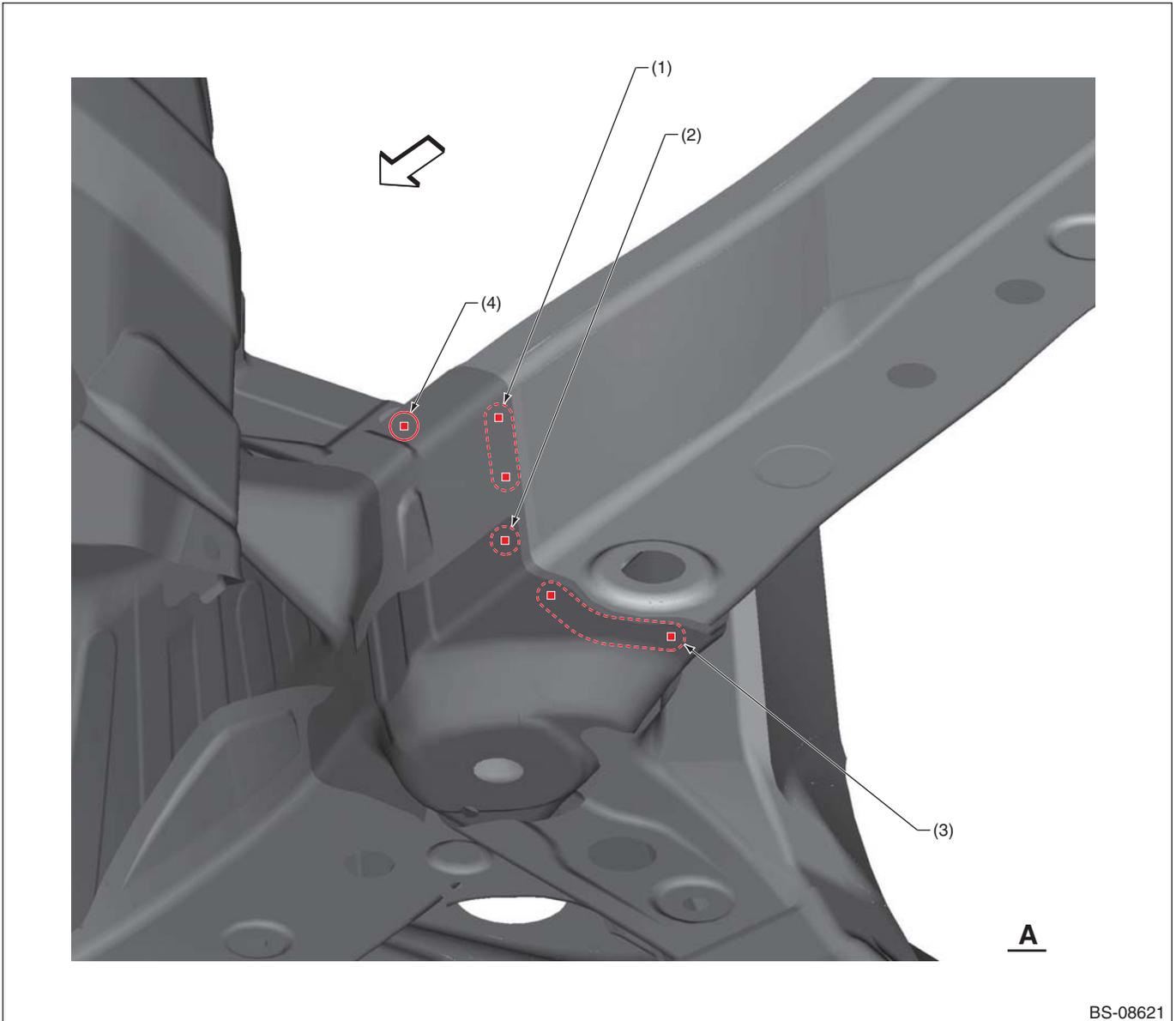
(1) 1 point

(2) 1 point (service)

(3) 2 points

# Panel Replacement

## • Views A



BS-08621

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

(3) 3 points (service)

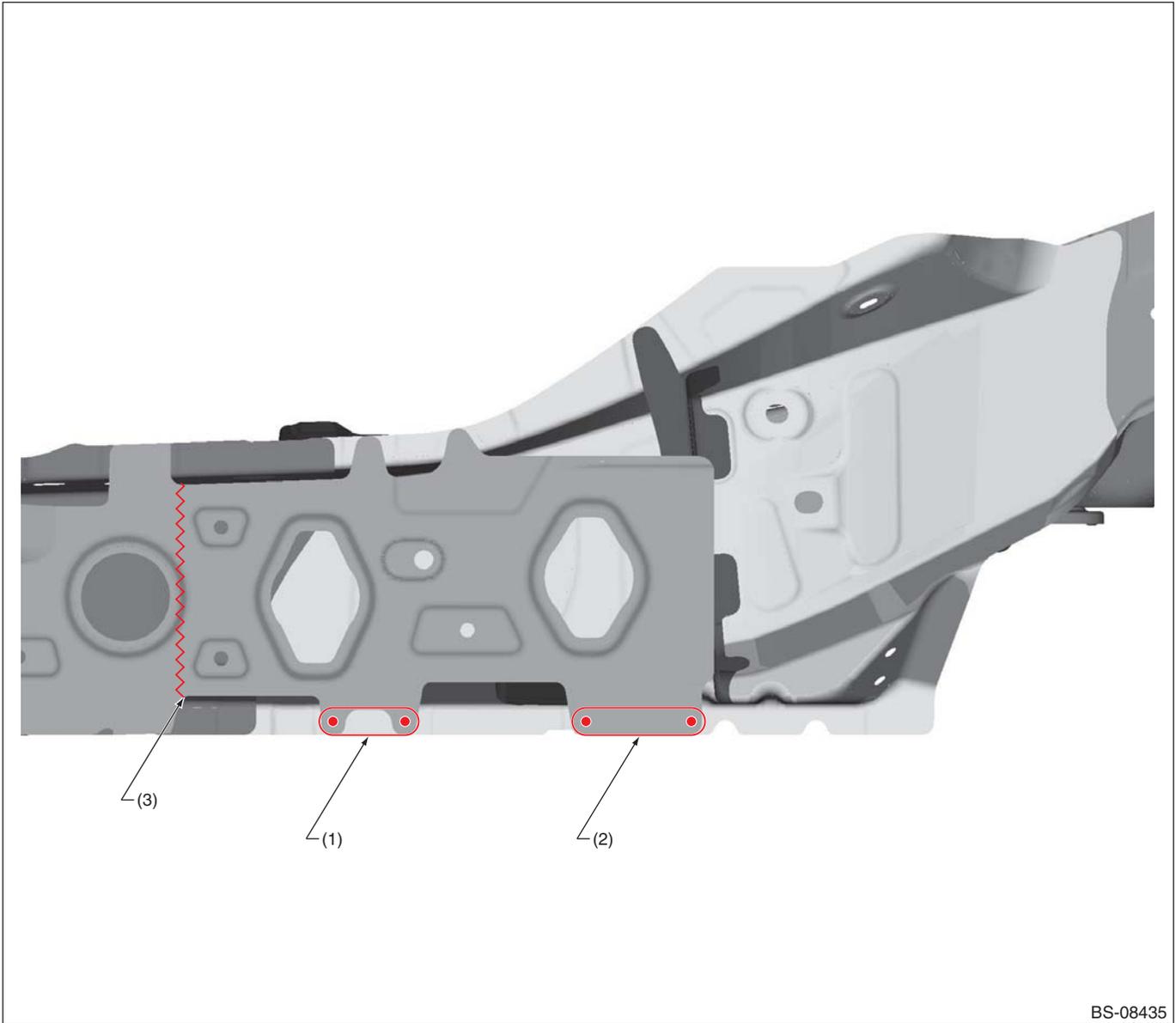
(4) 1 point

# Panel Replacement

## 8-49. Side Sill Inner Rear (total replacement)

### A: REMOVAL

- Overall view1



BS-08435

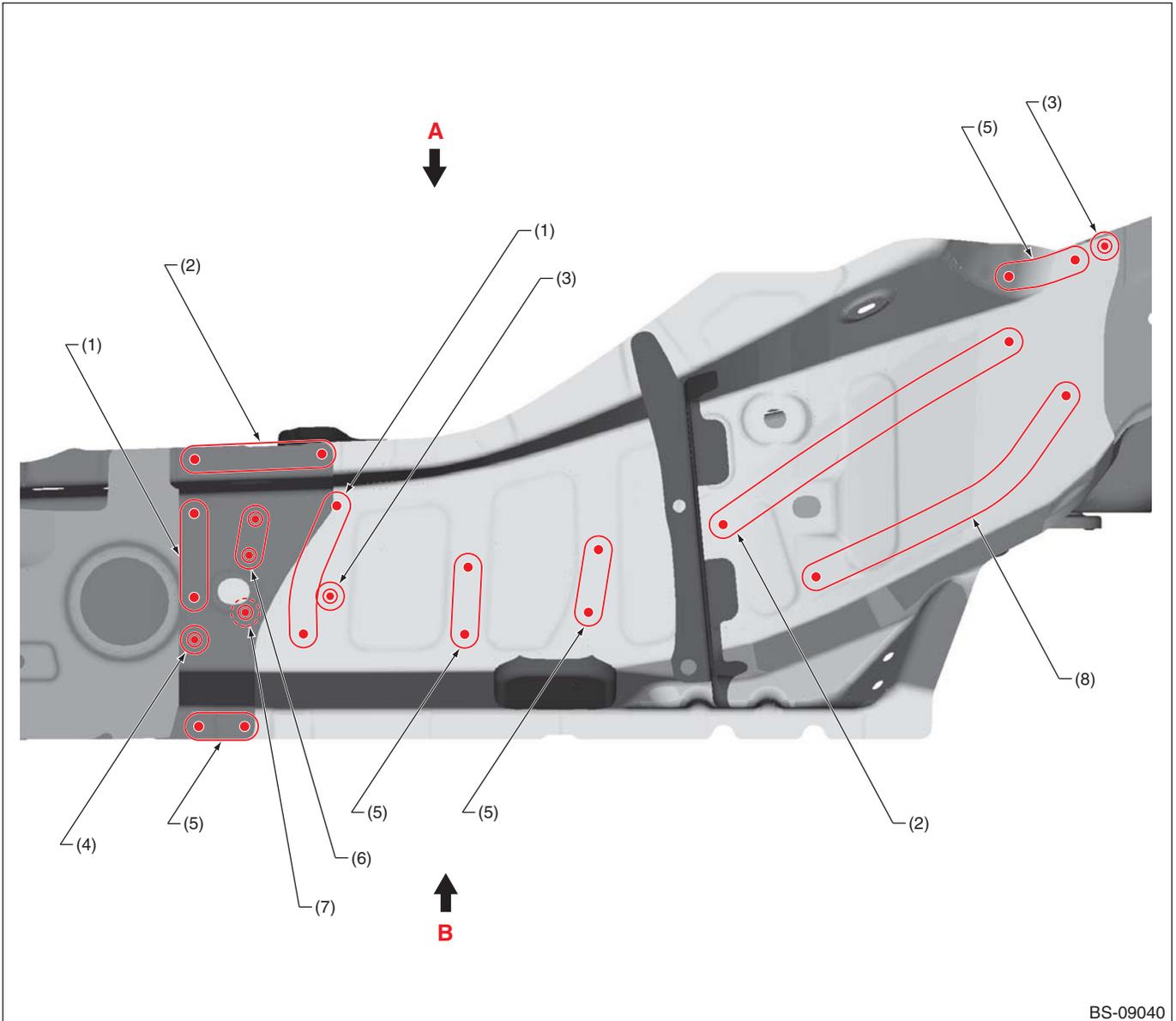
(1) 2 points (outside · 1)

(2) 3 points (outside · 1)

(3) Rough cutting

# Panel Replacement

## • Overall view2



BS-09040

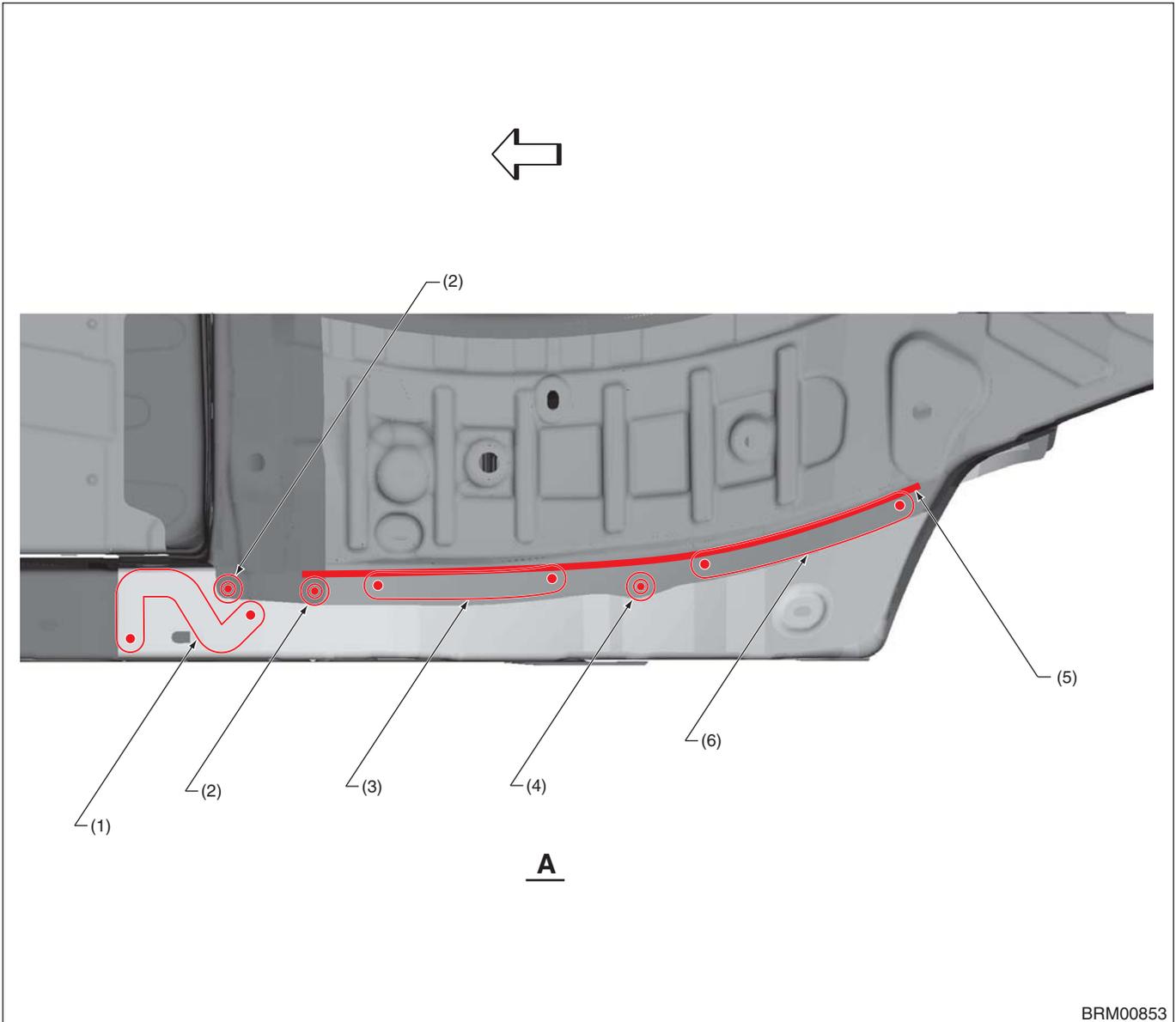
(1) 3 points (outside · 1)  
(2) 4 points (outside · 1)  
(3) 1 point (outside · 1)

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

(7) 1 point (inside · 2)  
(8) 4 points (outside · 1)

# Panel Replacement

## • Views A



(1) 5 points (top · 1)

(2) 1 point (top · 2)

(3) 4 points (top · 1)

(4) 1 point (bottom · 2)

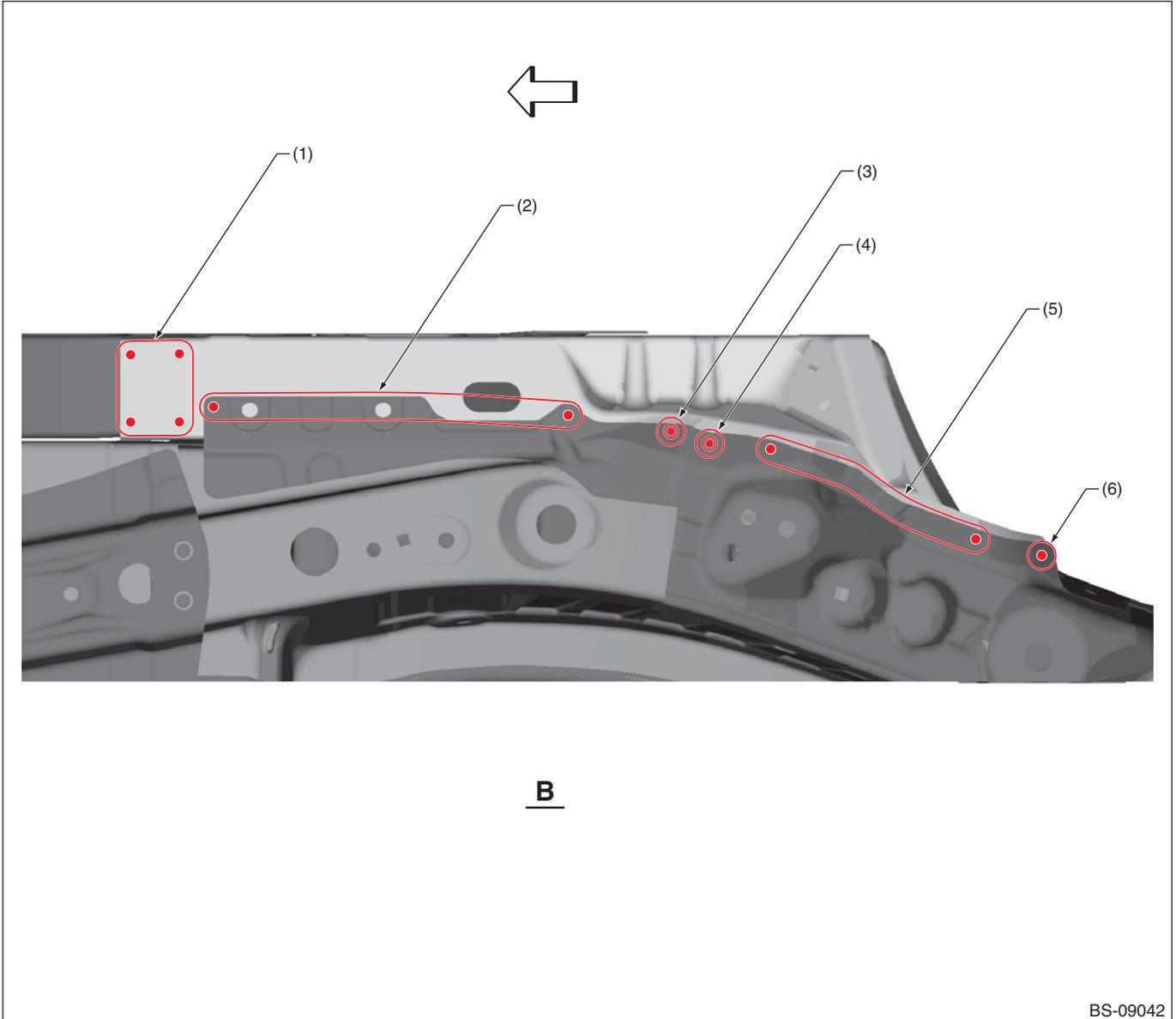
(5) Structural adhesive

(6) 4 points (bottom · 1)

— : Structural adhesive application location

# Panel Replacement

## • Views B



BS-09042

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

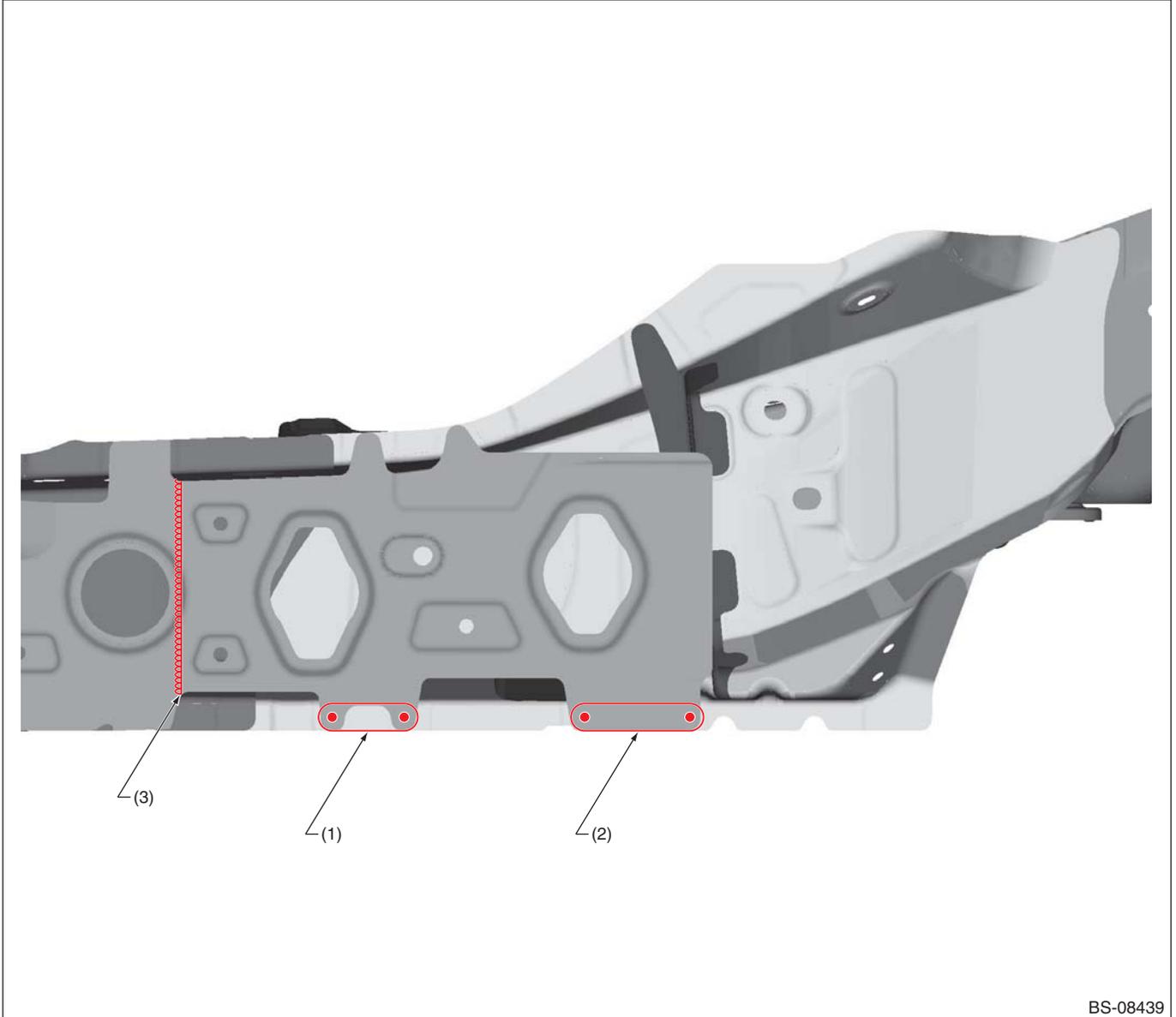
(3) 1 point (top · 2)  
(4) 1 point (top · 1)

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

# Panel Replacement

## B: INSTALLATION

### • Overall view1



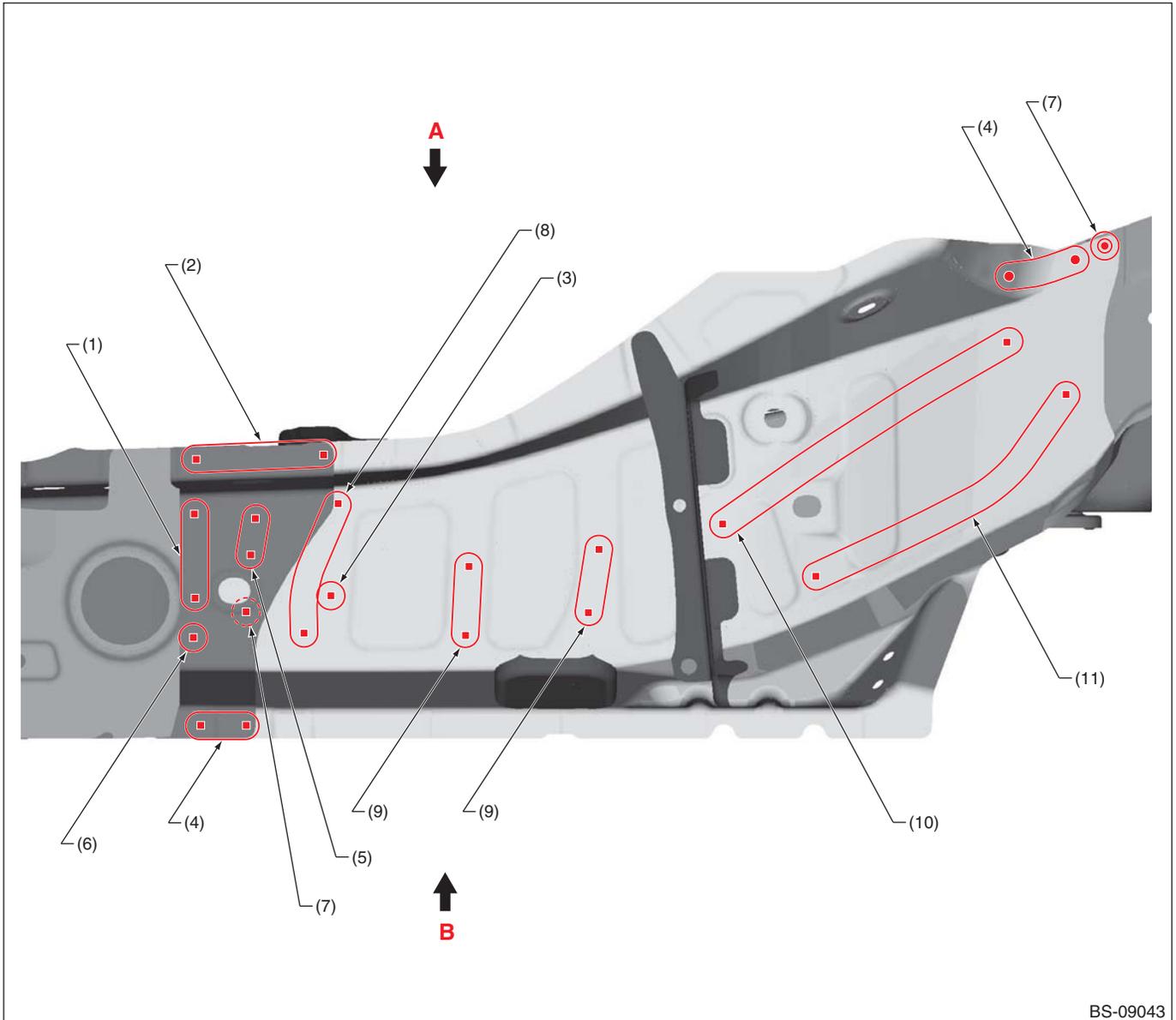
(1) 2 points

(2) 3 points

(3) 1 point (Continuous welding)

# Panel Replacement

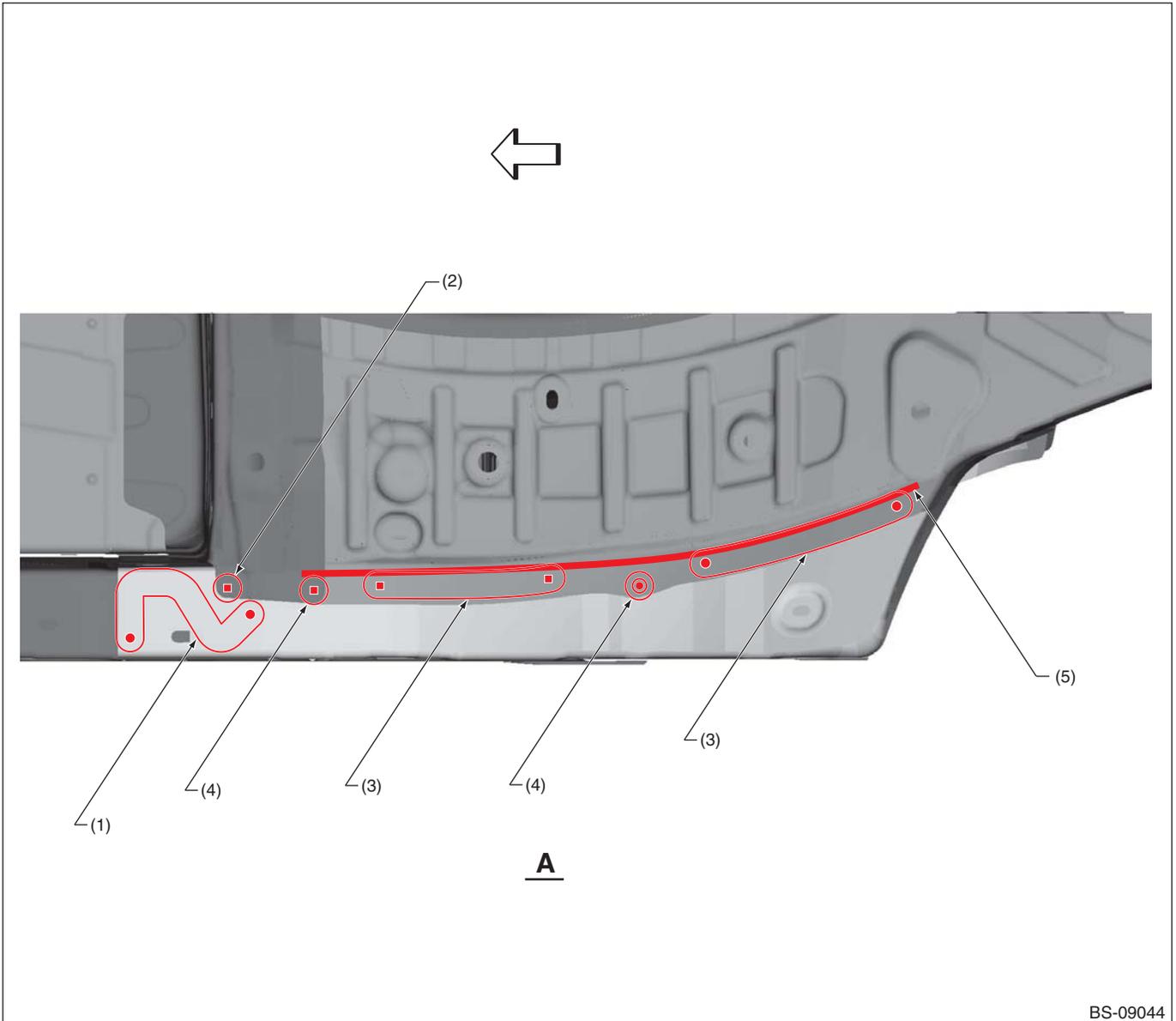
## • Overall view2



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

# Panel Replacement

## • Views A



(1) 5 points

(3) 4 points

(5) Structural adhesive

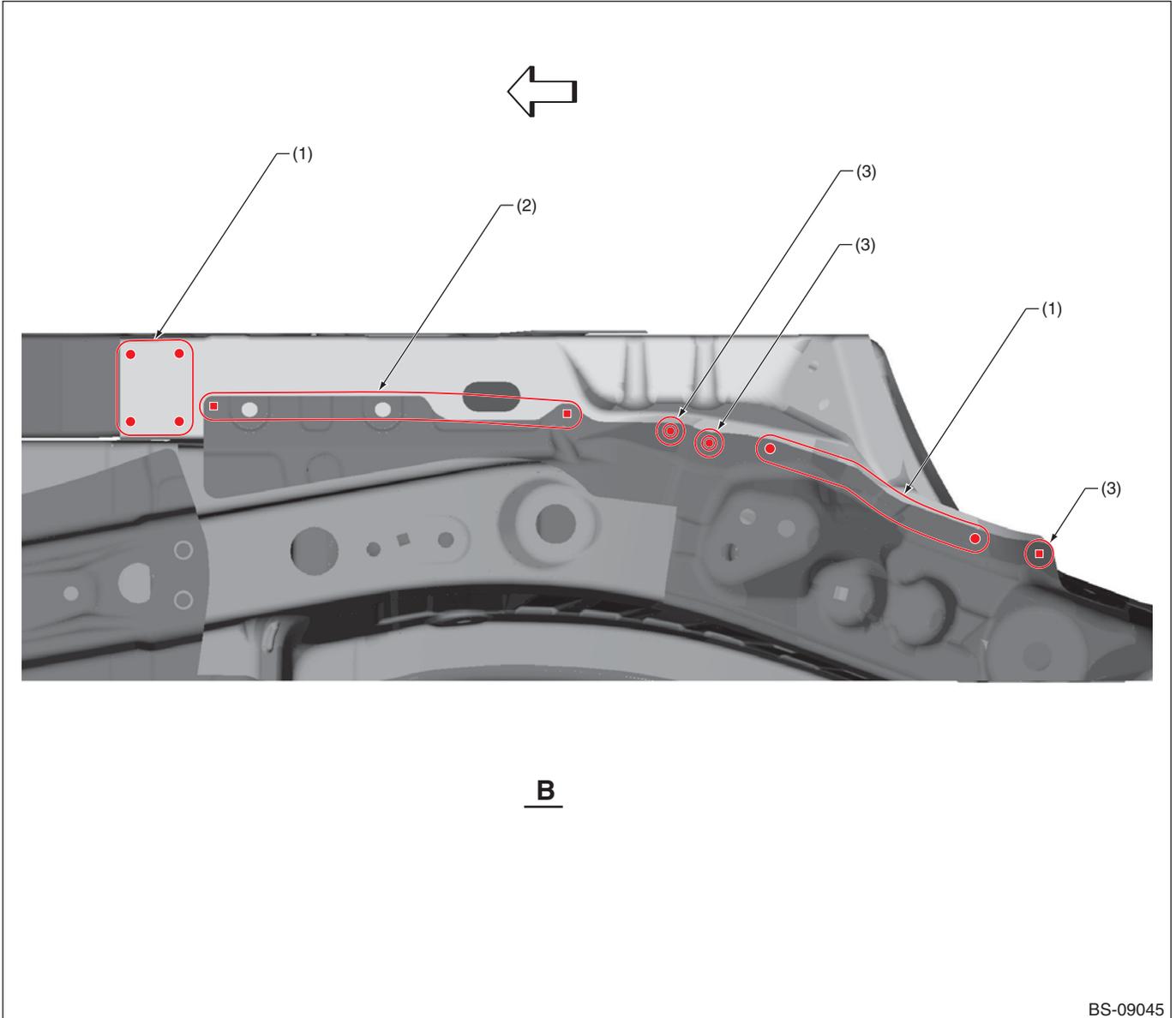
(2) 1 point (service - matching)

(4) 1 point

— : Structural adhesive application location

# Panel Replacement

## • Views B



(1) 4 points

(2) 5 points

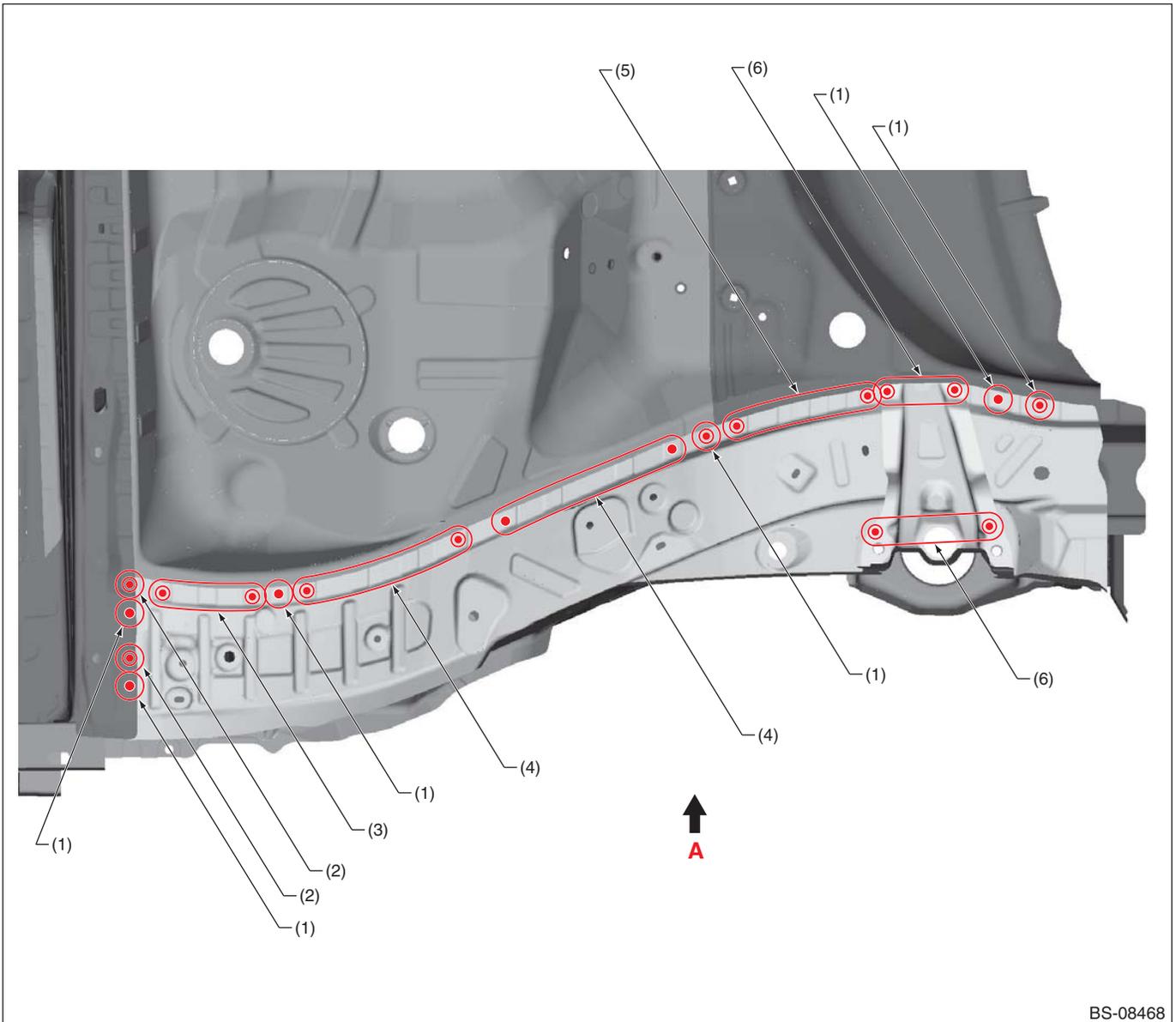
(3) 1 point

# Panel Replacement

## 8-50. Rear Side Frame Upper (total replacement)

### A: REMOVAL

#### • Overall view



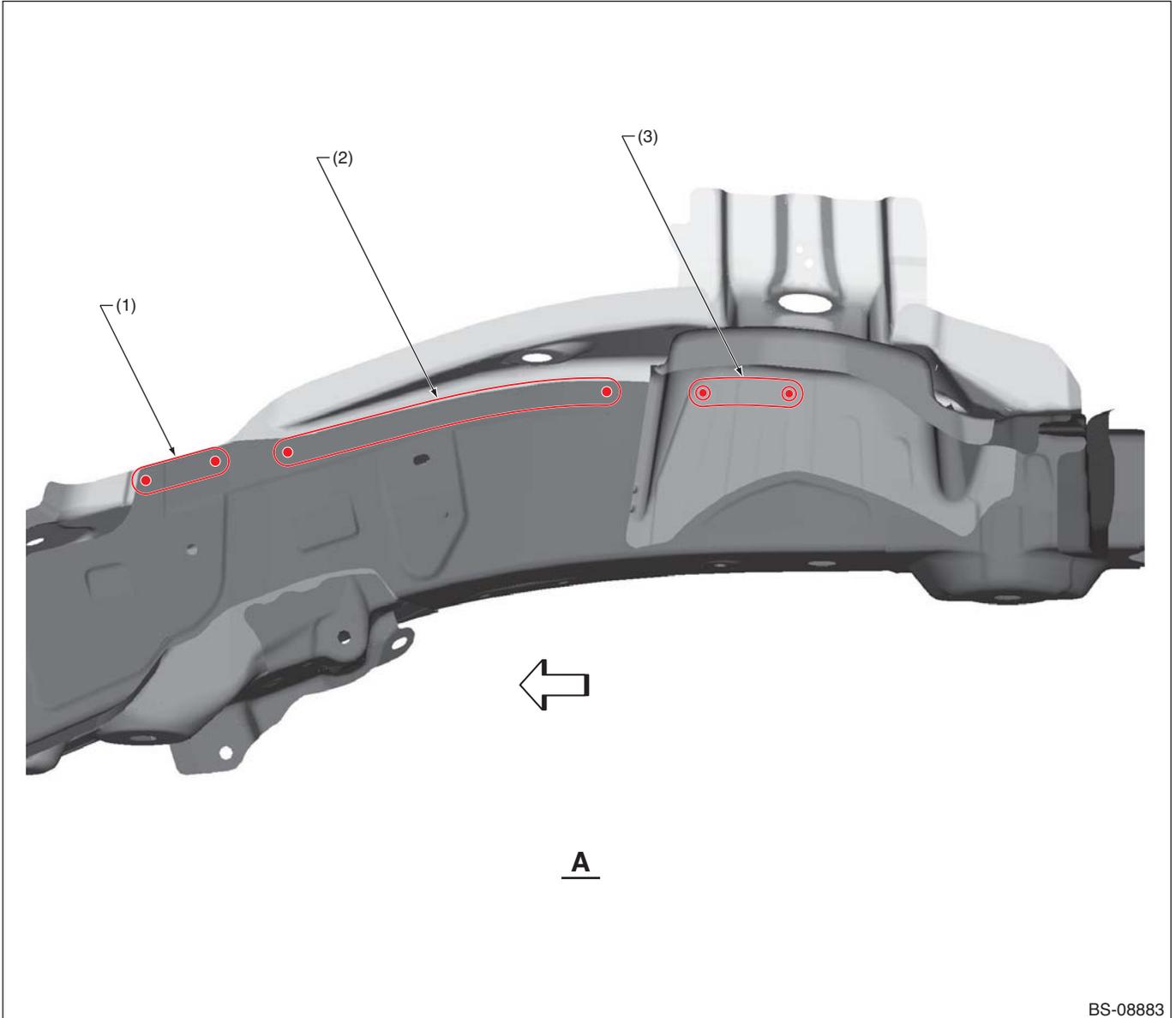
(1) 1 point (top · 1)  
(2) 1 point (top · 2)

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

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

# Panel Replacement

## • Views A



BS-08883

(1) 3 points (inside · 1)

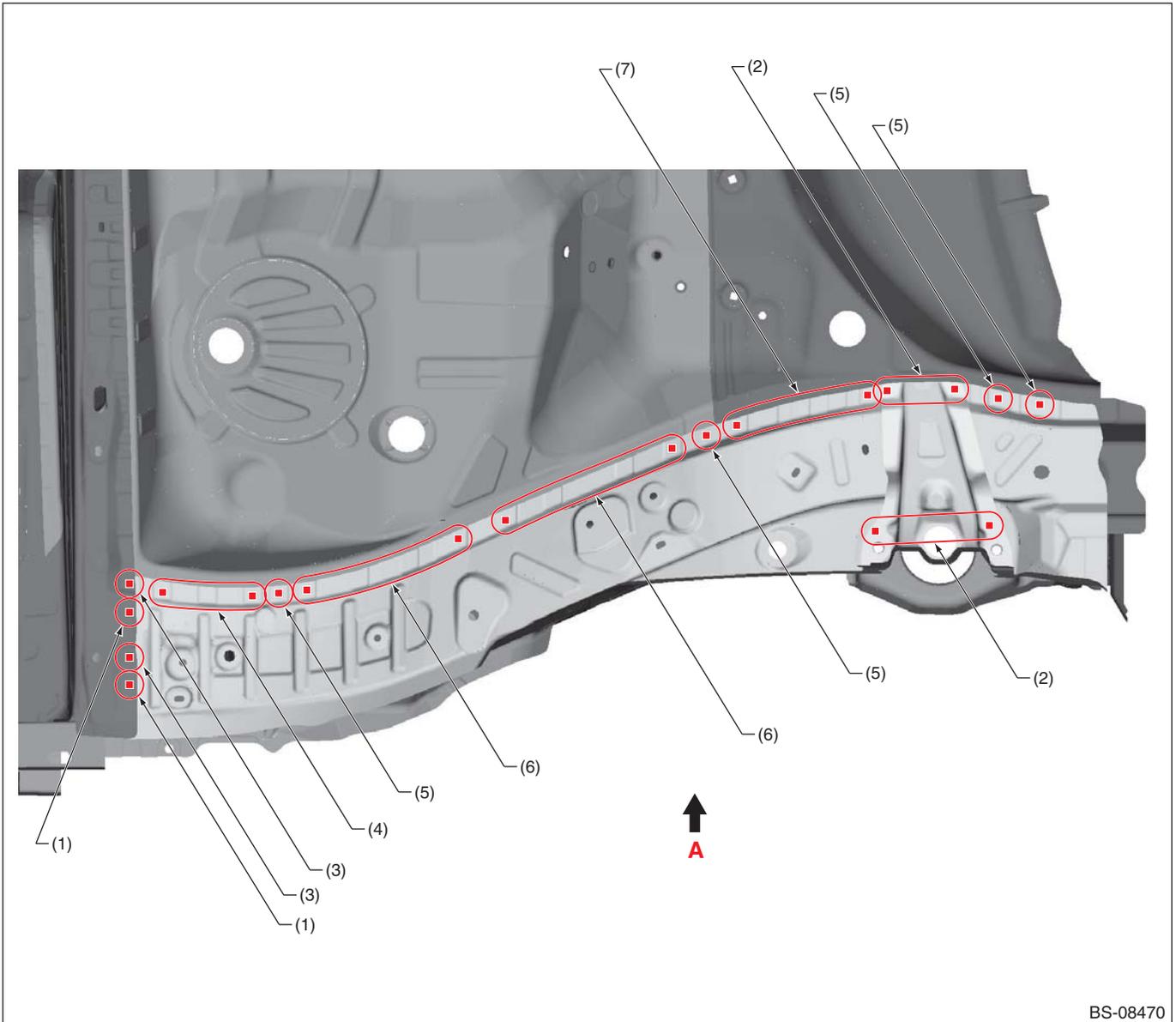
(2) 6 points (outside · 1)

(3) 2 points (outside · 2)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-08470

(1) 1 point

(2) 2 points (service)

(3) 1 point (service - matching)

(4) 3 points (service)

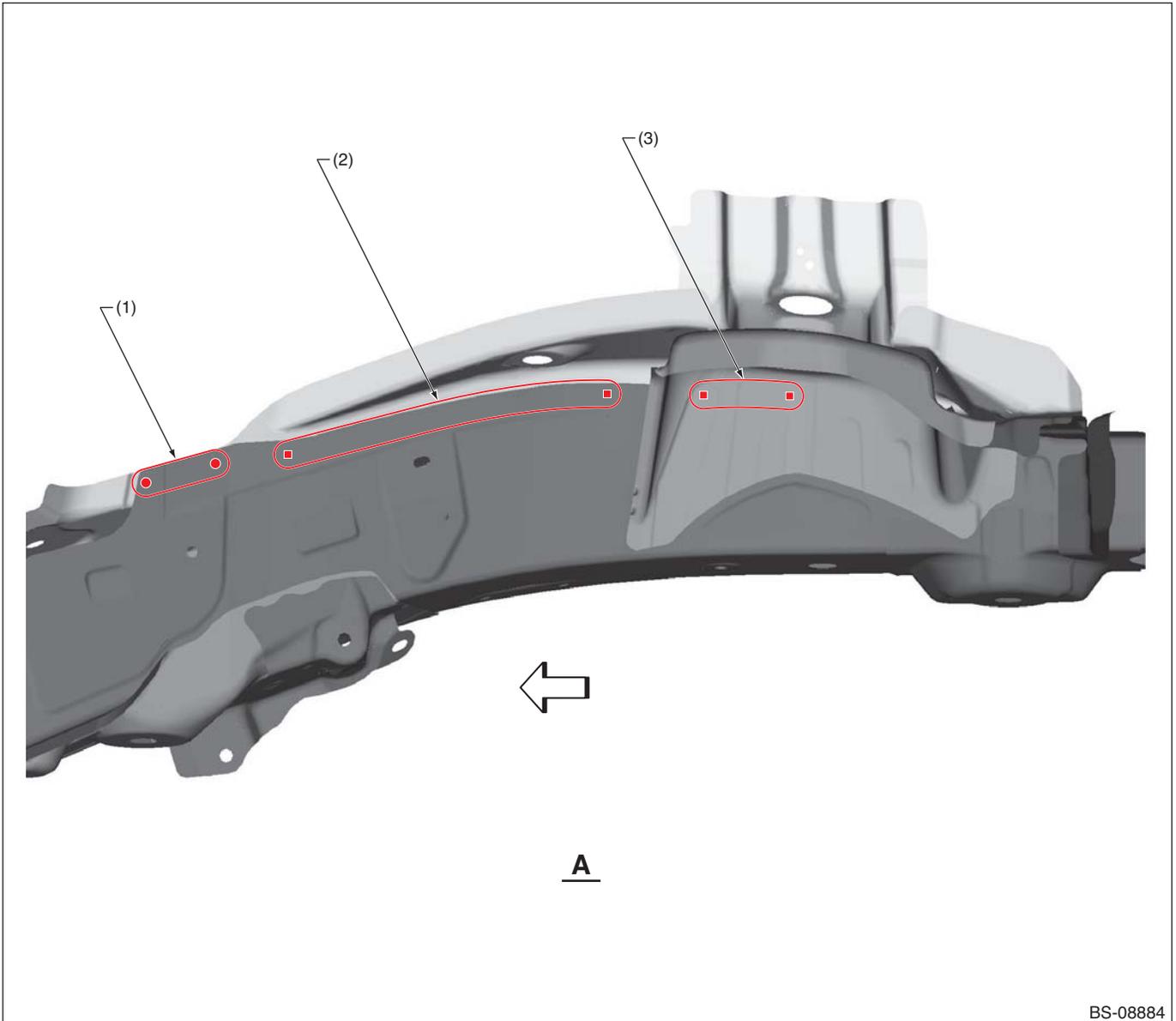
(5) 1 point (service)

(6) 4 points (service)

(7) 5 points (service)

# Panel Replacement

## • Views A



BS-08884

(1) 3 points

(2) 6 points

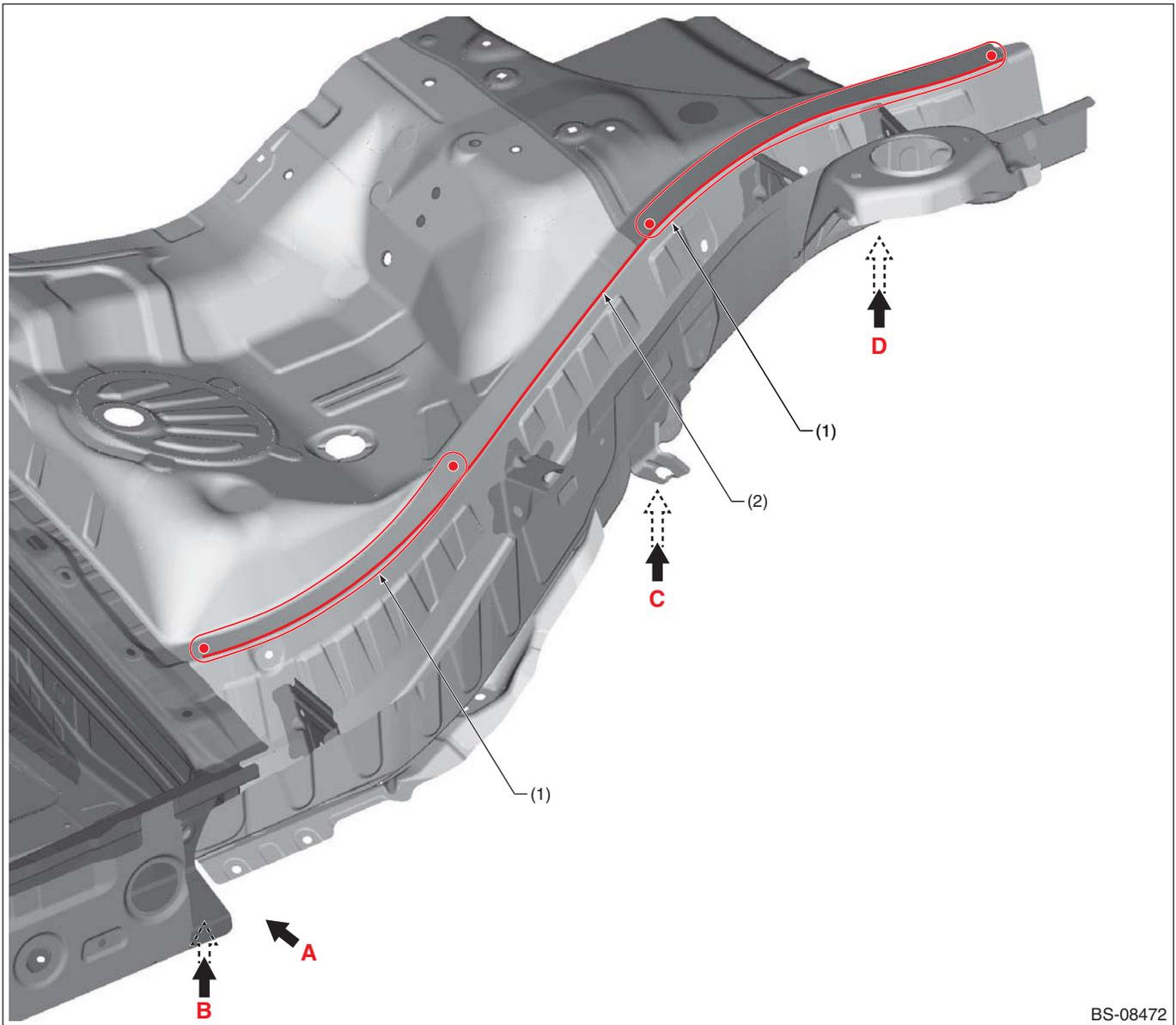
(3) 2 points

# Panel Replacement

## 8-51. Rear Side Frame

### A: REMOVAL

- Overall view



BS-08472

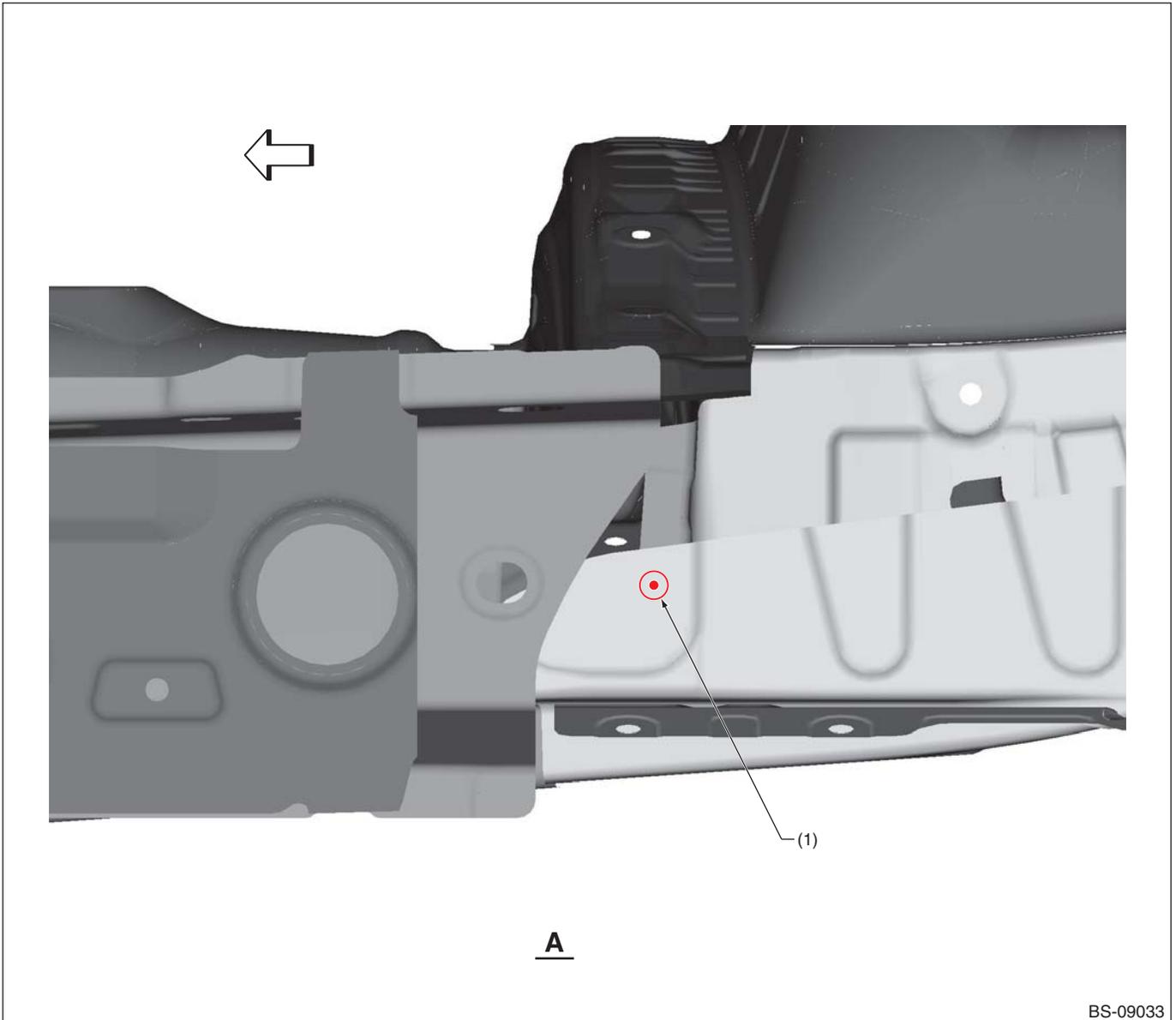
(1) 7 points (top · 1)

(2) Structural adhesive

— : Structural adhesive application location

# Panel Replacement

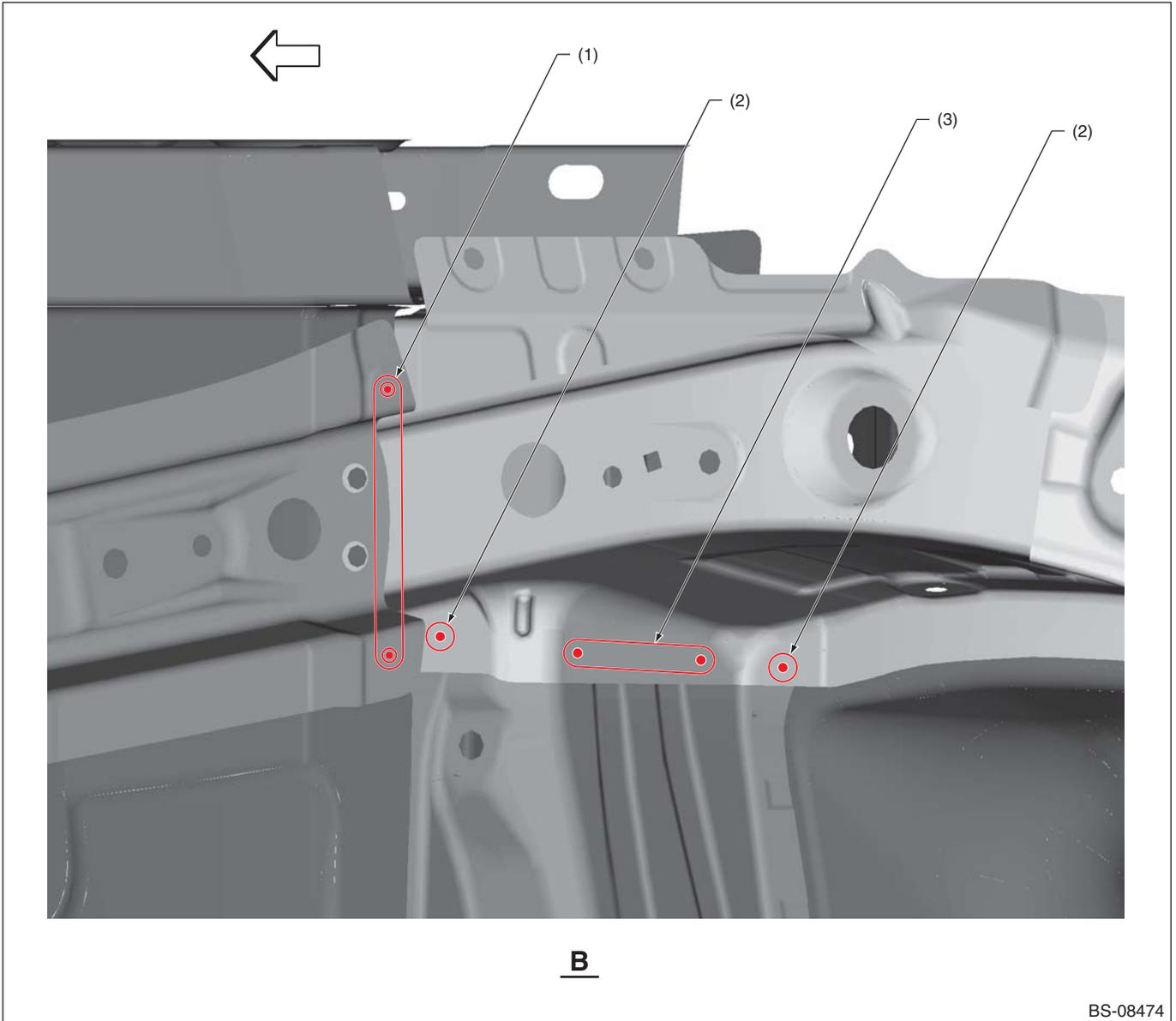
## • Views A



(1) 1 point (outside - 1)

# Panel Replacement

## • Views B



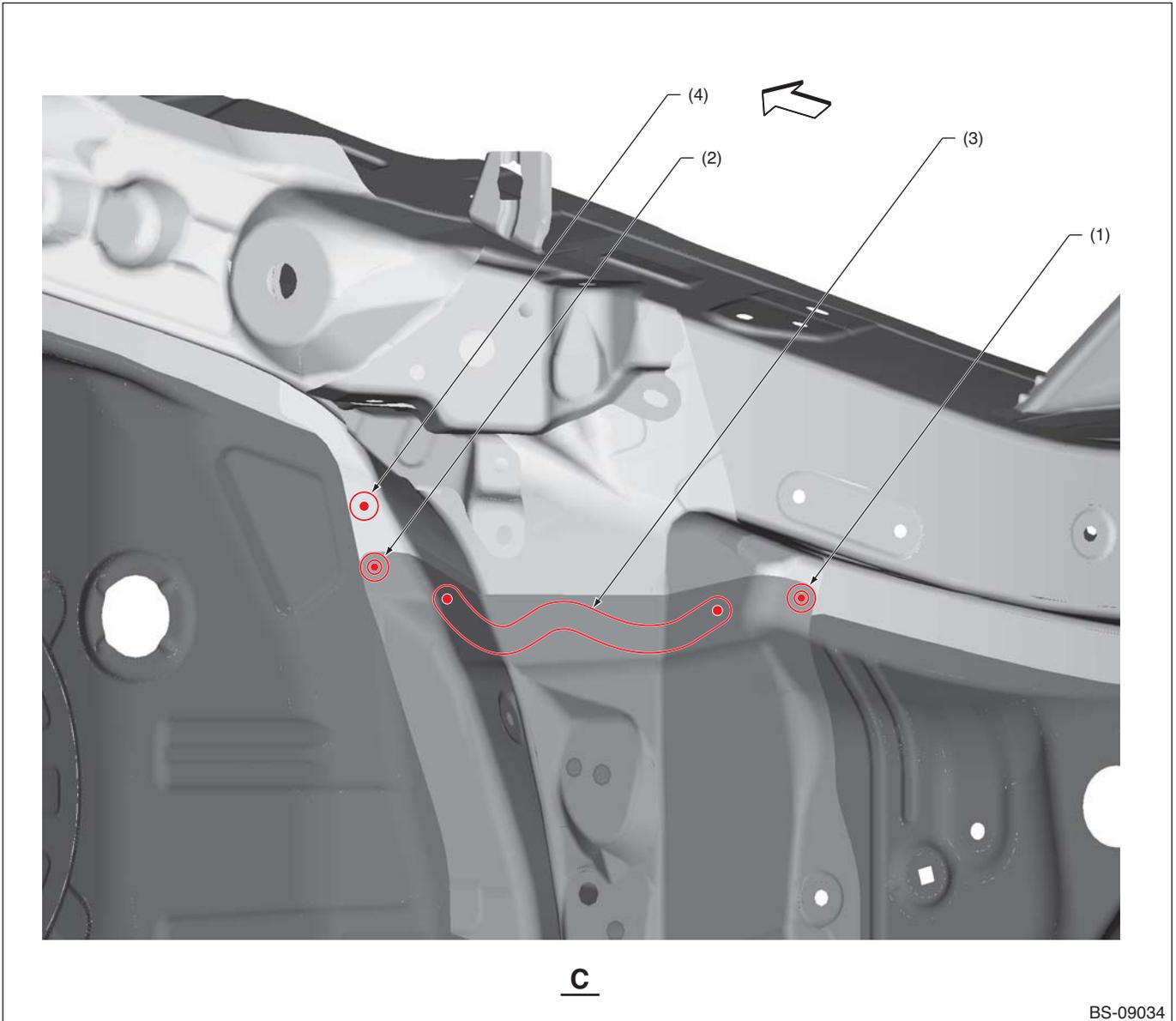
(1) 2 points (bottom · 2)

(2) 1 point (bottom · 1)

(3) 3 points (outside · 1)

# Panel Replacement

## • Views C



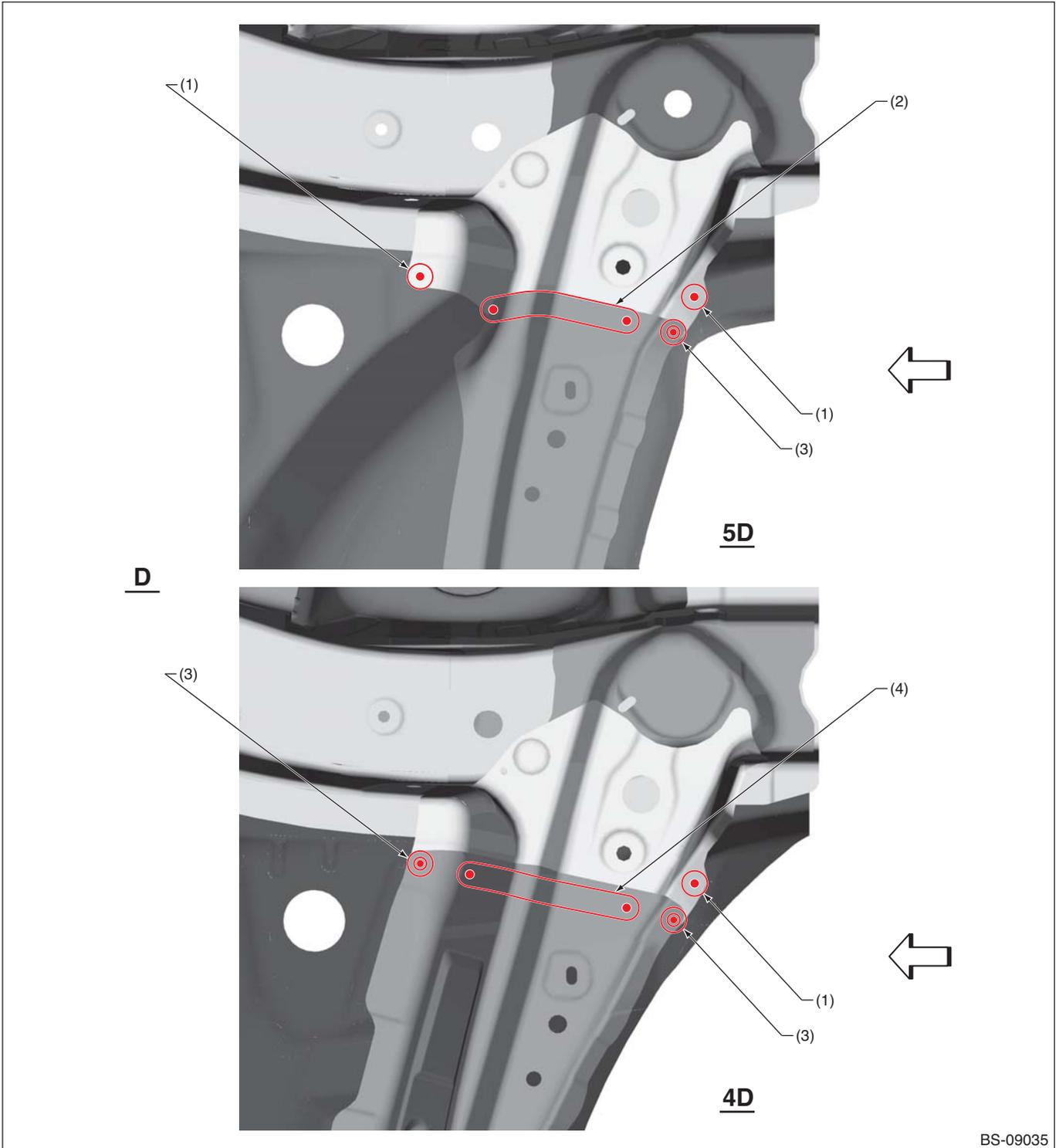
(1) 1 point (bottom · 1)  
(2) 1 point (top · 2)

(3) 7 points (bottom · 1)

(4) 1 point (top · 1)

# Panel Replacement

## • Views D (Gasoline model)



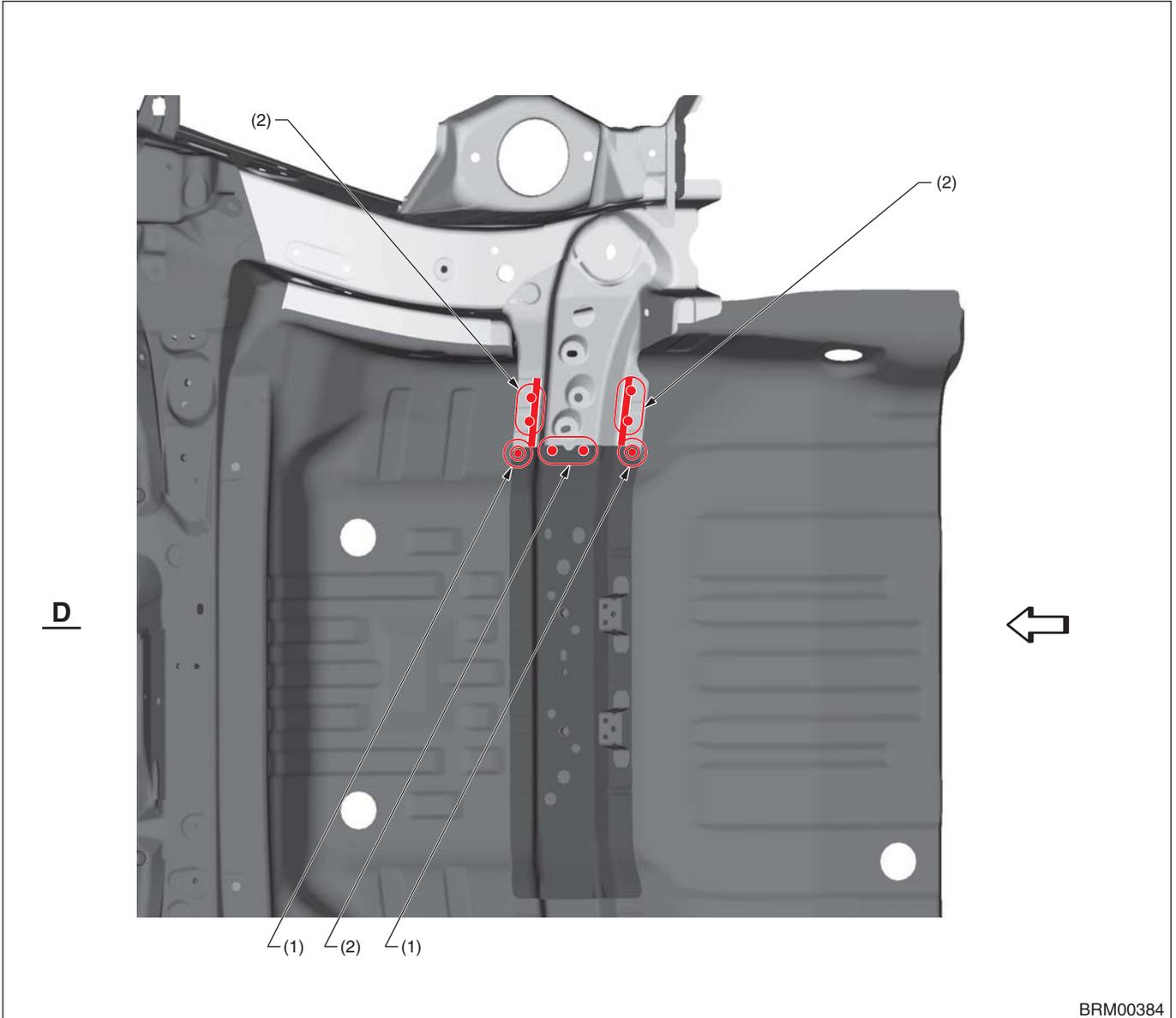
- (1) 1 point (top · 1)
- (2) 4 points (bottom · 1)

- (3) 1 point (top · 1, bottom · 1)

- (4) 5 points (bottom · 1)

# Panel Replacement

## • Views D (Hybrid model)



BRM00384

(1) 1 point (bottom · 2)

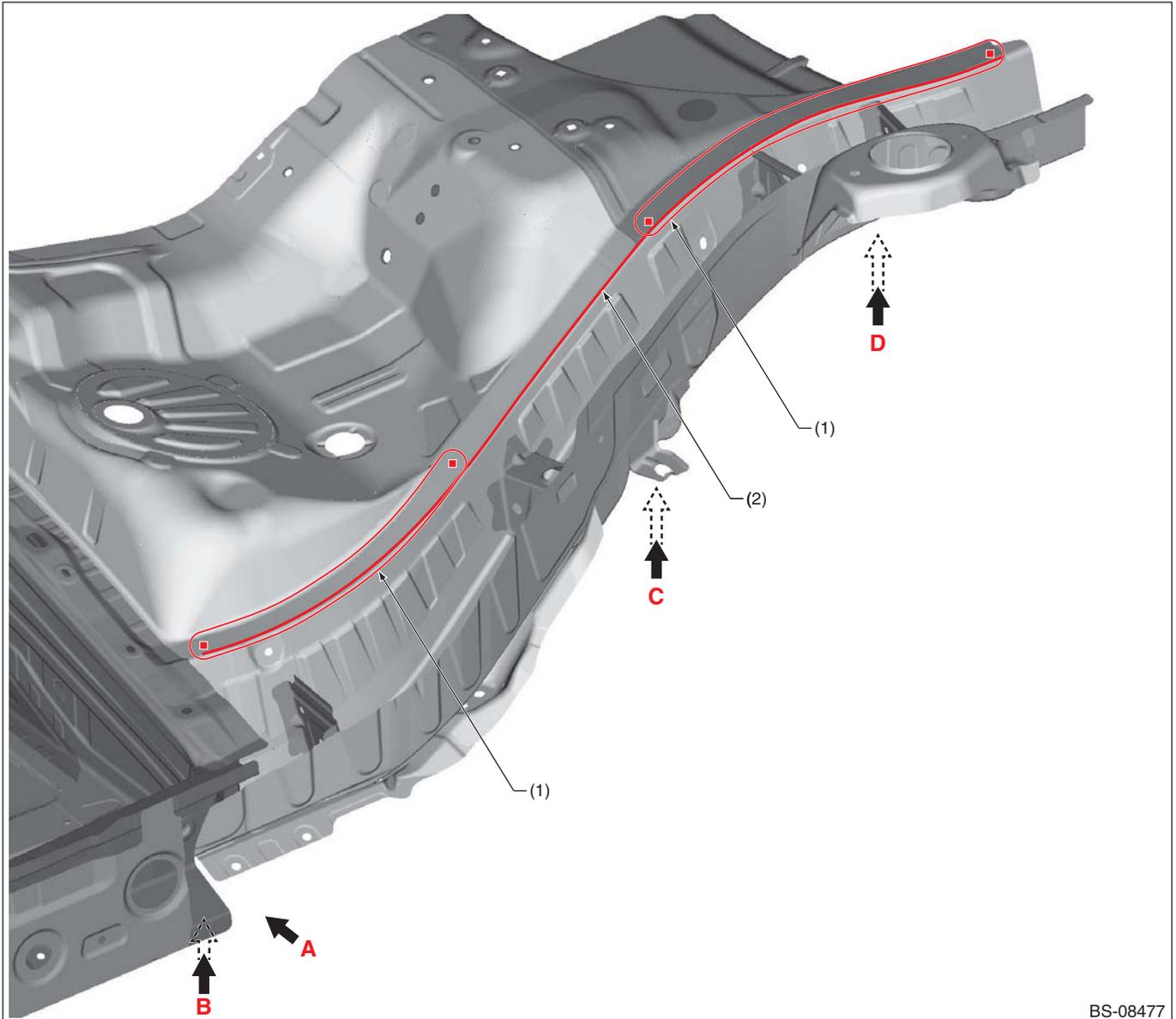
(2) 2 points (bottom · 1)

— : Structural adhesive application location

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-08477

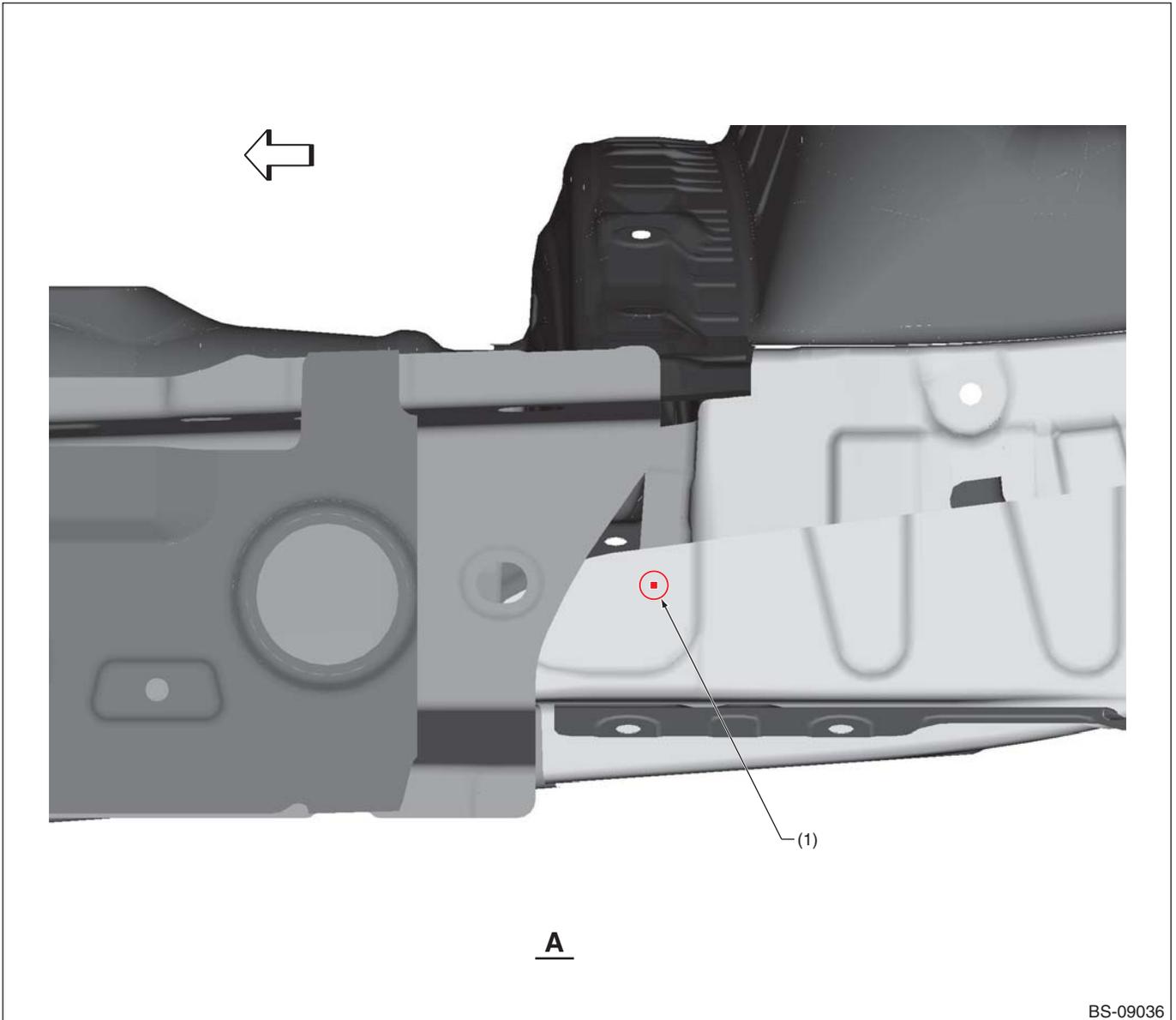
(1) 7 points

(2) Structural adhesive

— : Structural adhesive application location

# Panel Replacement

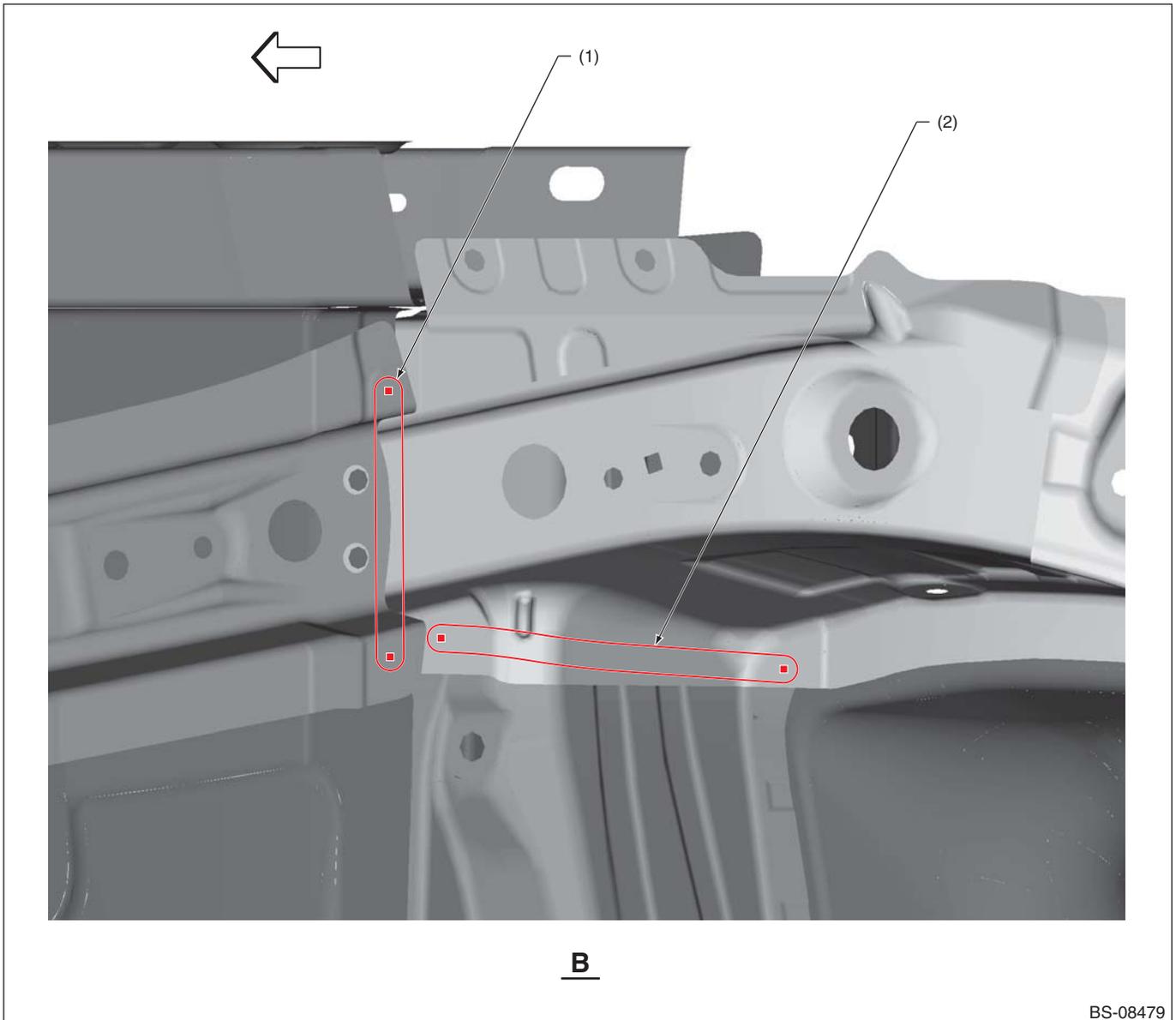
## • Views A



(1) 1 point (service)

# Panel Replacement

## • Views B

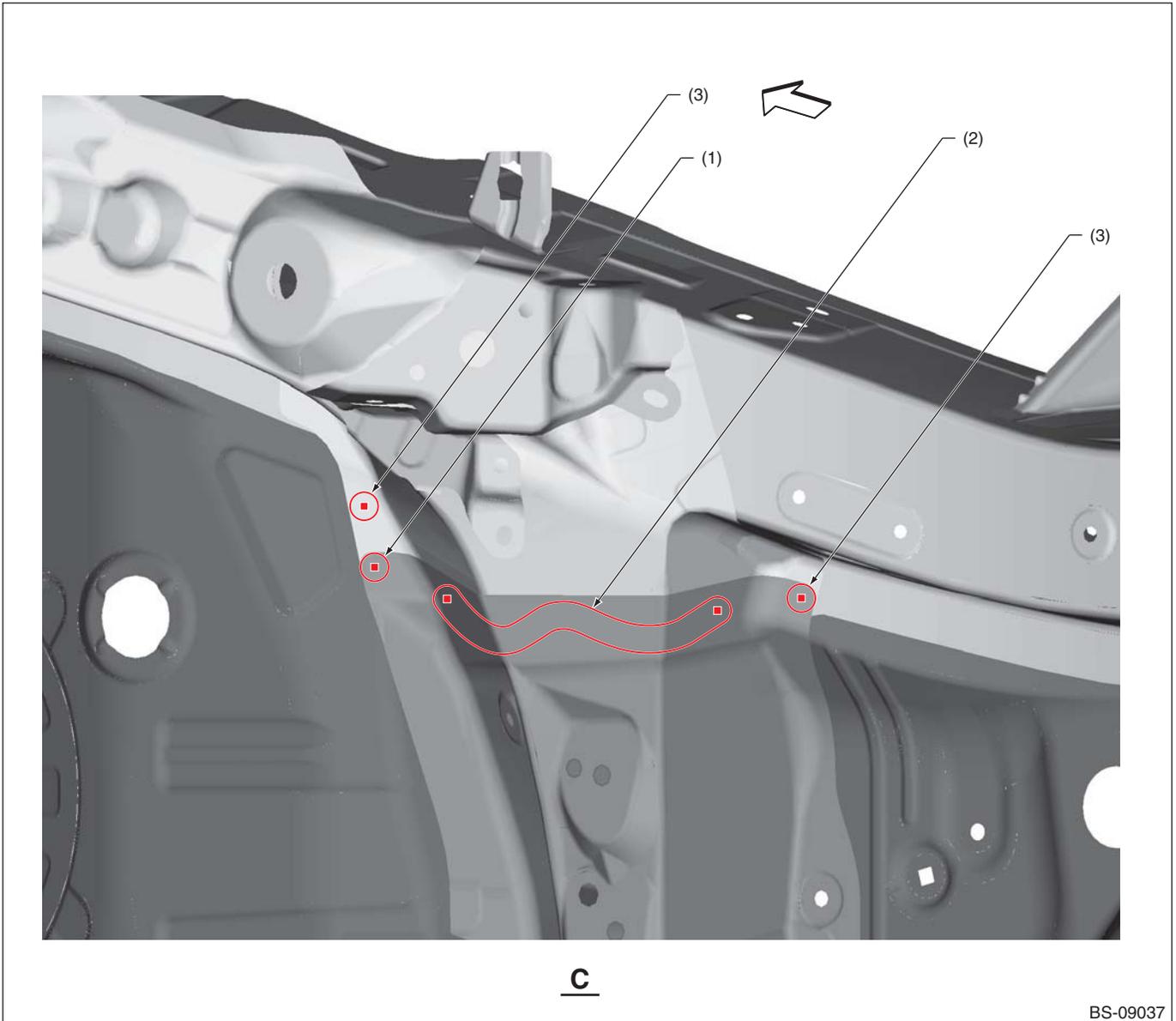


(1) 2 points (service · matching)

(2) 5 points (service)

# Panel Replacement

## • Views C



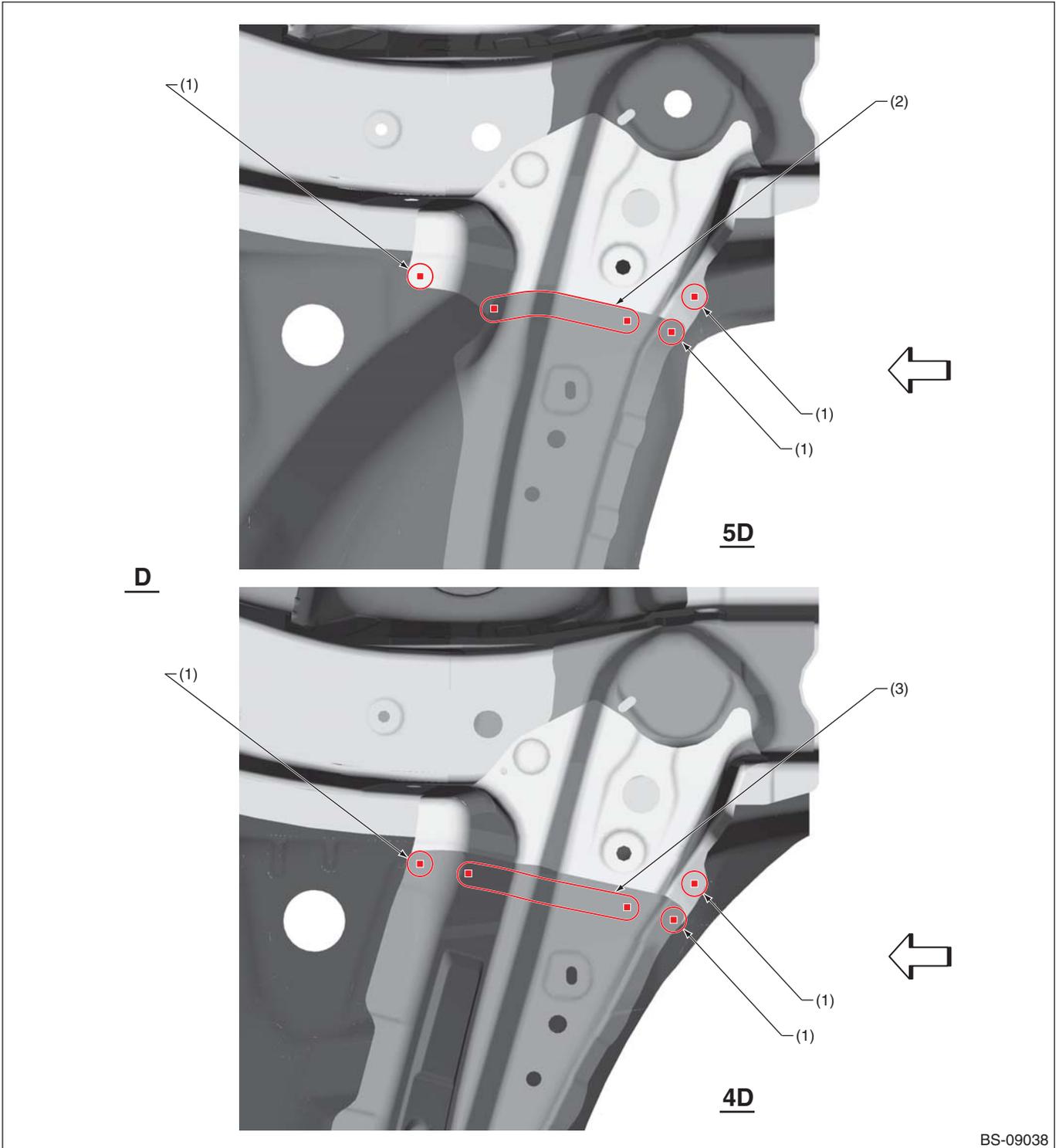
(1) 1 point (service · matching)

(2) 7 points

(3) 1 point

# Panel Replacement

## • Views D (Gasoline model)



BS-09038

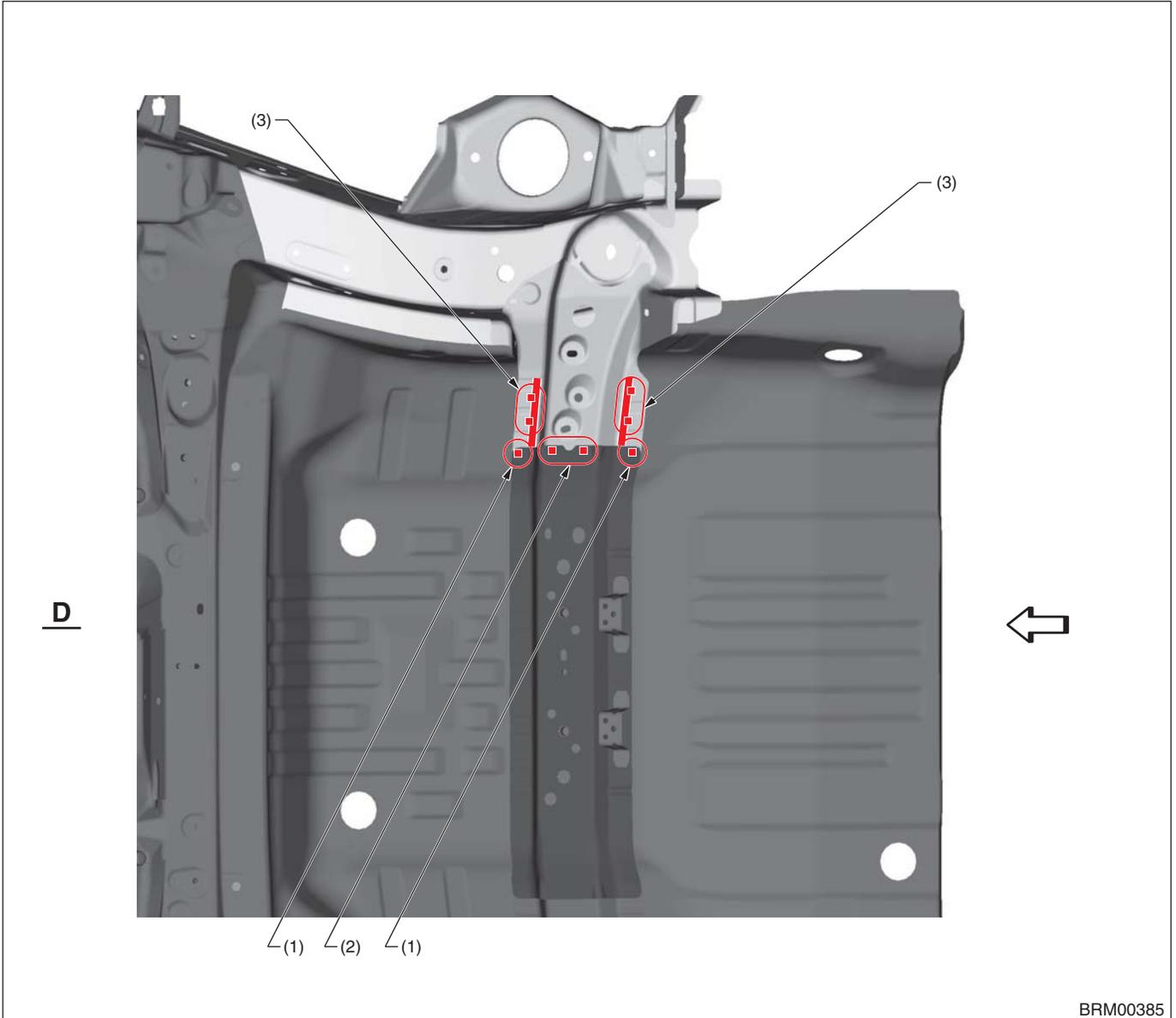
(1) 1 point

(2) 4 points

(3) 5 points

# Panel Replacement

## • Views D (Hybrid model)



BRM00385

(1) 1 point (service · matching)

(2) 2 points

(3) 2 points (service)

— : Structural adhesive application location

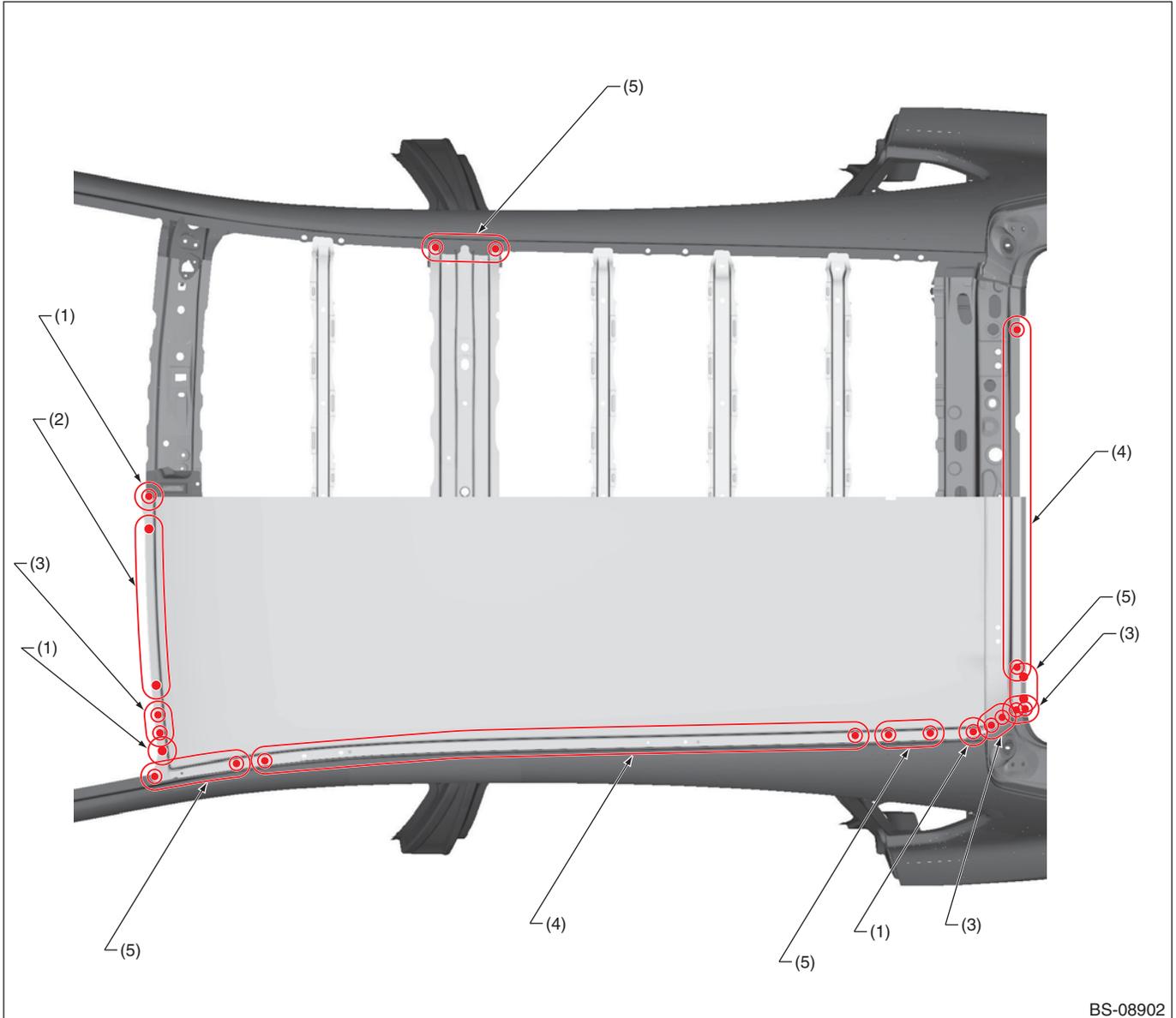
# Panel Replacement

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

Model without sunroof

### A: REMOVAL

• Overall view



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

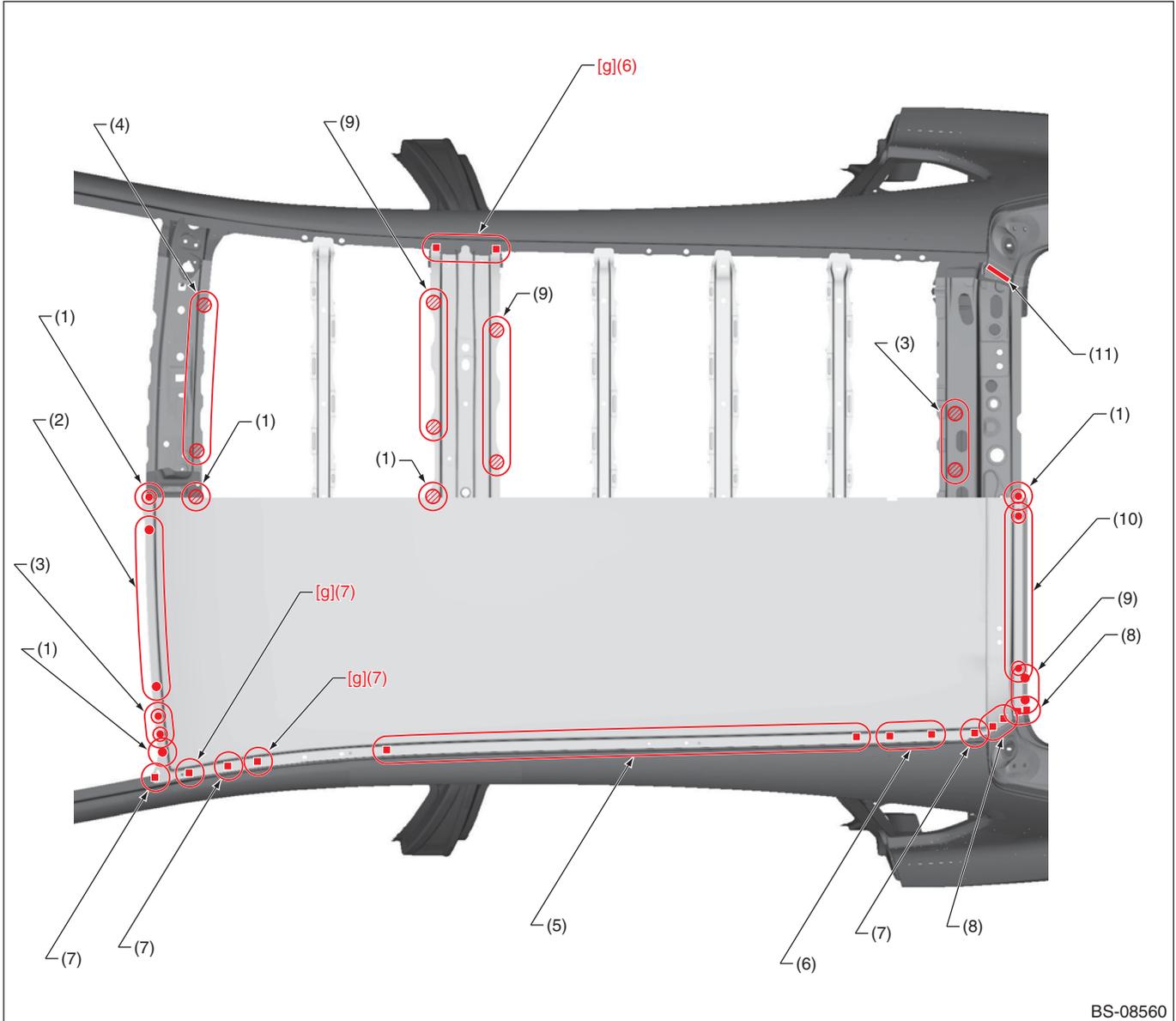
(3) 2 points (top · 1)  
(4) 13 points (top · 1)

(5) 3 points (top · 1)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-08560

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

 : Application of adhesive

 : Structural adhesive application location

**[g] Plug welding**

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

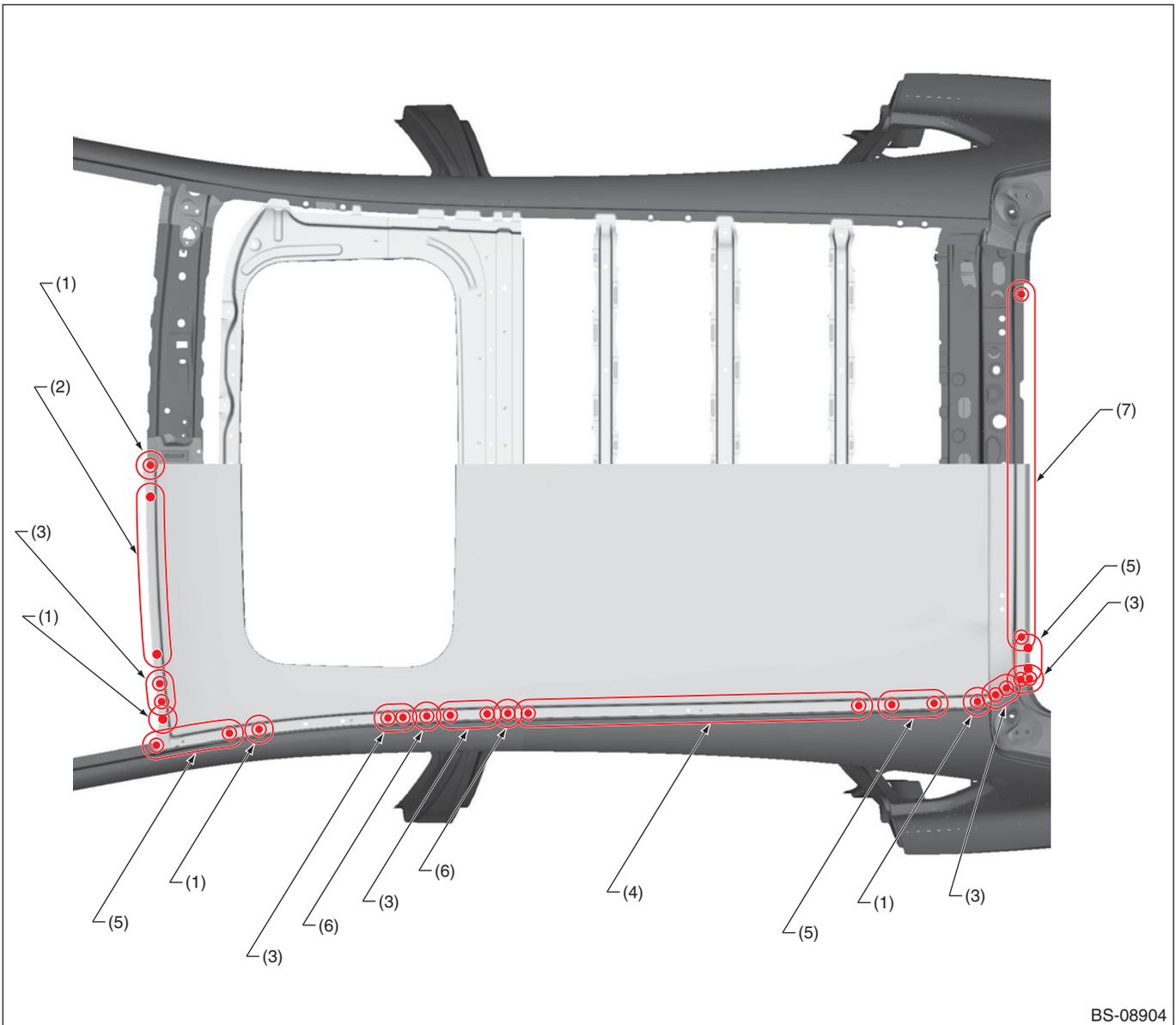
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

# Panel Replacement

Model with sunroof

## A: REMOVAL

### • Overall view



BS-08904

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

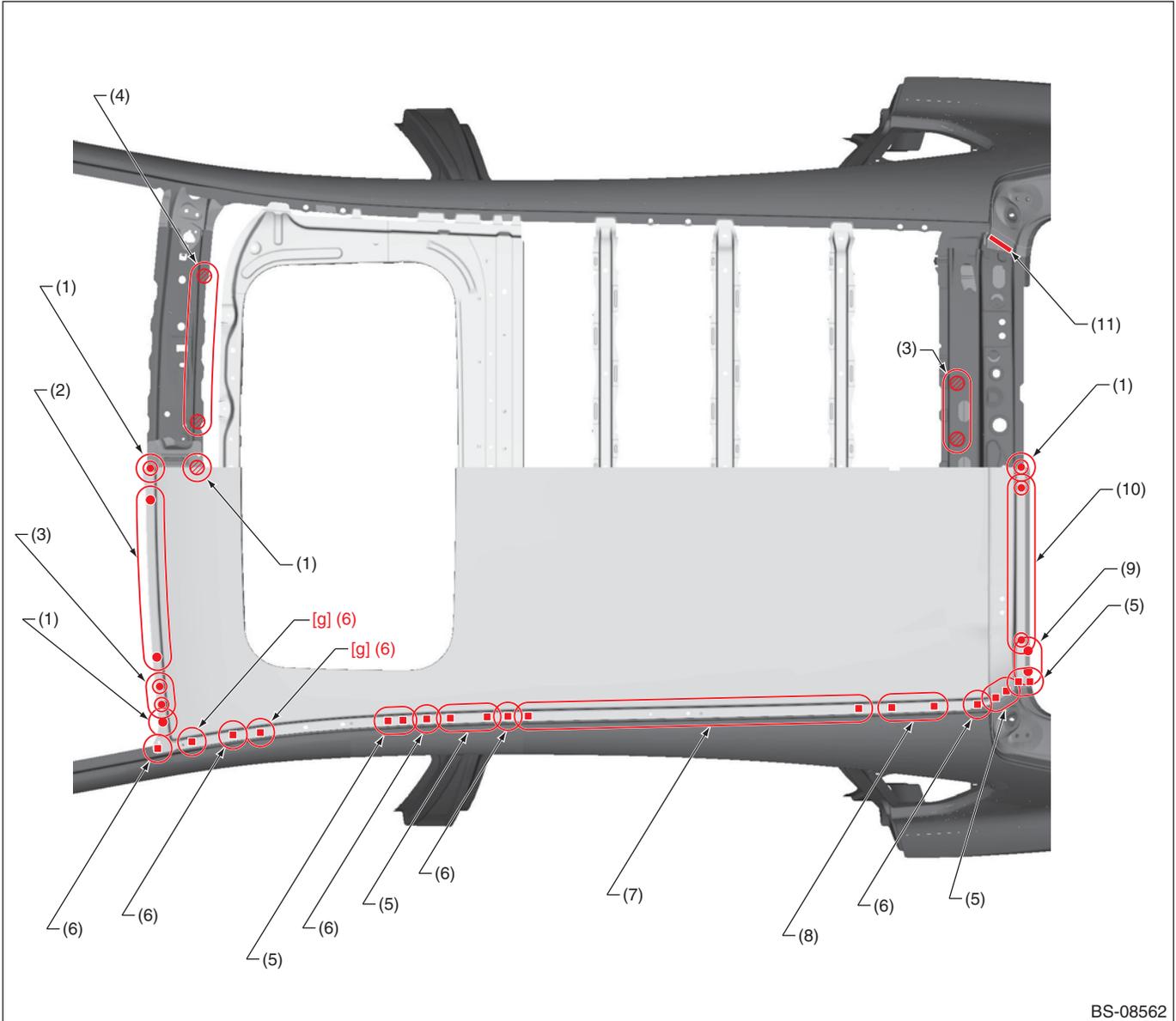
- (4) 8 points (top · 1)
- (5) 3 points (top · 1)

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

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-08562

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

 : Application of adhesive

 : Structural adhesive application location

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO<sub>2</sub>

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO<sub>2</sub>: 20 %)

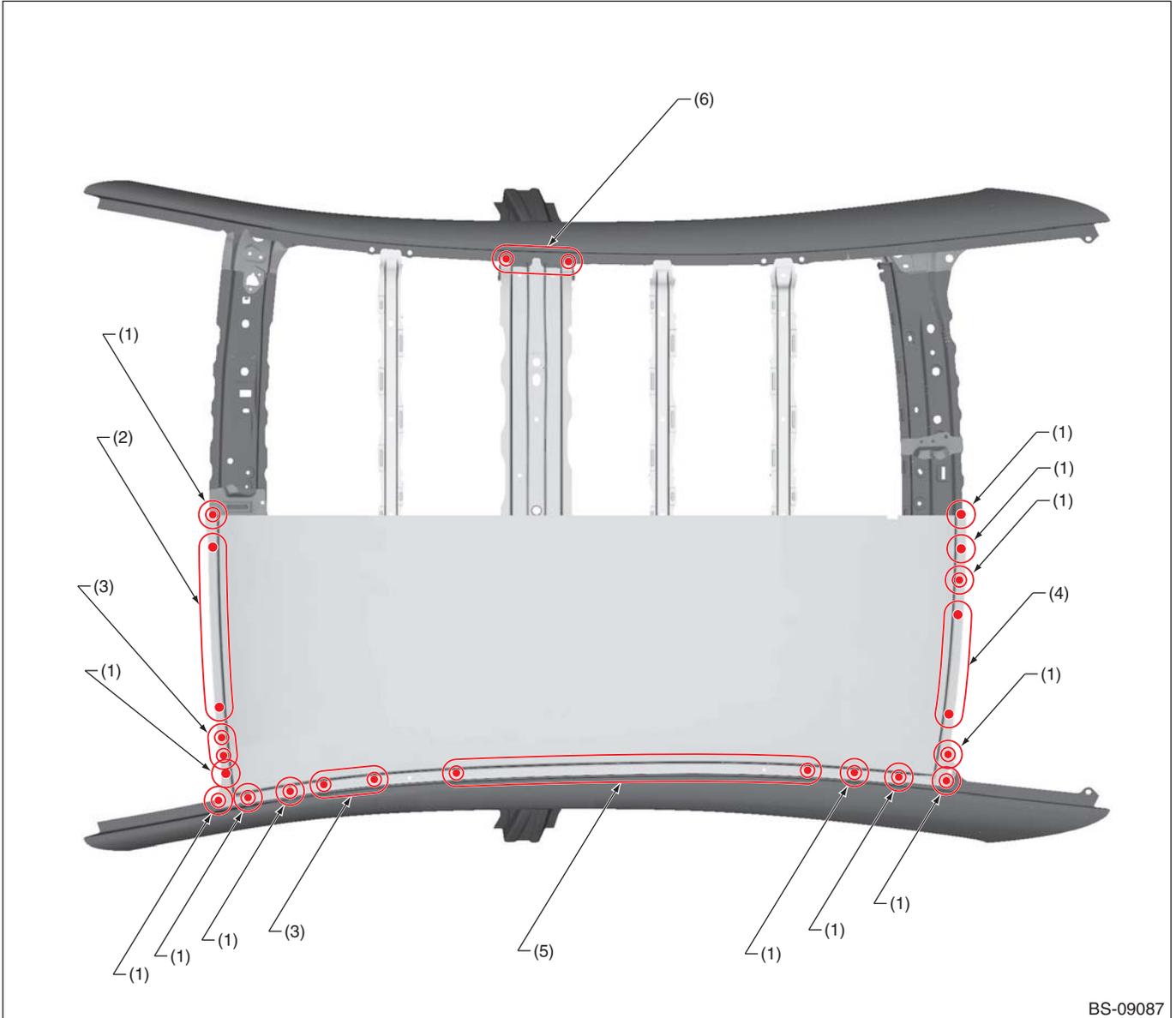
# Panel Replacement

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

Model without sunroof

### A: REMOVAL

• Overall view



BS-09087

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

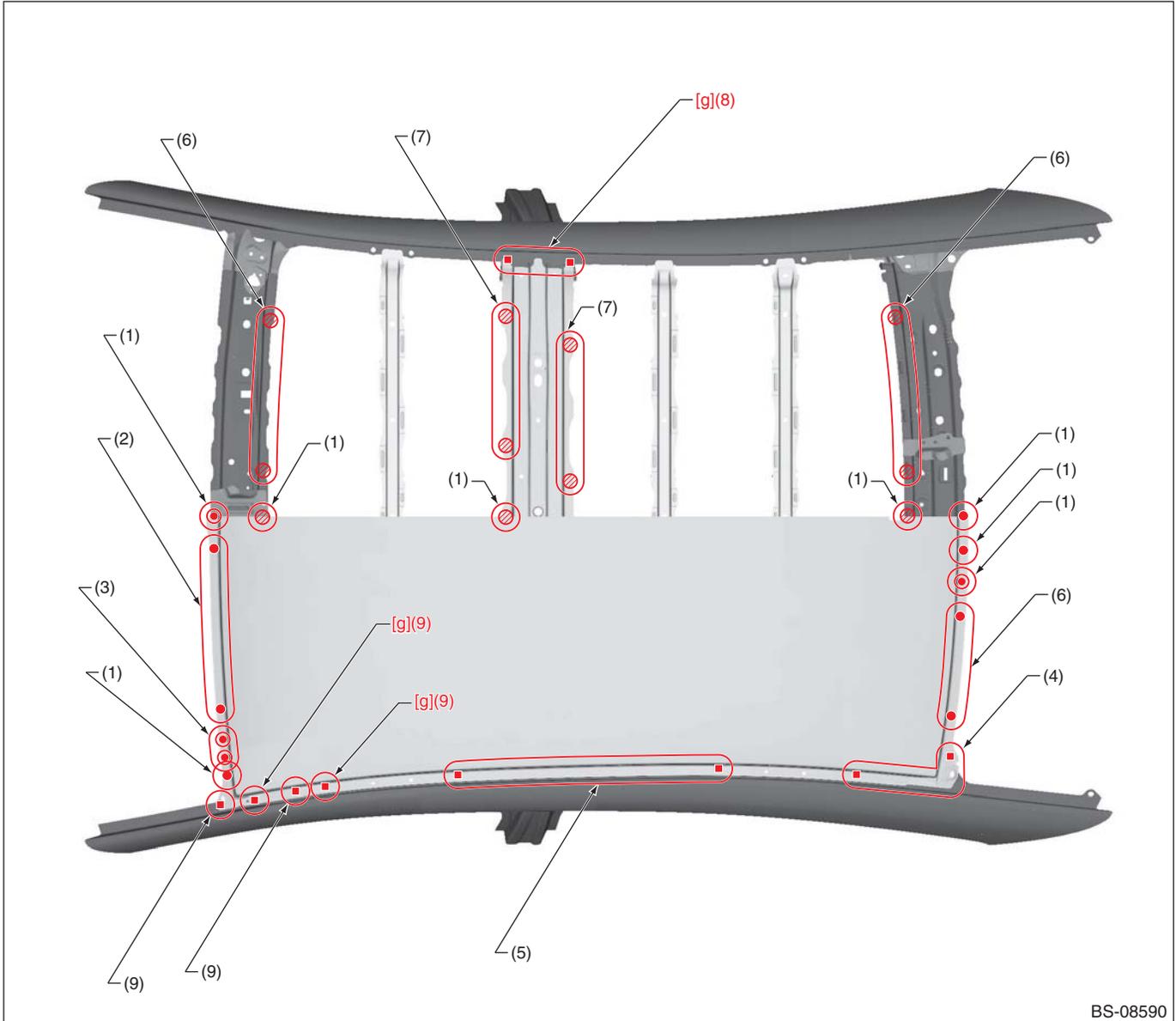
(3) 2 points (top · 1)  
(4) 4 points (top · 1)

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

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-08590

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

 : Application of adhesive

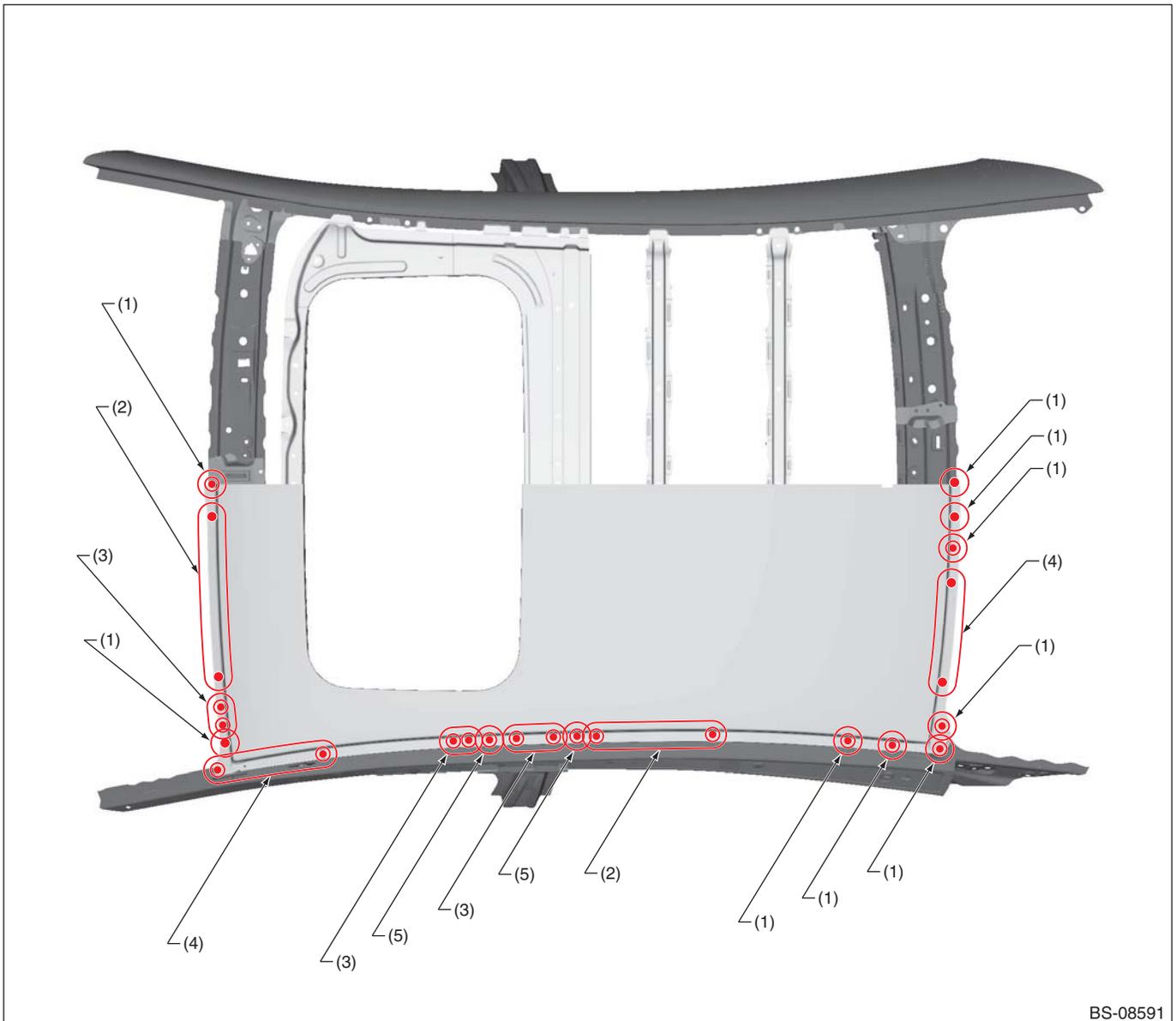
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2
	B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

# Panel Replacement

Model with sunroof

## A: REMOVAL

### • Overall view



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

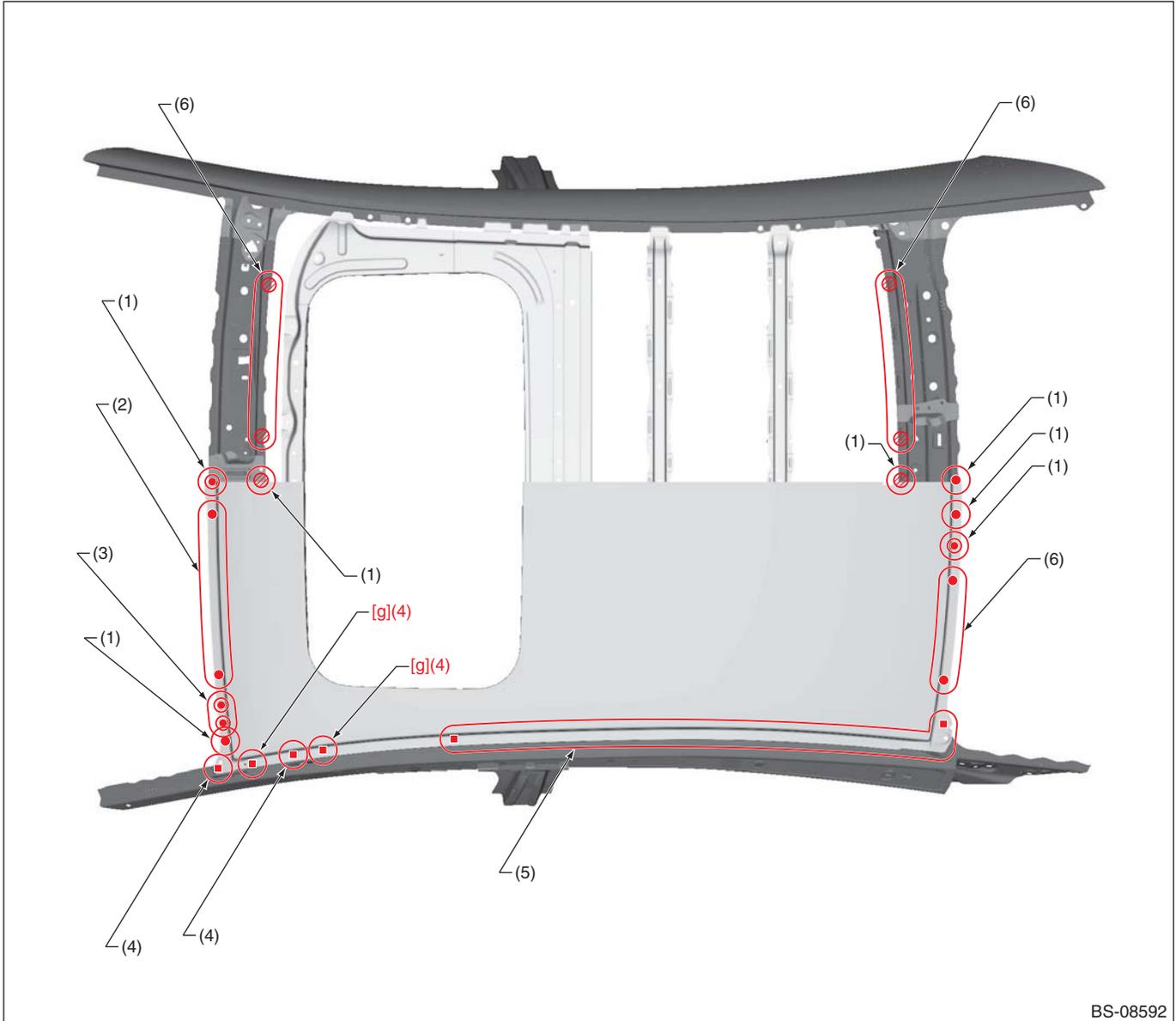
(3) 2 points (top · 1)  
(4) 4 points (top · 1)

(5) 1 point (top · 2)

# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-08592

(1) 1 point

(2) 5 points

(3) 2 points

(4) 1 point (service)

(5) 15 points (service)

(6) 4 points

 : Application of adhesive

 : Structural adhesive application location

[g] Plug welding

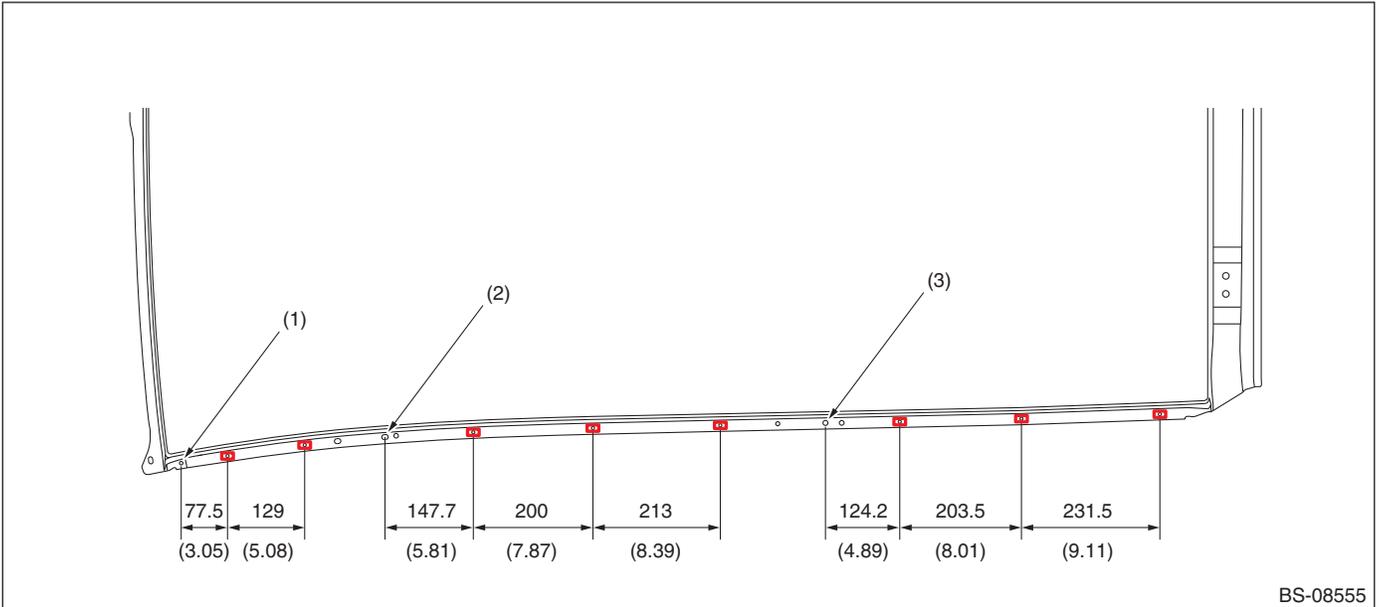
A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

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

# Panel Replacement

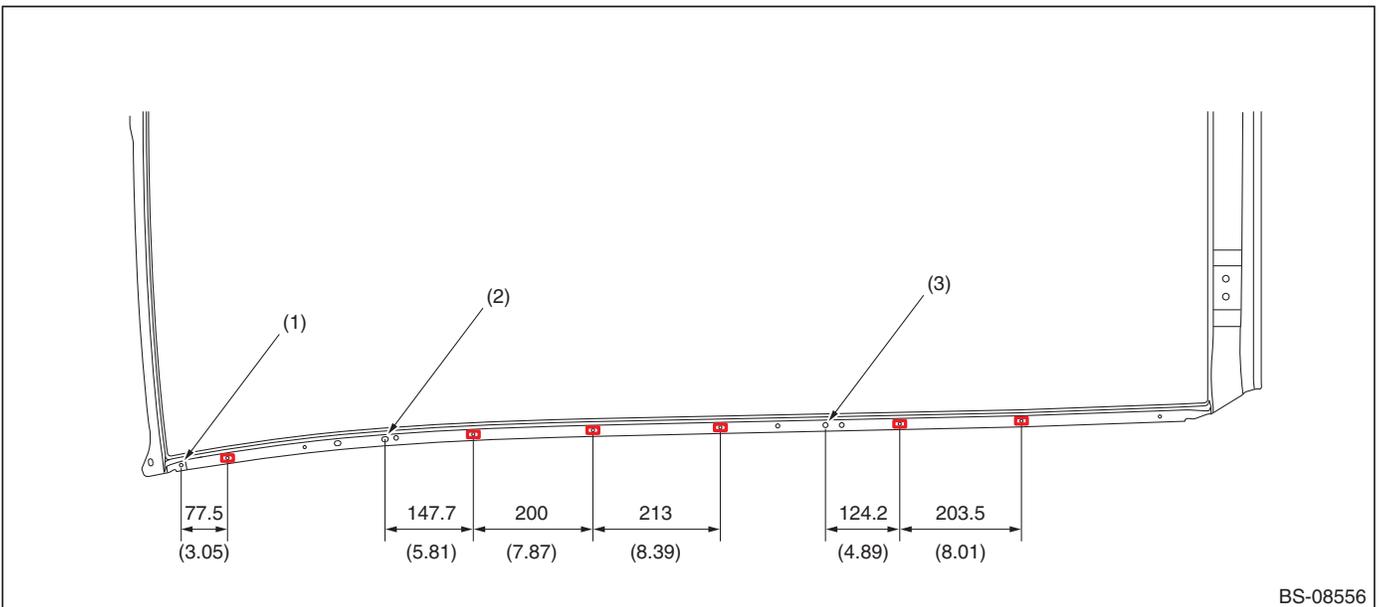
## 8-54. T Stud Installation

- 5 Door (Model without roof rail)



BS-08555

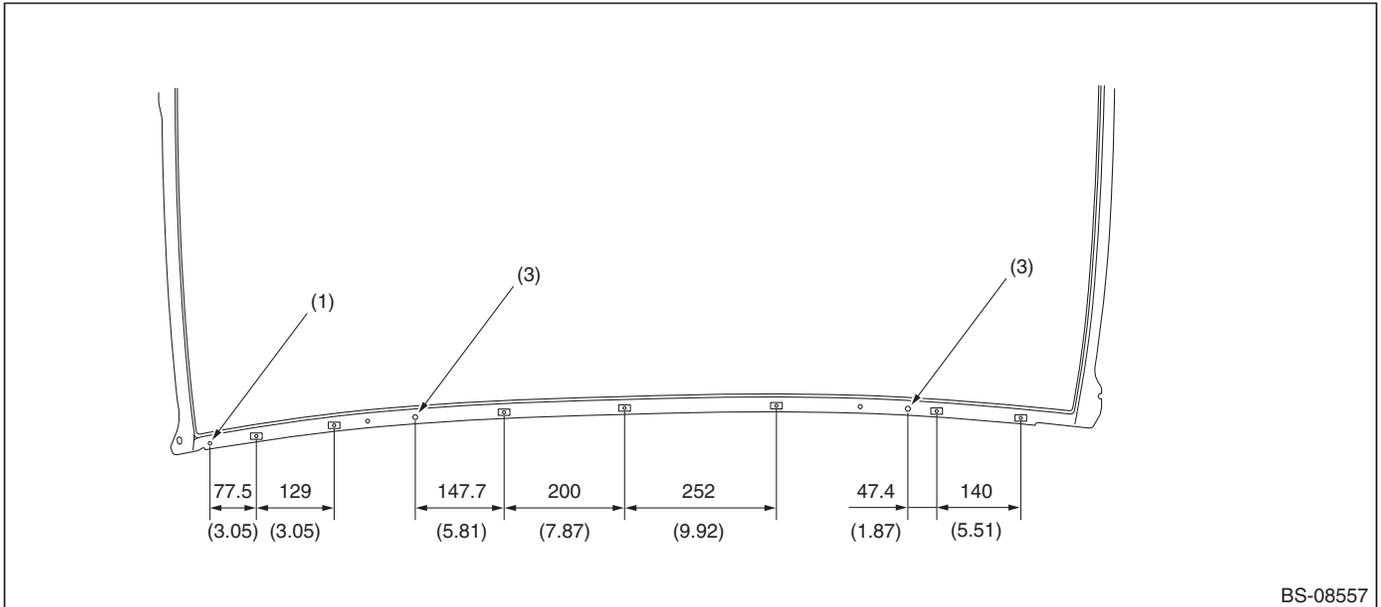
- 5 Door (Model with roof rail)



BS-08556

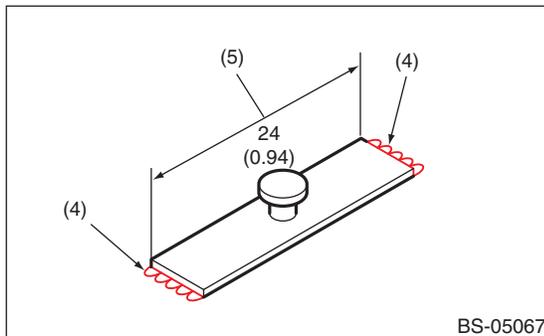
# Panel Replacement

## • 4 Door



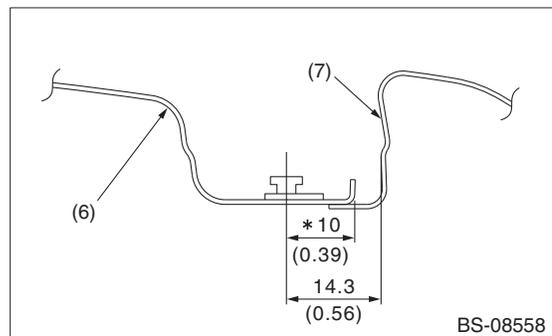
BS-08557

## • T stud welding



BS-05067

## • T stud basic cross section



BS-08558

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

\* Indicates dimensions for reference.

# Body Sealing

## 9. Body Sealing

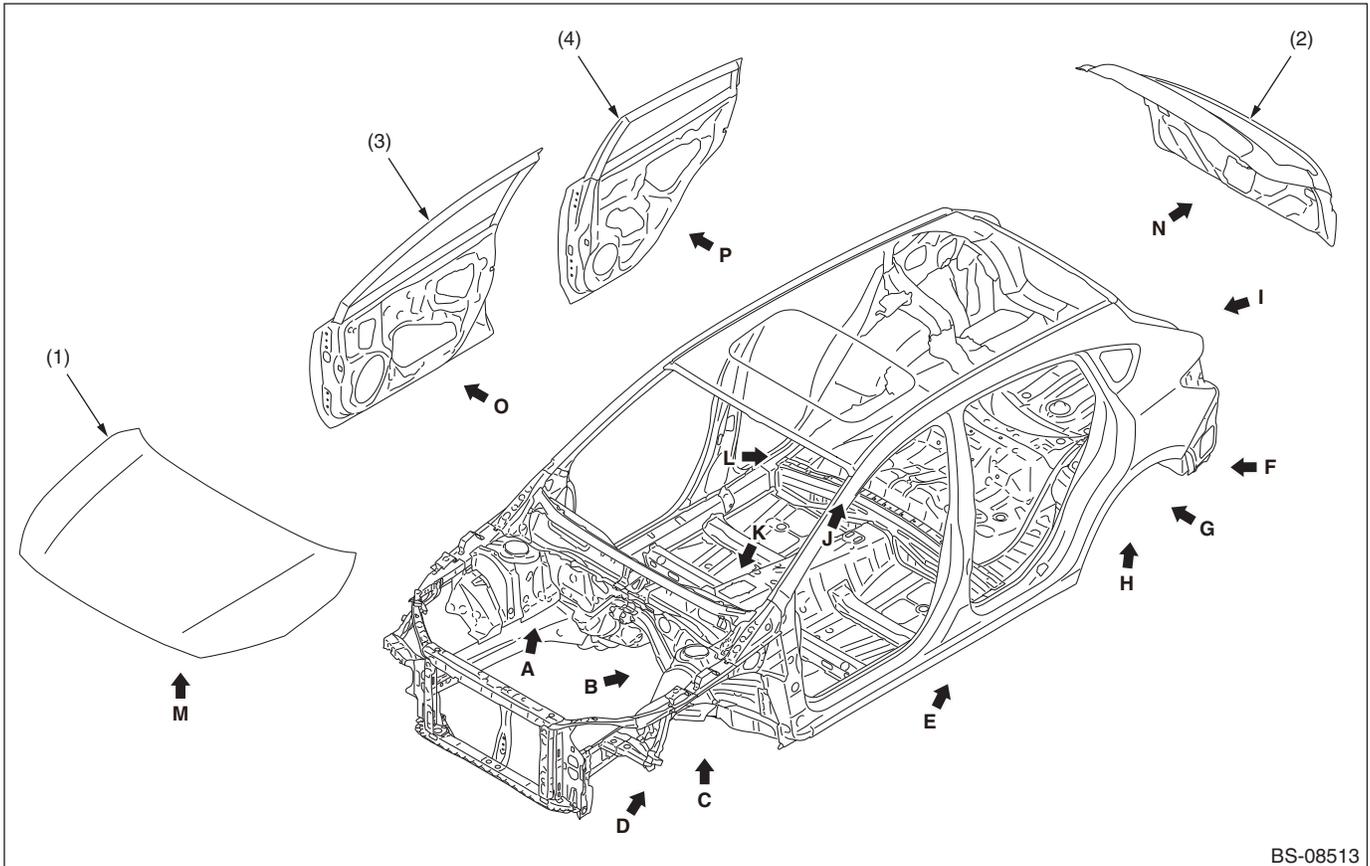
### A: SPECIFICATIONS

Used material: Three Bond 4101 (004403063)

— : Sealer application location

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

• Common parts for 5 door and 4 door



BS-08513

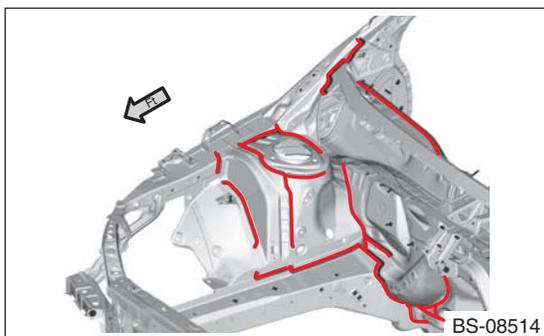
(1) Front hood

(3) Front door

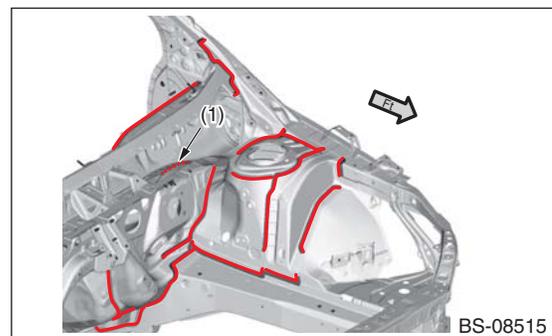
(4) Rear door

(2) Rear gate

View A



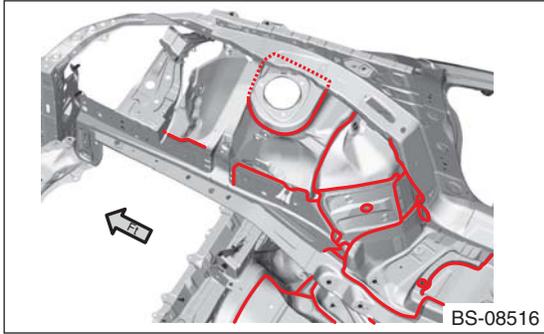
View B



(1) LH only

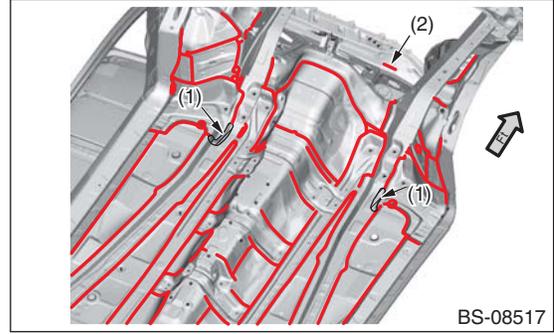
# Body Sealing

**View C**



BS-08516

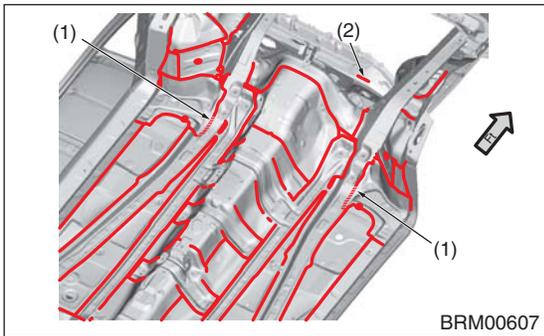
**View D (Gasoline model)**



BS-08517

- (1) Wax is allowable
- (2) LH only

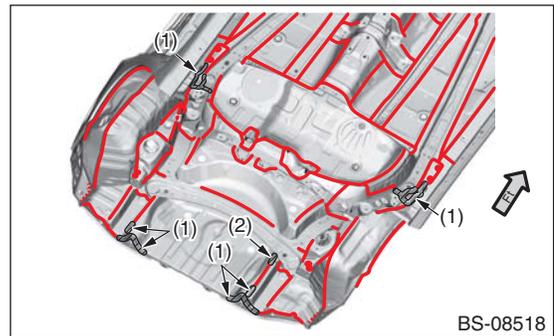
**View D (Hybrid model)**



BRM00607

- (1) Wax is allowable
- (2) LH only

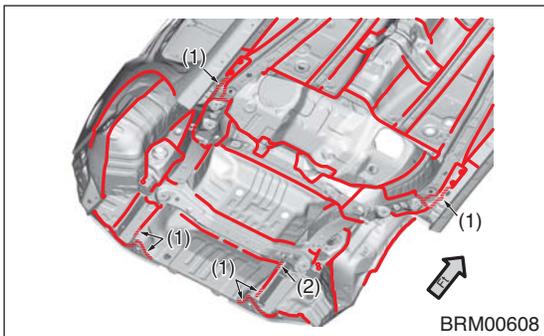
**View E (Gasoline model)**



BS-08518

- (1) Wax is allowable
- (2) Wax is allowable (LH only)

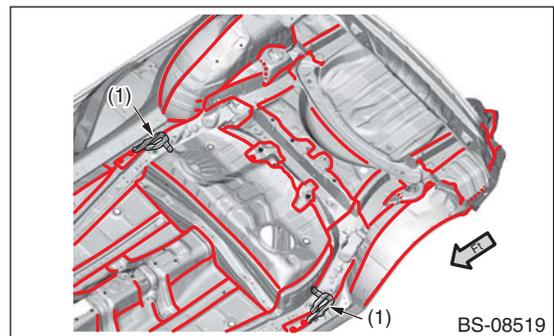
**View E (Hybrid model)**



BRM00608

- (1) Wax is allowable
- (2) Wax is allowable (LH only)

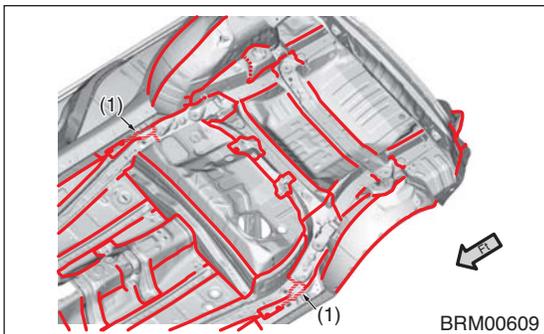
**View F (Gasoline model)**



BS-08519

- (1) Wax is allowable

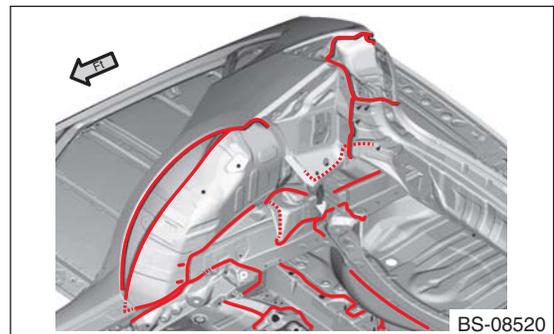
**View F (Hybrid model)**



BRM00609

- (1) Wax is allowable

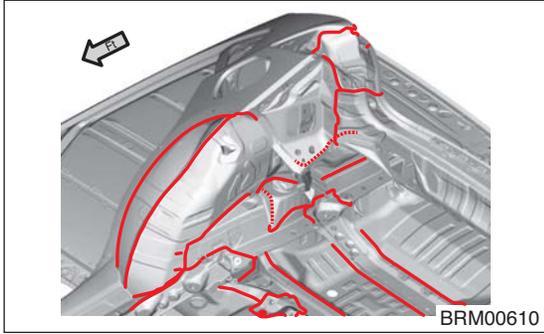
**View G (Gasoline model)**



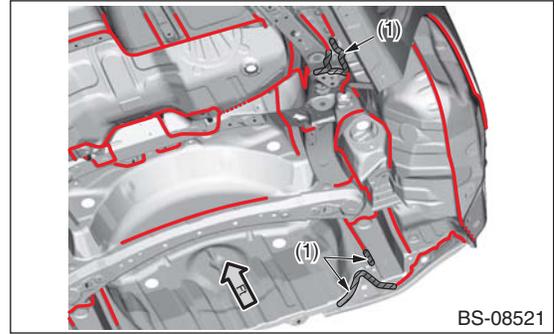
BS-08520

# Body Sealing

View G (Hybrid model)

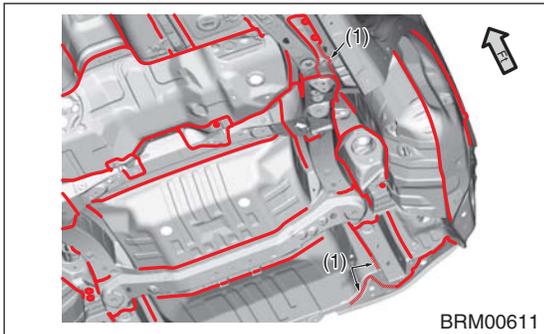


View H (Gasoline model)



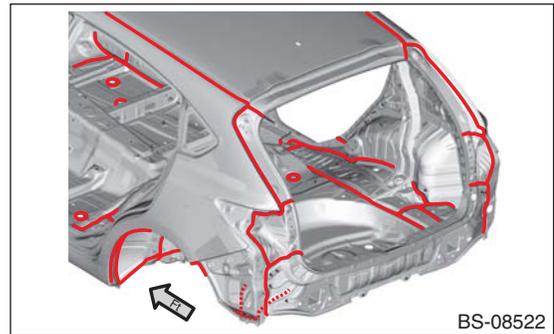
(1) Wax is allowable

View H (Hybrid model)

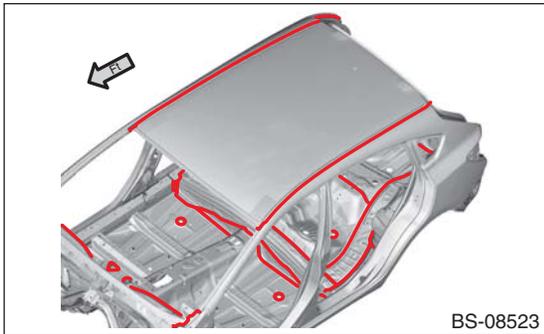


(1) Wax is allowable

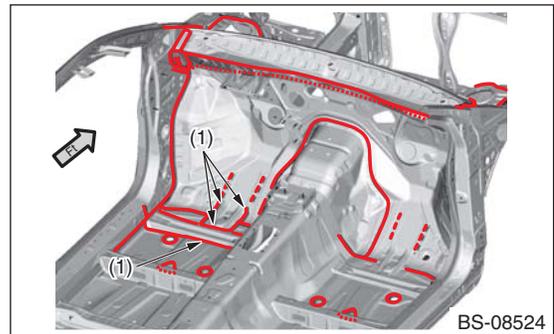
View I



View J

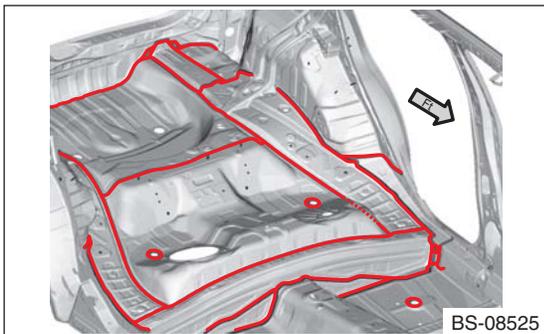


View K

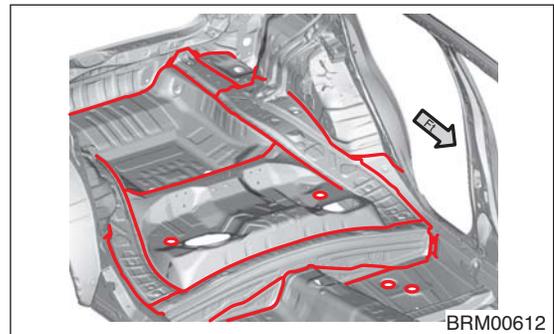


(1) LH only

View L (Gasoline model)

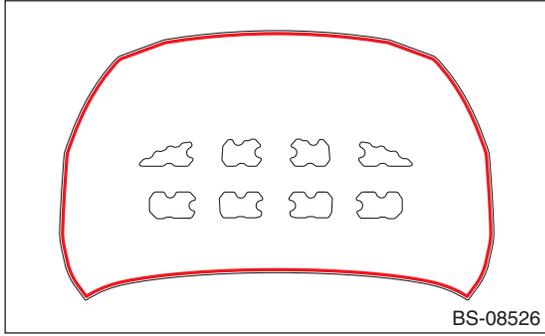


View L (Hybrid model)

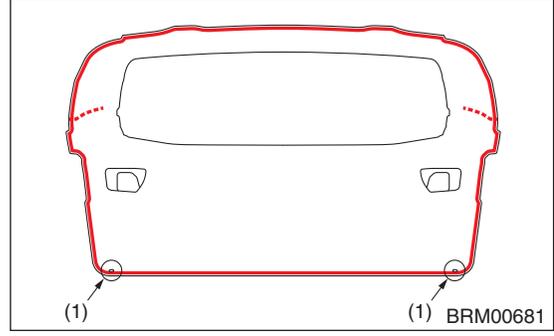


# Body Sealing

View M

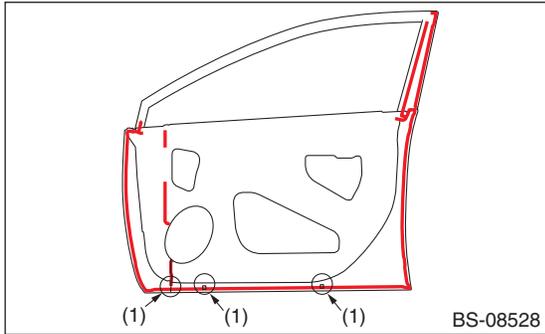


View N



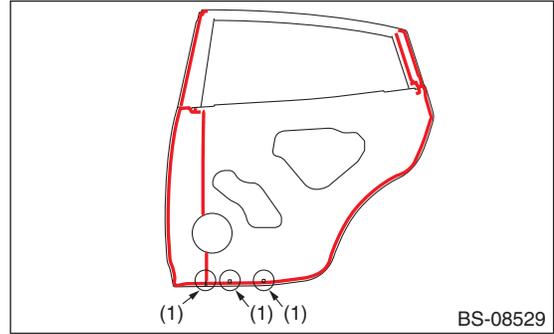
(1) Do not block the water drain holes.

View O



(1) Do not block the water drain holes.

View P



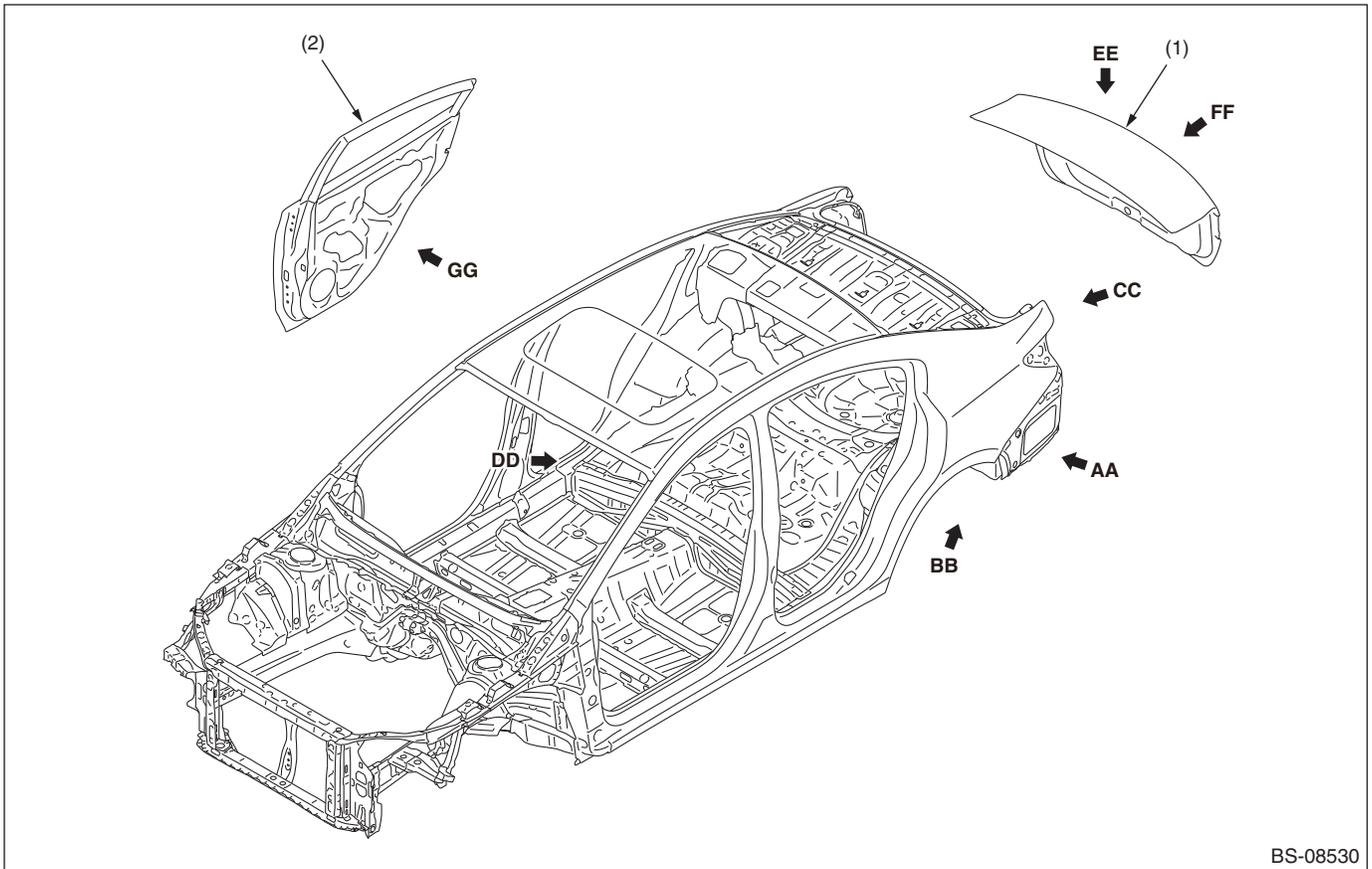
(1) Do not block the water drain holes.

**CAUTION:**

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

# Body Sealing

## • SPECIAL PARTS FOR 4 DOOR

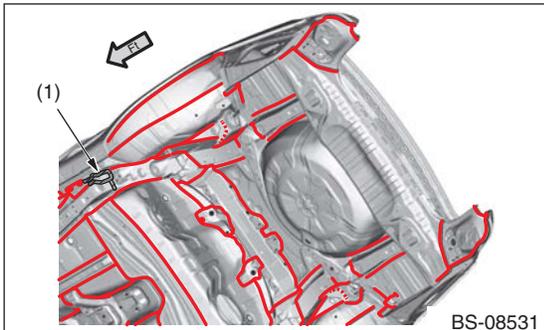


BS-08530

(1) Trunk

(2) Rear door

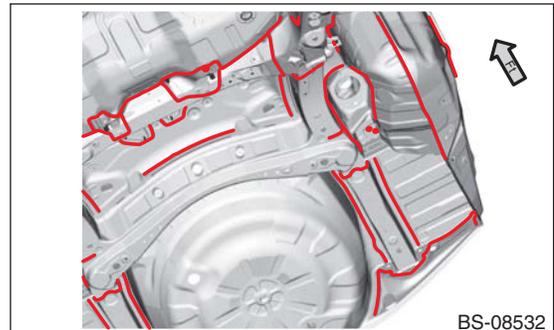
**View AA**



BS-08531

(1) Wax is allowable

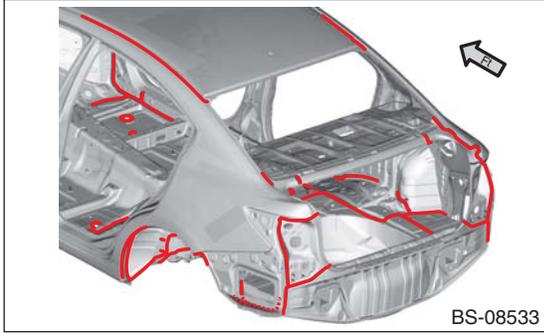
**View BB**



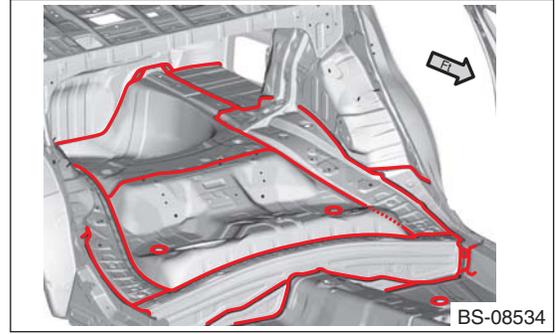
BS-08532

# Body Sealing

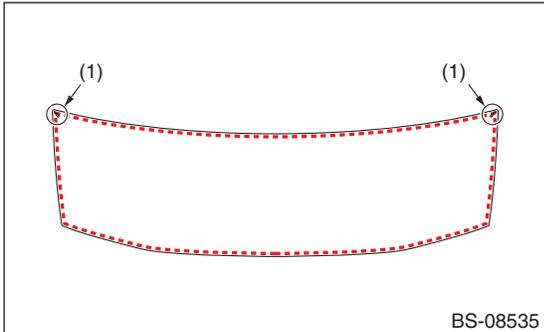
View CC



View DD

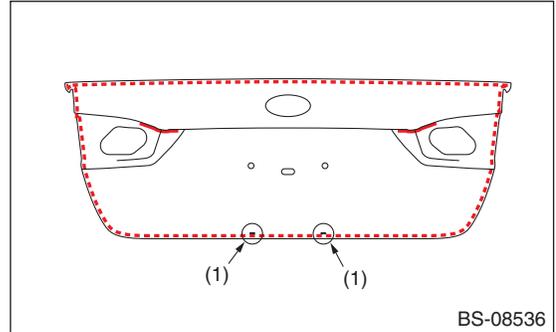


View EE



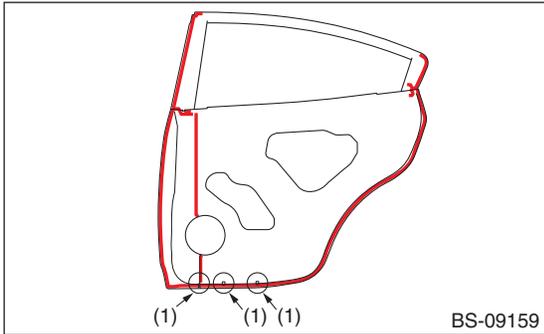
(1) The hole shall be blocked.

View FF



(1) Do not block the water drain holes.

View GG



(1) Do not block the water drain holes.

SUBARU.

## CAUTION:

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

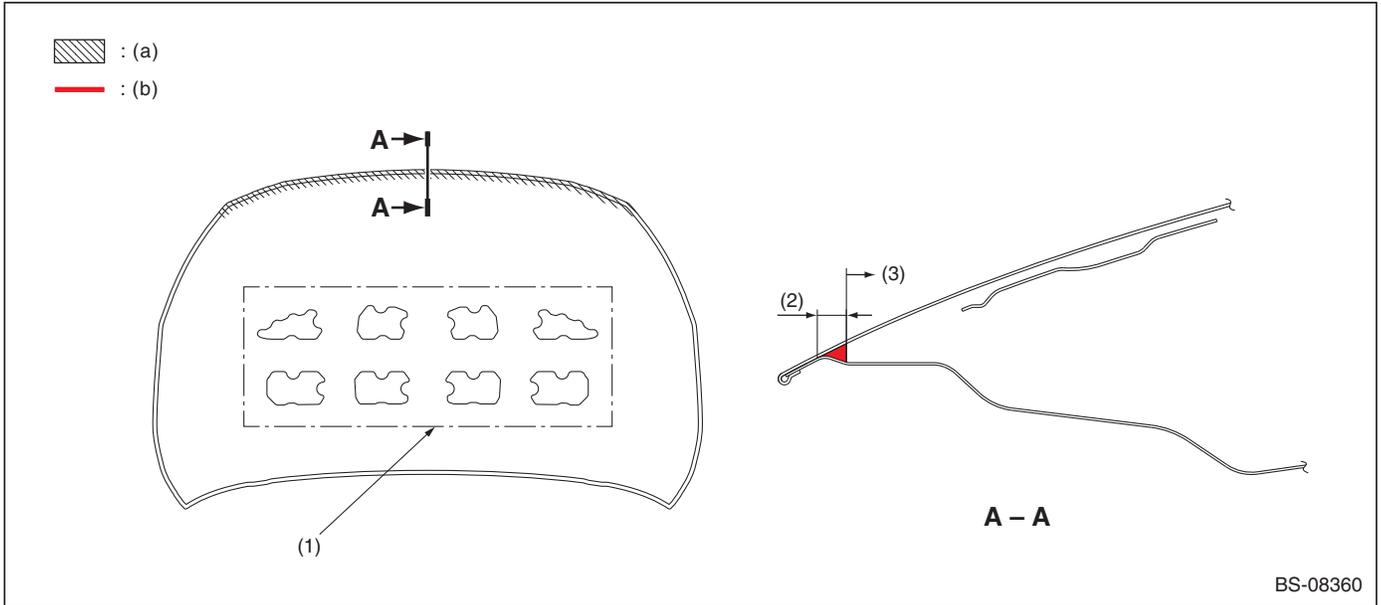
## 10. Anticorrosion Wax

### A: SPECIFICATIONS (5D/4D model)

Used material: Rust-stop aerosol (K0877YA015)

— and   :Application area

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



(a) Rust-stop aerosol

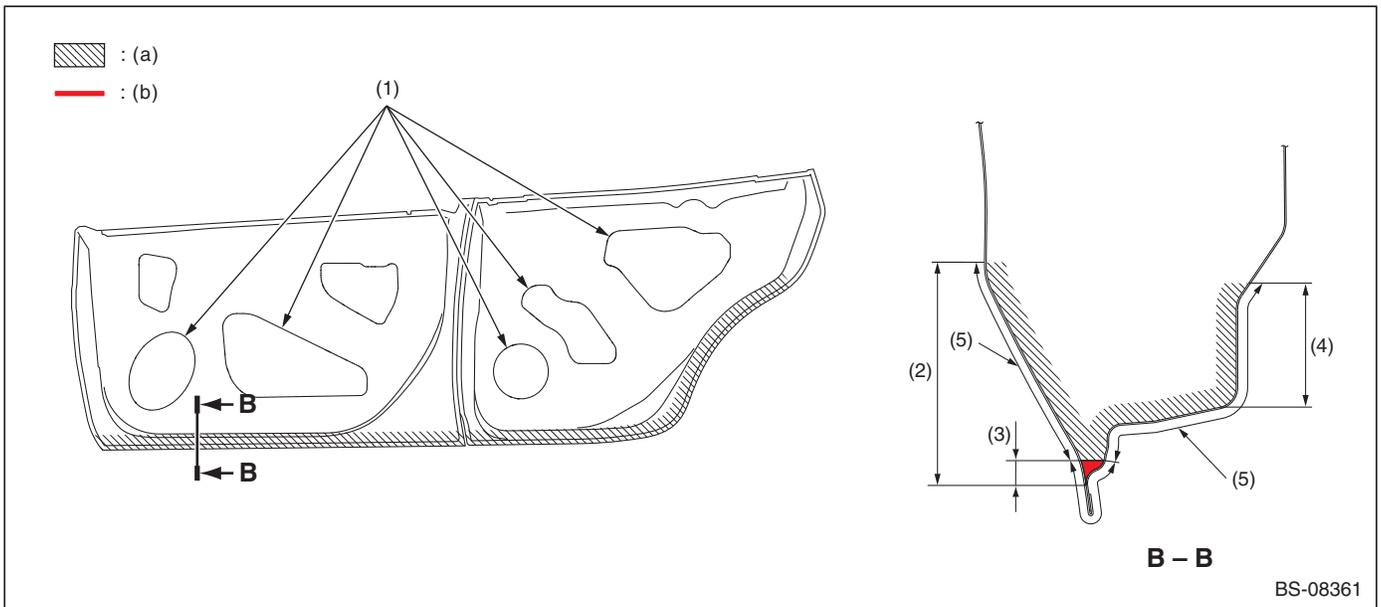
(b) To be filled into the plate joint

(1) Wax application work openings

(2) 10 mm (0.39 in)

(3) Adherence of mist is allowable

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



(a) Rust-stop aerosol

(b) To be filled into the plate joint

(1) Wax application work openings

(3) 10 mm (0.39 in)

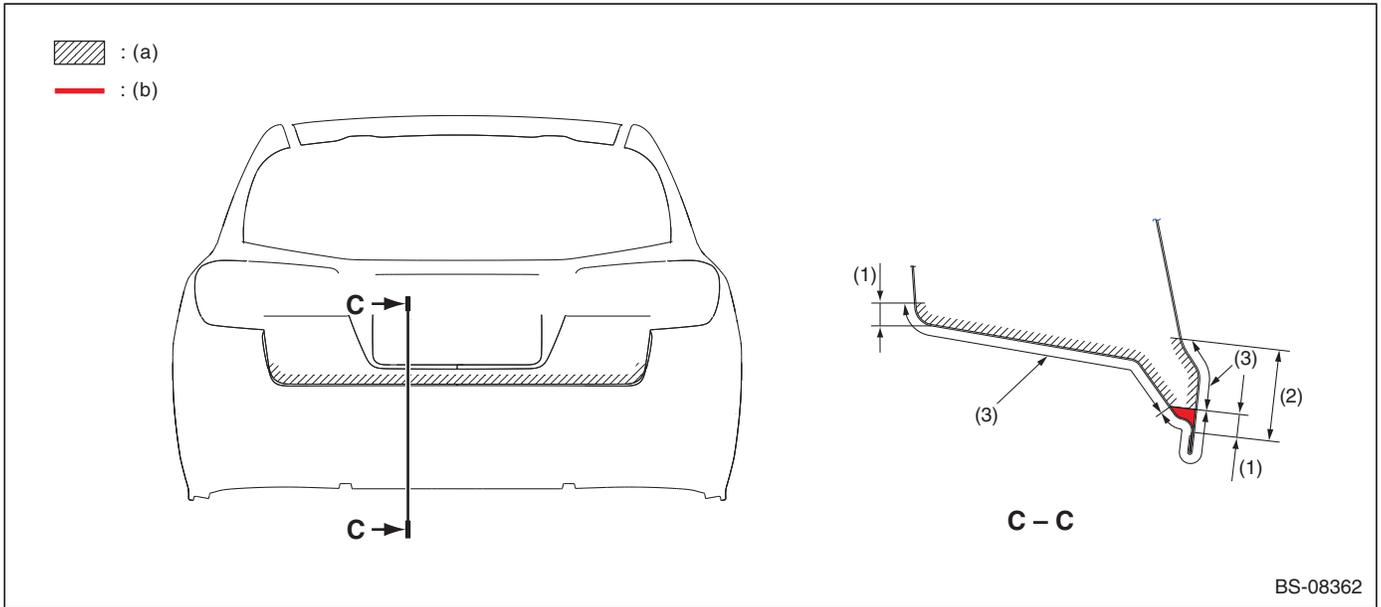
(5) Adherence of mist is allowable

(2) 90 mm (3.54 in)

(4) 50 mm (1.97 in)

# Anticorrosion Wax

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



(a) Rust-stop aerosol

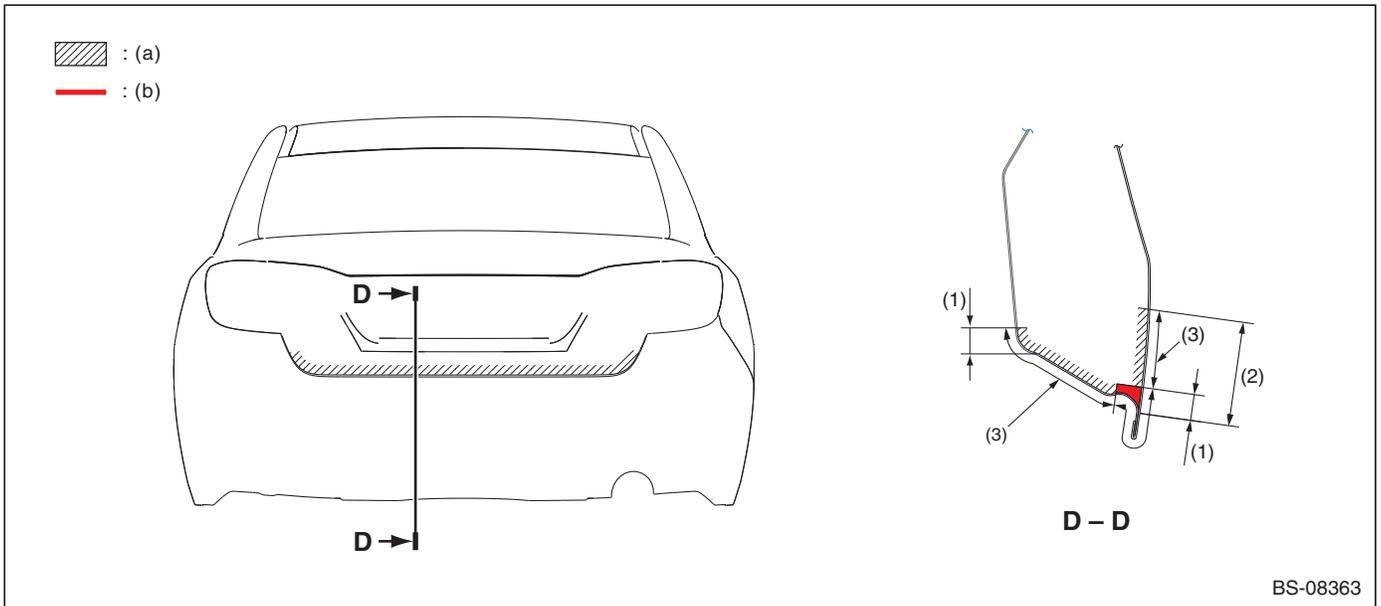
(b) To be filled into the plate joint

(1) 10 mm (0.39 in)

(2) 40 mm (1.57 in)

(3) Adherence of mist is allowable

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



(a) Rust-stop aerosol

(b) To be filled into the plate joint

(1) 10 mm (0.39 in)

(2) 40 mm (1.57 in)

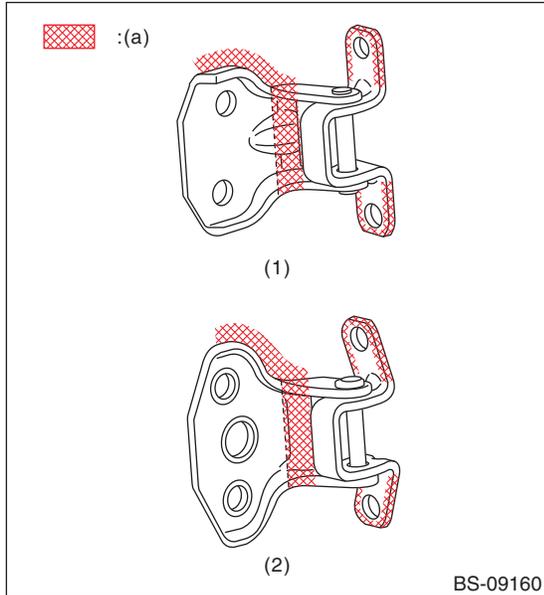
(3) Adherence of mist is allowable

# Anticorrosion Wax

- Front door hinge

(Application thickness = 50  $\mu\text{m}$  or more)

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



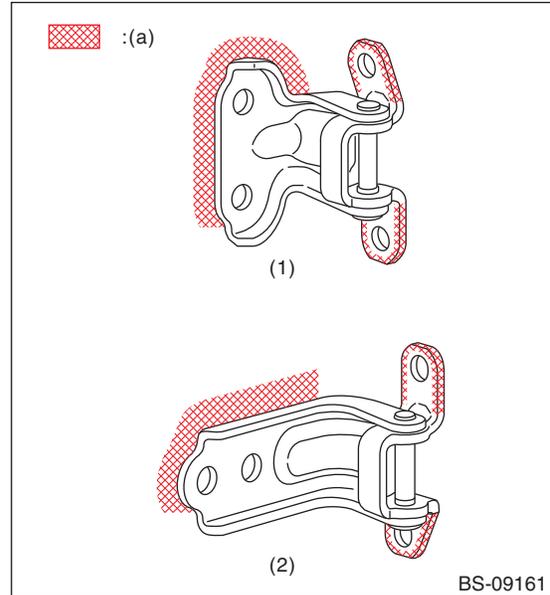
(a) Rust-stop aerosol

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

- Rear door hinge

(Application thickness = 50  $\mu\text{m}$  or more)

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



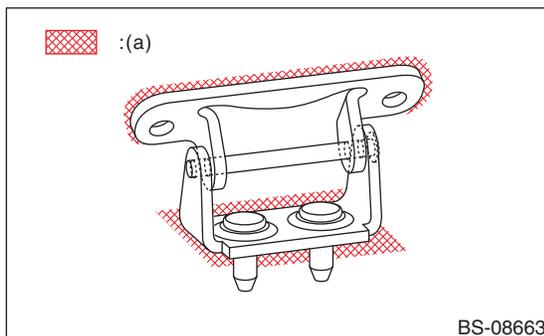
(a) Rust-stop aerosol

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

- Rear gate hinge

(Application thickness = 50  $\mu\text{m}$  or more)

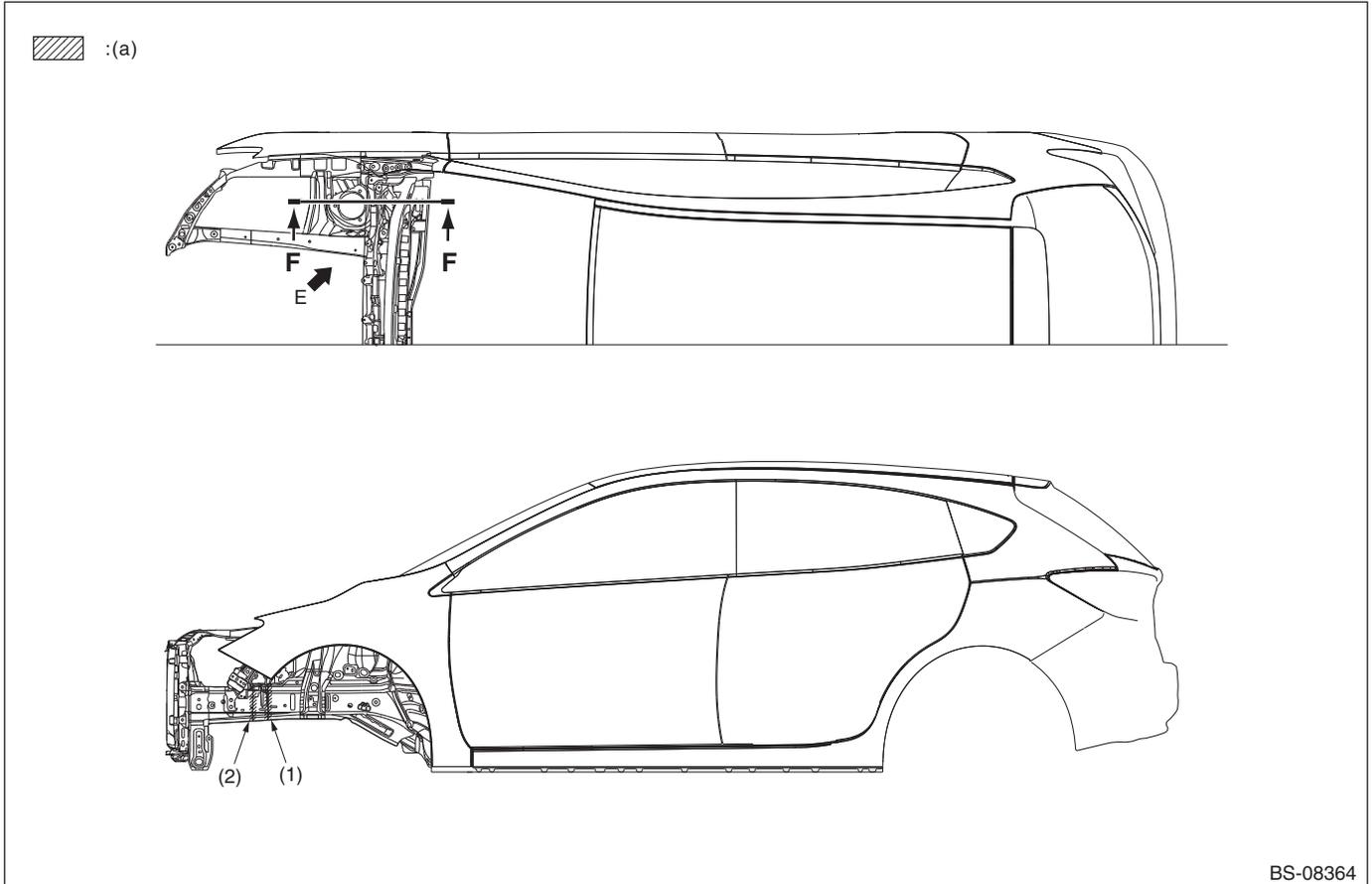
Apply to the contact surface on the body side at two locations on the left and right, and to installation outer circumference (indicated range, plate edges) on the rear gate side and to the head of the bolts.



(a) Rust-stop aerosol

# Anticorrosion Wax

- Overall view



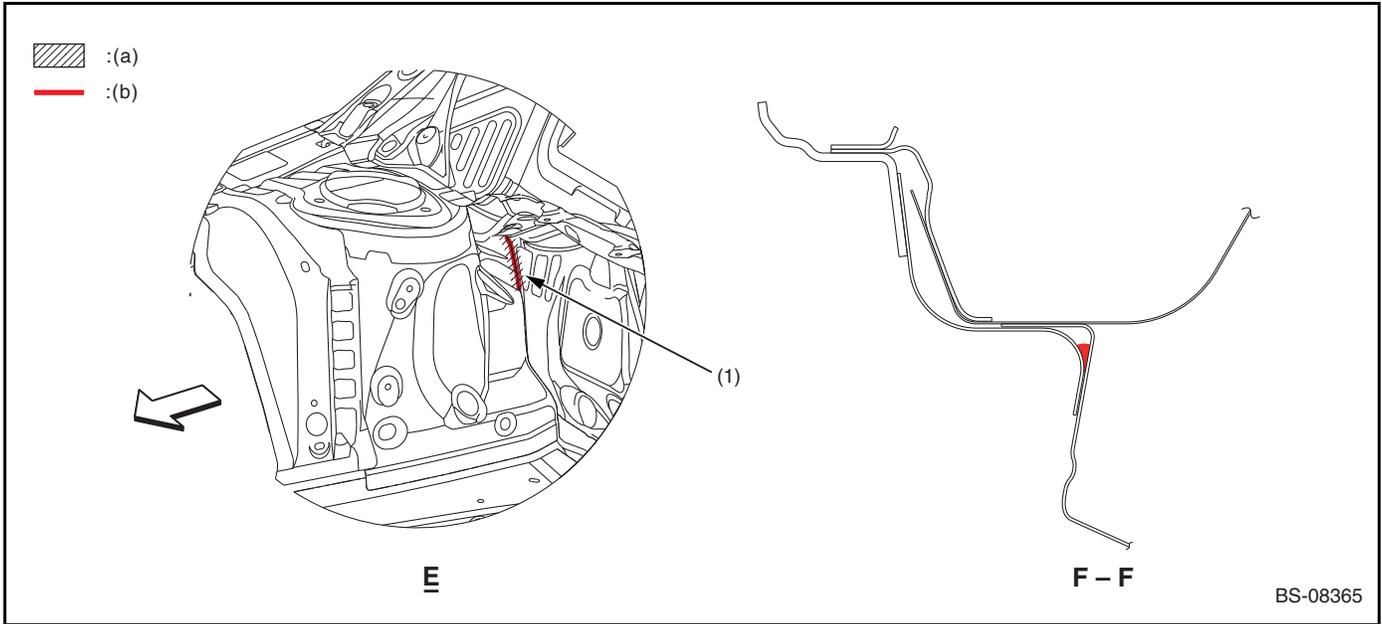
BS-08364

(a) Rust-stop aerosol  
(Application thickness = 50  $\mu\text{m}$  or more)

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

# Anticorrosion Wax

- View / Cross section



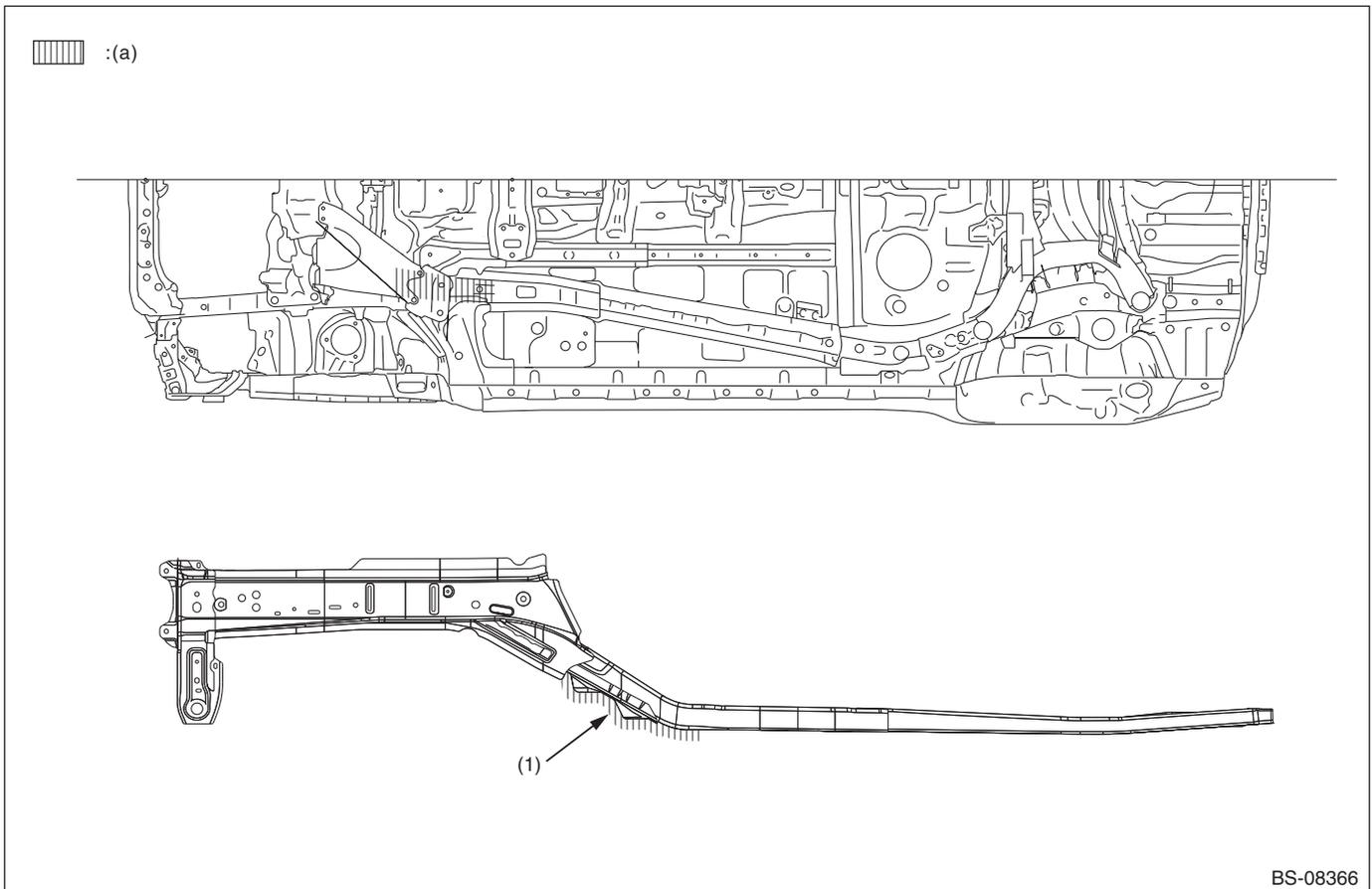
(a) Rust-stop aerosol  
(Application thickness = 50  $\mu\text{m}$  or more)

(b) Fill the mating area between plates.

(1) Securely cover the contact surface of the toe board, front suspension bracket. Wrap the sealing and wax securely.

# Anticorrosion Wax

- Bottom view 1

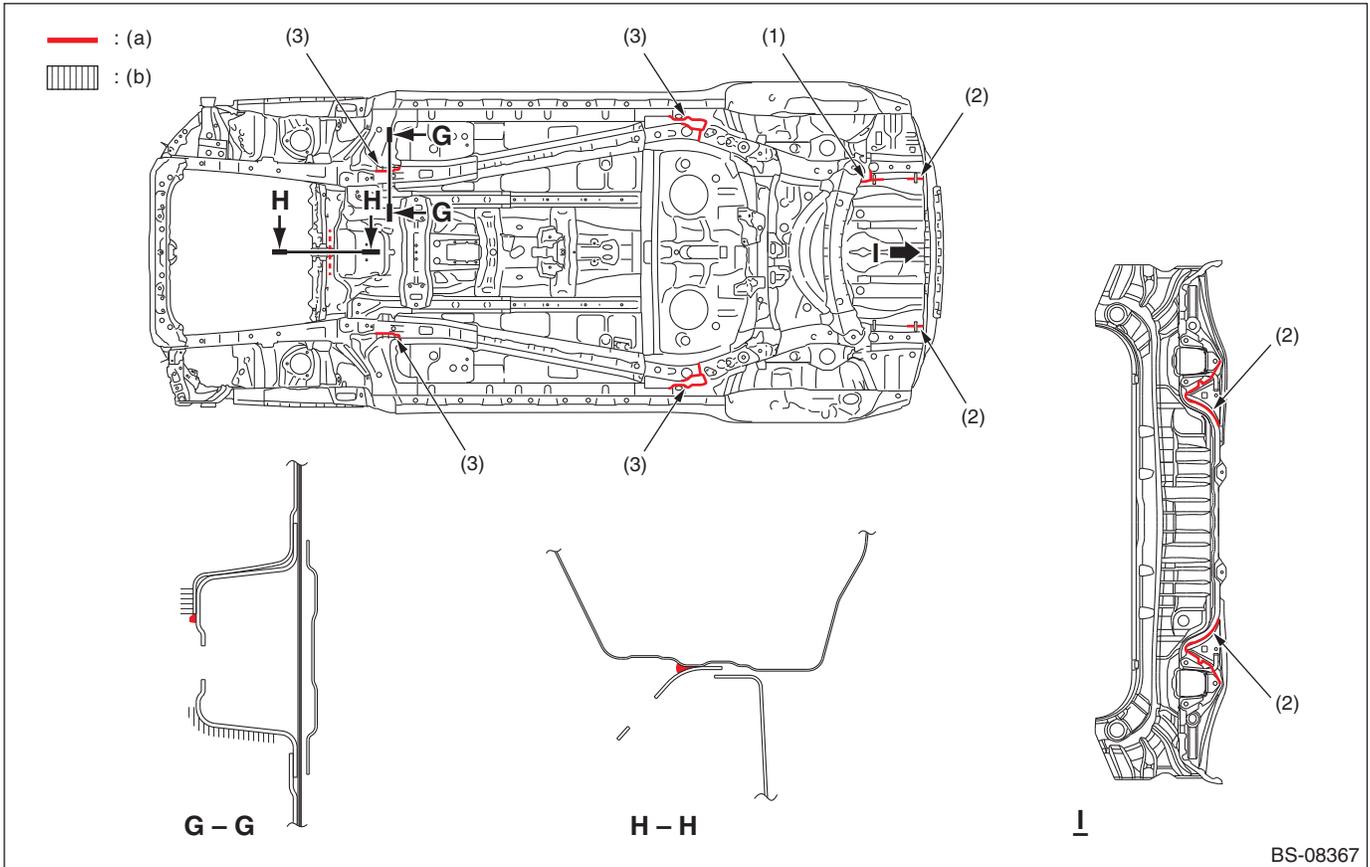


BS-08366

- (a) Rust-stop aerosol  
(Application thickness = 150  $\mu\text{m}$   
or more)
- (1) Apply wax so that the suspension arm bush and exhaust pipe are not waxed.

# Anticorrosion Wax

- Bottom view 2



(a) Rust-stop aerosol  
(Application thickness = 50  $\mu\text{m}$  or more)

(b) Rust-stop aerosol  
(Application thickness = 150  $\mu\text{m}$  or more)

(1) 5 door LH only  
(Sealing is allowable)

(2) 5 door only (Sealing is allowable)

(3) Common parts for 5 door and 4 door  
(Sealing is allowable)

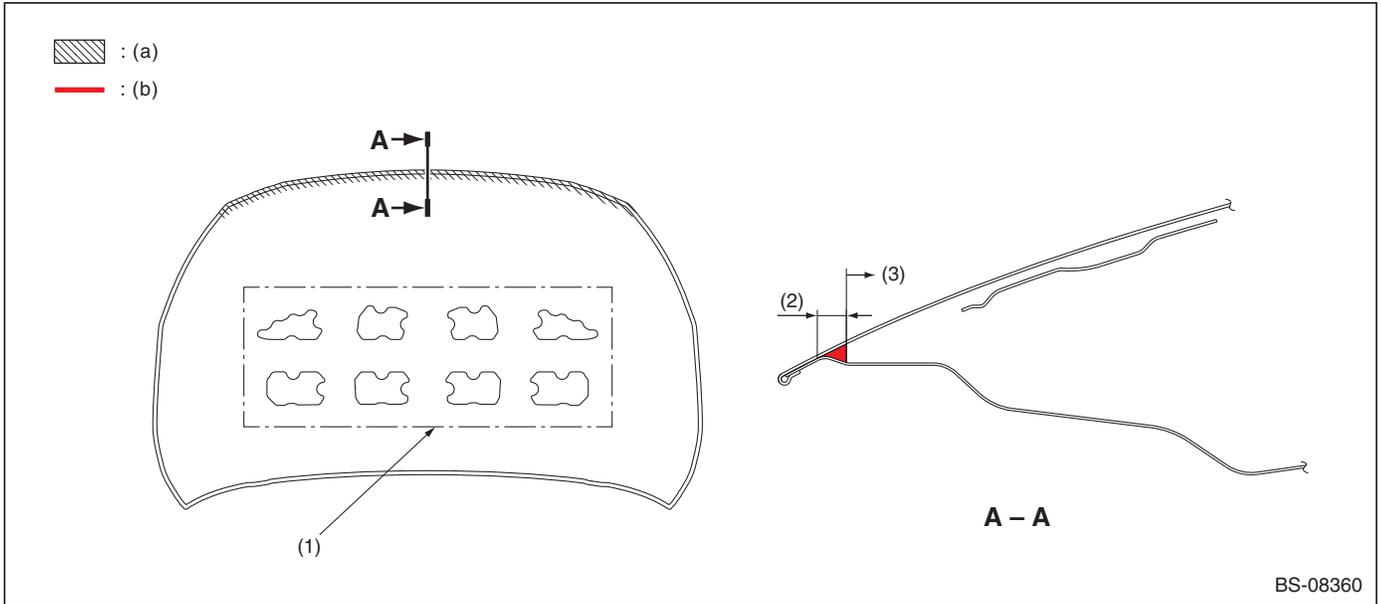
# Anticorrosion Wax

## B: SPECIFICATIONS (XV / Hybrid model)

Used material: Rust-stop aerosol (K0877YA015)

— and    : Application area

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



BS-08360

(a) Rust-stop aerosol

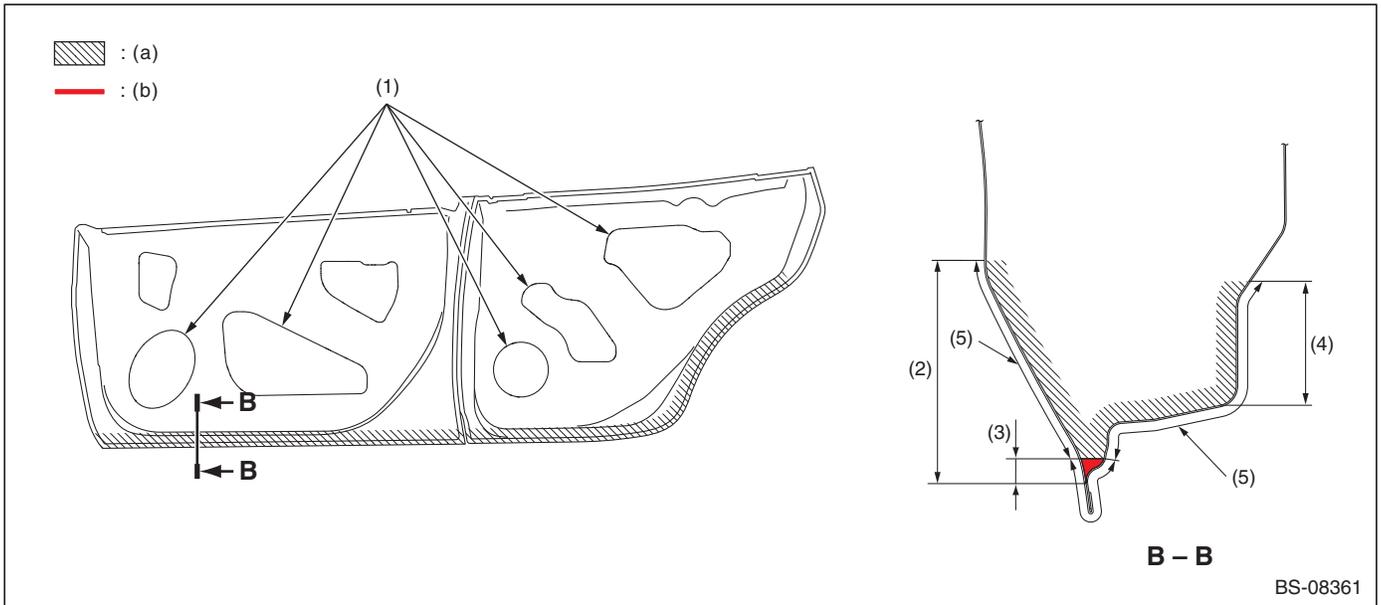
(b) To be filled into the plate joint

(1) Wax application work openings

(2) 10 mm (0.39 in)

(3) Adherence of mist is allowable

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



BS-08361

(a) Rust-stop aerosol

(b) To be filled into the plate joint

(1) Wax application work openings

(2) 10 mm (0.39 in)

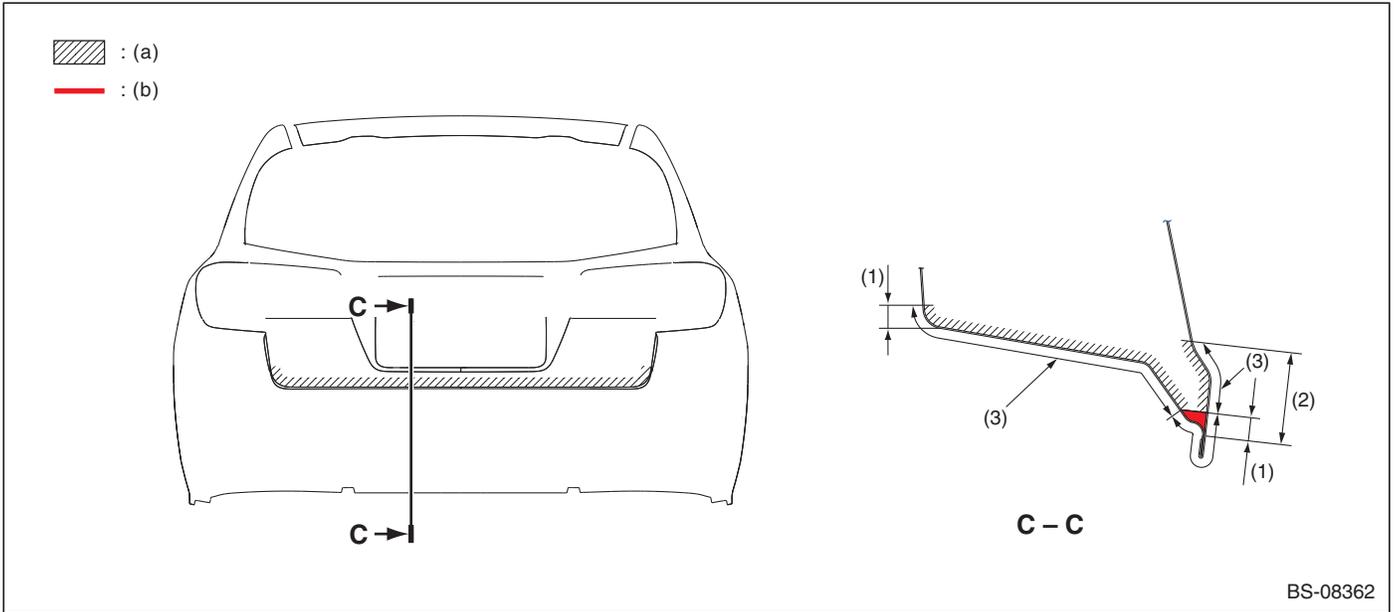
(3) Adherence of mist is allowable

(4) 90 mm (3.54 in)

(5) 50 mm (1.97 in)

# Anticorrosion Wax

- **Rear gate** (Application thickness = 50  $\mu\text{m}$  or more)



(a) Rust-stop aerosol

(b) To be filled into the plate joint

(1) 10 mm (0.39 in)

(2) 40 mm (1.57 in)

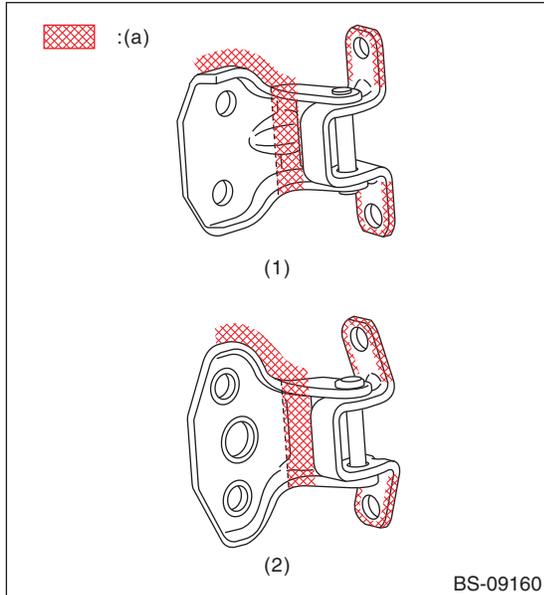
(3) Adherence of mist is allowable

# Anticorrosion Wax

- Front door hinge

(Application thickness = 15  $\mu\text{m}$  or more)

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

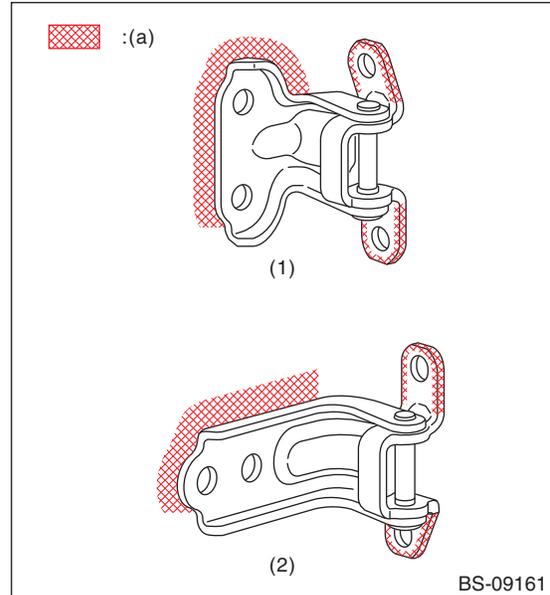


(a) Rust-stop aerosol

- Rear door hinge

(Application thickness = 15  $\mu\text{m}$  or more)

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

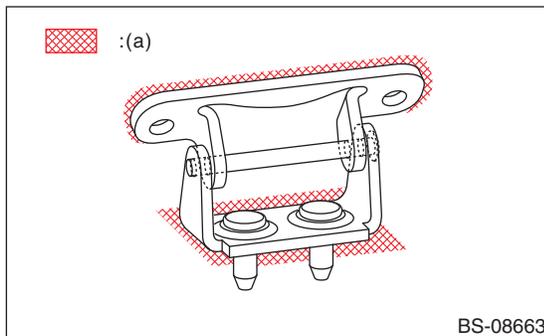


(a) Rust-stop aerosol

- Rear gate hinge

(Application thickness = 15  $\mu\text{m}$  or more)

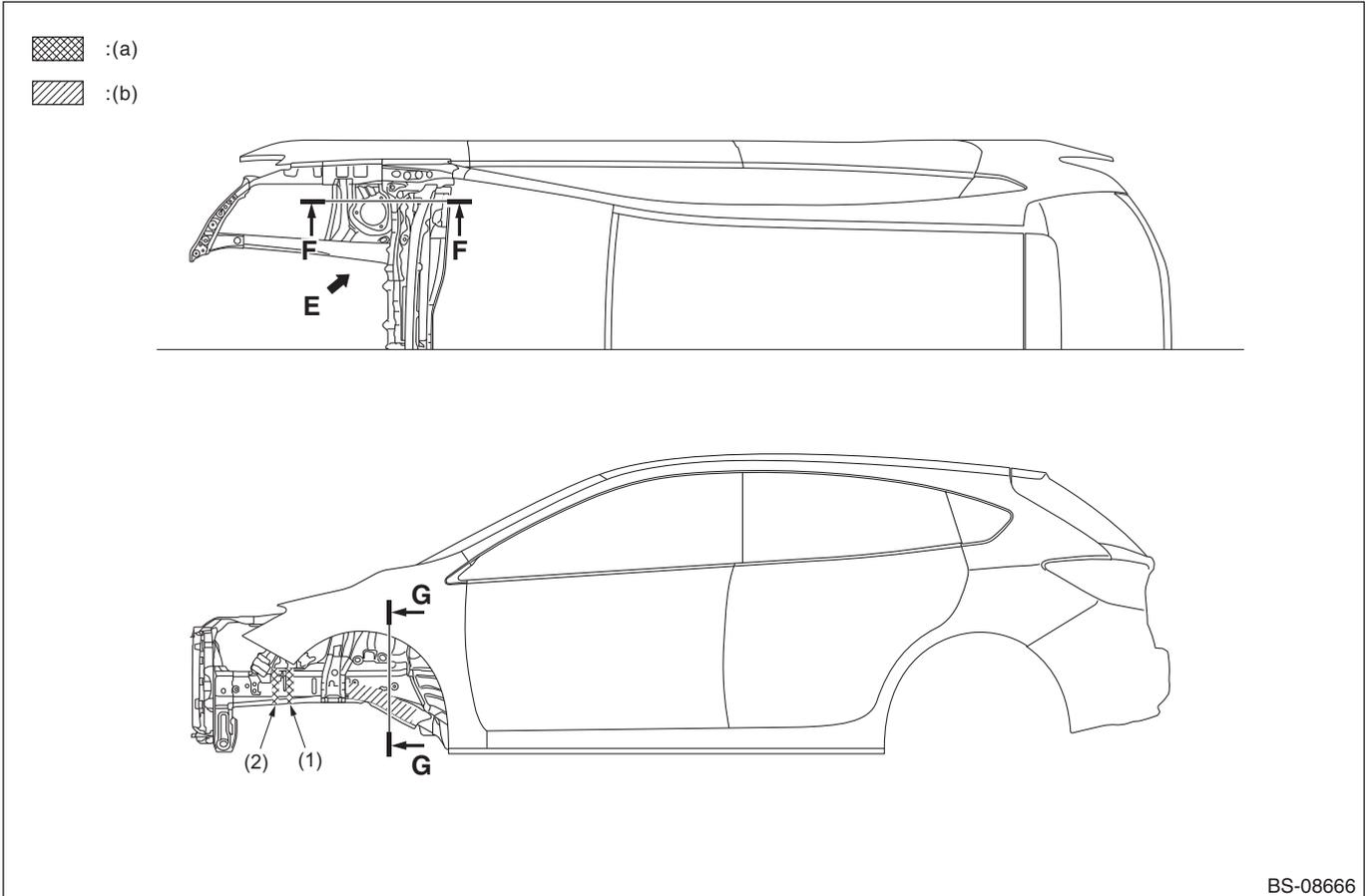
Apply to the contact surface on the body side at two locations on the left and right, and to installation outer circumference (indicated range, plate edges) on the rear gate side and to the head of the bolts.



(a) Rust-stop aerosol

# Anticorrosion Wax

- Overall view



BS-08666

(a) Rust-stop aerosol  
(Application thickness = 15  $\mu\text{m}$  or more)

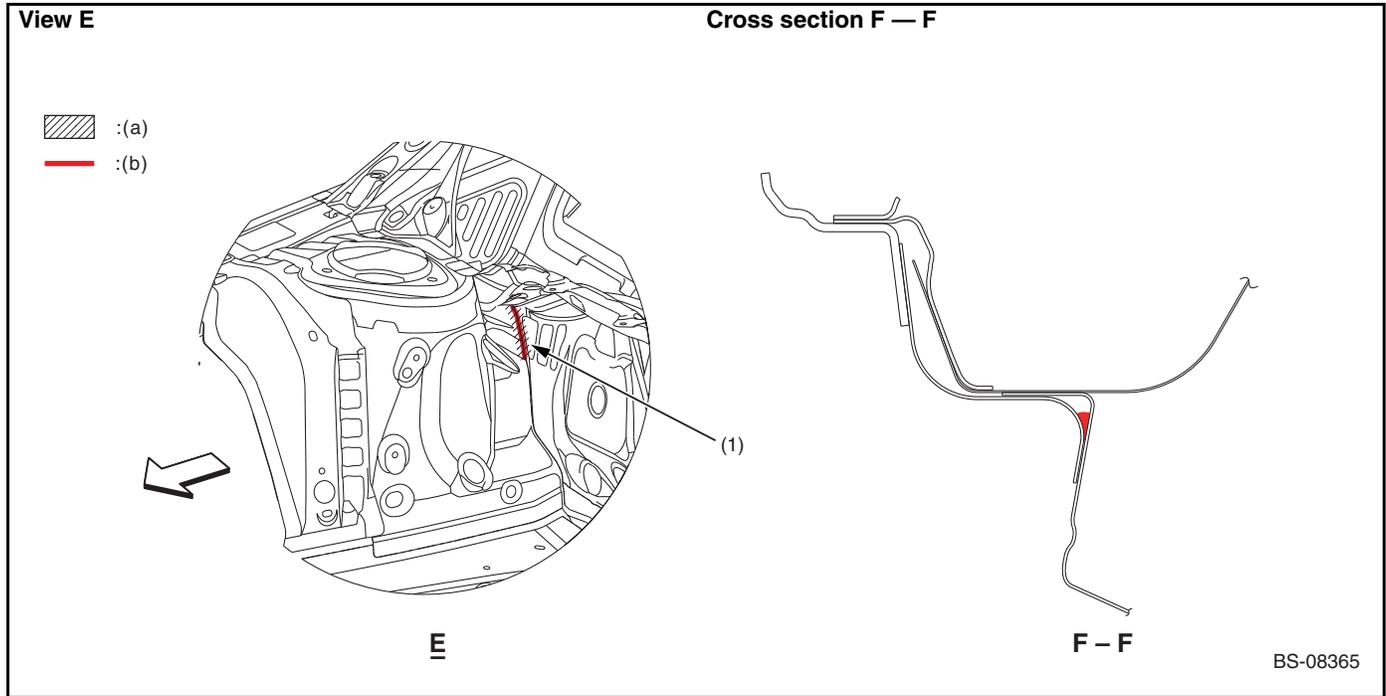
(b) Rust-stop aerosol  
(Application thickness = 50  $\mu\text{m}$  or more)

(1) The panel joints shall be covered

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

# Anticorrosion Wax

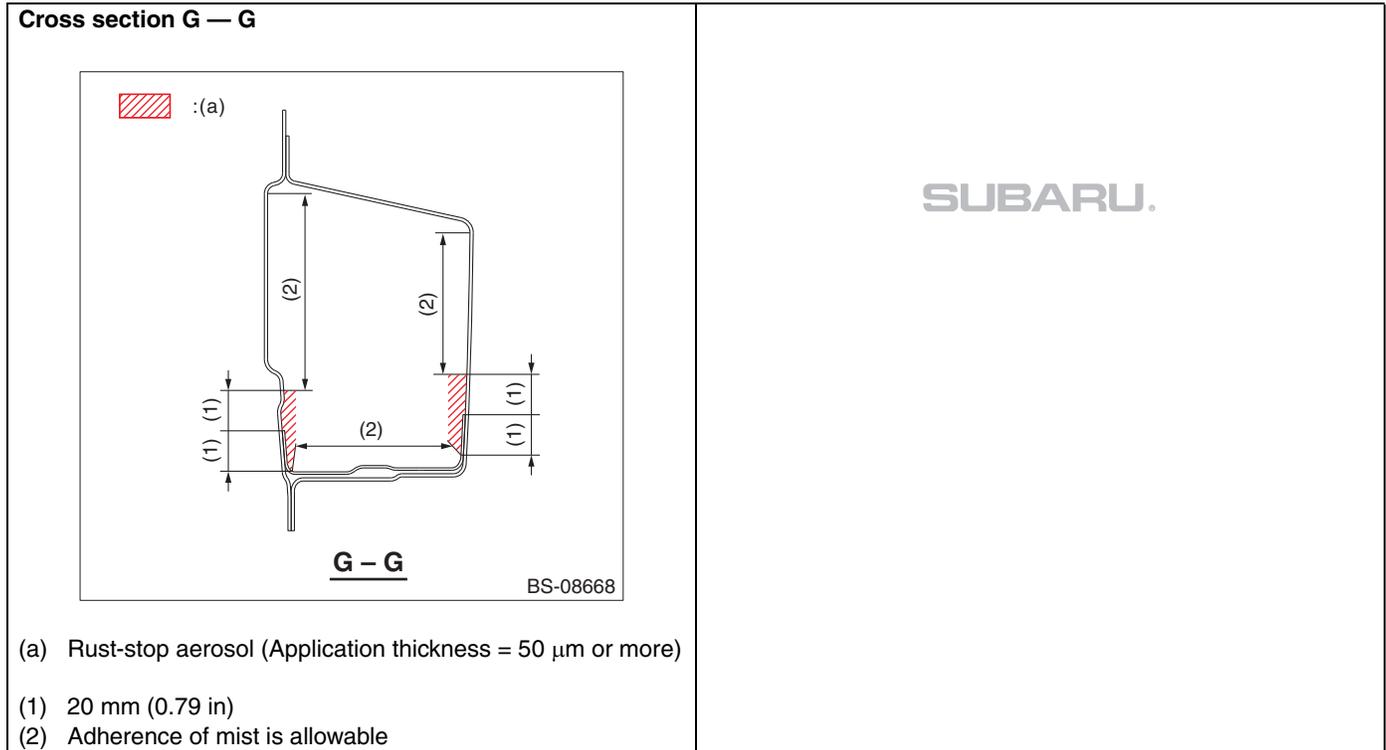
- View / Cross section



(a) Rust-stop aerosol  
(Application thickness = 50  $\mu\text{m}$  or more)

(b) Fill the mating area between plates.

(1) Securely cover the contact surface of the toe board, front suspension bracket. Wrap the sealing and wax securely.



(a) Rust-stop aerosol (Application thickness = 50  $\mu\text{m}$  or more)

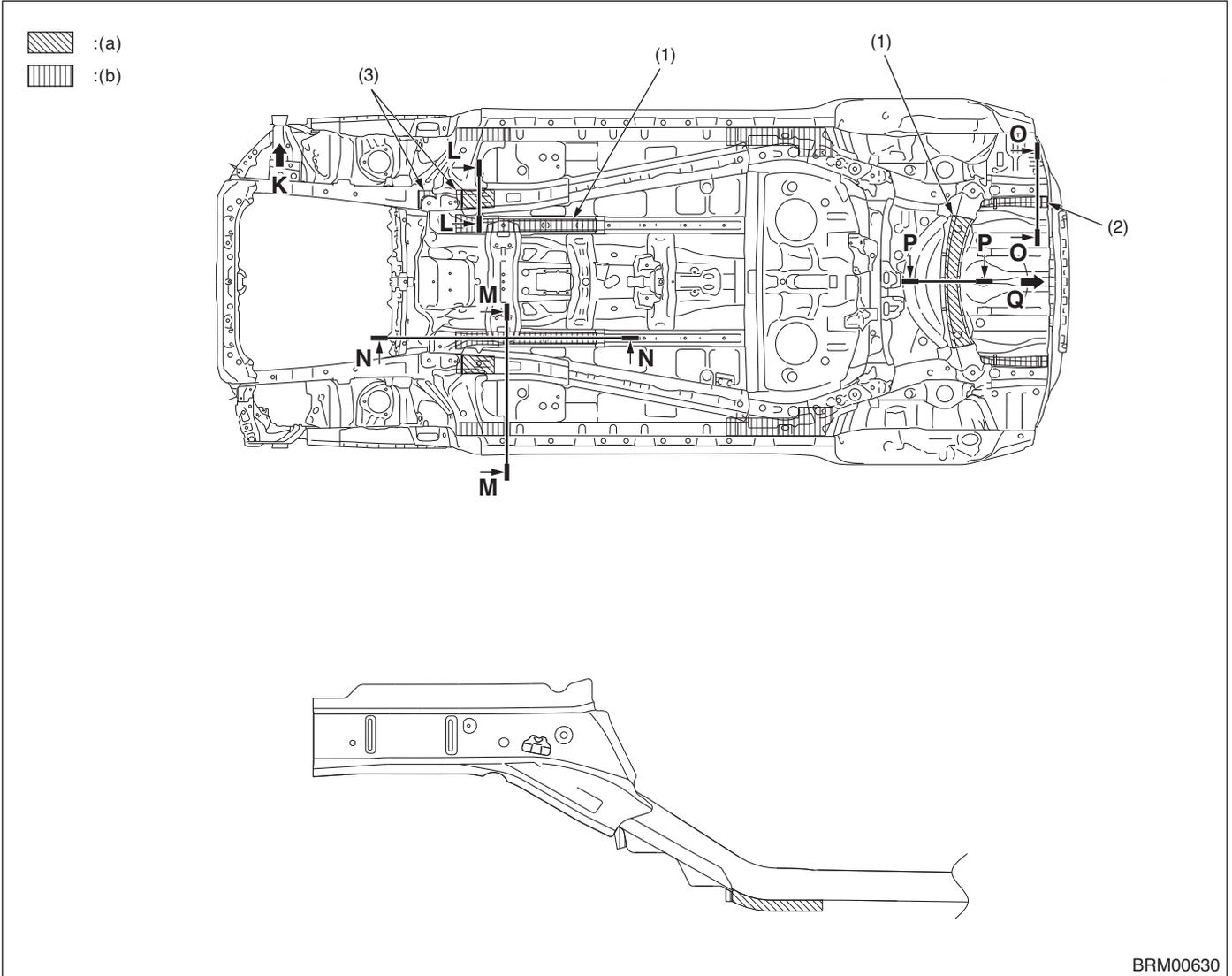
(1) 20 mm (0.79 in)

(2) Adherence of mist is allowable



# Anticorrosion Wax

- Bottom view



BRM00630

(a) Rust-stop aerosol  
(Application thickness = 50  $\mu\text{m}$  or more)

(b) Rust-stop aerosol  
(Application thickness = 150  $\mu\text{m}$  or more)

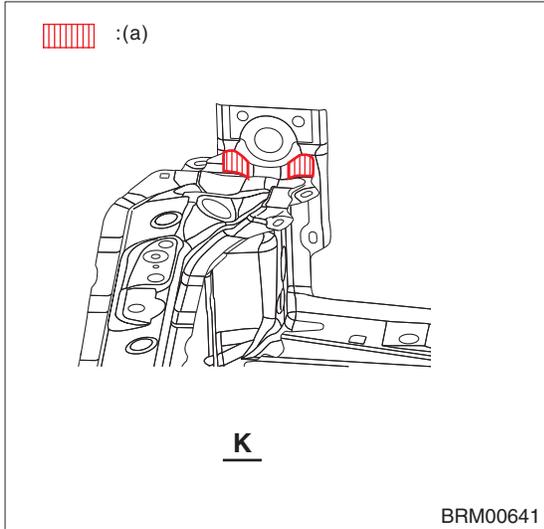
(1) Only XV model

(2) Be sure to apply wax to the plate round edge and also the area where sealant was not applied.

(3) Apply wax so that the ARM F bush and EPF are not waxed.

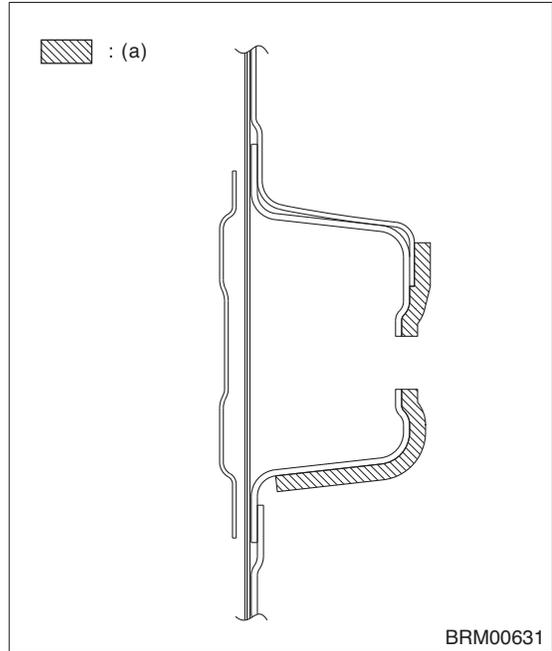
# Anticorrosion Wax

**View K**



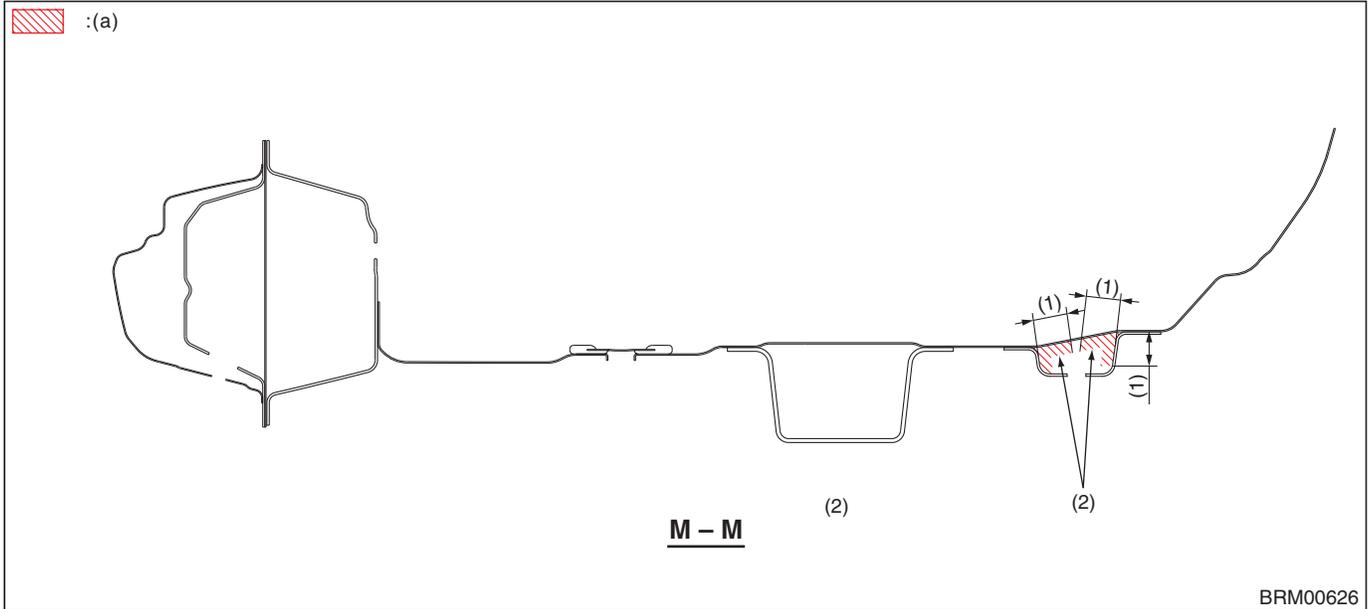
(a) Rust-stop aerosol (Application thickness = 150  $\mu\text{m}$  or more)

**Cross section L — L**



(a) Rust-stop aerosol (Application thickness = 50  $\mu\text{m}$  or more)

**Cross section M — M (Only XV model)**



(a) 50  $\mu\text{m}$  or more

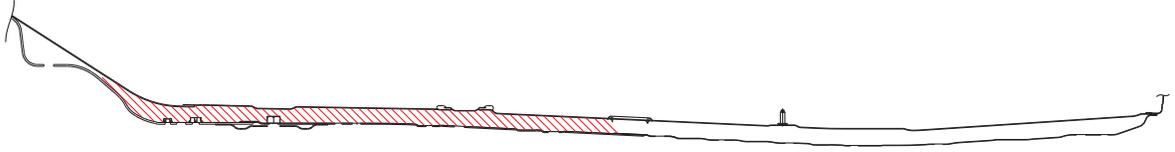
(1) 20 mm (0.79 in)

(2) Wax can be applied in the area outside of the application range of the tubular structure

# Anticorrosion Wax

## Cross section N — N (Only XV model)

 : (a)



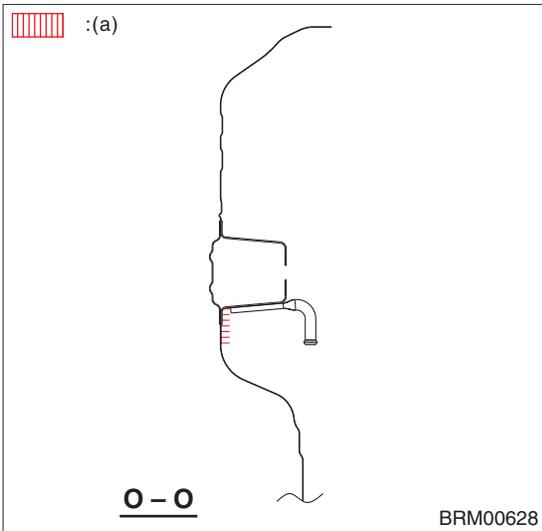
N - N

BRM00627

(a) 50  $\mu\text{m}$  or more

## Cross section O — O

 : (a)



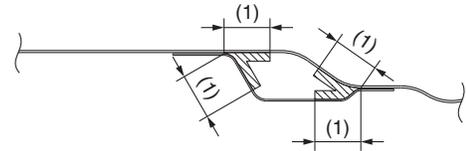
O - O

BRM00628

(a) 150  $\mu\text{m}$  or more

## Cross section P — P (Only XV model)

 : (a)



P - P

BRM00632

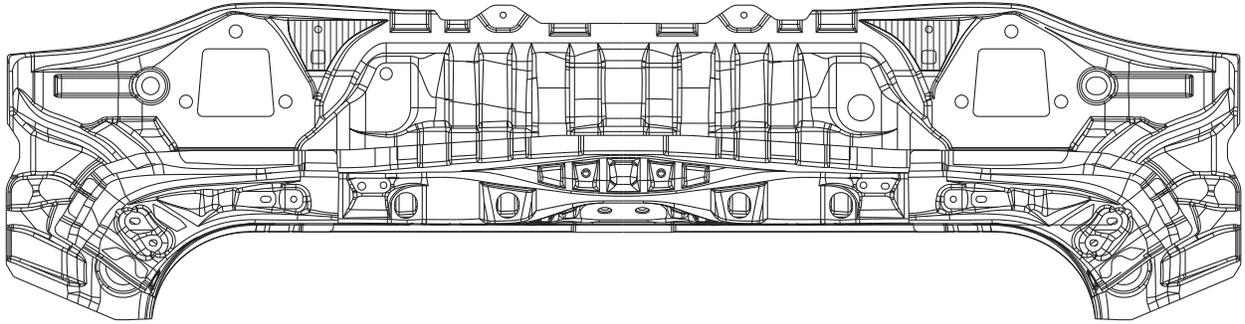
(a) 50  $\mu\text{m}$  or more

(1) 20 mm (0.79 in)

# Anticorrosion Wax

View Q

 : (a)



Q

BRM00633

(a) 150  $\mu$ m or more

# Undercoat

## 11.Undercoat

### A: SPECIFICATIONS (5D/4D model)

Repair material: PVC (NT guardcoat 5900FL)

#### CAUTION:

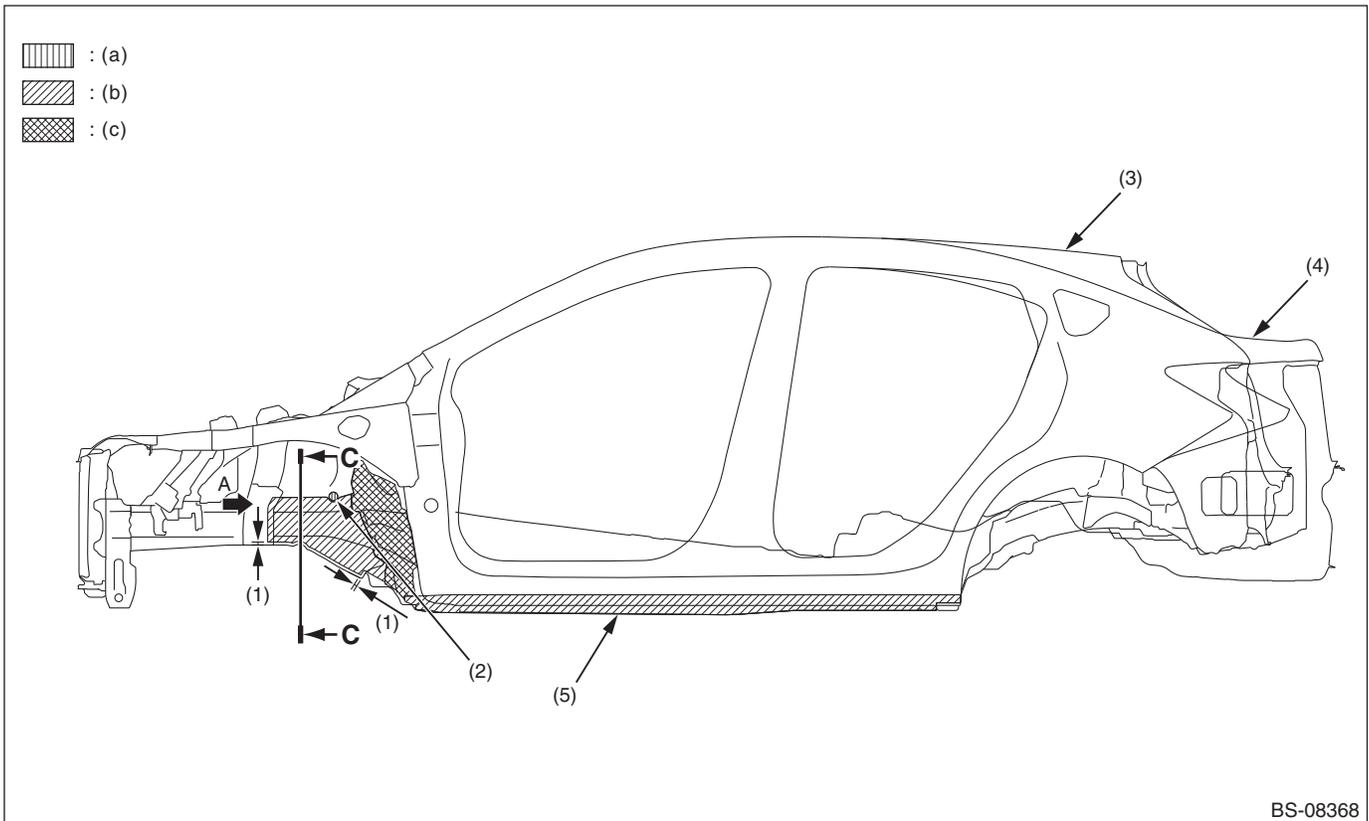
**Be careful not to let the undercoating be attached to any parts not indicated below and to the following locations.**

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

#### 1) Application area and application thickness

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

#### • Side view



BS-08368

(a) 200 μm or more

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

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

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

(3) 5 Door

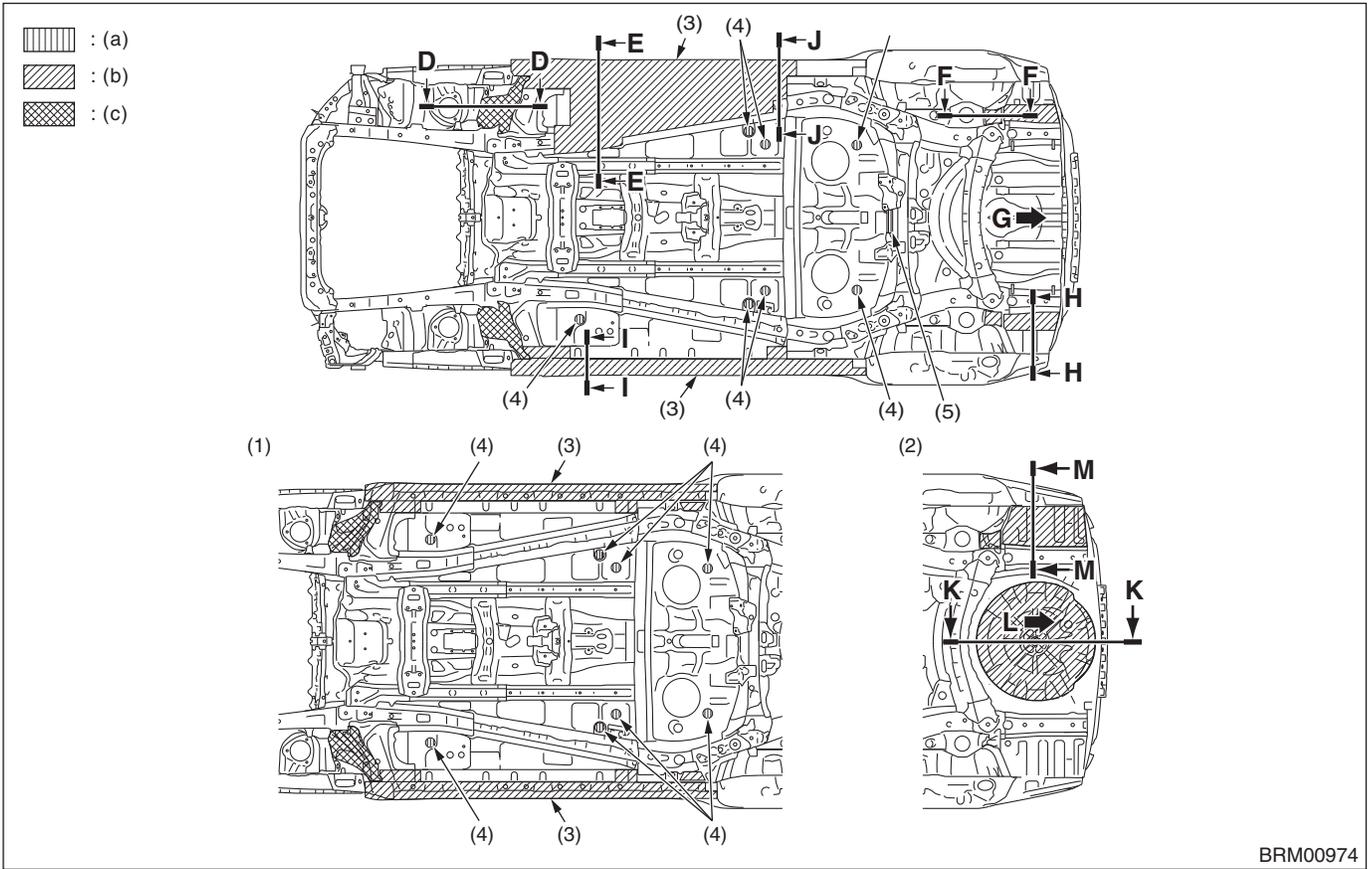
(5) Only for the models without under  
cover, and the models with under  
cover and without side sill spoiler

(2) Plug must be covered with PVC

(4) 4 Door

# Undercoat

- Bottom view



BRM00974

(a) 200 μm or more

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

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

(1) Only for the models with under cover

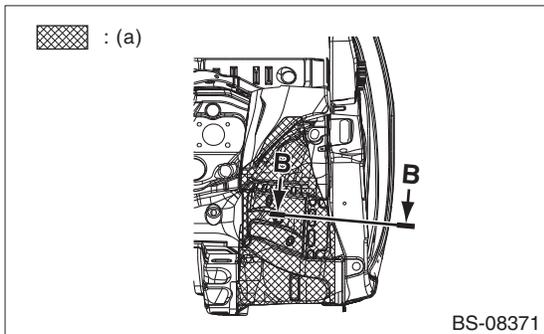
(3) Only for the models without side sill spoiler

(5) Apply PVC to the air pocket area.

(2) 4 Door

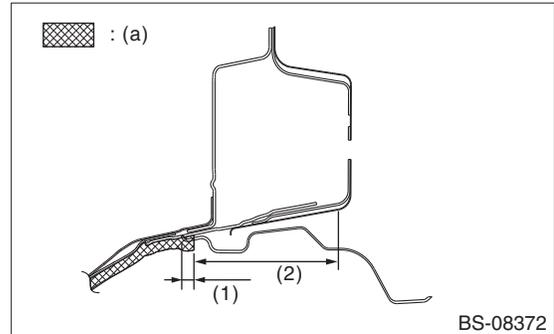
(4) Plug must be covered with undercoat

## View A



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

## Cross section B — B



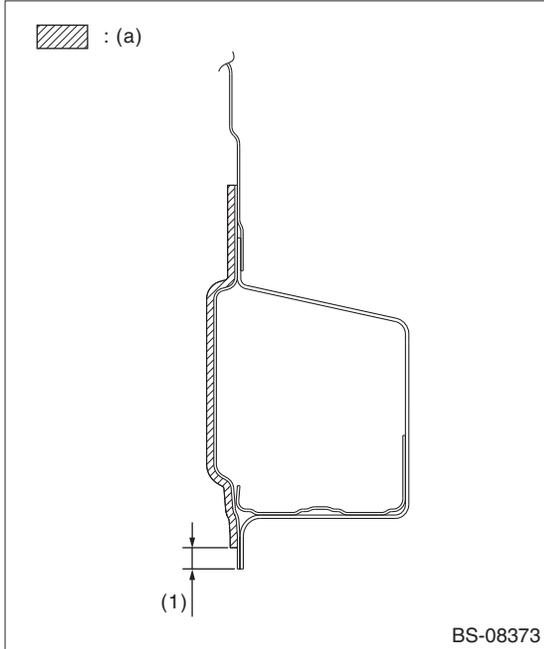
(a) Dry: 780 μm or more, Wet: 630 μm or more

(1) 10 mm (0.39 in)

(2) Adherence of mist is allowable

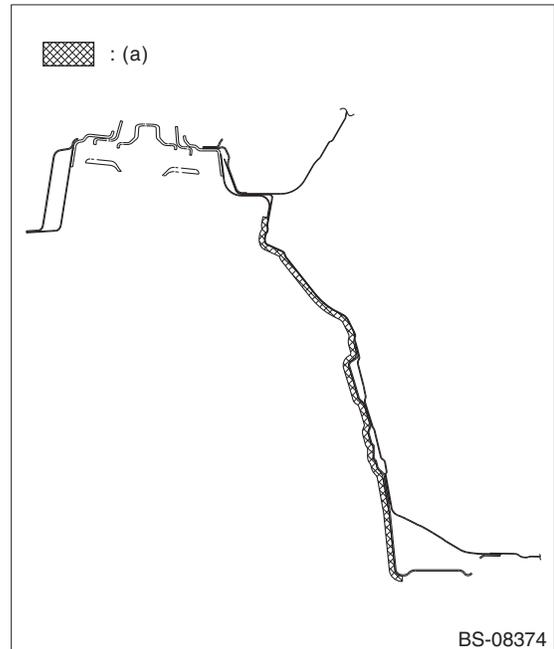
# Undercoat

**Cross section C — C**



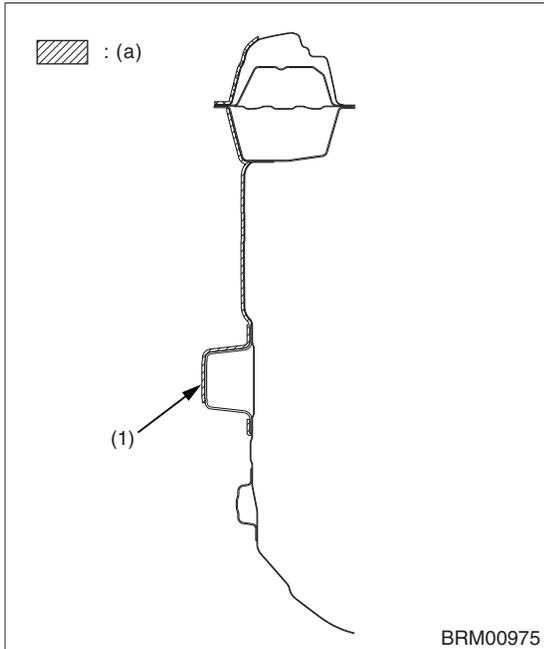
- (a) Dry: 340  $\mu\text{m}$  or more, Wet: 330  $\mu\text{m}$  or more
- (1) 10 mm (0.39 in) (Adherence of mist is allowable)

**Cross section D — D**



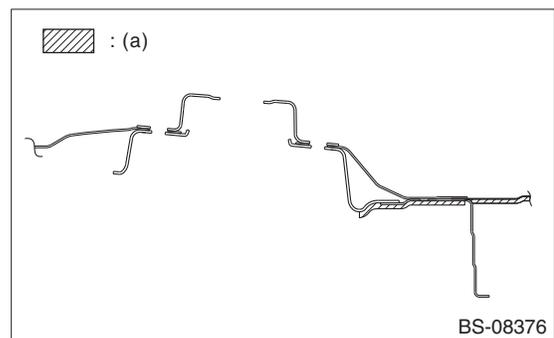
- (a) Dry: 780  $\mu\text{m}$  or more, Wet: 630  $\mu\text{m}$  or more

**Cross section E — E**



- (a) Dry: 340  $\mu\text{m}$  or more, Wet: 330  $\mu\text{m}$  or more
- (1) Model without under cover: LH only

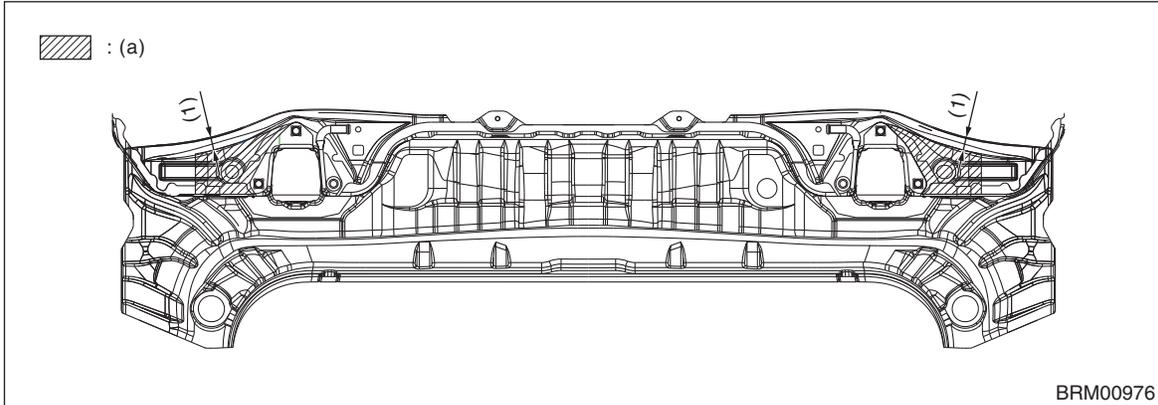
**Cross section F — F**



- (a) Dry: 340  $\mu\text{m}$  or more, Wet: 330  $\mu\text{m}$  or more

# Undercoat

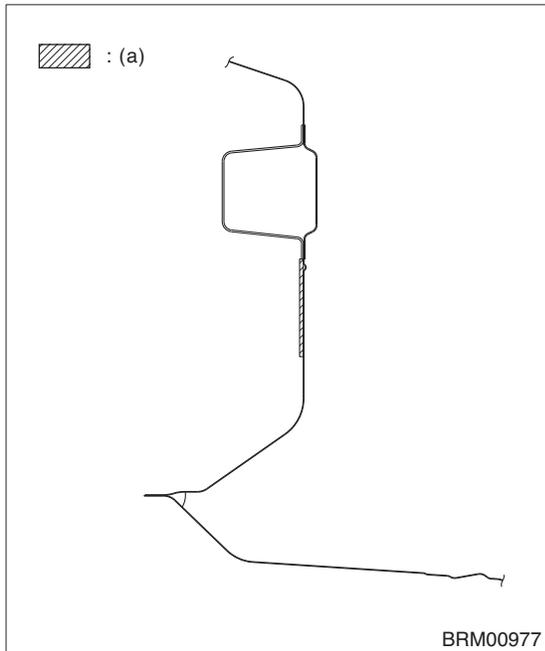
View G



(a) Dry: 340  $\mu\text{m}$  or more, Wet: 330  $\mu\text{m}$  or more

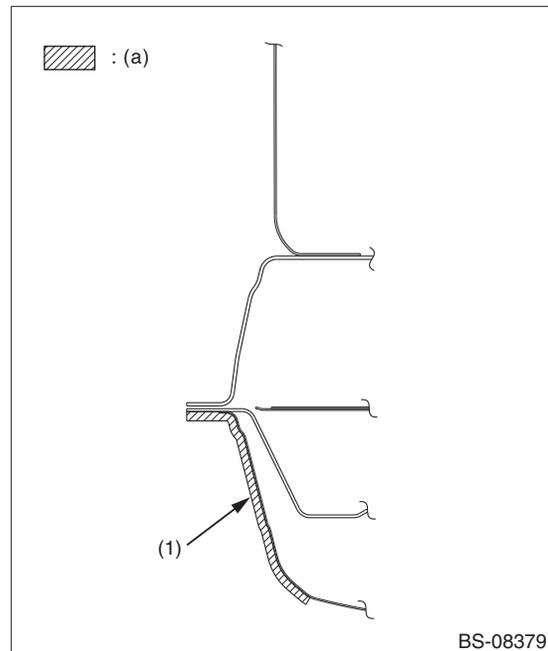
(1) 20 mm (0.79 in)

Cross section H — H



(a) Dry: 340  $\mu\text{m}$  or more, Wet: 330  $\mu\text{m}$  or more

Cross section I — I

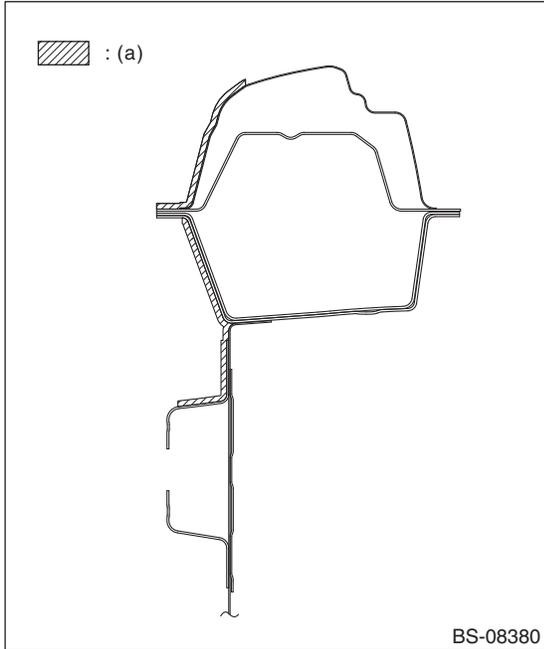


(a) Dry: 340  $\mu\text{m}$  or more, Wet: 330  $\mu\text{m}$  or more

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

# Undercoat

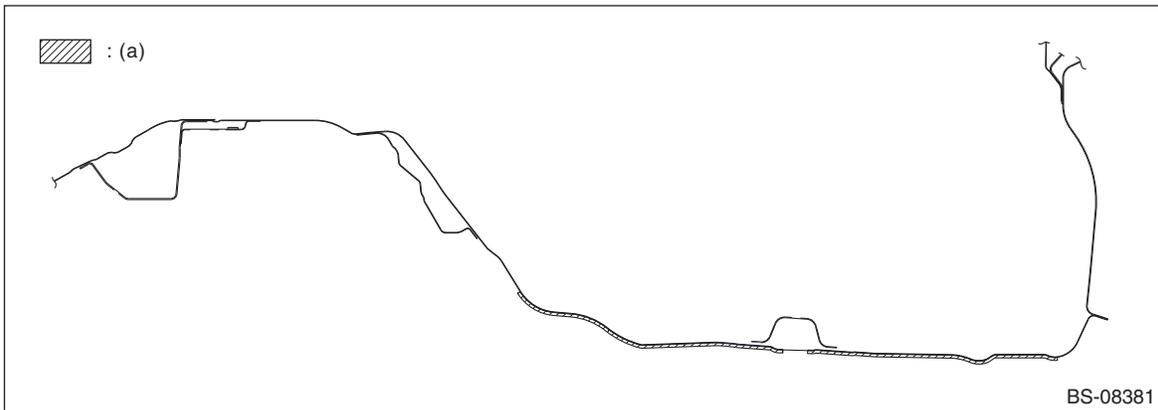
Cross section J — J



(a) Dry: 340  $\mu\text{m}$  or more, Wet: 330  $\mu\text{m}$  or more

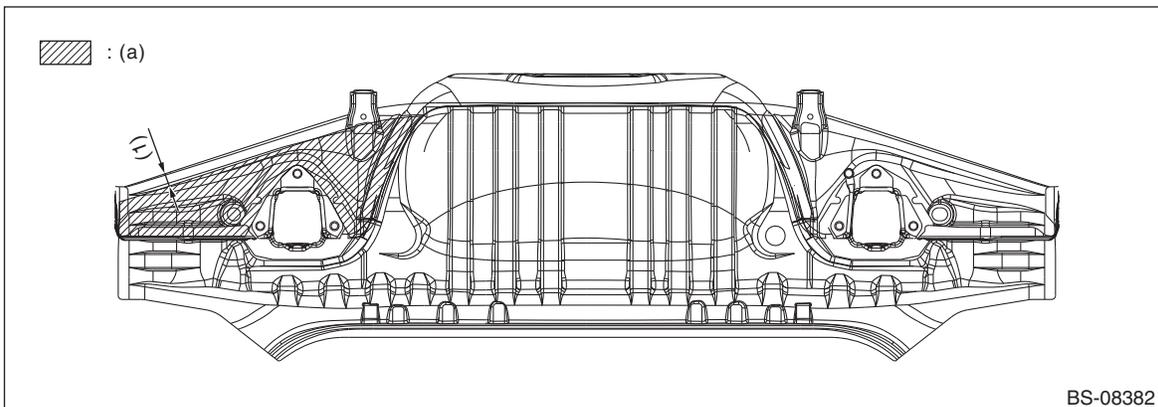
SUBARU.

Cross section K — K



(a) Dry: 340  $\mu\text{m}$  or more, Wet: 330  $\mu\text{m}$  or more

View L

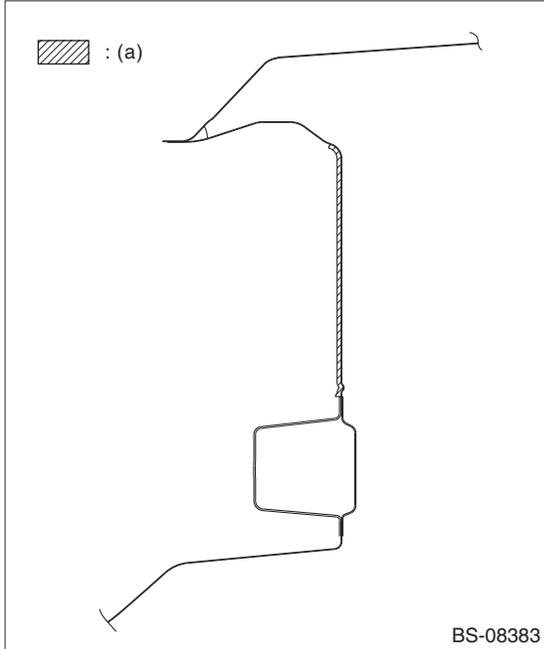


(a) Dry: 340  $\mu\text{m}$  or more, Wet: 330  $\mu\text{m}$  or more

(1) 20 mm (0.79 in)

# Undercoat

Cross section M — M



(a) Dry: 340  $\mu\text{m}$  or more, Wet: 330  $\mu\text{m}$  or more

SUBARU.

# Undercoat

## B: SPECIFICATIONS (XV / Hybrid model)

Repair material: PVC (NT guardcoat 5900FL)

### CAUTION:

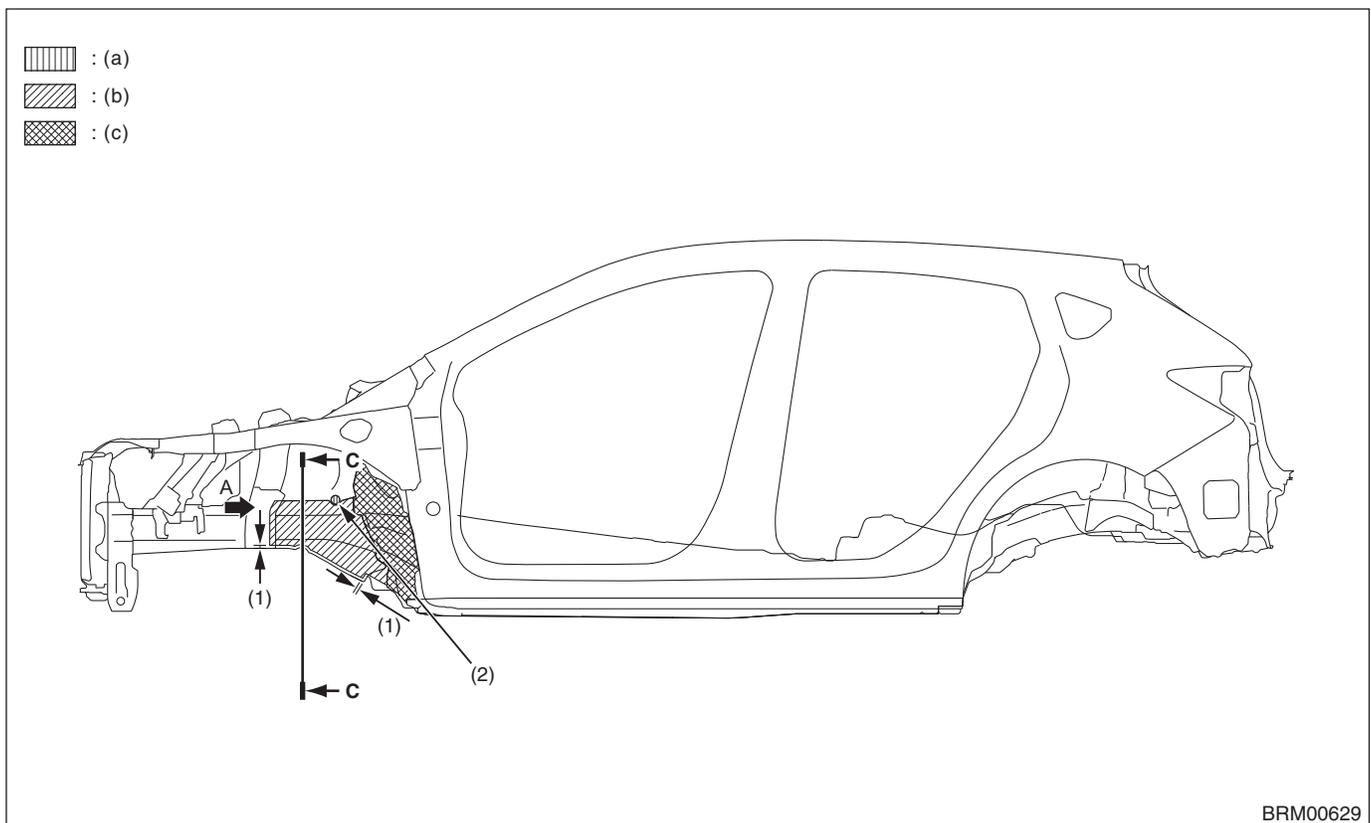
Be careful not to let the undercoating be attached to any parts not indicated below and to the following locations.

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

### 1) Application area and application thickness

	200 μm or more
	300 μm — 500 μm
	600 μm — 800 μm

### • Side view



(a) 200 μm or more

(b) 300 μm — 500 μm

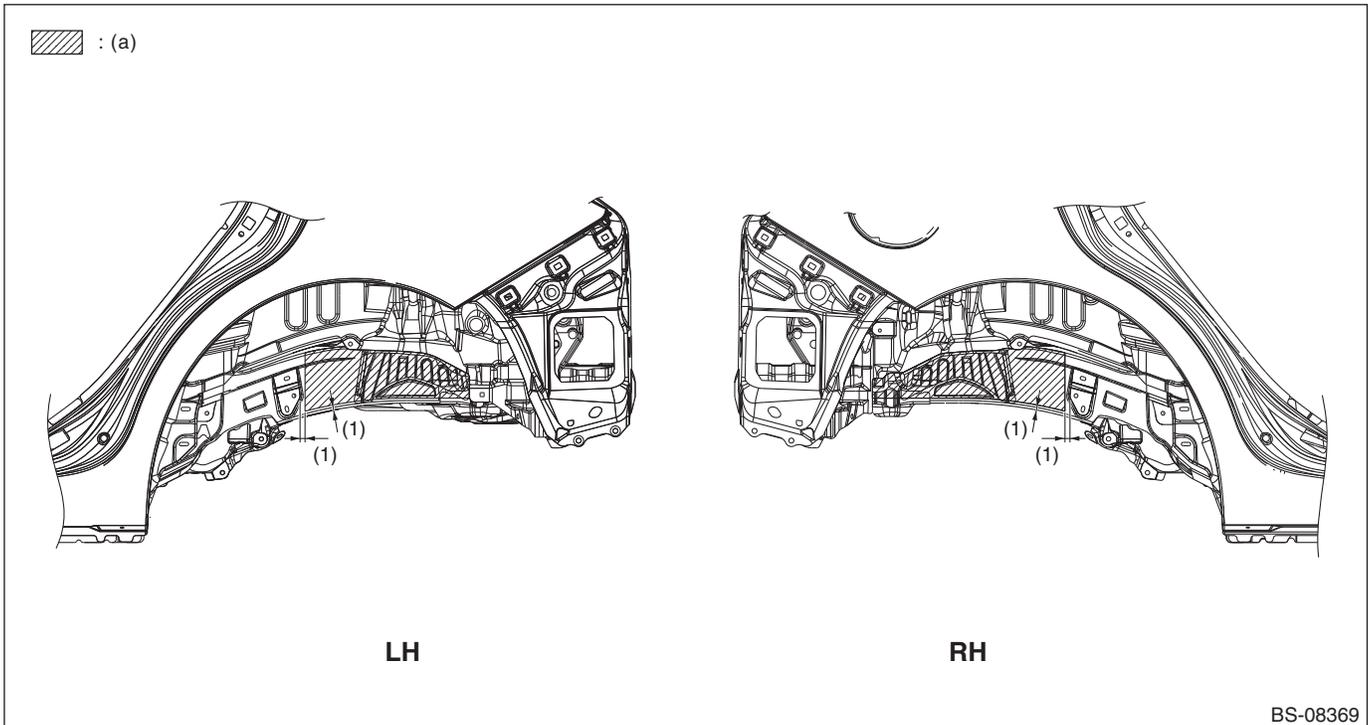
(c) 600 μm — 800 μm

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

(2) Plug must be covered with PVC

# Undercoat

- Rear wheel apron side view

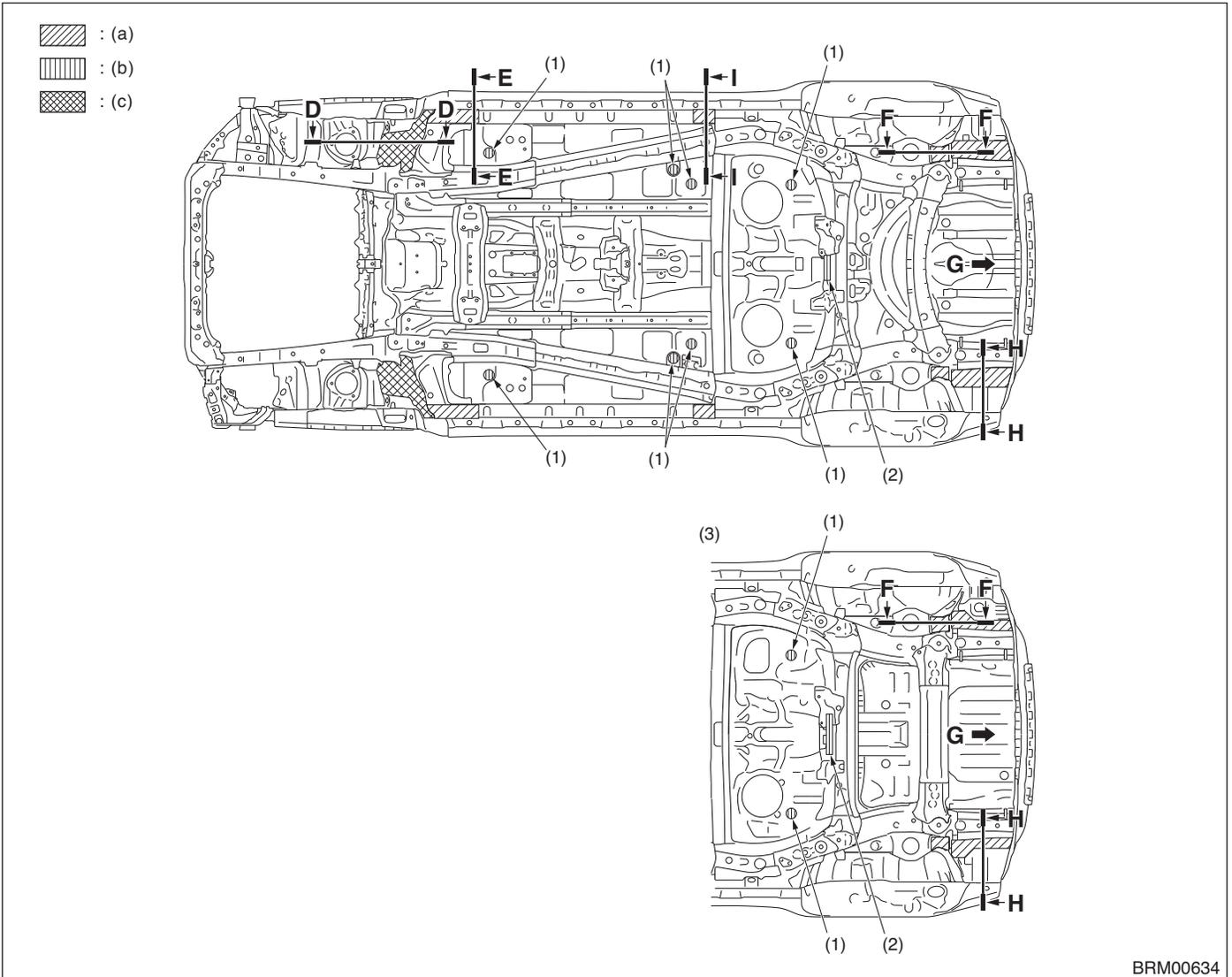


(a) 300  $\mu\text{m}$  — 500  $\mu\text{m}$

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

# Undercoat

- Bottom view



BRM00634

(a) 300 μm — 500 μm

(b) 200 μm or more

(c) 600 μm — 800 μm

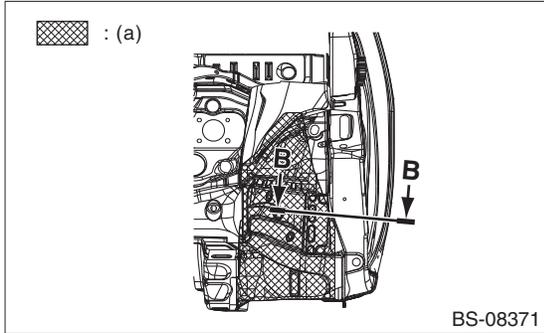
(1) Plug must be covered with PVC

(2) Apply PVC to the air pocket area.

(3) Hybrid model

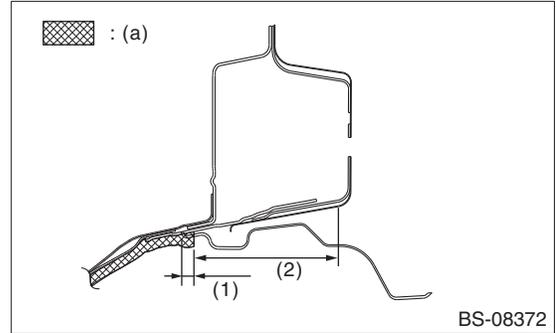
# Undercoat

**View A**



(a) 600  $\mu\text{m}$  — 800  $\mu\text{m}$

**Cross section B — B**

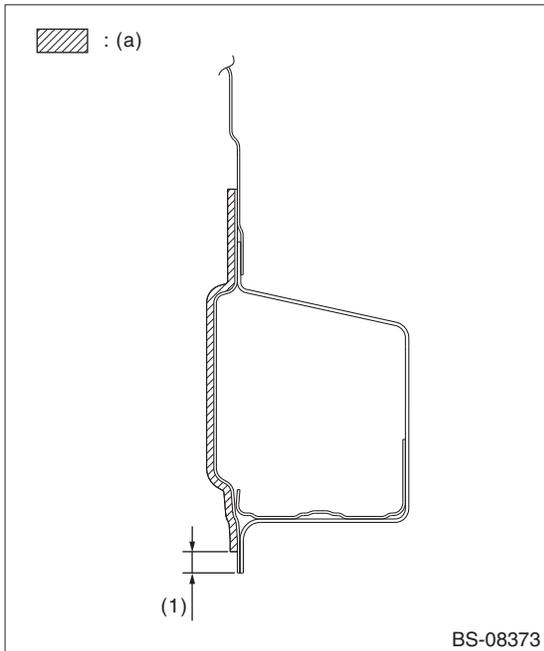


(a) 600  $\mu\text{m}$  — 800  $\mu\text{m}$

(1) 10 mm (0.39 in)

(2) Adherence of mist is allowable

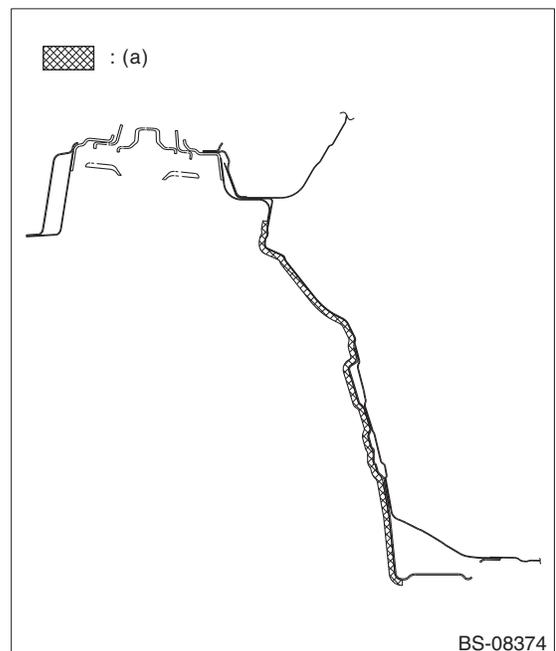
**Cross section C — C**



(a) 300  $\mu\text{m}$  — 500  $\mu\text{m}$

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

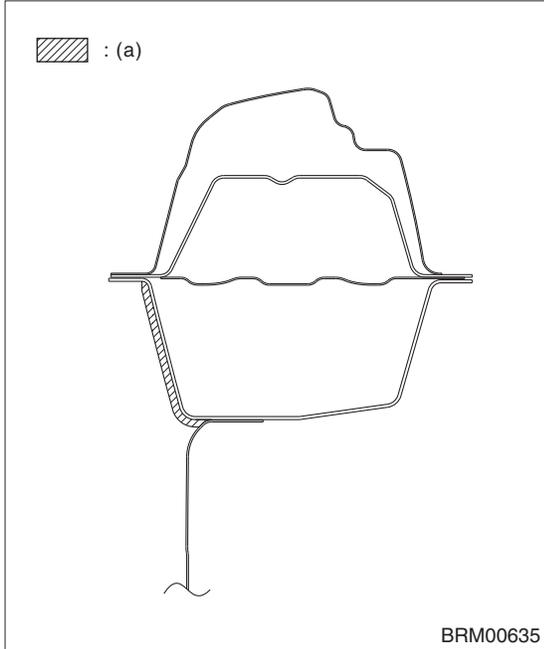
**Cross section D — D**



(a) 600  $\mu\text{m}$  — 800  $\mu\text{m}$

# Undercoat

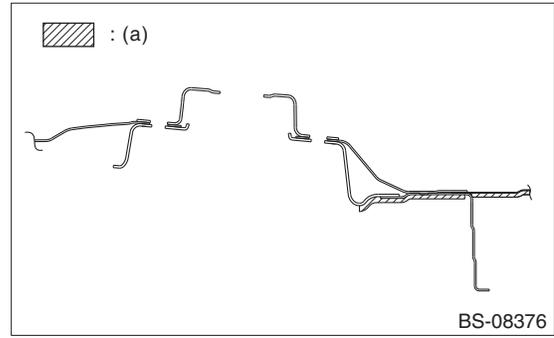
Cross section E — E



(a) 300  $\mu\text{m}$  — 500  $\mu\text{m}$

BRM00635

Cross section F — F

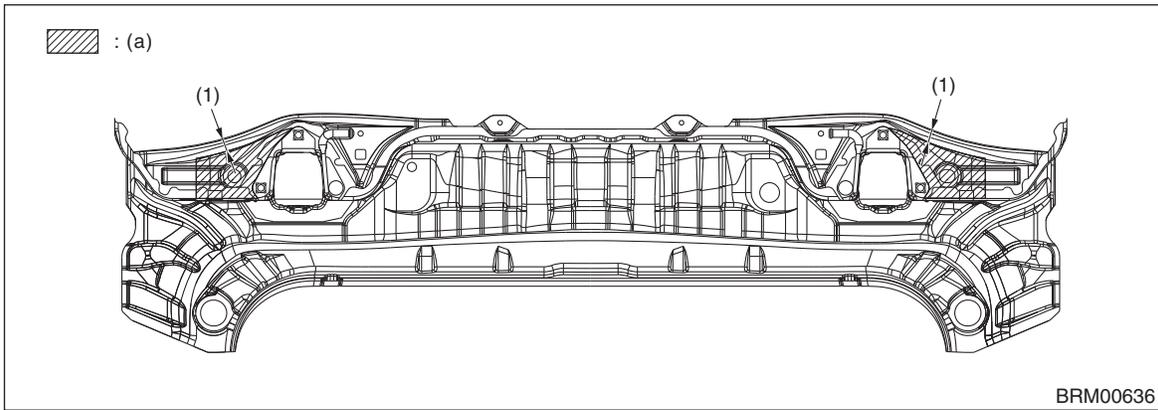


BS-08376

(a) 300  $\mu\text{m}$  — 500  $\mu\text{m}$

SUBARU.

View G



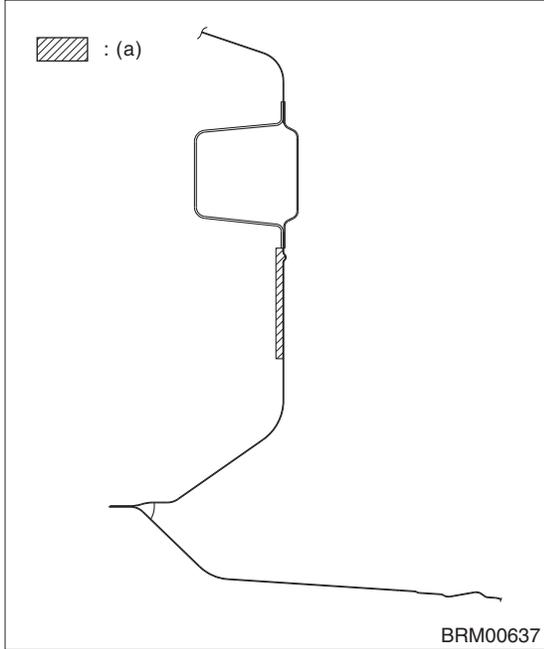
BRM00636

(a) 300  $\mu\text{m}$  — 500  $\mu\text{m}$

(1) 20 mm (0.79 in)

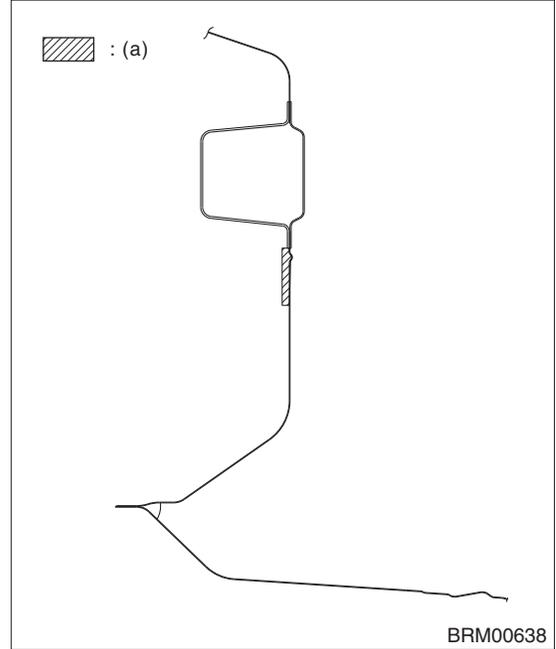
# Undercoat

Cross section H — H (XV model)



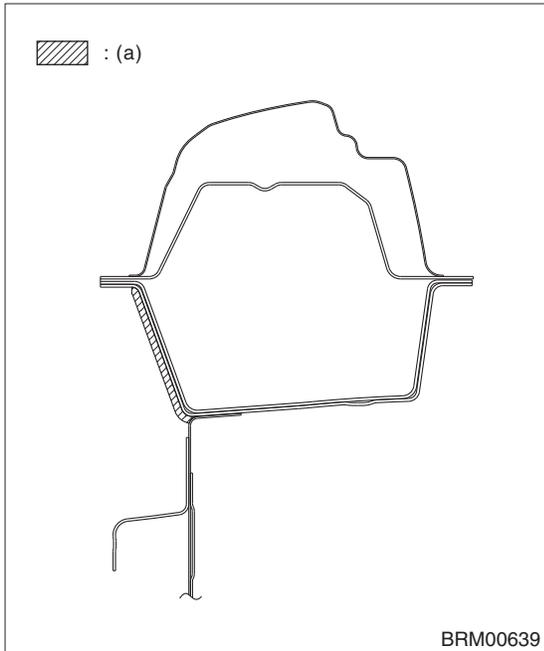
(a) 300  $\mu$ m — 500  $\mu$ m

Cross section H — H (Hybrid model)



(a) 300  $\mu$ m — 500  $\mu$ m

Cross section I — I



(a) 300  $\mu$ m — 500  $\mu$ m

SUBARU.

# Damping Seat

## 12. Damping Seat

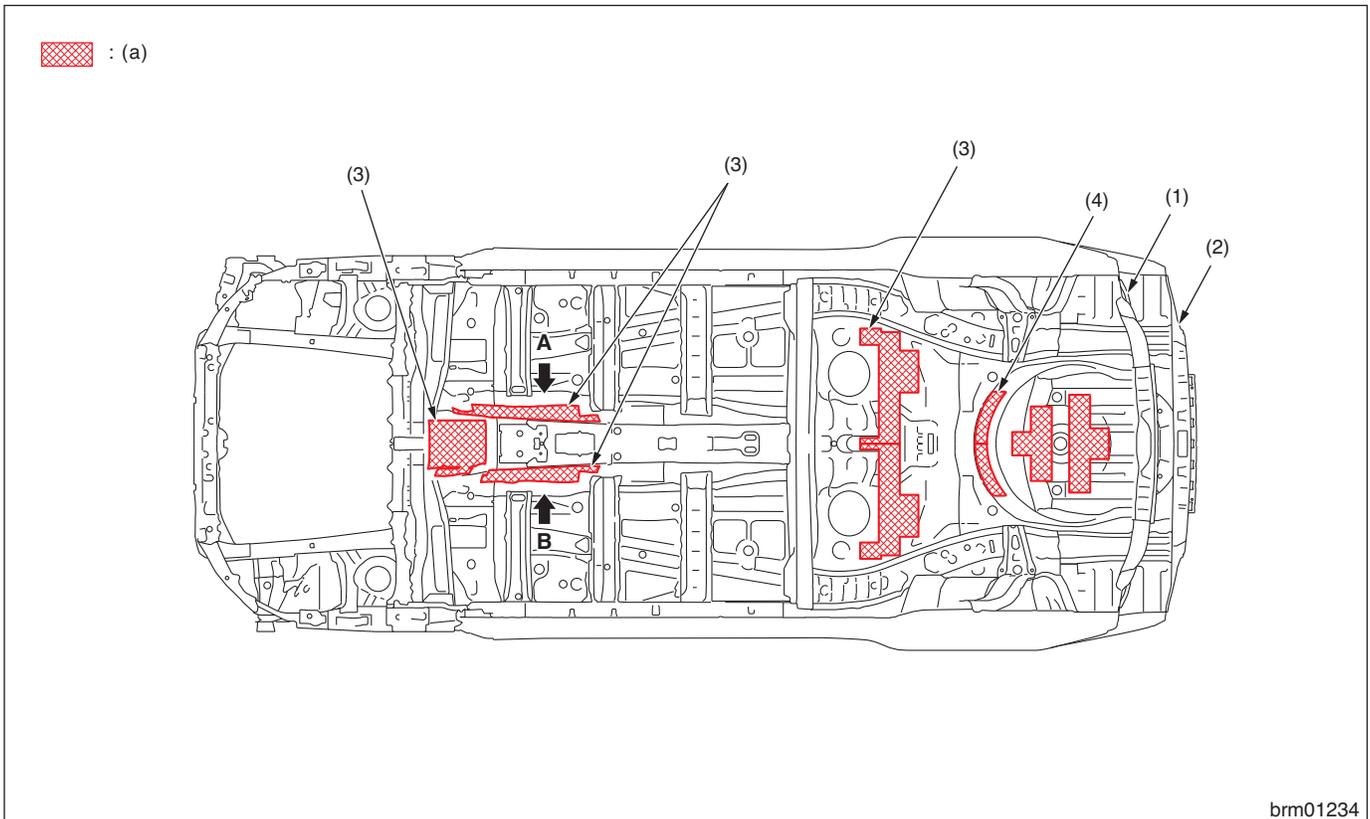
### A: SPECIFICATIONS

#### 1. COMMON PARTS FOR 5 DOOR AND 4 DOOR

##### CAUTION:

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

##### • Upper view



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

(1) 5 Door

(3) Except for 2.0 i models

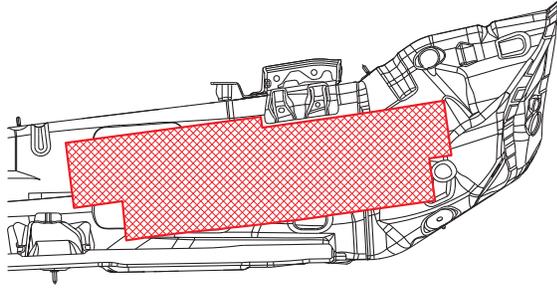
(4) Only for 5 Door models except for  
2.0 i

(2) 4 Door

# Damping Seat

View A (turned 180°)

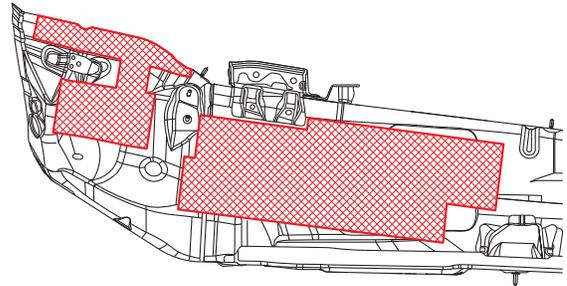
 : (a)



BRM01235

View B

 : (a)



BRM01236

- (a) Thickness of the silencer:  
2.5 mm (0.10 in)

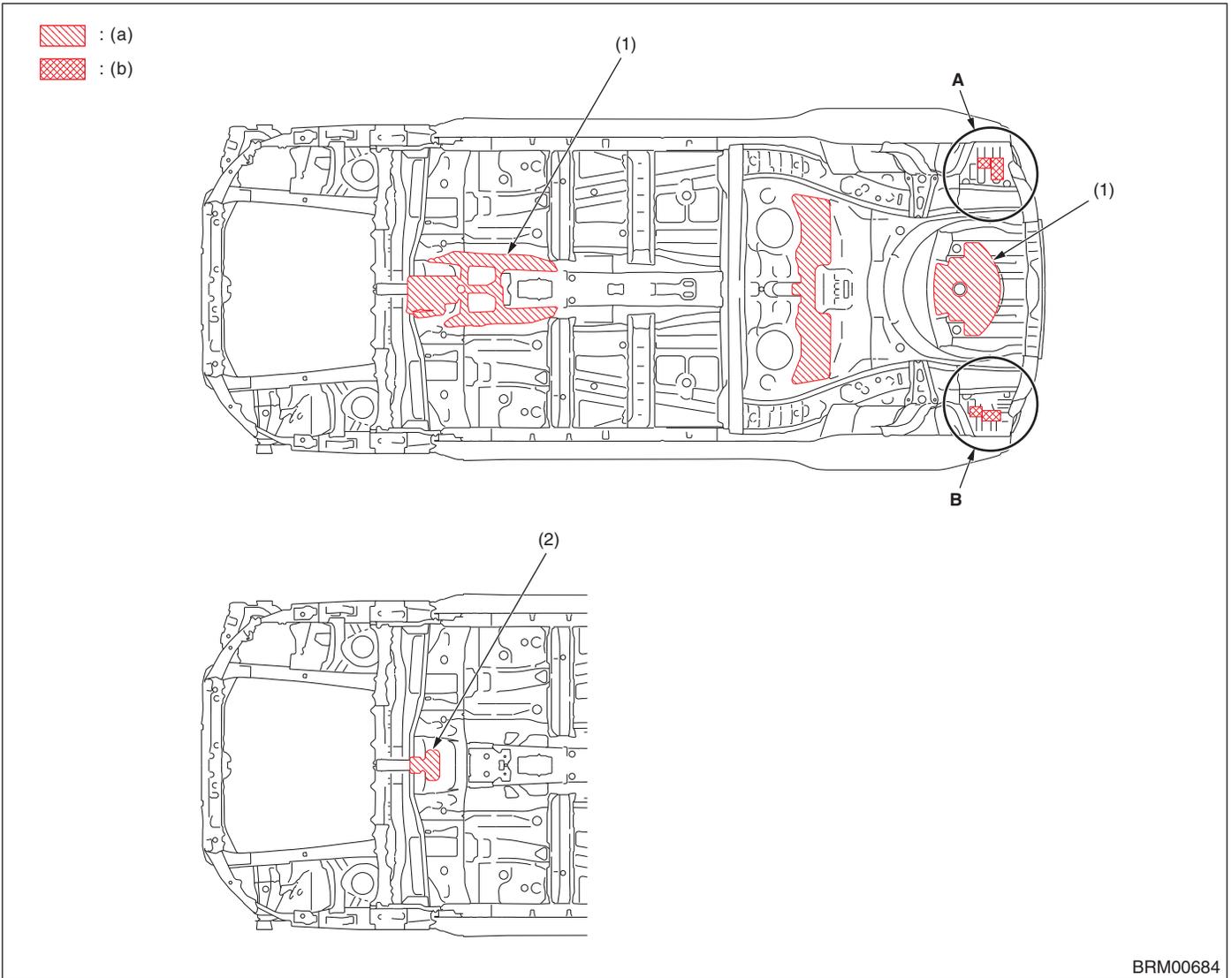
# Damping Seat

## 2. XV model

### CAUTION:

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

### • Upper view 1



BRM00684

(a) Silencer

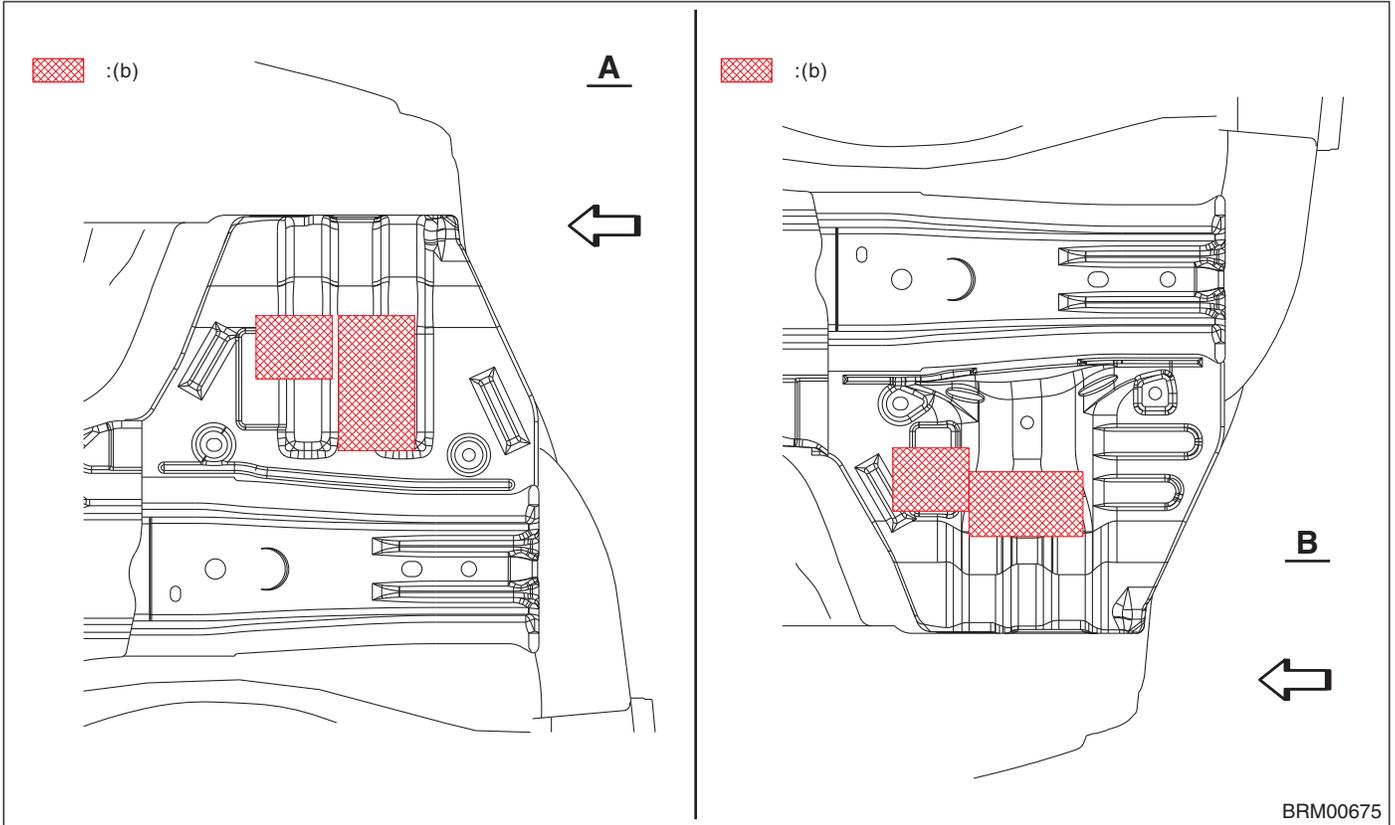
(b) Thickness of the silencer:  
5.5 mm (0.22 in)

(1) Only for models with increased  
vibration/noise reduction

(2) Models other than those with  
increased vibration/noise reduction

# Damping Seat

## • Upper view 2



- (b) Thickness of the silencer:  
5.5 mm (0.22 in)

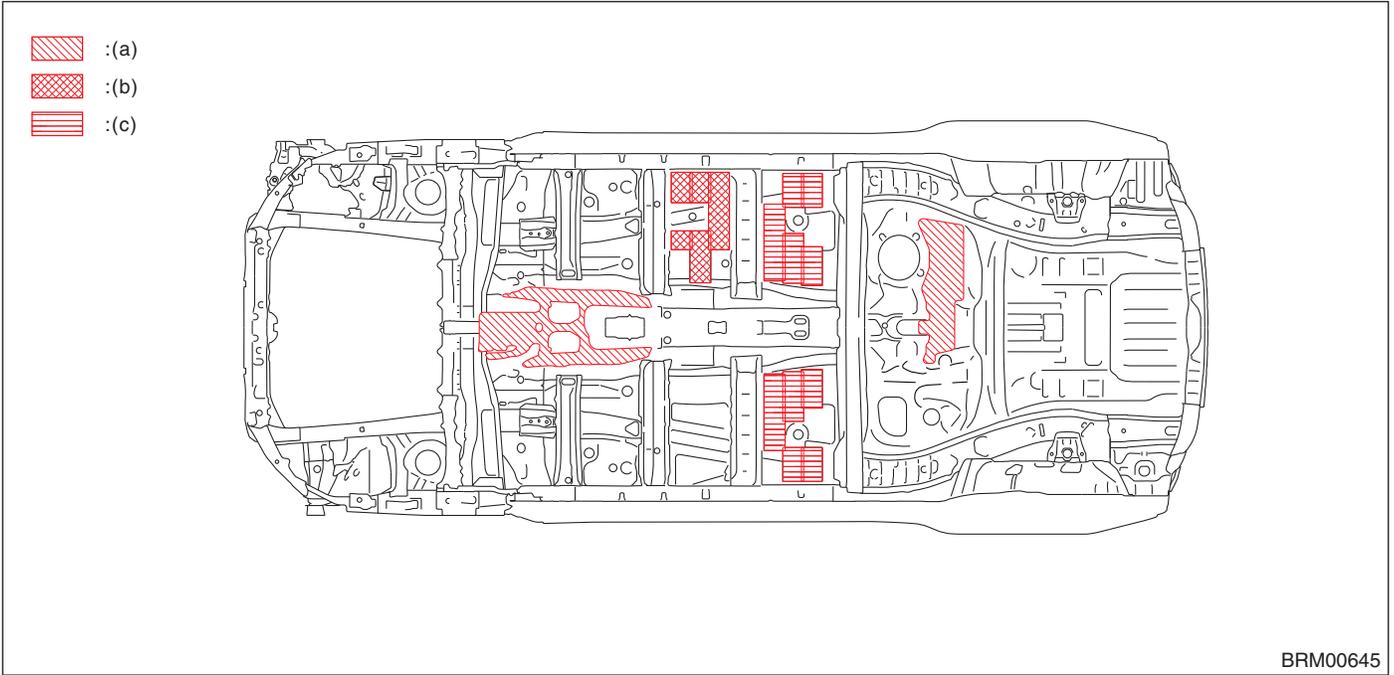
# Damping Seat

## 3. Hybrid model

### CAUTION:

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

### • Upper view



BRM00645

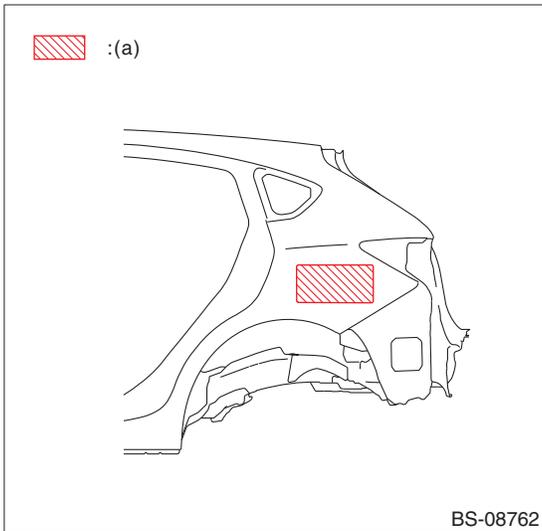
(a) Silencer

(b) Thickness of the silencer:  
3.0 mm (0.12 in)

(c) Thickness of the silencer:  
4.0 mm (0.16 in)

## 4. SPECIAL PARTS FOR 5 DOOR

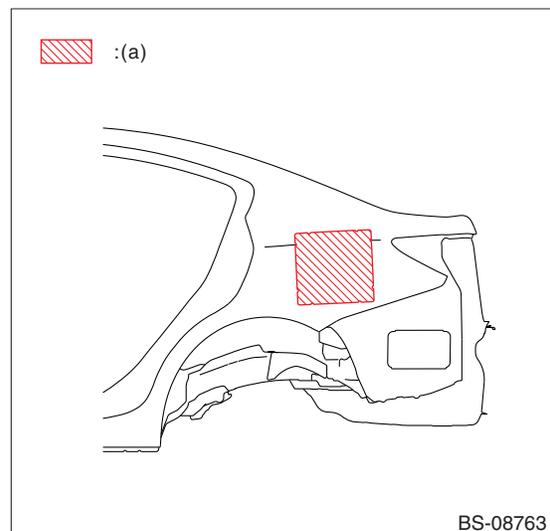
### • Side view



(a) Damping Seat

## 5. SPECIAL PARTS FOR 4 DOOR

### • Side view



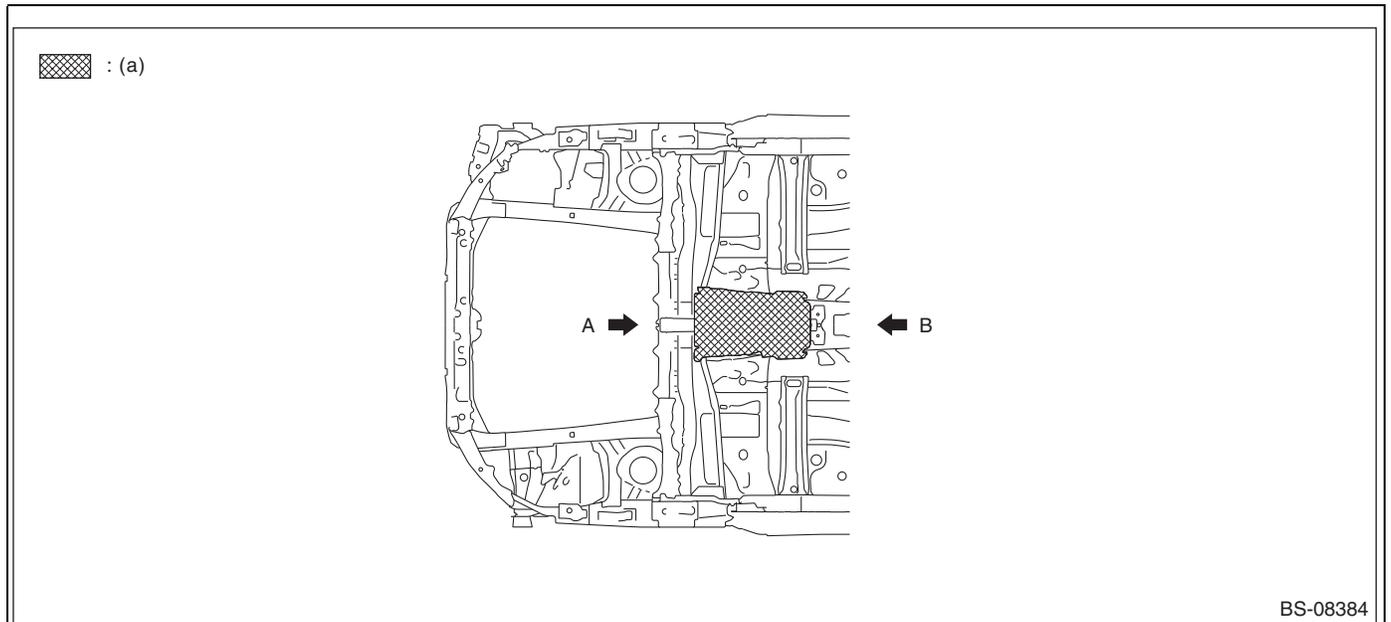
(a) Damping Seat

# Insulator

## 13. Insulator

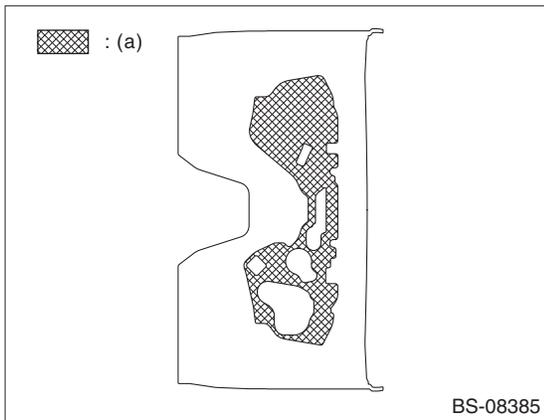
### A: SPECIFICATIONS

#### 1. UPPER VIEW



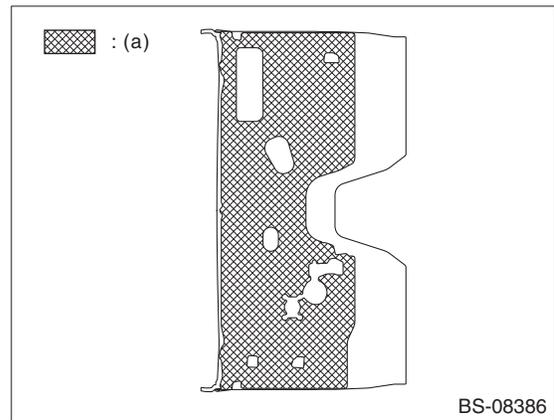
BS-08384

View A



BS-08385

View B

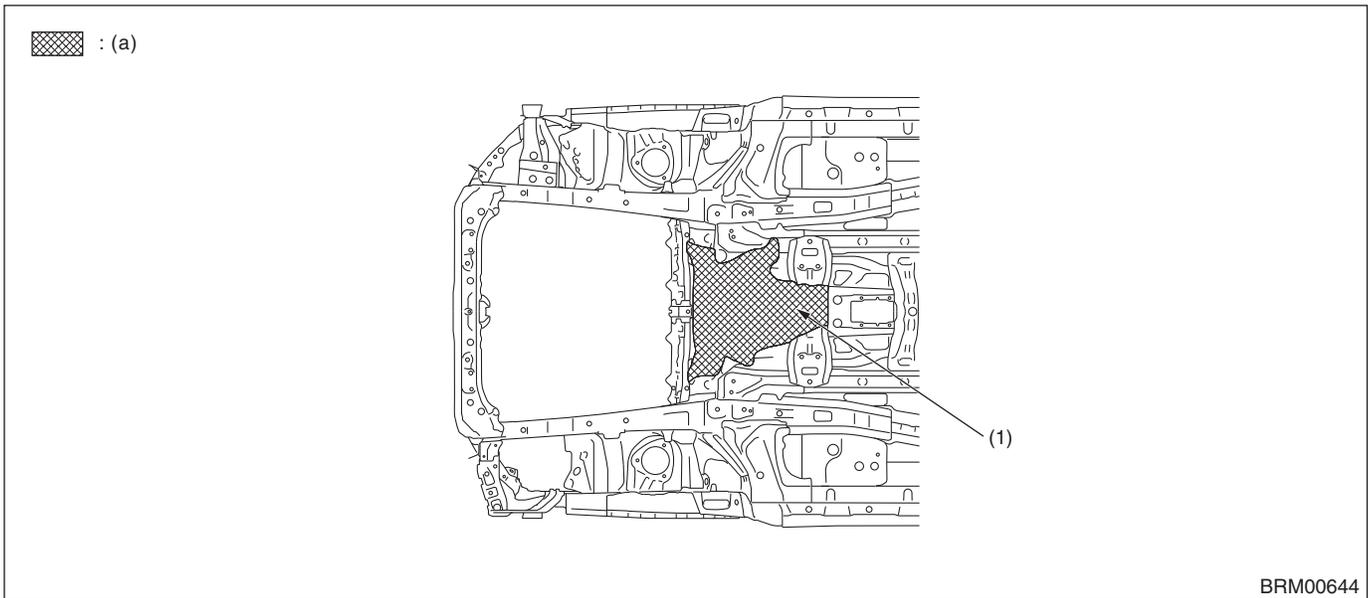


BS-08386

(a) Insulator

# Insulator

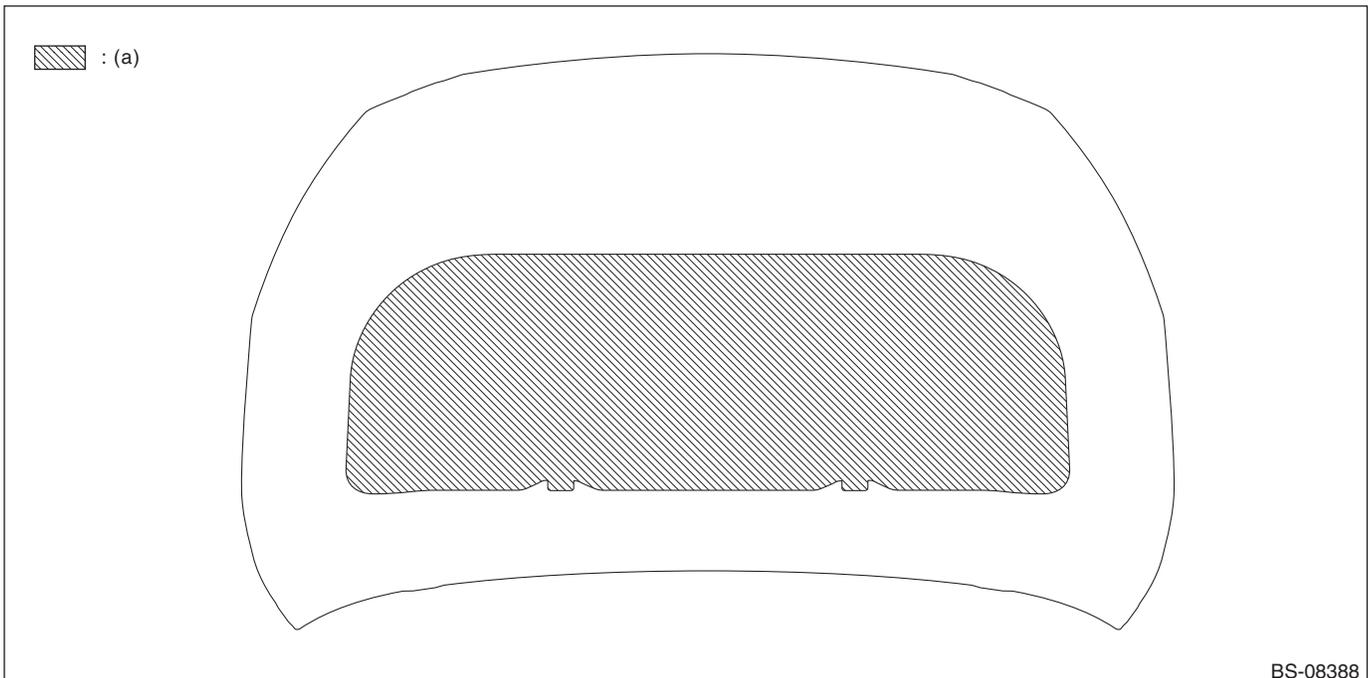
## 2. BOTTOM VIEW (Except for 2.0 i models)



(a) Insulator

(1) Gasoline model only

## 3. FRONT HOOD

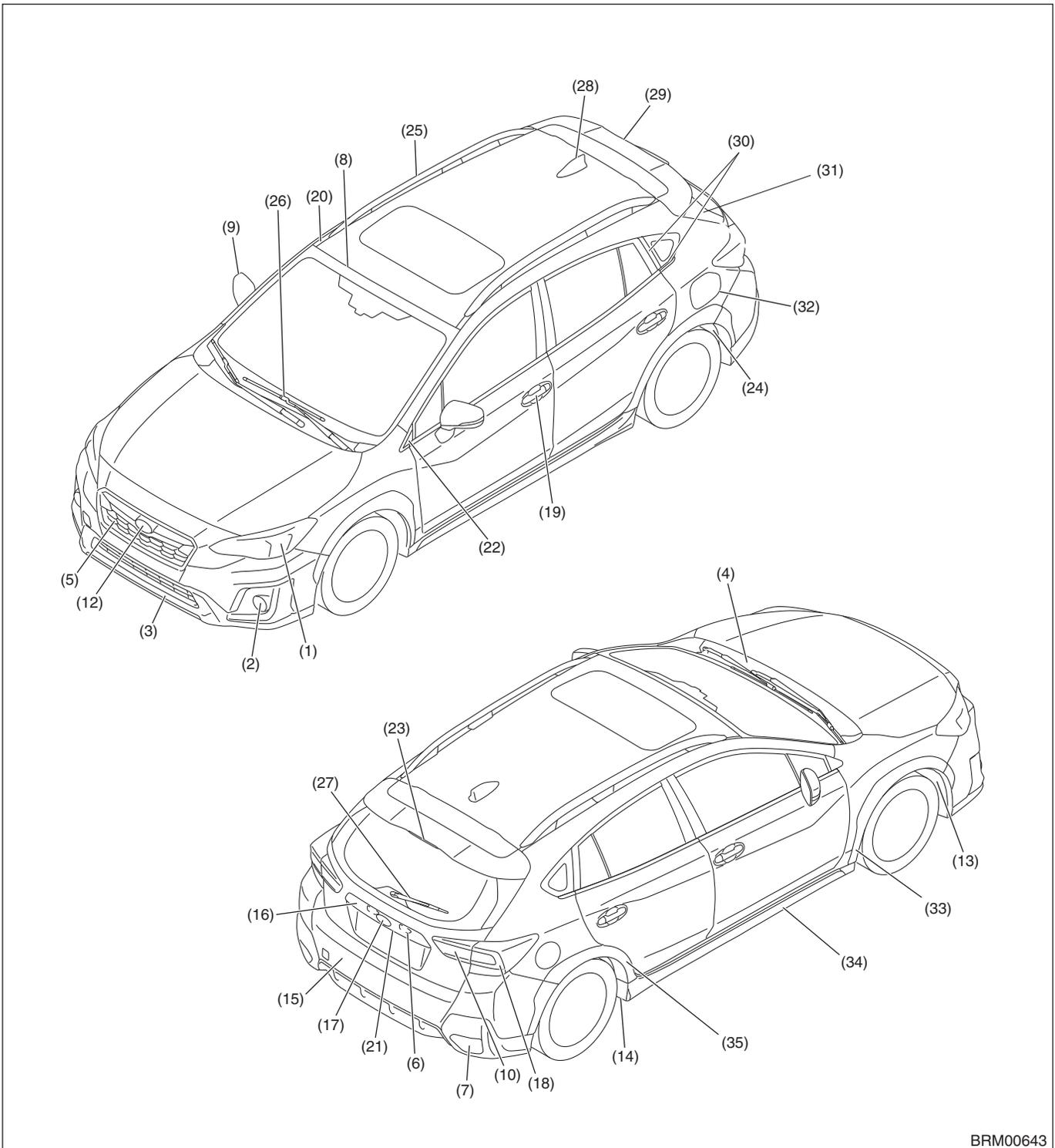


(a) Insulator



# Plastic Parts and Materials

## 2. XV and Hybrid model



BRM00643

## Plastic Parts and Materials

(1) Headlight	(13) Front mudguard	(25) Roof rail
(2) Front fog light	(14) Air flap rear	(26) Front wiper
(3) Front bumper	(15) Rear bumper	(27) Rear wiper
(4) Cowl panel	(16) Rear gate garnish	(28) Antenna
(5) Front grill	(17) Ornament rear	(29) Roof spoiler
(6) License light	(18) Rear combination light	(30) Rear quarter molding
(7) Rear reflex reflector	(19) Door handle	(31) Roof spoiler side
(8) Front window moulding	(20) Roof moulding	(32) Flap outer charge
(9) Door mirror	(21) Rear gate opener switch	(33) Fender garnish
(10) Rear finisher light	(22) A pillar cover	(34) Side sill garnish
(11) Side spoiler	(23) High mount stop light	(35) Rear quarter garnish
(12) Ornament front	(24) Rear mudguard	

No	Part name	Material	
(1)	Headlight (Halogen) (5D/4D model)	Lens	PC
		Housing	PP-TD20
		Inner panel A	PC-HT
		Inner panel B	PC-HT
		Reflector A	UP-(MD+GF)80
		Reflector B	PC-HT
		Inner lens	PC
	Headlight (Halogen) (XV and Hybrid model)	Lens	PC
		Housing	PP-TD20
		Extension	PBT
		Reflector (Hi & Lo beam)	BMC
		Reflector (turn)	PBT+PET
		Reflex reflector	PC
	Headlight (LED) (5D/4D model)	Lens	PC
		Housing	PP-TD40
		Reflector A	PBT
		Reflector B	PC
		Bezel	PBT
		Inner panel A	PBT
		Inner panel B	PC
		Inner lens A, B	PC
		Bracket A, B, D	PA6-GF35
		Bracket C	PC
	Headlight (LED) (XV and Hybrid model)	Lens	PC
Housing		PP-TD40	
Extension		PBT	
Reflector		PBT	
Reflex reflector		PC	

## Plastic Parts and Materials

No	Part name		Material	
(2)	Front fog light	Lens	PC	
		Reflector	PC	
		Bracket (Housing)	PP-TD30	
	Front fog light (SRF)	Bracket (Housing)	PP-GF40	
	Front fog light (LED) (Hybrid model only)	Lens	PC	
		Reflector	PC	
Bracket (Housing)		PP-GF40		
(3)	Front bumper	Face	PP	
		Fog light cover	Standard	PP
			High grade	Base: PP Mole: ABS
			XV models	PP
			Hybrid models	Base: PP Mole: ABS Ring: ABS
		DRL cover	Base: PP Mole: ABS	
		Hook cover	PP	
		Center lower bracket	PP	
		Side bracket	POM	
		Corner bracket	PP-GF30	
		Upper cover	PP	
		Sealing bumper	EPDM	
		EA form	PP+PS	
		EA lower	PP	
		Intake cover	PP	
Bumper guard (Hybrid model only)	PP			
(4)	Cowl panel		PP-TD10	
(5)	Front grill (5D/4D model)	Grille part	ASA	
		Moulding	Ring	ABS
			Wing	ABS
	Front grill (XV and Hybrid model)	Grille part	ASA	
		Moulding	Ring	ASA
			Wing	ABS
(6)	License light	Lens	PC	
		Housing	PC	
(7)	Rear reflex reflector (5D/4D model)	Lens	PMMA	
		Housing	PC	
	Rear reflex reflector (XV and Hybrid model)	Lens	PMMA	
		Housing	PC+PET	
(8)	Front window moulding		PVC	

## Plastic Parts and Materials

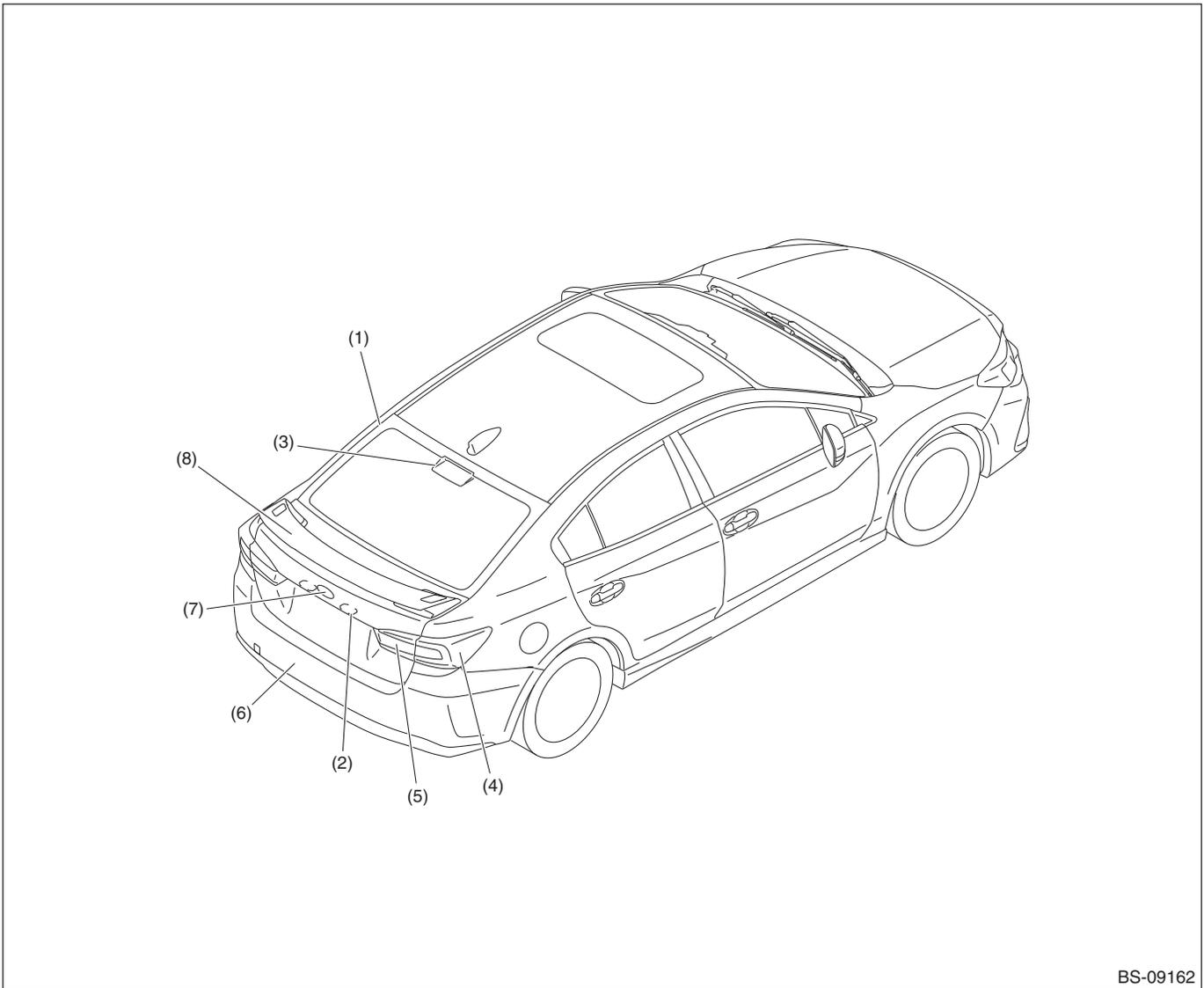
No	Part name		Material	
(9)	Door mirror	Body	ASA	
		Cover body	ASA	
		Cover front	ABS	
		Cover stay A	ASA	
		Cover stay B	ASA	
		Side turn light	Housing	ABS
			Lens	PMMA
			Inner lens	PMMA
	Packing stay	TPO		
(10)	Rear finisher light	Outer lens	PMMA	
		Housing	ASA	
(11)	Side spoiler (5D/4D model)		PP	
(12)	Ornament front		ABS+PMMA	
(13)	Front mudguard	Body	PE	
		Air flap	PE	
		Insulator	POM	
		Cover fender lower (XV and Hybrid model)	PP	
(14)	Air flap rear		PP+EPDM	
(15)	Rear bumper	Face	PP	
		Hook cover	PP	
		Side bracket	POM	
		Corner bracket	PP-GF30	
		Bracket lower rear (5 Door only)	PP-GF30	
		Cover side lower	PP	
(16)	Rear gate garnish		ABS	
(17)	Ornament rear		ABS+PMMA	
(18)	Rear combination light	Outer lens	PMMA	
		Inner lens	Stop light	PMMA
			Side reflex reflector	PMMA
			Tail light	PC
		Extension	PC	
		Housing	ASA	
(19)	Door handle (5D/4D model)	Handle	Paint	PC+PBT
			Paint (Model with smart entry)	PC+PBT-MD10
			Plating	PC+PBT-MD10
		Handle cover	Paint	PC+PBT
			Paint (Model with smart entry)	PC+PBT-MD10
			Plating	PC+ABS
	Door handle (XV model)	Handle	Paint	PC+PBT-TD10
			Plating	PC+PBT-MD10
		Handle cover	Paint	PC+PBT-MD10
			Plating	PC+ABS
	Door handle (Hybrid model)	Handle	Paint (Front)	PC+PBT-MD10
			Paint (Rear)	PC+PBT-TD10
Handle cover		Paint	PC+PBT-MD10	

## Plastic Parts and Materials

No	Part name		Material	
(20)	Roof moulding (5D and XV model)	Body	PVC	
		End cap	POM	
		Carrier cover	AES	
	Roof moulding (Hybrid model)	Body	PVC	
		End	POM	
(21)	Rear gate opener switch	Operation part	TPE	
		Plastic part	PP-F35	
(22)	A pillar cover	Body	AES	
		Protector	TPO	
(23)	High mount stop light	Lens	PMMA	
		Housing	ABS	
(24)	Rear mudguard	Body	PET+PP	
		Protector	PP	
(25)	Roof rail (Gasoline model)	Leg	Front & Center & Rear	PA66-GF50
		Leg cover	Front & Center & Rear	ASA
		Protector	Front & Center & Rear	TPO
	Roof rail (Hybrid model)	Leg	Front & Center & Rear	PA66-GF50
		Leg cover	Front & Center & Rear	PC+ABS
		Protector	Front & Center & Rear	TPO
(26)	Front wiper	Blade		PBT
				PBT-GF45
				PP+ELASTOMER
(27)	Rear wiper	Blade		PBT-GF30
		Arm		PET-GF45
		Arm cover		PBT
(28)	Antenna	Shark fin type		PC+ASA
		Fixed pole type	Cover	ASA
			Rod	ELASTOMER
(29)	Roof spoiler		ASA	
(30)	Rear quarter molding	Front		PVC
		Lower		PVC
(31)	Roof spoiler side	No painting		ABS
		Painted		ASA+ABS
	Roof spoiler side (XV model)	No painting		ASA
		Painted		ASA
	Roof spoiler side (Hybrid model)			ASA
(32)	Flap outer charge (Hybrid model only)		PPE+PA	
(33)	Fender garnish (Only XV and Hybrid models)		PP	
(34)	Side sill garnish (Only XV and Hybrid models)		PP	
(35)	Rear quarter garnish (Only XV and Hybrid models)		PP	
	Undercover		PP	
	Splash board		TPO	

# Plastic Parts and Materials

## 3. SPECIAL 4 DOOR PARTS



BS-09162

- (1) Rear window moulding
- (2) License light
- (3) High mount stop light  
(Indoor type)

- (4) Rear combination light
- (5) Rear finisher light
- (6) Rear bumper

- (7) Ornament rear
- (8) Spoiler rear

## Plastic Parts and Materials

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

## List of Plastic Material Notations

### 15. List of Plastic Material Notations

#### A: SPECIFICATIONS

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