

BODY REPAIR MANUAL

BS

	Page
1. Foreword	3
2. Assembly of Exterior Parts.....	12
3. Panel Components.....	14
4. Galvanized Sheet Metal	38
5. Body Construction.....	42
6. Body Reference Points.....	50
7. Measurement for Combined Parts	77
8. Panel Replacement.....	80
8-1. Radiator Panel (total replacement)	80
8-2. Radiator Core Support (total replacement)	90
8-3. Side Upper Frame (total replacement)	101
8-4. Front Wheel Apron (total replacement)	107
8-5. Toe Board Reinforcement (total replacement).....	119
8-6. Closing Plate LH (partial replacement) Pattern 1	125
8-7. Closing Plate RH (partial replacement) Pattern 1	129
8-8. Closing Plate LH (partial replacement) Pattern 2	137
8-9. Closing Plate RH (partial replacement) Pattern 2	143
8-10. Front Side Frame (partial replacement).....	151
8-11. Front Side Frame (total replacement)	163
8-12. Front Pillar Outer (partial replacement)	169
8-13. Front Pillar Reinforcement (total replacement)	184
8-14. Front Pillar Reinforcement (partial replacement)	193
8-15. Center Pillar Outer Panel (partial replacement)	199
8-16. Center Pillar Reinforcement Outer (total replacement)	203
8-17. Center Pillar Inner (total replacement)	213
8-18. Side Sill Outer Panel (partial replacement)	217
8-19. Side Sill Reinforcement Outer Rear (total replacement)	225
8-20. Side Sill Reinforcement Outer (total replacement)	231
8-21. Rear Quarter Panel (partial replacement) / 5D.....	243
8-22. Rear Quarter Panel (partial replacement) / 4D.....	252
8-23. Rear Pillar Reinforcement Outer LH (partial replacement) / 5D	261
8-24. Rear Pillar Reinforcement Outer RH (partial replacement) / 5D	263
8-25. Rear Pillar Reinforcement Outer (total replacement) / 4D	265
8-26. Patch Rear Pillar · Corner Patch (total replacement) / 4D	267
8-27. Arch Rear Inner LH (total replacement) / 5D	271
8-28. Arch Rear Inner RH (total replacement) / 5D	273
8-29. Arch Rear Inner LH (total replacement) / 4D	275
8-30. Arch Rear Inner RH (total replacement) / 4D	277
8-31. Rear Quarter Inner LH (total replacement) / 5D	279
8-32. Rear Quarter Inner RH (total replacement) / 5D	287
8-33. Rear Quarter Inner (total replacement) / 4D.....	295
8-34. D Pillar Extension (partial replacement) / 5D	303
8-35. D Pillar Reinforcement (total replacement) / 5D	305

8-36.	Rear Panel (total replacement) / 4D	315
8-37.	Rear Quarter End Panel (total replacement) / 5D	319
8-38.	Rear Quarter End Panel (total replacement) / 4D	323
8-39.	Rear Skirt (total replacement) / 5D	325
8-40.	Rear Skirt (total replacement) / 4D	329
8-41.	Rear Side Frame Upper Rear (total replacement) / 5D	331
8-42.	Rear Side Frame Upper Rear (total replacement) / 4D	339
8-43.	Rear Floor Pan (partial replacement) / 5D	343
8-44.	Rear Floor Pan (partial replacement) / 4D	347
8-45.	Rear Floor Side (total replacement) / 5D	349
8-46.	Rear Floor Side (total replacement) / 4D	353
8-47.	Rear Side Frame Lower Rear (total replacement) / 5D	357
8-48.	Rear Side Frame Lower Rear (total replacement) / 4D	361
8-49.	Side Sill Inner Rear (total replacement)	365
8-50.	Rear Side Frame Upper (total replacement)	373
8-51.	Rear Side Frame	377
8-52.	Roof Panel (total replacement) / 5D	389
8-53.	Roof Panel (total replacement) / 4D	393
8-54.	T Stud Installation	397
9.	Body Sealing	399
10.	Anticorrosion Wax	405
11.	Undercoat	422
12.	Damping Seat	434
13.	Insulator	439
14.	Plastic Parts and Materials	441
15.	List of Plastic Material Notations	449

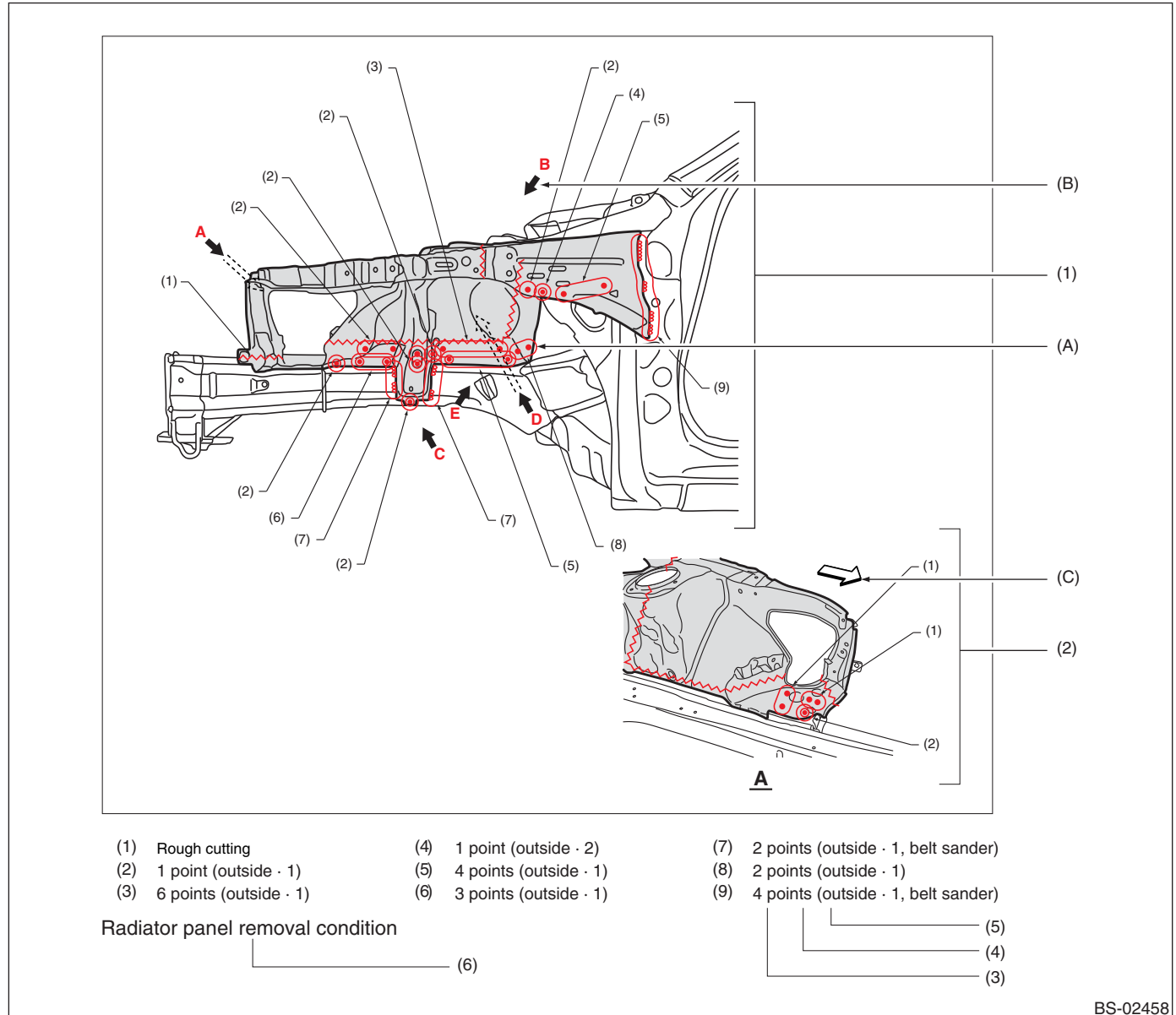
1. Foreword

A: USE OF THIS MANUAL

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

1. ILLUSTRATION EXAMPLE

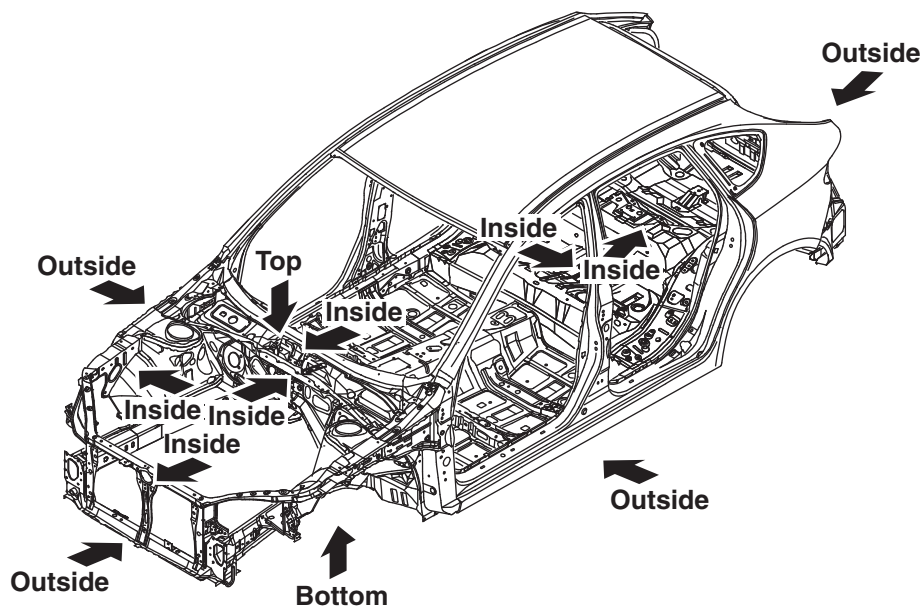
- Symbols and number of points indicate the welding method and the number of welding points. Text in brackets indicates the direction for removal of welded parts, and numbers indicate the number of plates to be drilled in panels of welded parts to be removed.
- An enclosure by a broken line indicates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



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

2. REMOVAL DIRECTION

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

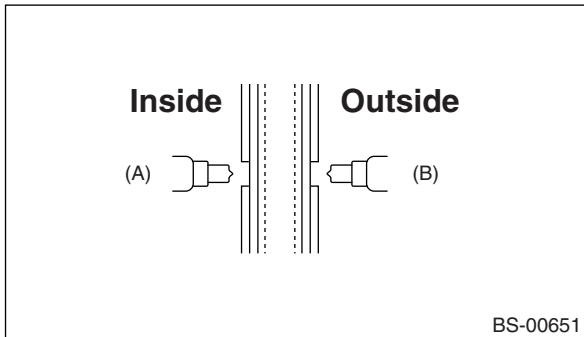


BS-02459

3. NUMBER OF PANELS TO BE DRILLED

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

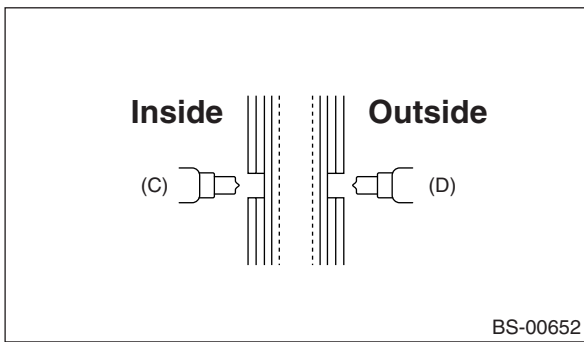
(1) Drilling through one plate



(A) (Inside · 1)

(B) (Outside · 1)

(2) Drilling through two plates

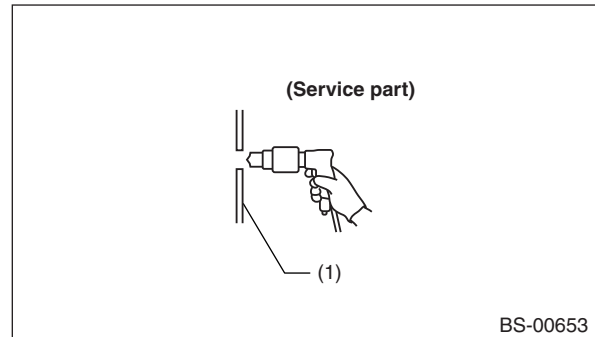


(C) (Inside · 2)

(D) (Outside · 2)

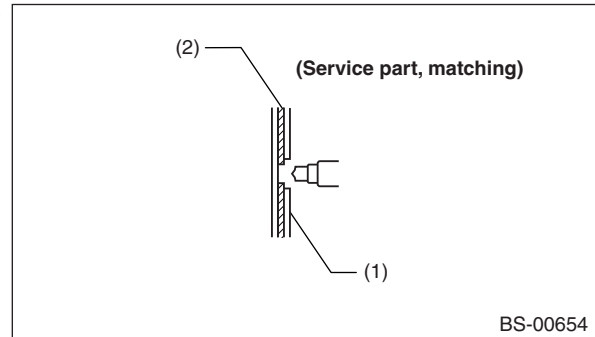
4. HOLE DRILLING FOR PLUG WELDING

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



(1) Service part

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




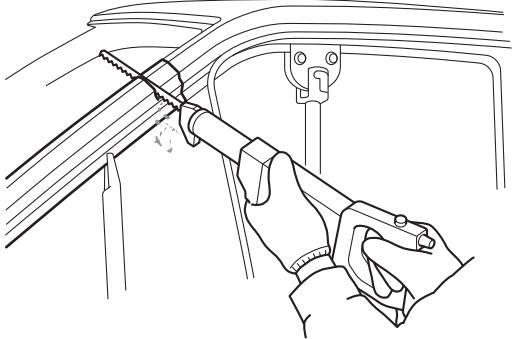
(1) Vehicle side

(2) Service part


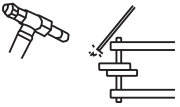
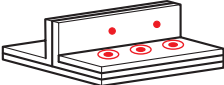
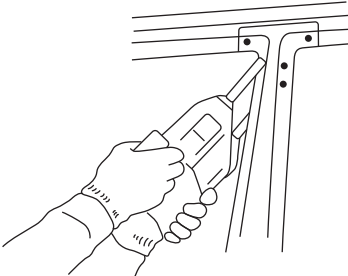


Foreword

5. MEANING OF SYMBOLS



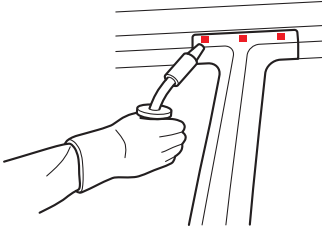


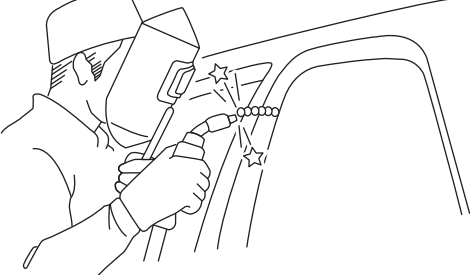
• Cutting

	
BS-00352	BS-00267

• Spot welding


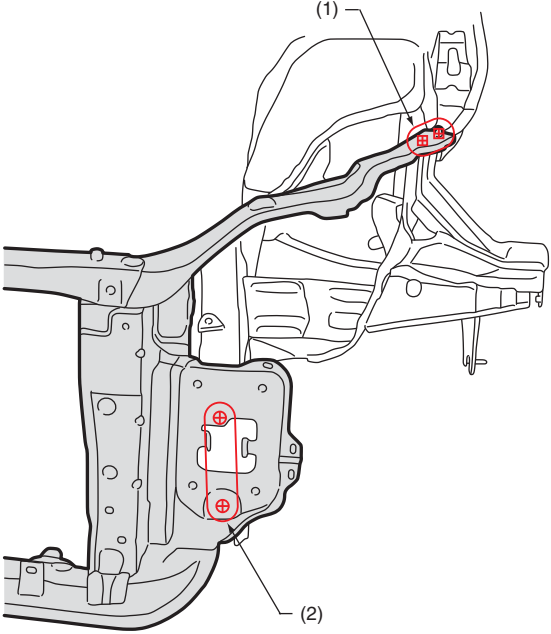

Two overlapping parts	 BS-00655	 BS-00656	 BS-00657	 BS-00658
Three or more overlapping parts	 BS-00659	 BS-00660		

• Carbon dioxide gas arc welding (MIG welding)

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

Foreword

- Bolt, nut tightening portion

Bolt	 BS-04481	 BS-04483
Nut	 BS-04482	

(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		
		Current	8.0 kA		
		Welding time	20 cyc		
[f]	Compression	4.4 kN	Total number of 2 or 3 overlapping sheets		
	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.

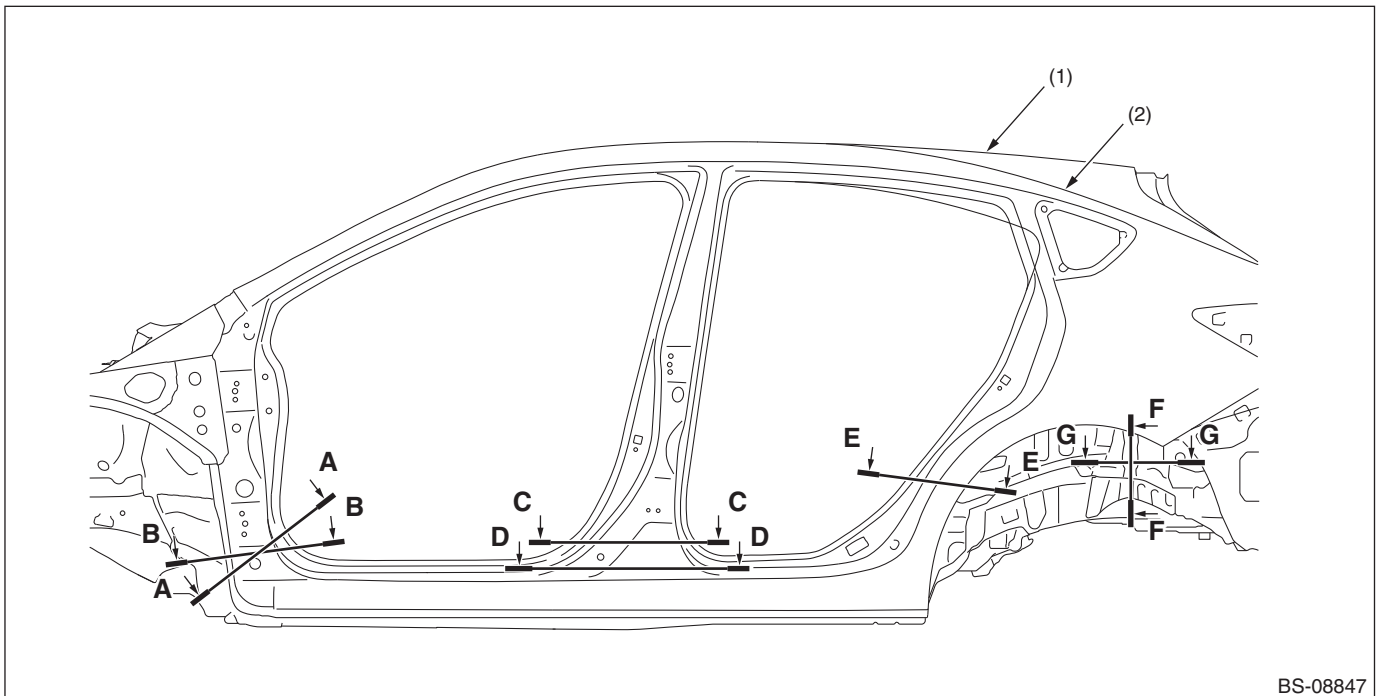
Recommended materials: Equivalent to High Span Foam made by Cemedine

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

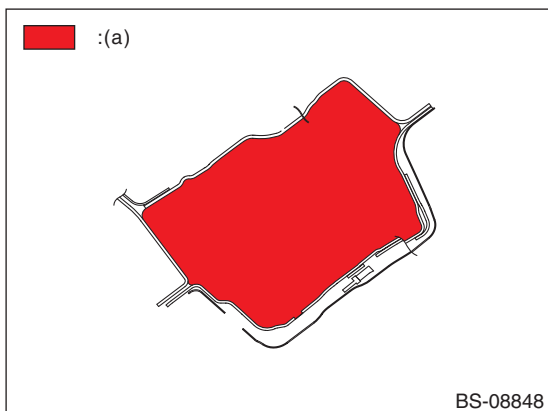


BS-08847

(1) 5 Door

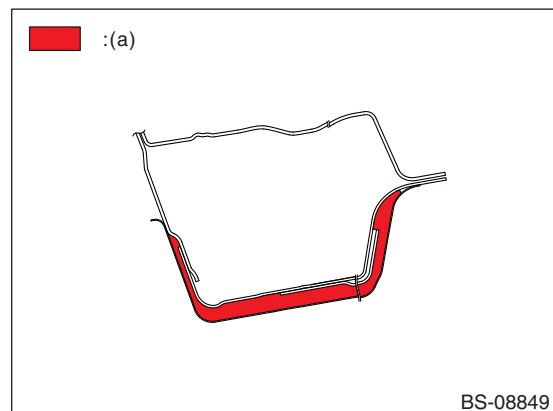
(2) 4 Door

Cross section A — A



(a) Urethane foam injection locations

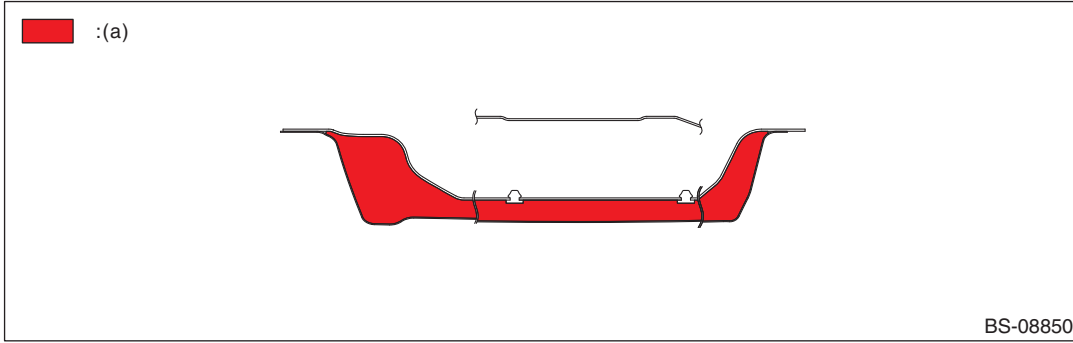
Cross section B — B



(a) Urethane foam injection locations

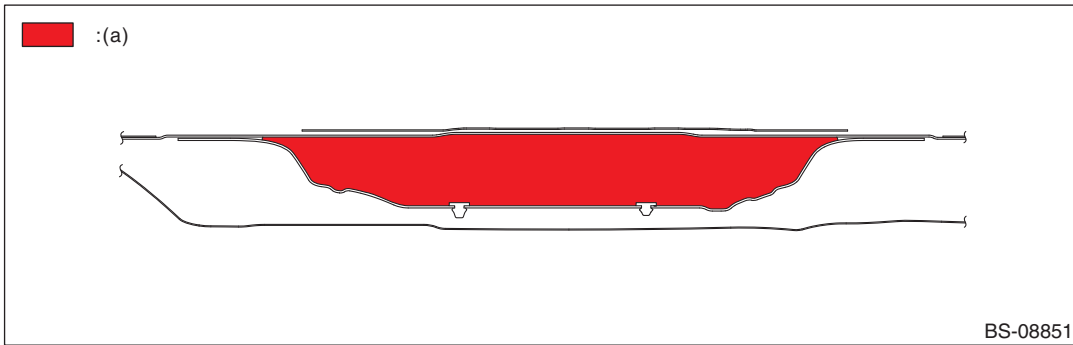
Foreword

Cross section C — C



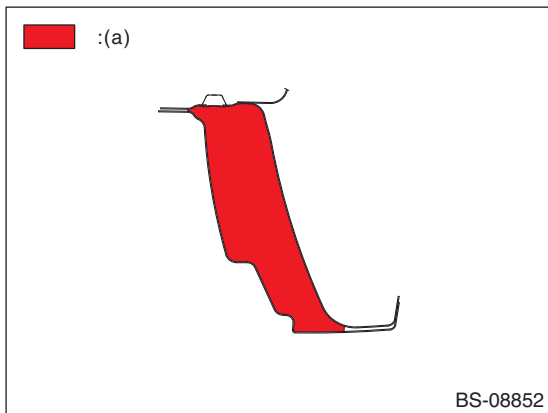
(a) Urethane foam injection locations

Cross section D — D



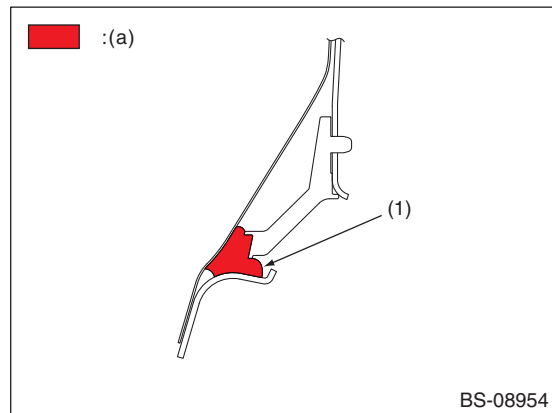
(a) Urethane foam injection locations

Cross section E — E



(a) Urethane foam injection locations

Cross section F — F

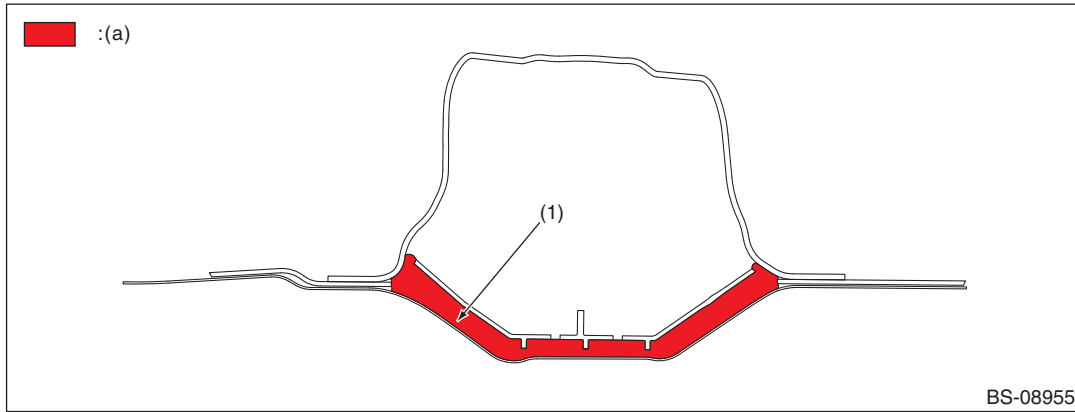


(a) Urethane foam injection locations

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

Foreword

Cross section G — G



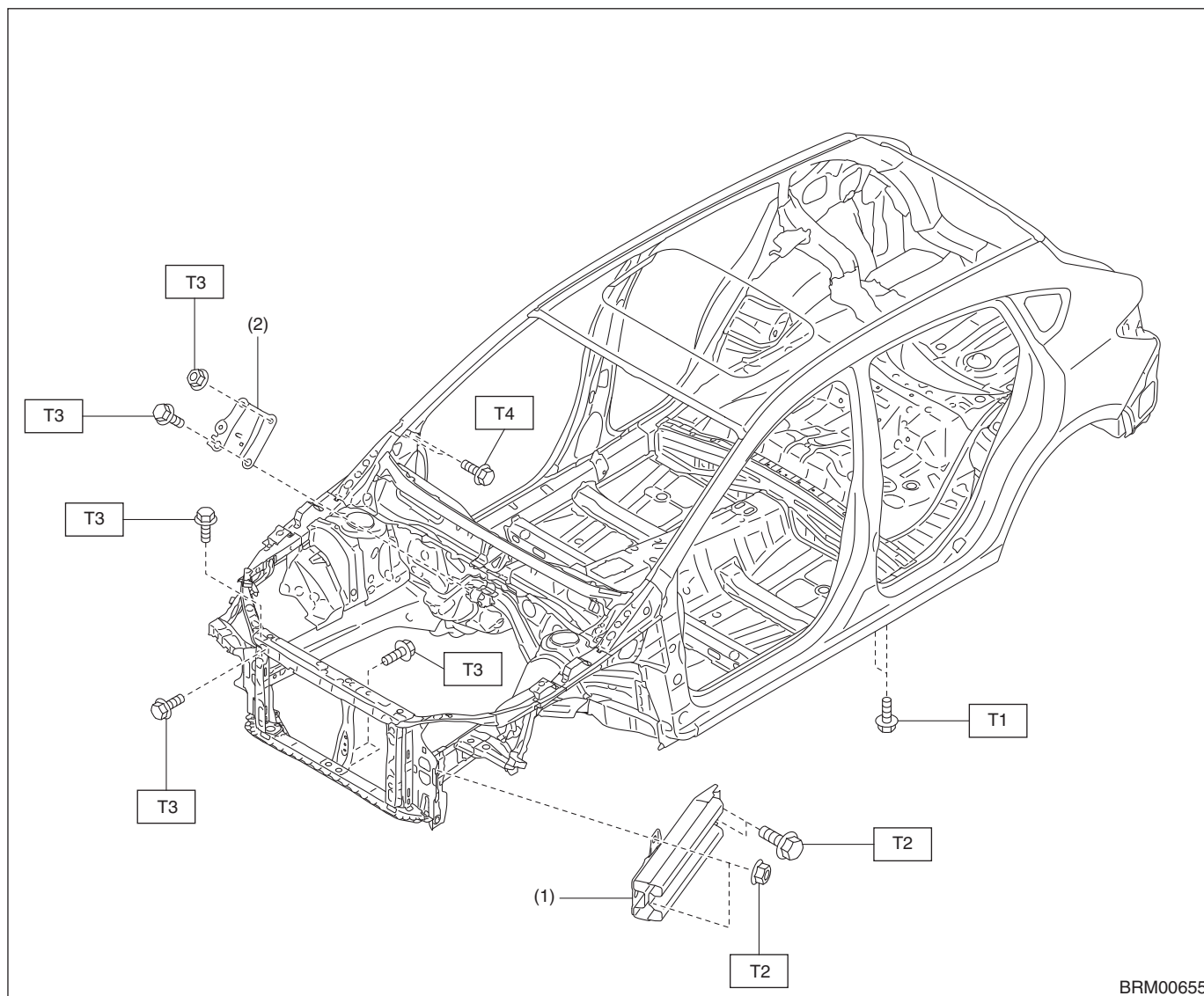
(a) Urethane foam injection locations

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

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)

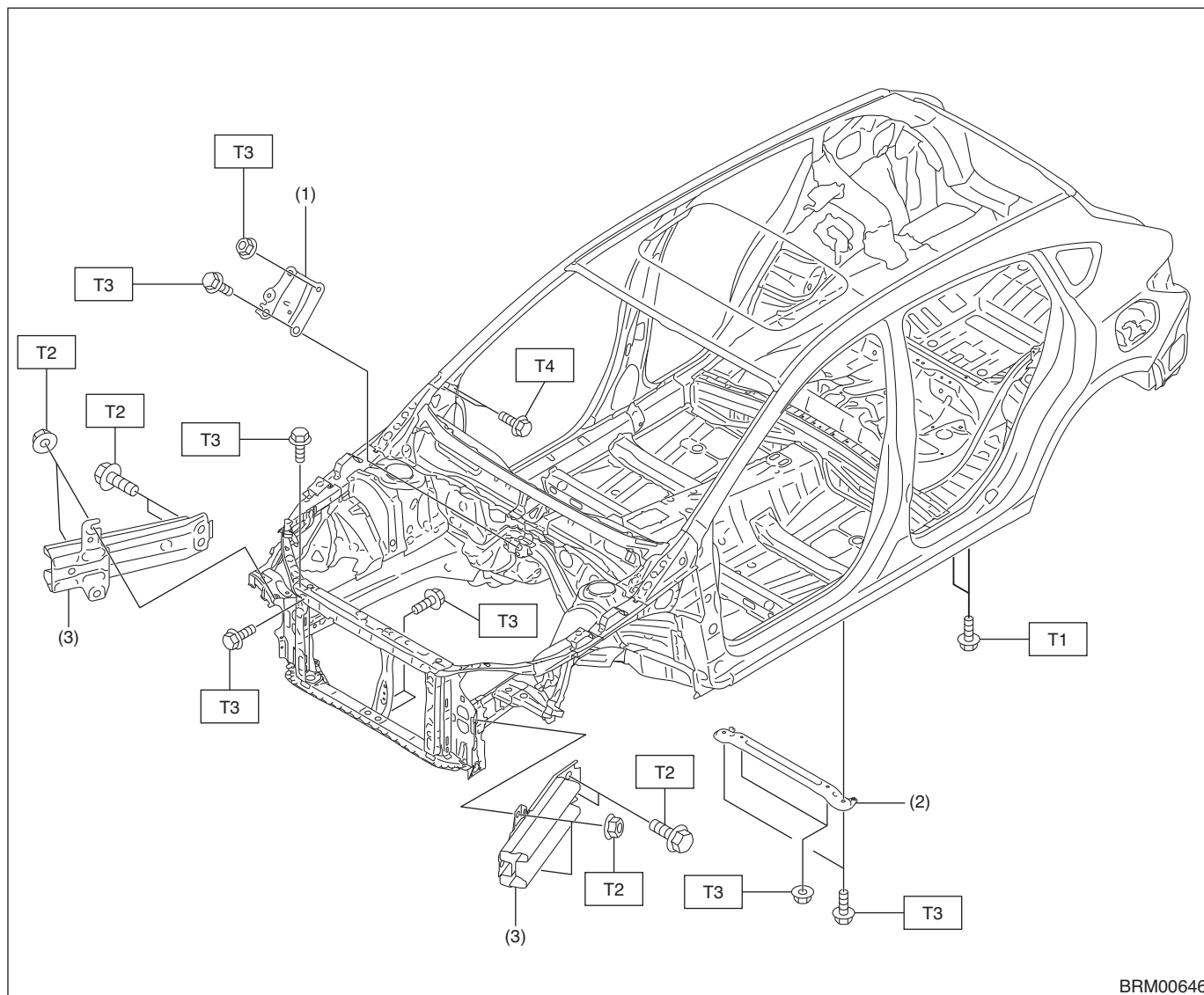
T2: 37 (3.77, 27.3)

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)

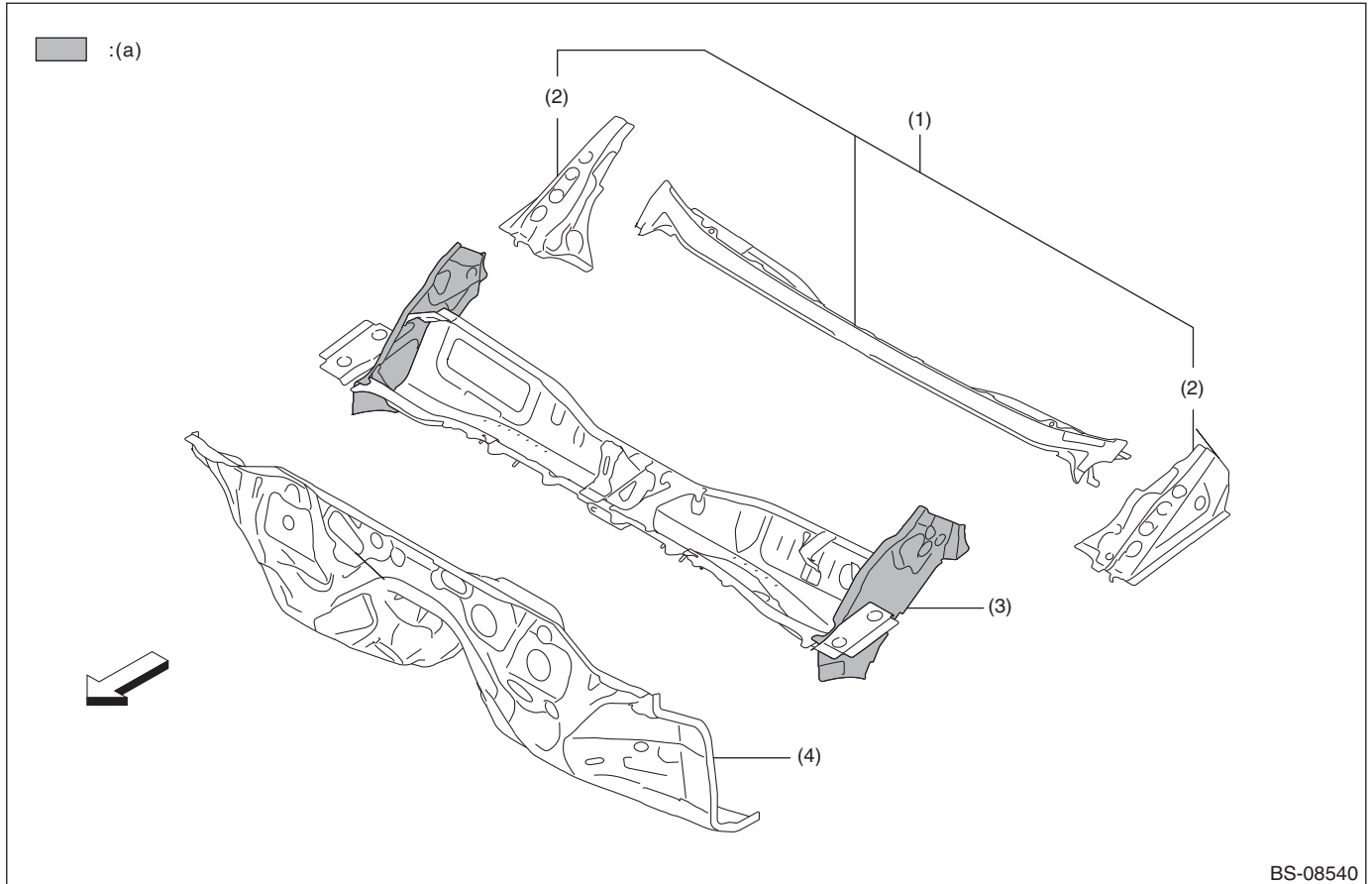
***T4: Secure 18 (1.84, 13.28) or more.
The bolts should be seated and
not broken.***

3. Panel Components

A: COMPONENTS

1. TOE BOARD & FRONT PANEL

• Gasoline model



BS-08540

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

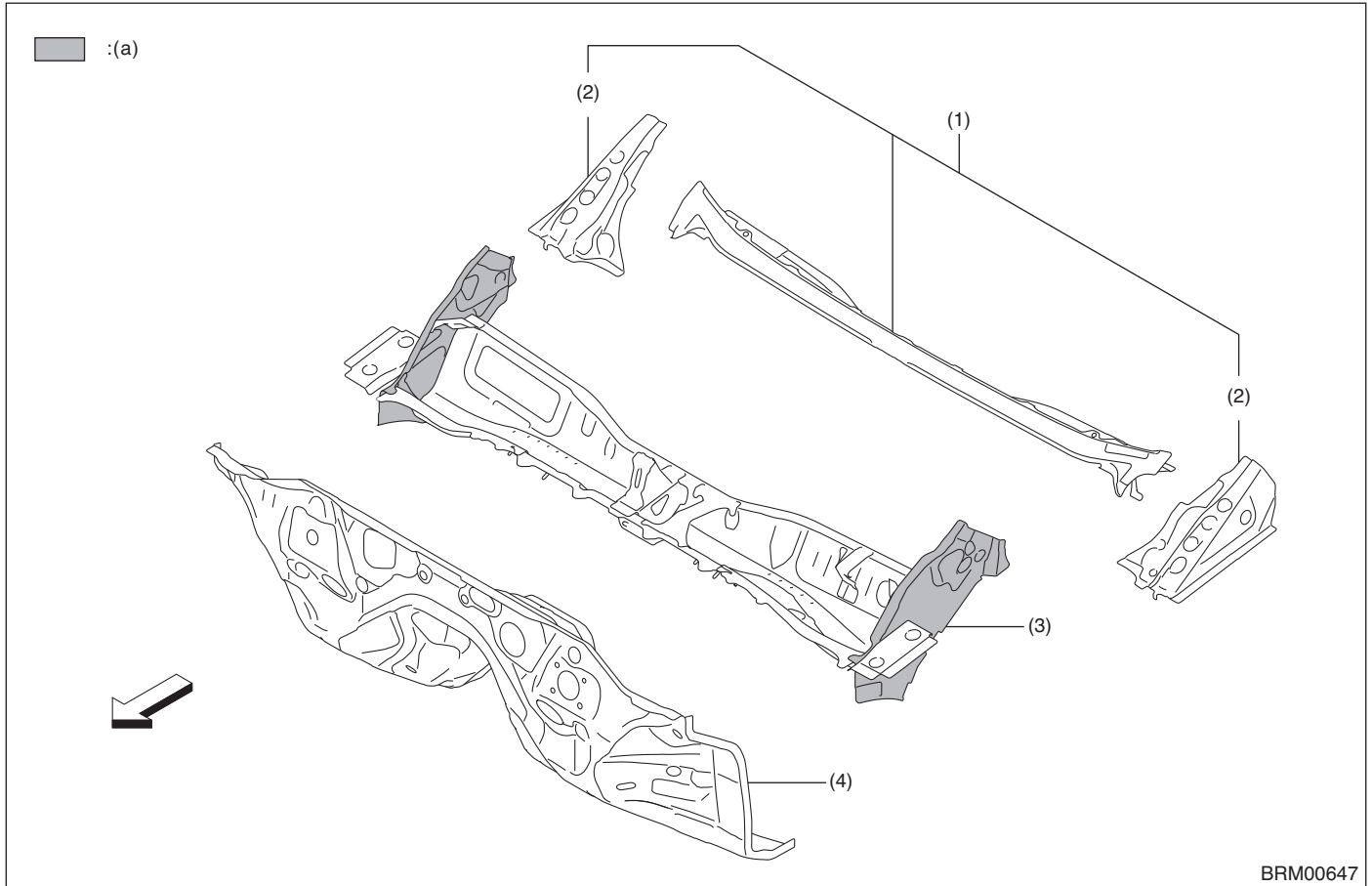
(1) Front panel
(2) Front panel side reinforcement

(3) Duct

(4) Toe board

Panel Components

• Hybrid model



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

(1) Front panel

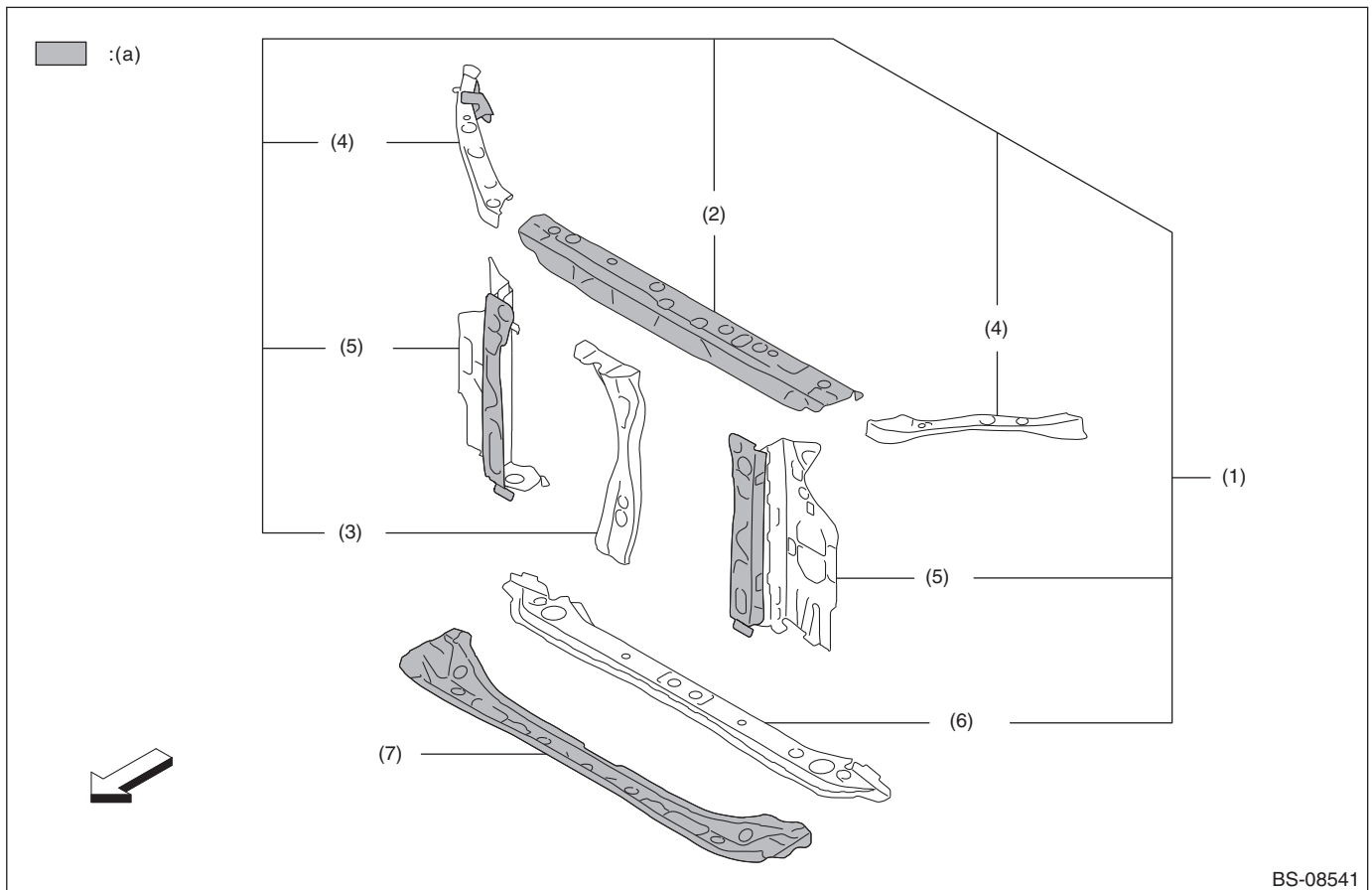
(3) Duct

(4) Toe board

(2) Front panel side reinforcement

Panel Components

2. RADIATOR PANEL



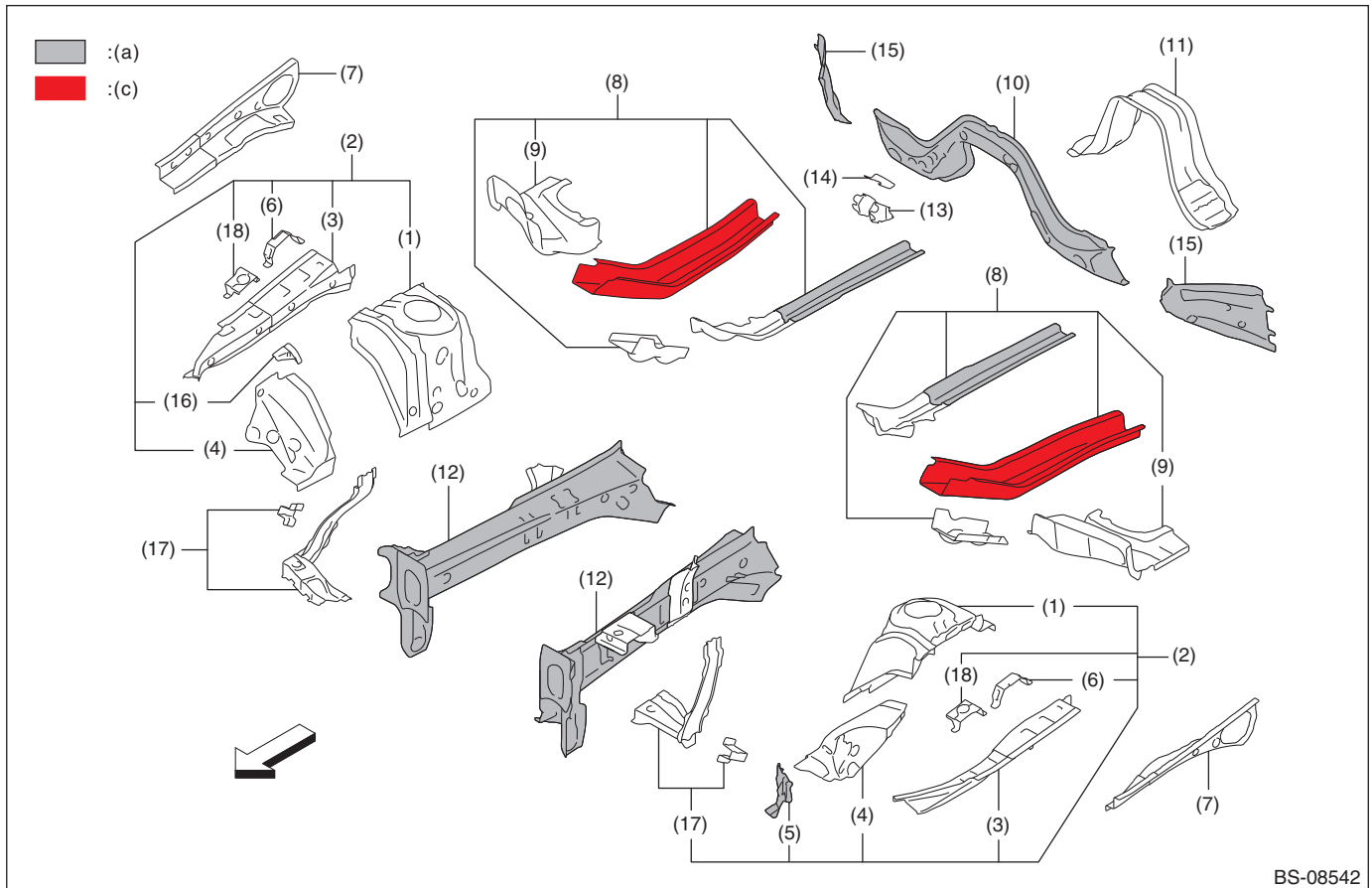
(a) High-strength tensile steel
(440 — 590 MPa class)

- | | | |
|--------------------------|-------------------------------|----------------------------|
| (1) Radiator panel | (4) Radiator side frame upper | (7) Radiator frame lower B |
| (2) Radiator frame upper | (5) Radiator panel side | |
| (3) Hood lock stay | (6) Radiator frame lower A | |

Panel Components

3. FRONT WHEEL APRON

• Gasoline model



BS-08542

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

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

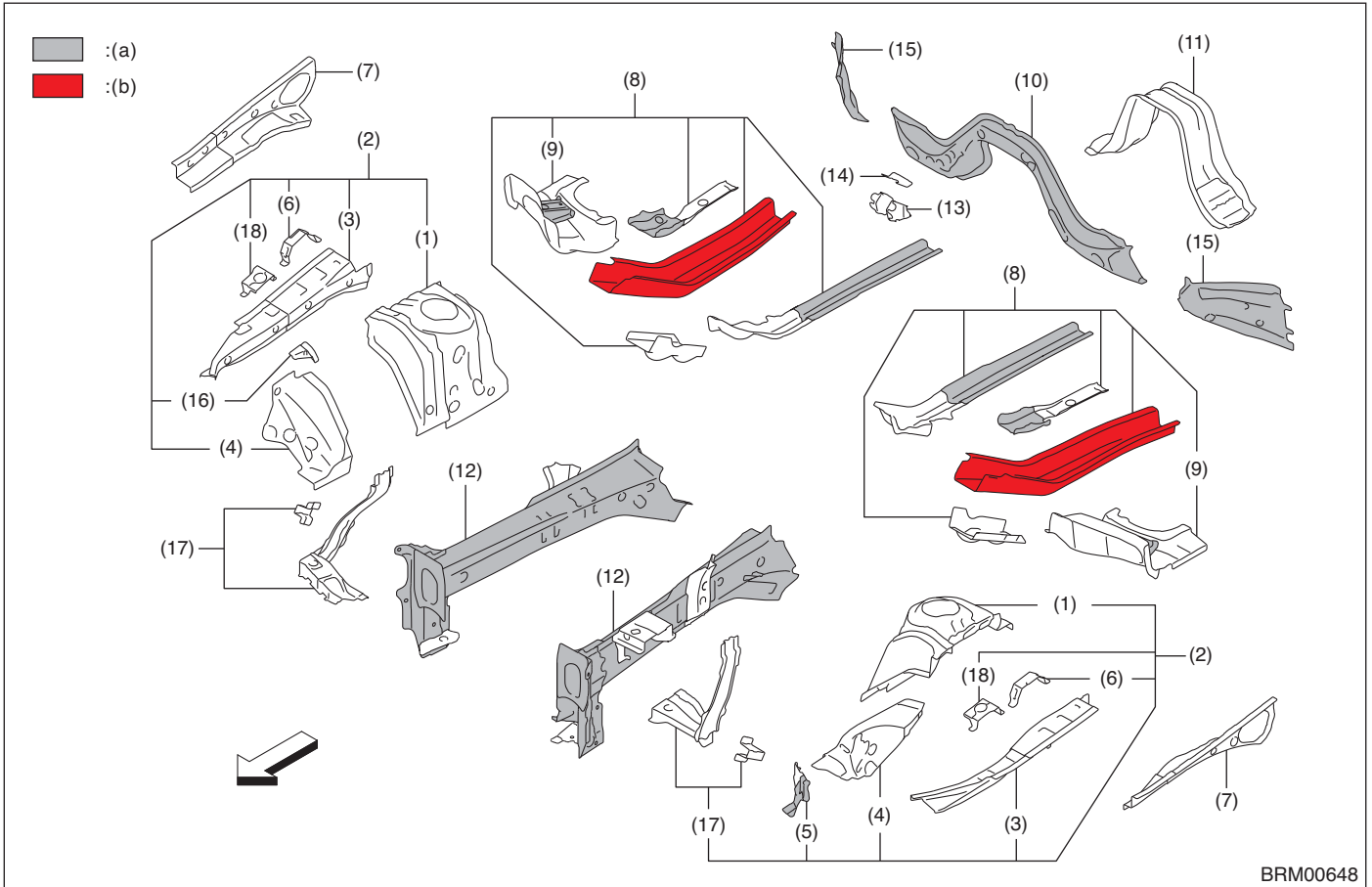
- (1) Front suspension bracket
- (2) Wheel apron
- (3) Side upper inner frame
- (4) Front wheel apron
- (5) Battery rod bracket
- (6) Bracket fender upper front

- (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

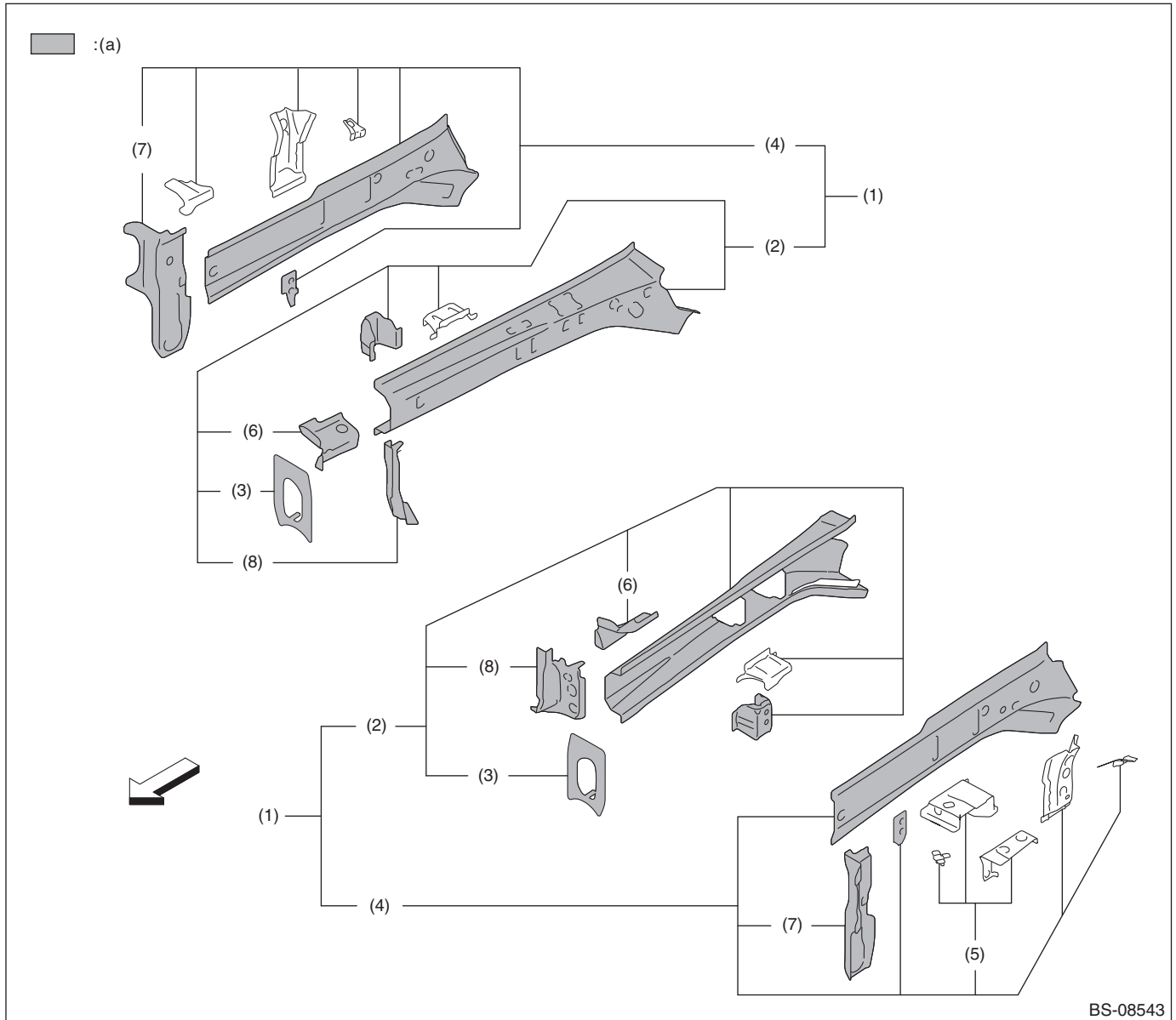
- (7) Side upper frame
- (8) Front side frame rear
- (9) Toe board reinforcement
- (10) Toe board crossmember center
- (11) Floor crossmember front
- (12) Front side frame front

- (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



(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

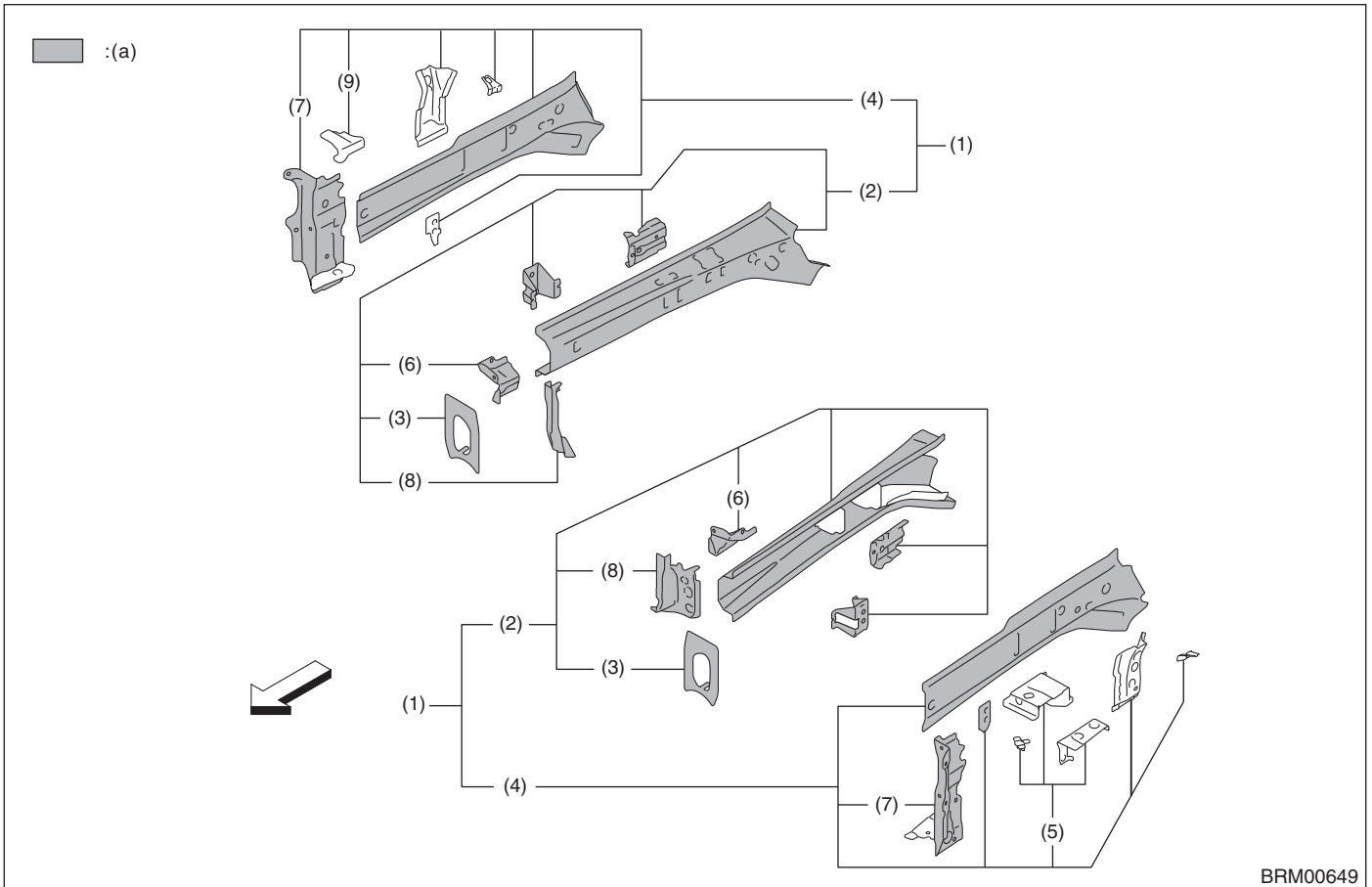
(6) Beam bracket

(7) Front hook reinforcement

(8) Front frame gusset

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

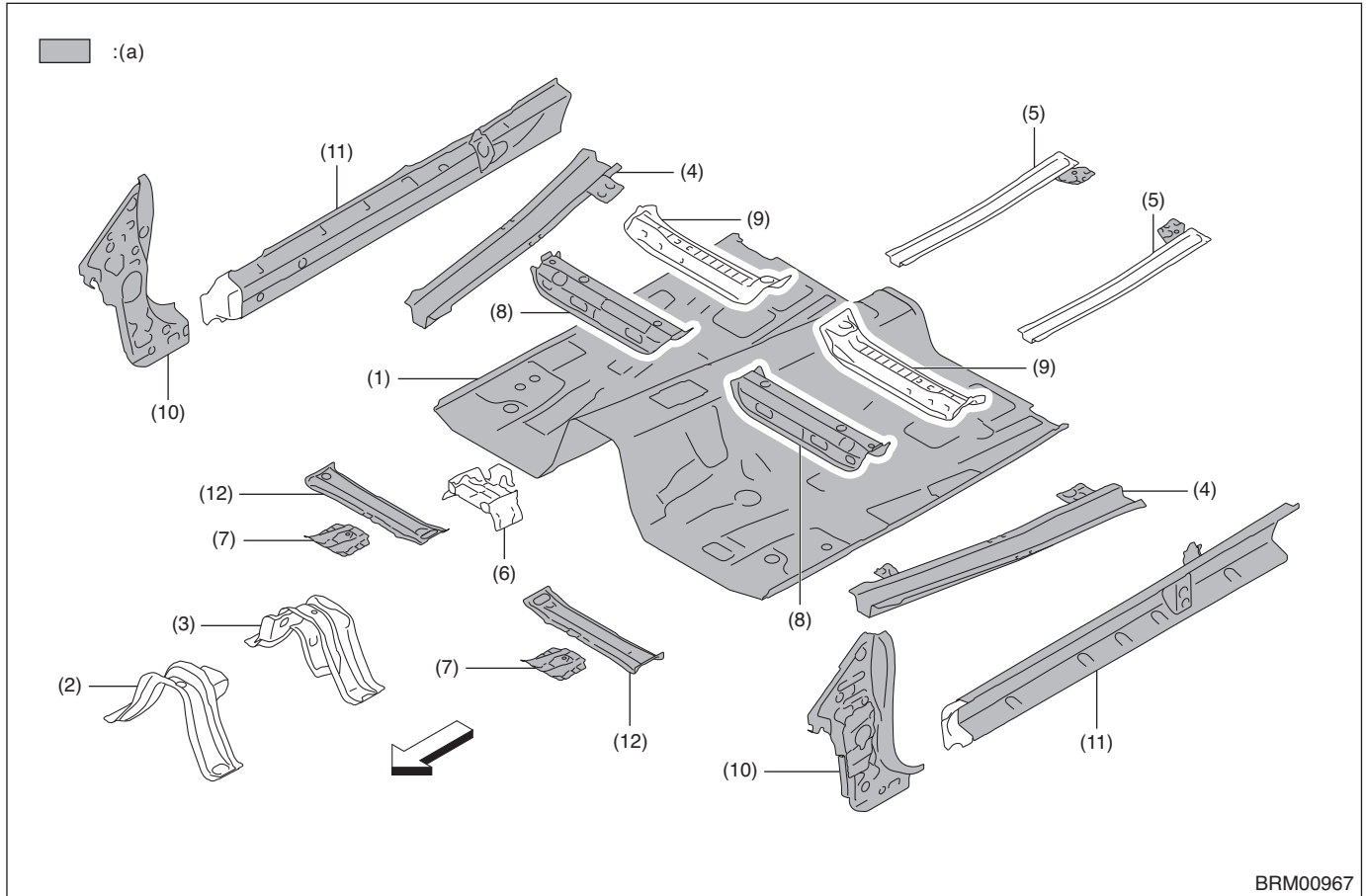
- (4) Closing plate
- (5) Battery bracket
- (6) Beam bracket

- (7) Front hook reinforcement
- (8) Front frame gusset
- (9) Extension apron FF

Panel Components

5. FRONT FLOOR PANEL

• Gasoline model

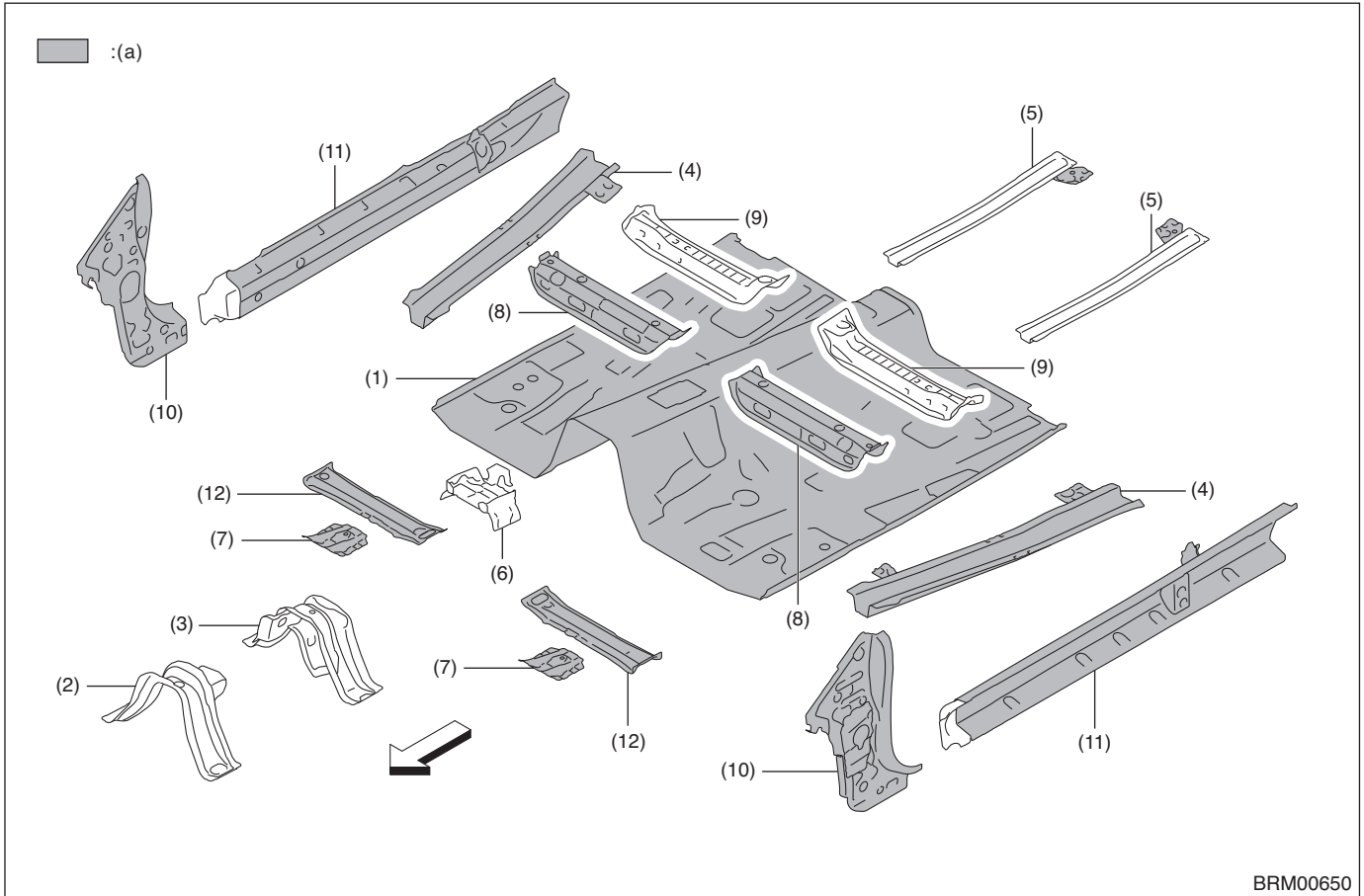


(a) High-strength tensile steel
(440 — 590 MPa class)

- | | | |
|------------------------------|----------------------------------|---------------------------------|
| (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



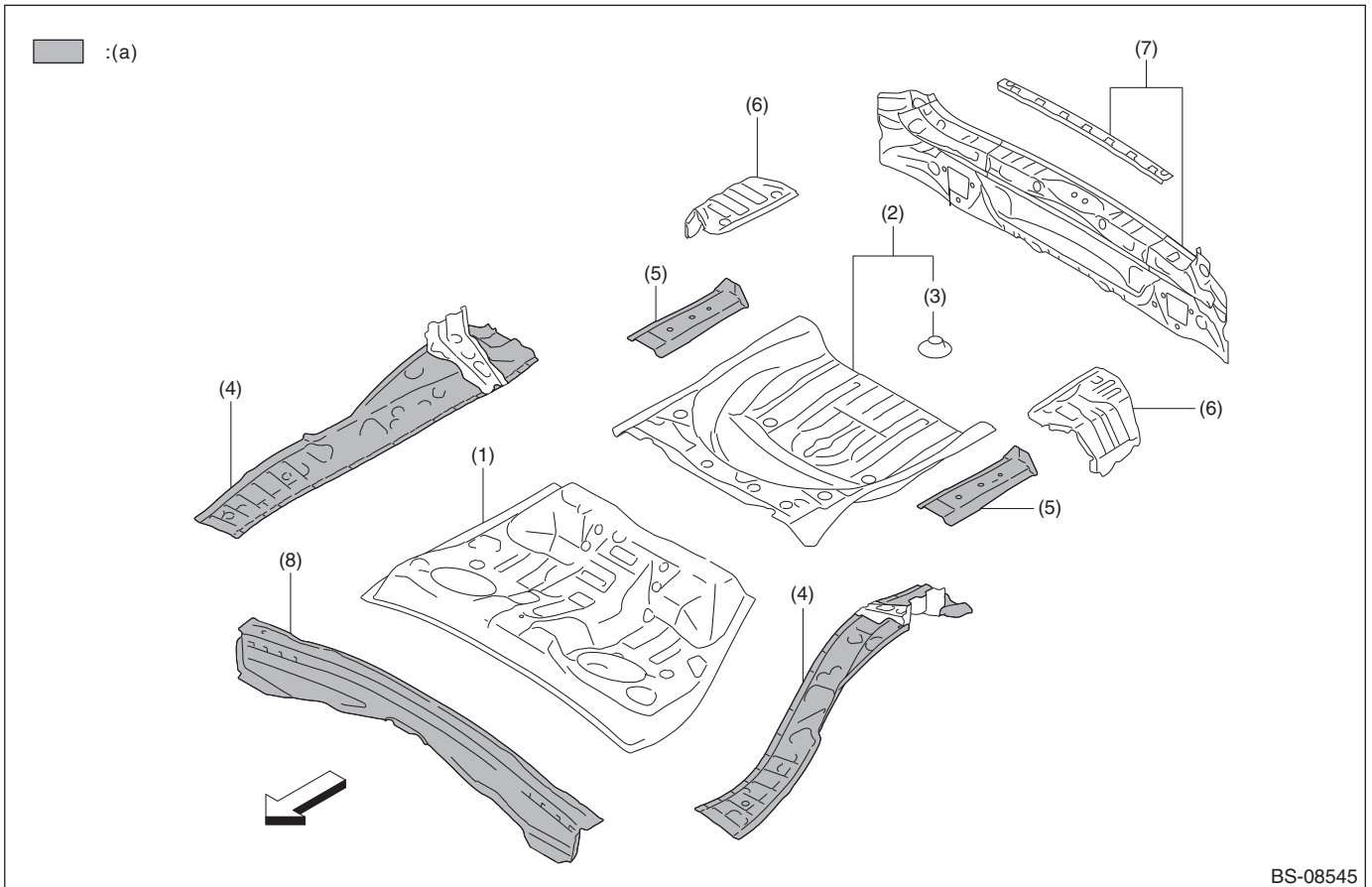
(a) High-strength tensile steel
(440 — 590 MPa class)

- | | | |
|------------------------------|----------------------------------|---------------------------------|
| (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

6. REAR FLOOR PANEL & REAR SKIRT

• 5 Door (Gasoline model)



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

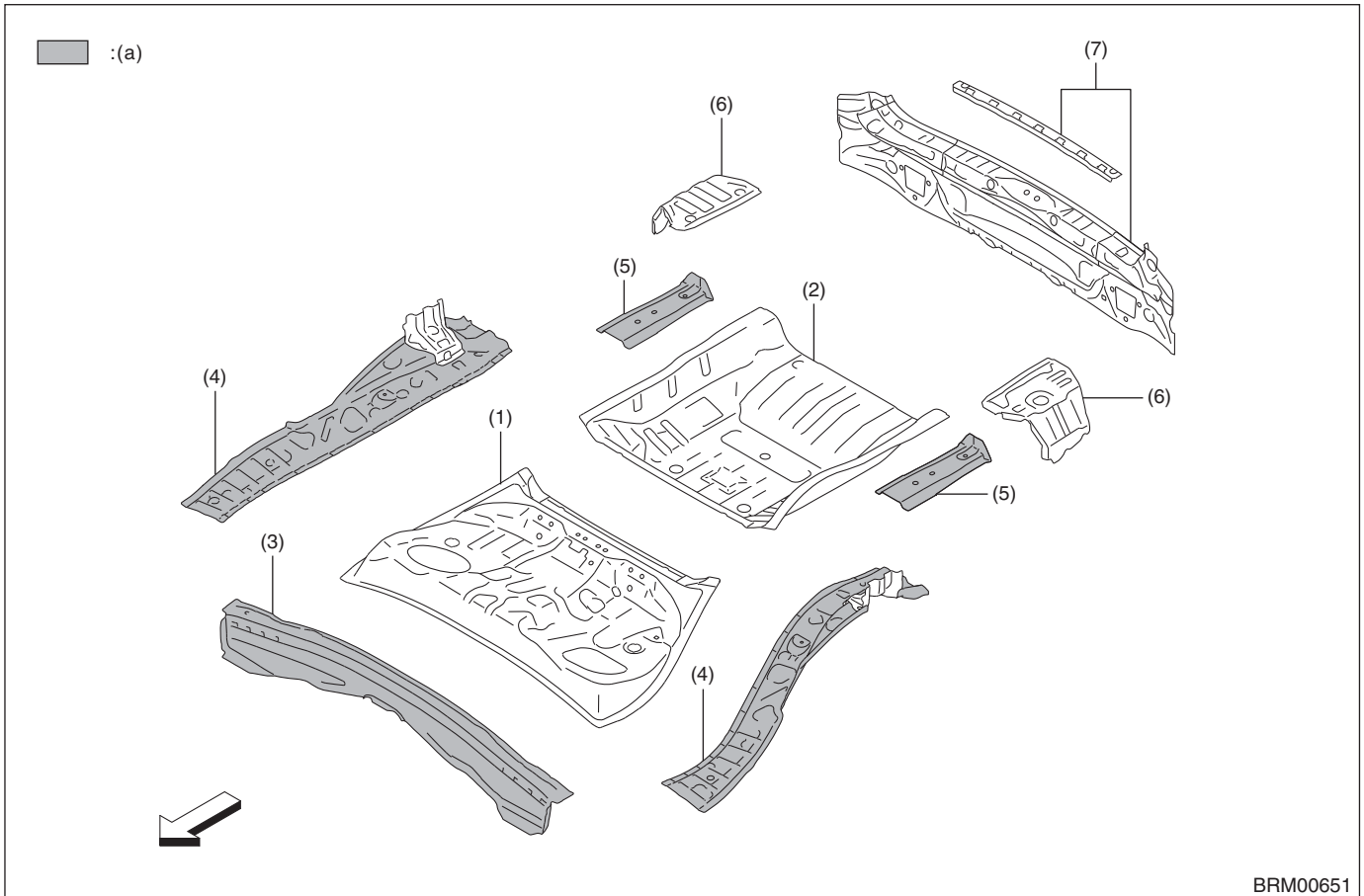
- (1) Rear floor pan front
- (2) Rear floor pan rear
- (3) Spare tire bracket

- (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

• 5 Door (Hybrid model)



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

(1) Rear floor pan front

(2) Rear floor pan rear

(3) Rear crossmember A front

(4) Damper bracket floor upper

(5) Rear side frame upper rear

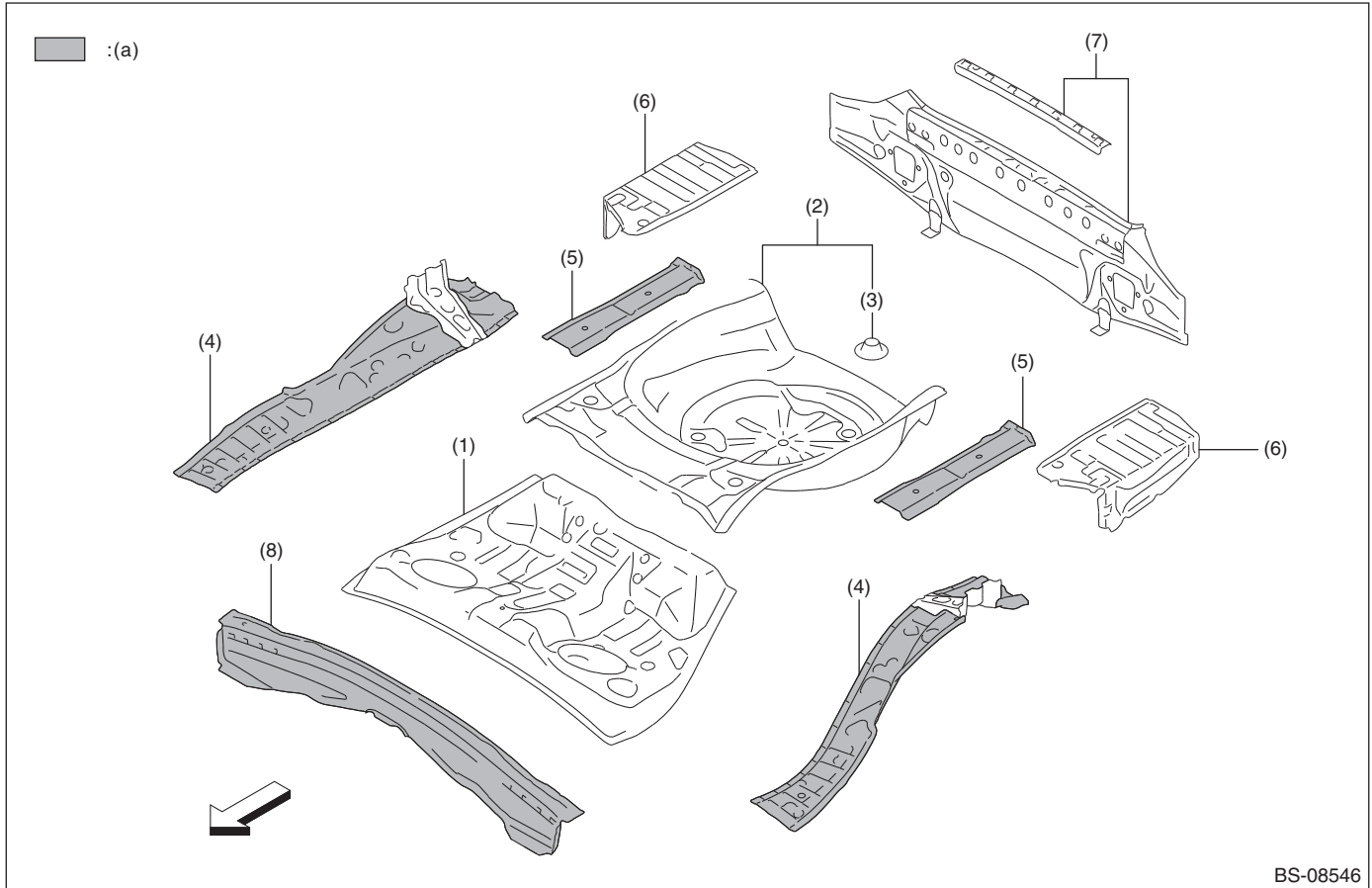
(6) Floor side rear

(7) Rear skirt

(8) Rear floor crossmember A front

Panel Components

• 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

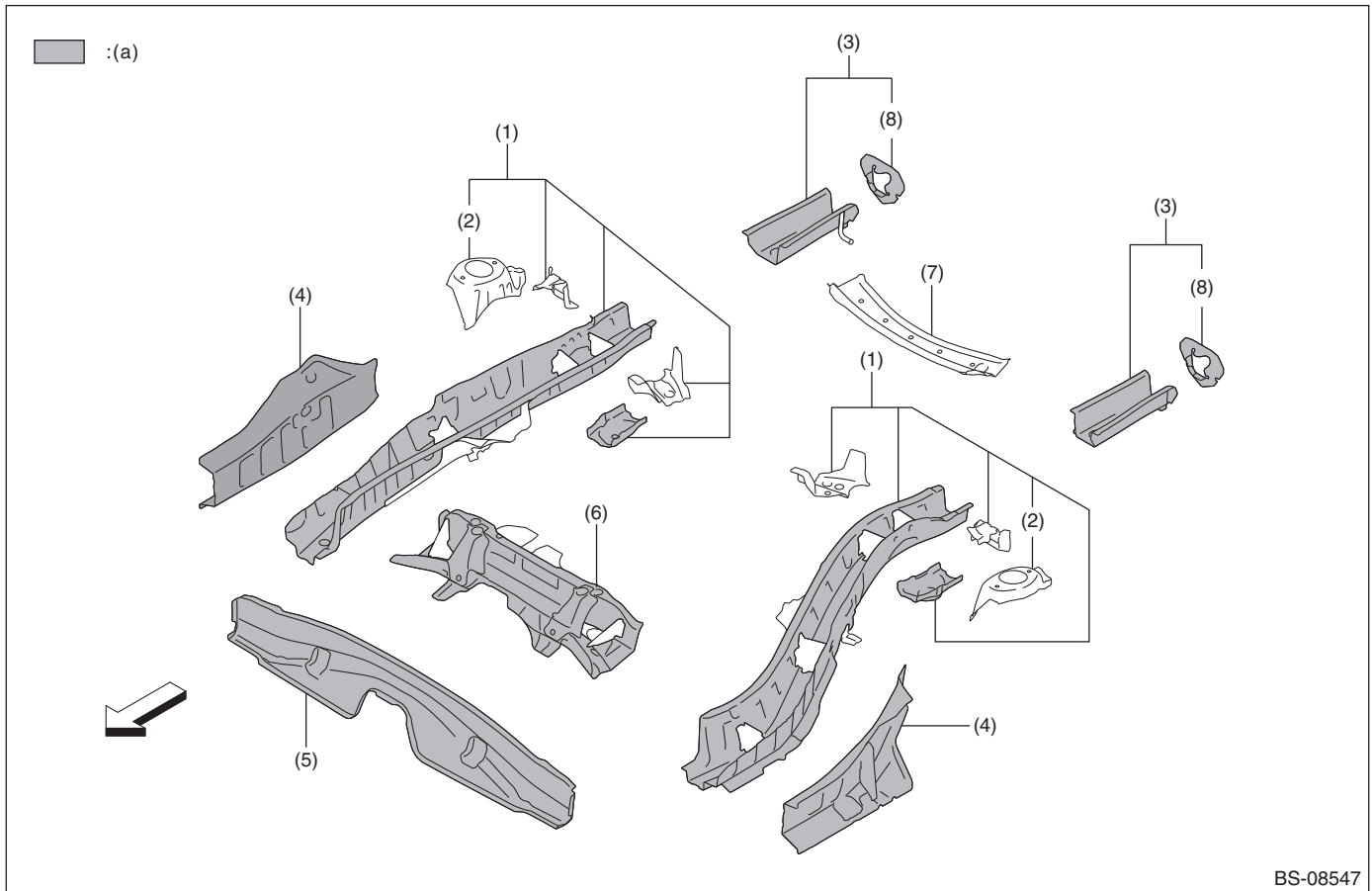
(7) Rear skirt

(8) Rear floor crossmember A front

Panel Components

7. REAR FLOOR SIDE FRAME

• 5 Door (Gasoline model)

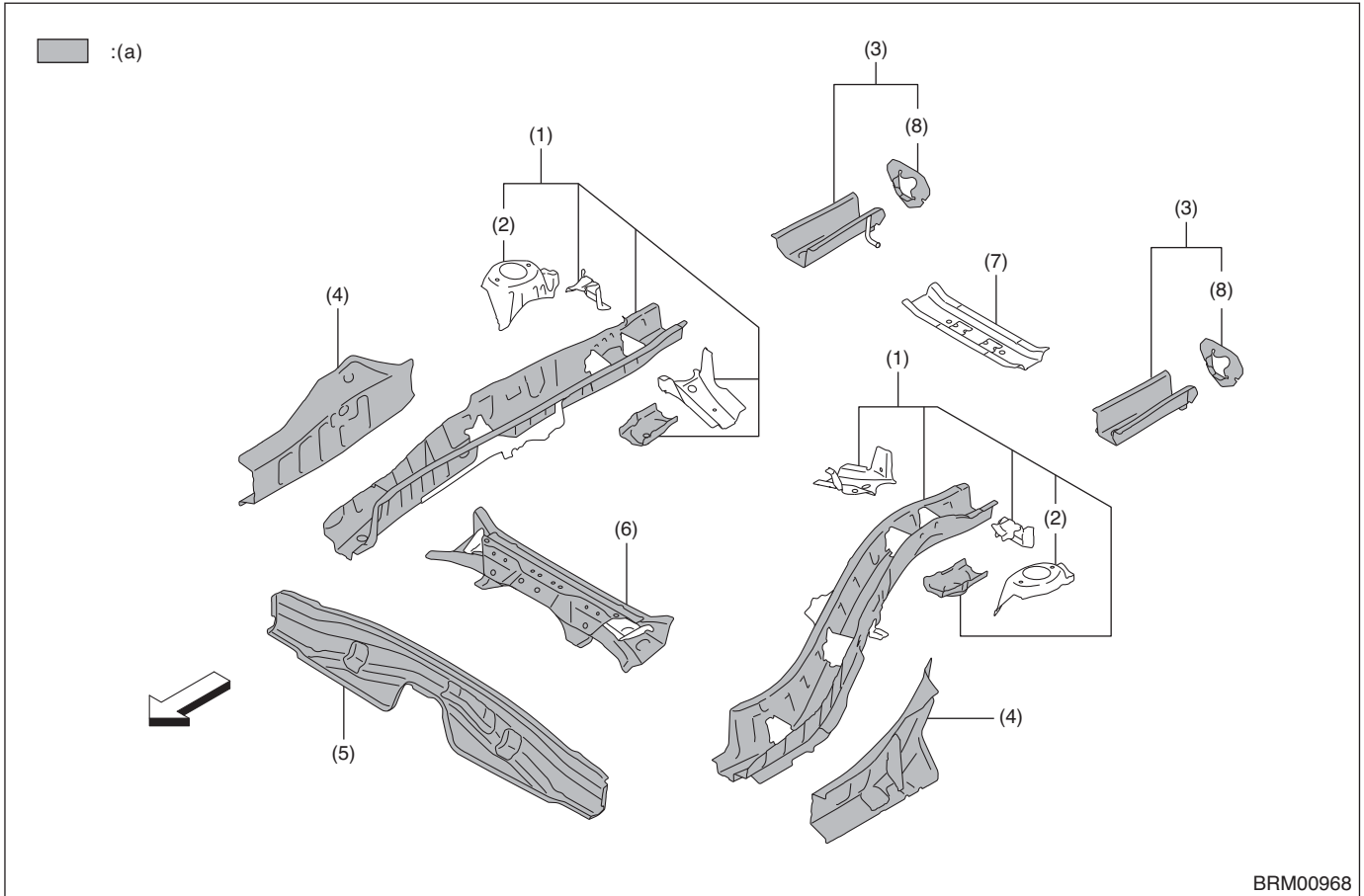


(a) High-strength tensile steel
(440 — 590 MPa class)

- | | | |
|--------------------------------------|-----------------------------------|------------------------------|
| (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)

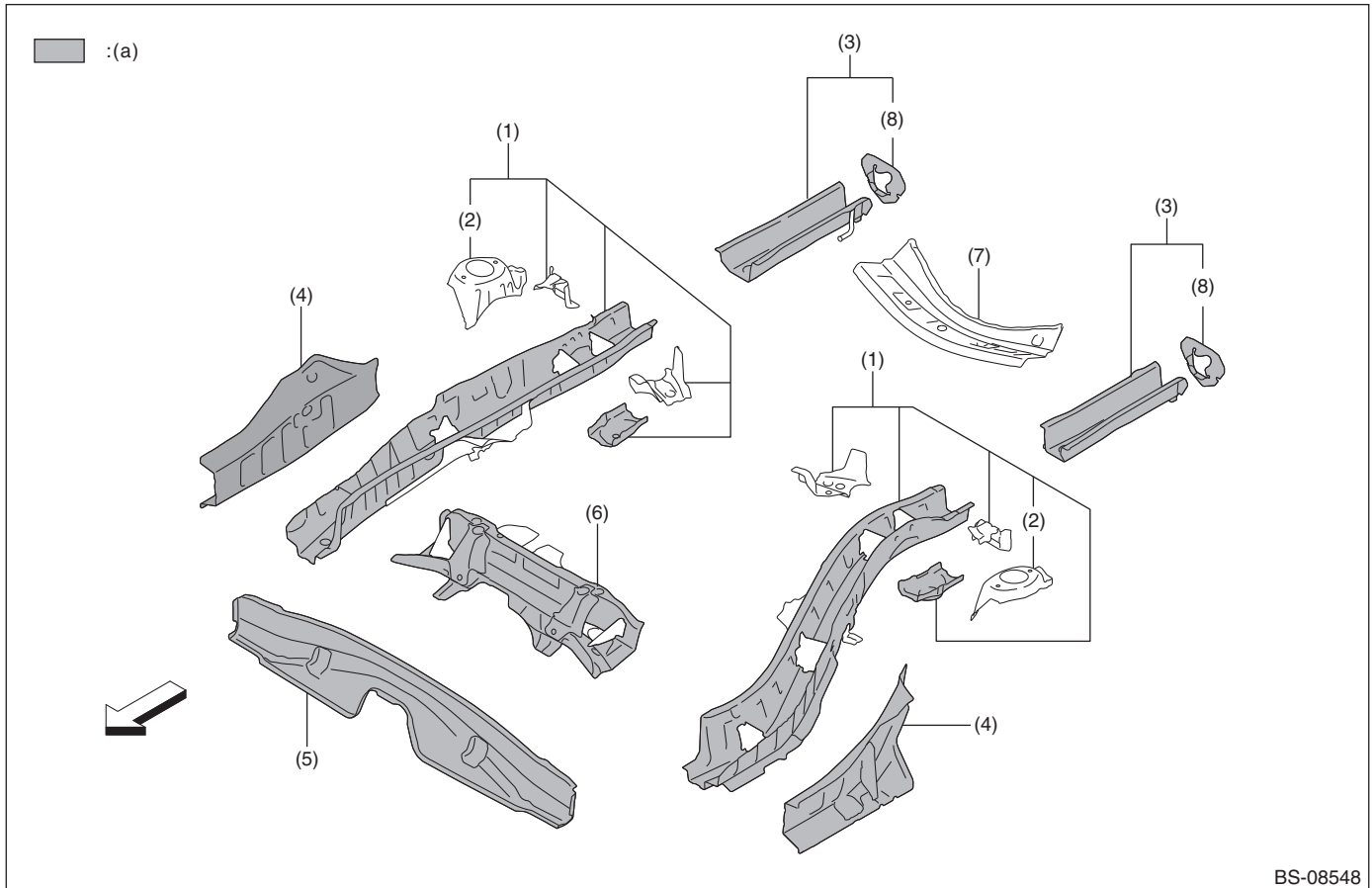


(a) High-strength tensile steel
(440 — 590 MPa class)

- | | | |
|--------------------------------------|-----------------------------------|------------------------------|
| (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

• 4 Door



BS-08548

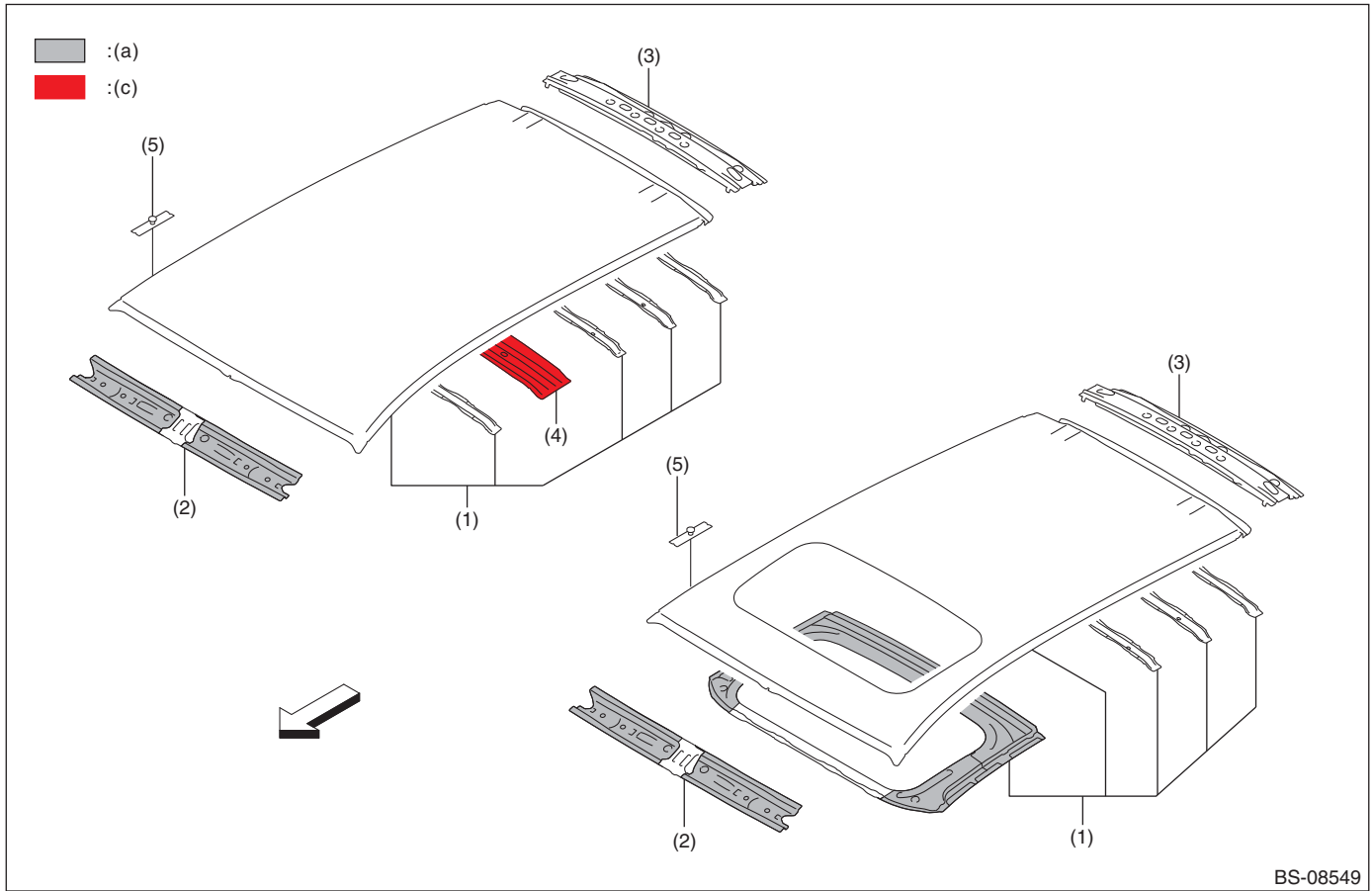
(a) High-strength tensile steel
(440 — 590 MPa class)

- | | | |
|--------------------------------------|-----------------------------------|------------------------------|
| (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

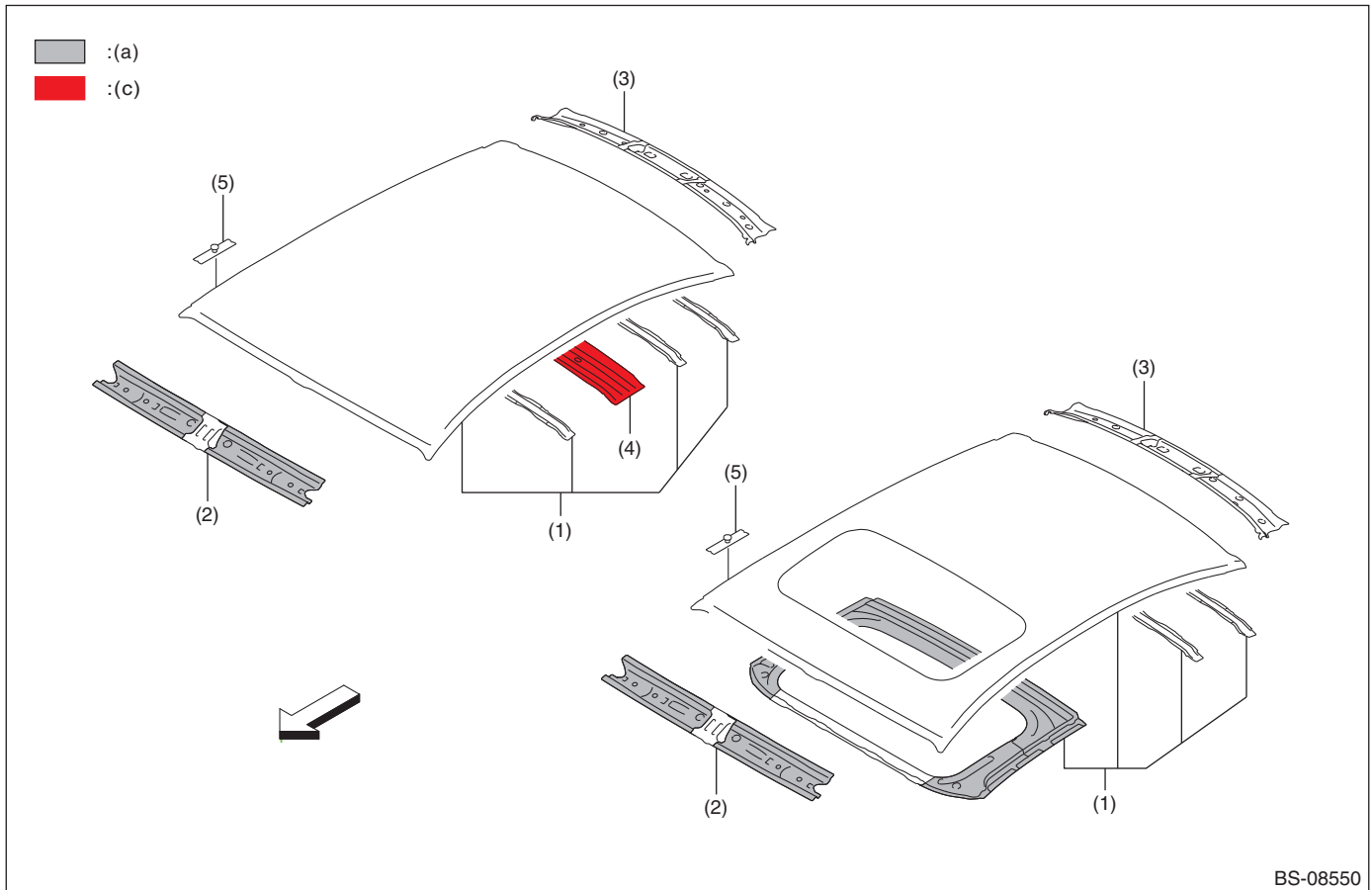
8. ROOF

• 5 Door



Panel Components

• 4 Door



(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

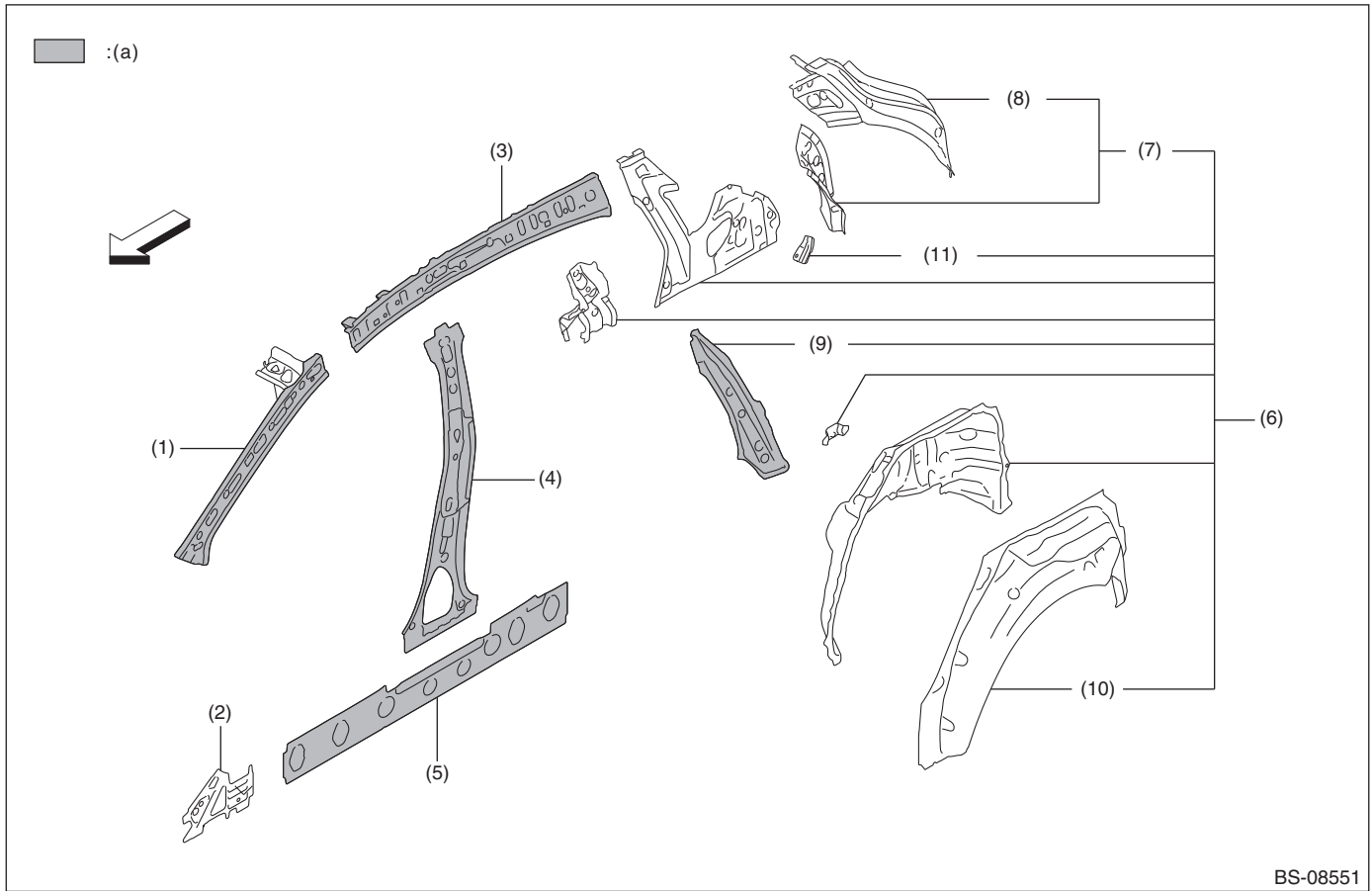
(2) Front roof rail

(4) Roof center brace

Panel Components

9. SIDE PANEL INNER

• 5 Door (Gasoline model)

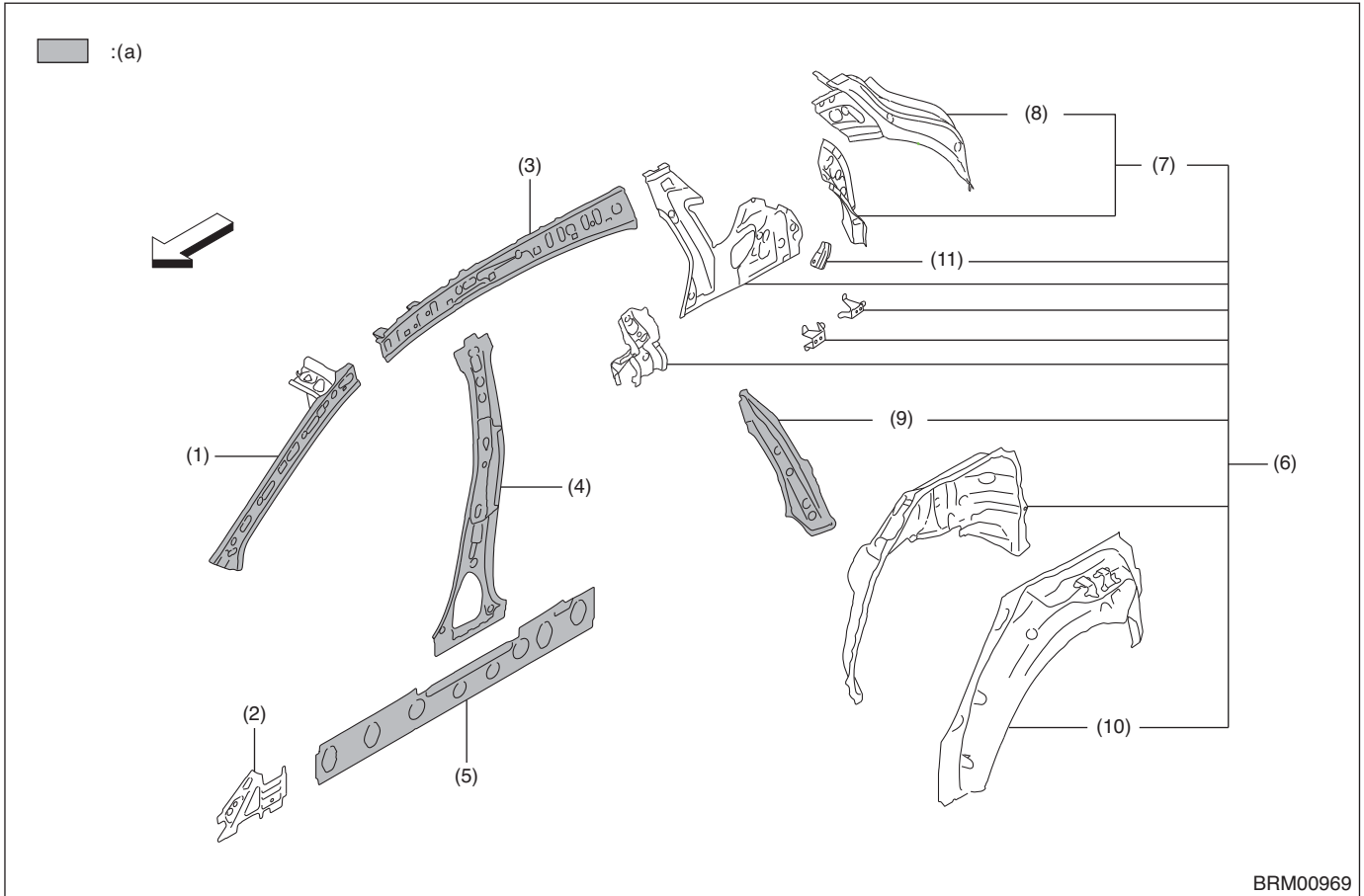


(a) High-strength tensile steel
(440 — 590 MPa class)

- | | | |
|-----------------------------------|----------------------------------|----------------------------------|
| (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)



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

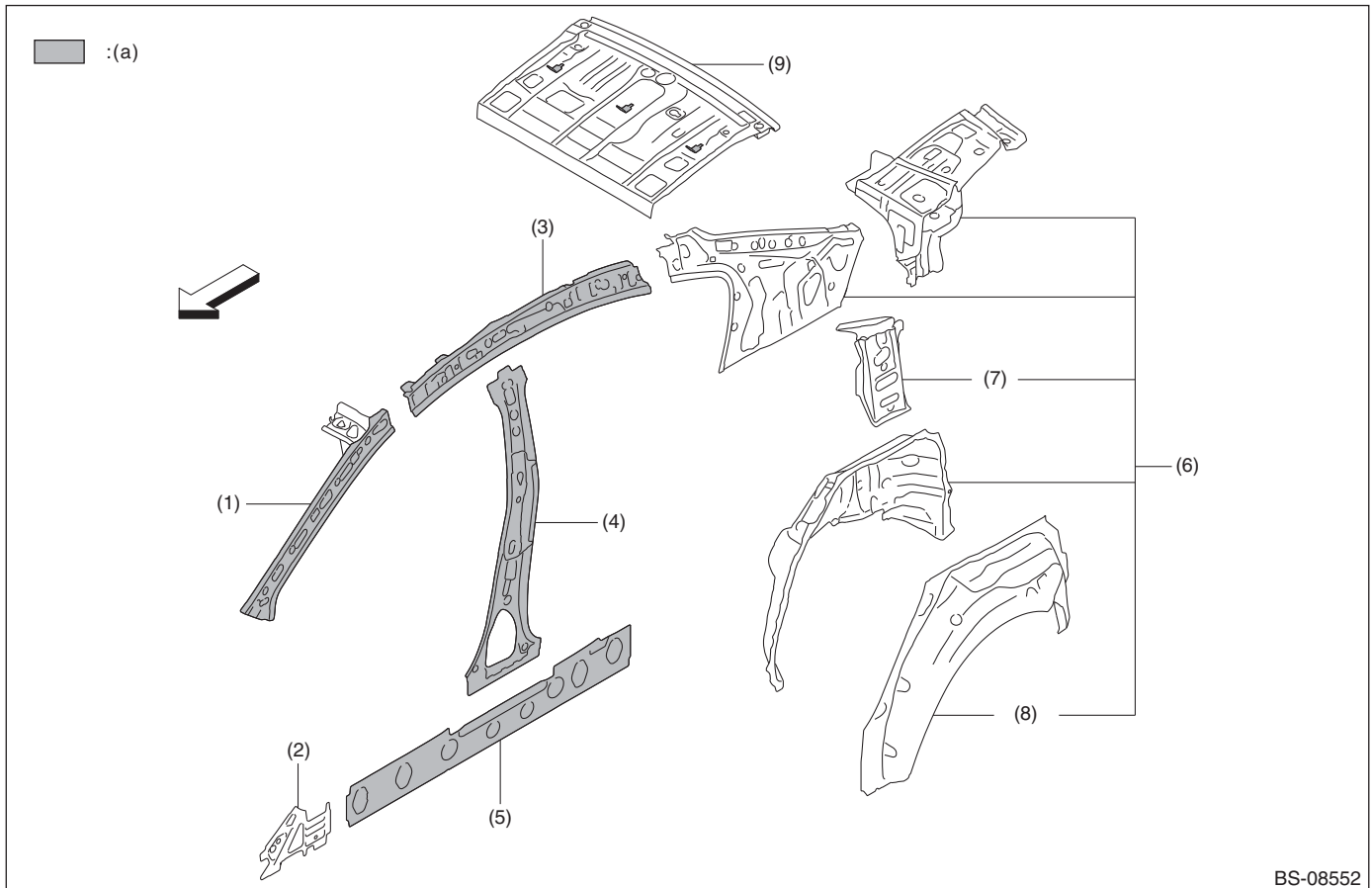
- (1) Pillar front inner upper
- (2) Reinforcement sill side front
- (3) Rail side inner
- (4) Pillar center inner

- (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

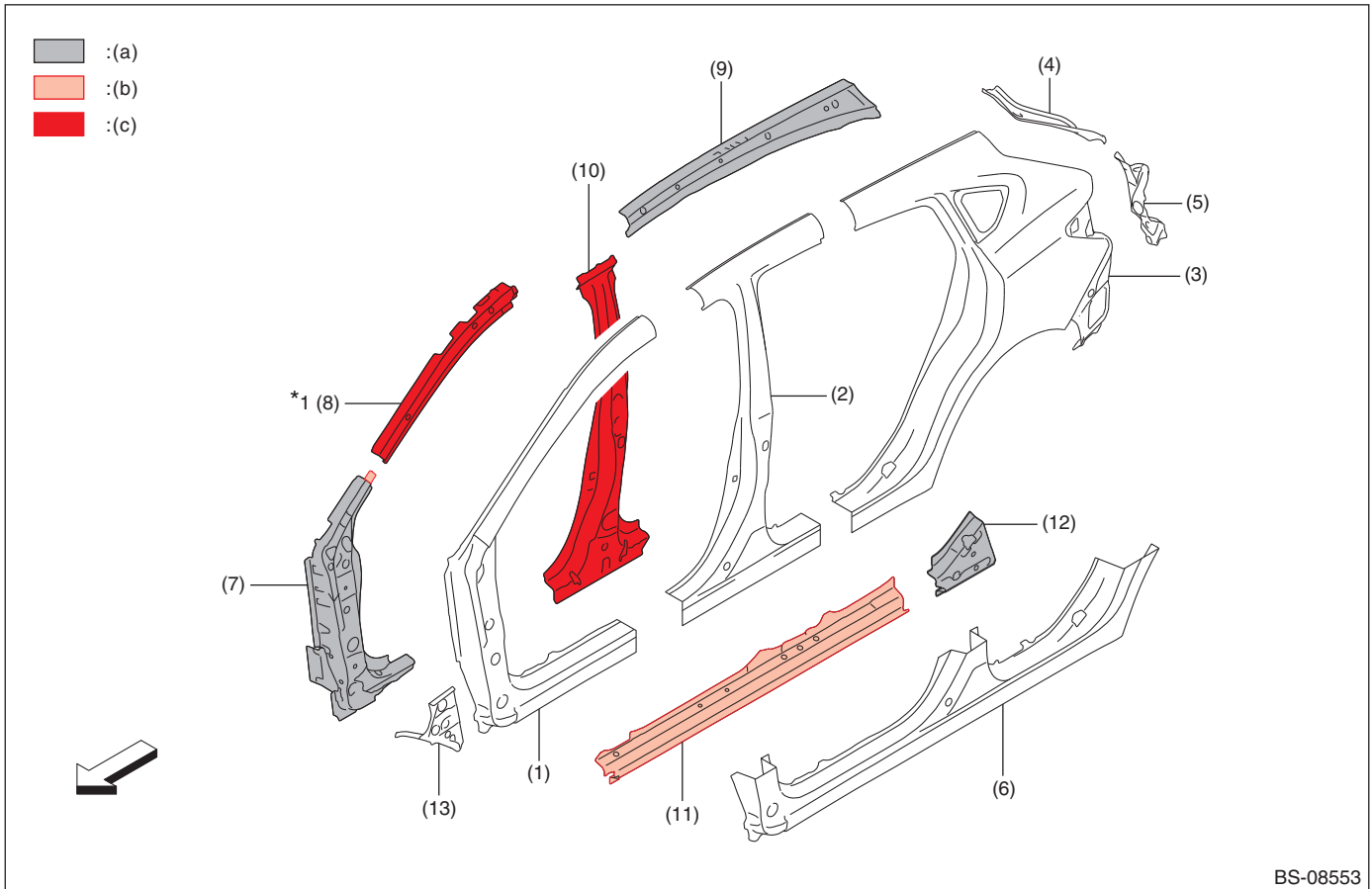
- (4) Pillar center inner
- (5) Reinforcement sill side rear
- (6) Rear quarter inner

- (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)

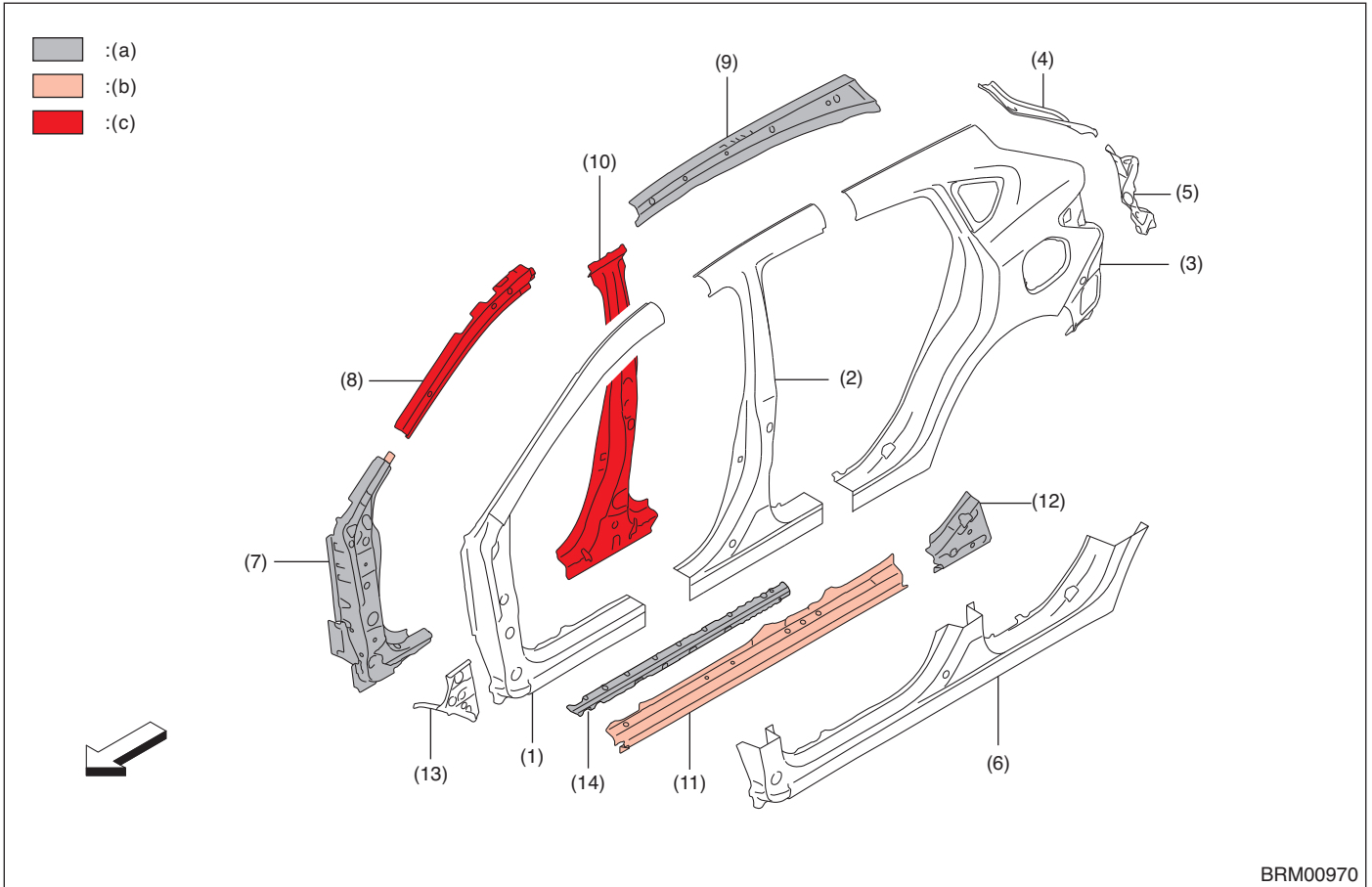
(1) Front pillar outer
(2) Center pillar outer
(3) Rear quarter outer
(4) Extension D pillar
(5) Rear quarter end

(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)

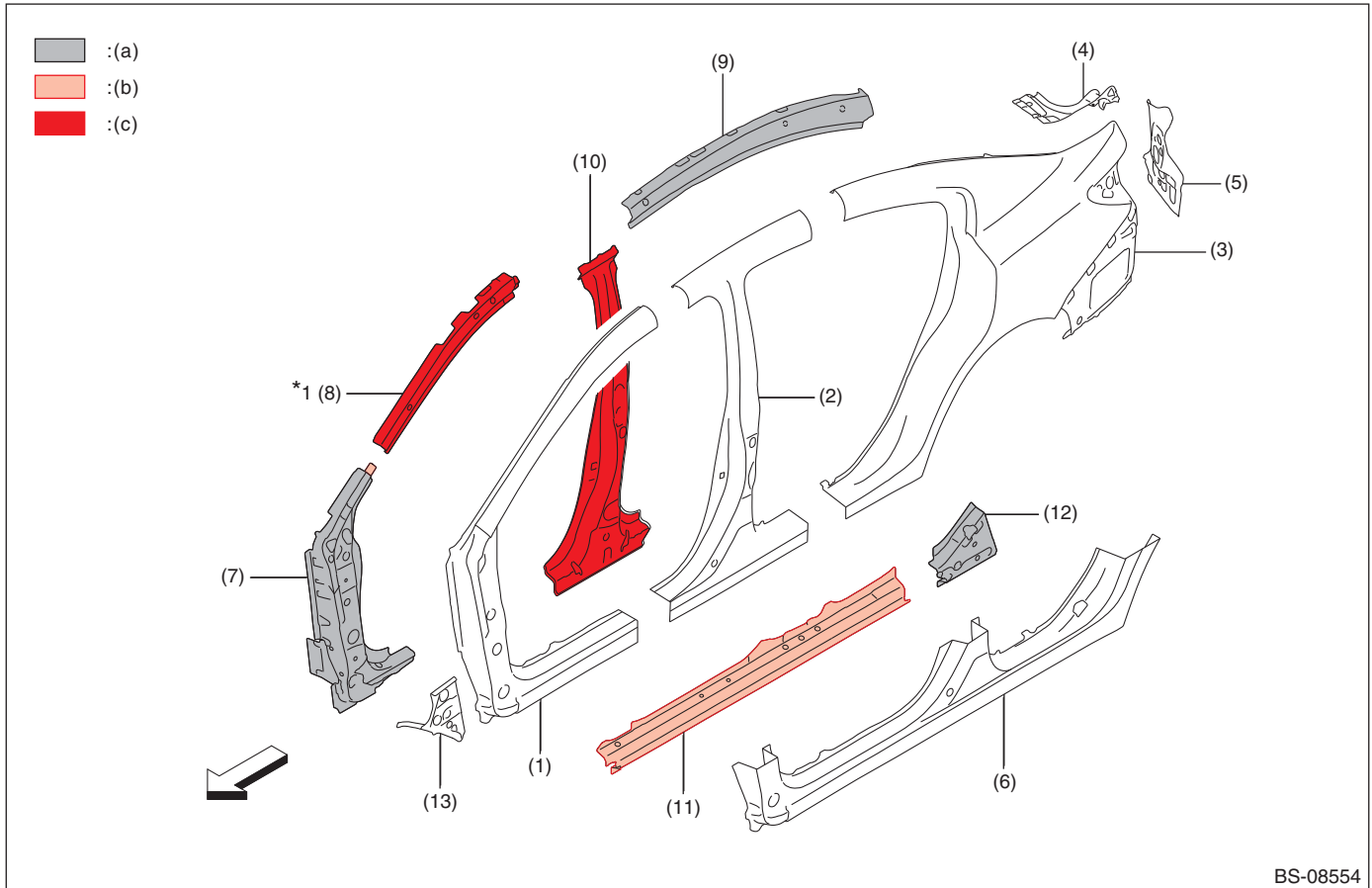
- (1) Front pillar outer
- (2) Center pillar outer
- (3) Rear quarter outer
- (4) Extension D pillar
- (5) Rear quarter end

- (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

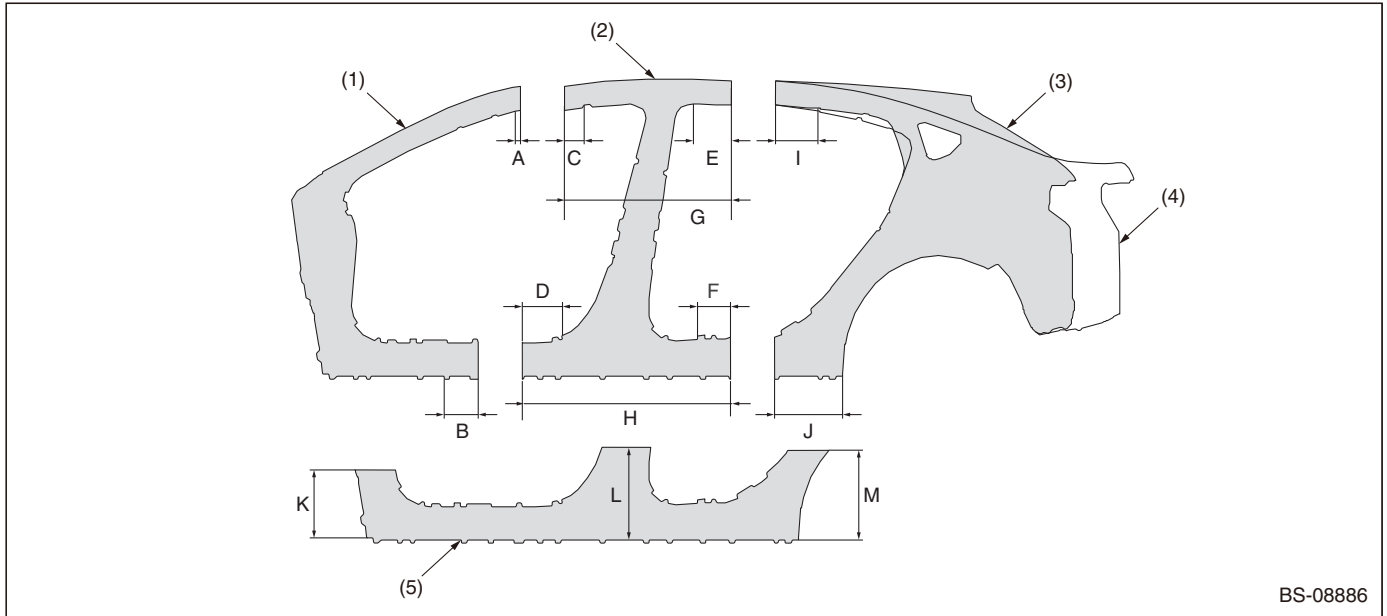
(6) Side sill outer
(7) Reinforcement pillar front outer
(8) Reinforcement rail side outer front
(9) Reinforcement rail side outer rear
(10) Reinforcement pillar center outer

(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

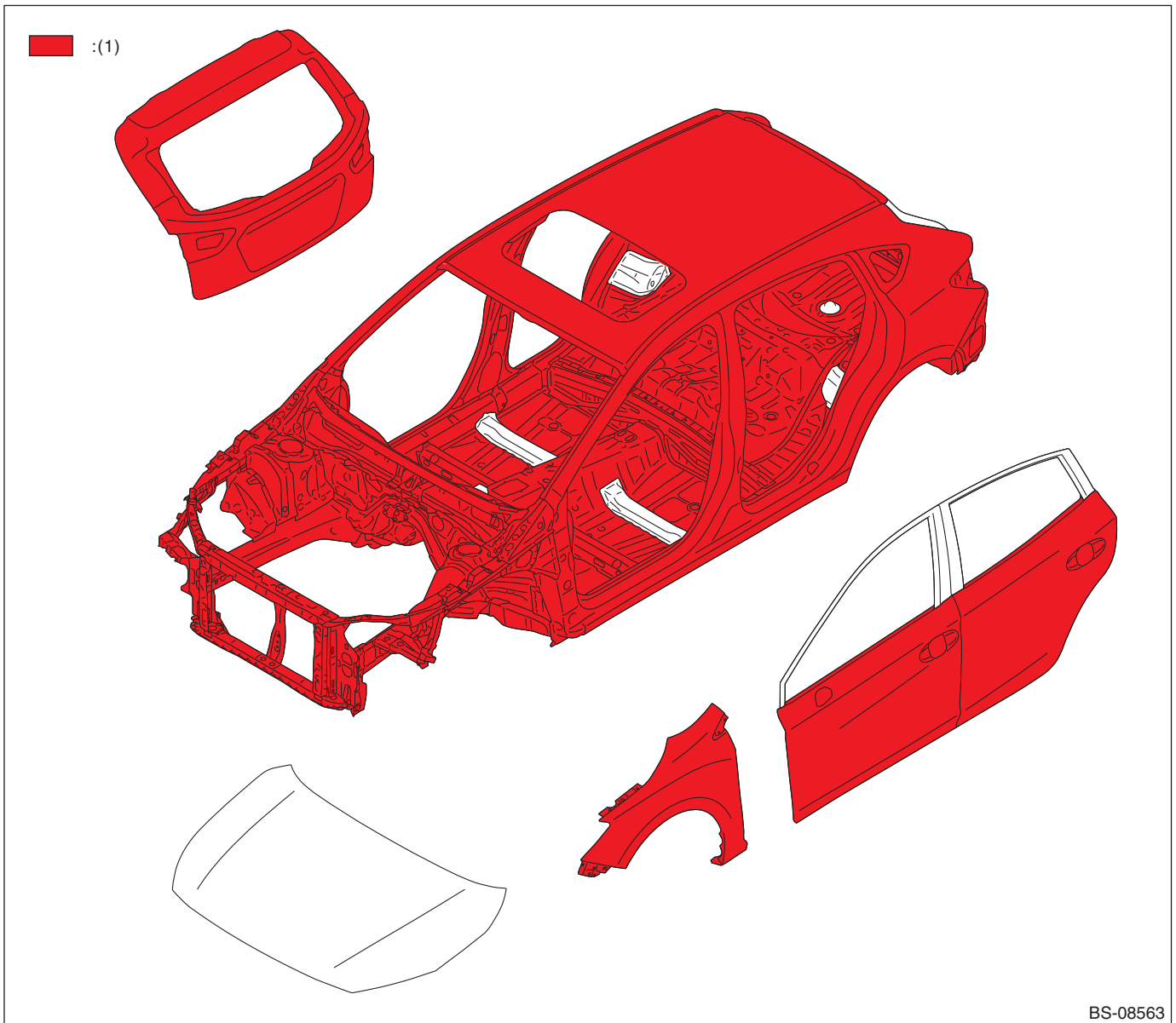


No	Part name	Measuring point	Datum dimension mm (in)
(1)	Front pillar outer	A	24 (0.94)
		B	146 (5.75)
(2)	Center pillar outer	C	81 (3.19)
		D	168 (6.61)
		E	159 (6.26)
		F	140 (5.51)
		G	705 (27.76)
		H	880 (34.65)
(3)	Rear quarter outer (5 door)	I	179 (7.05)
		J	289 (11.38)
(4)	Rear quarter outer (4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

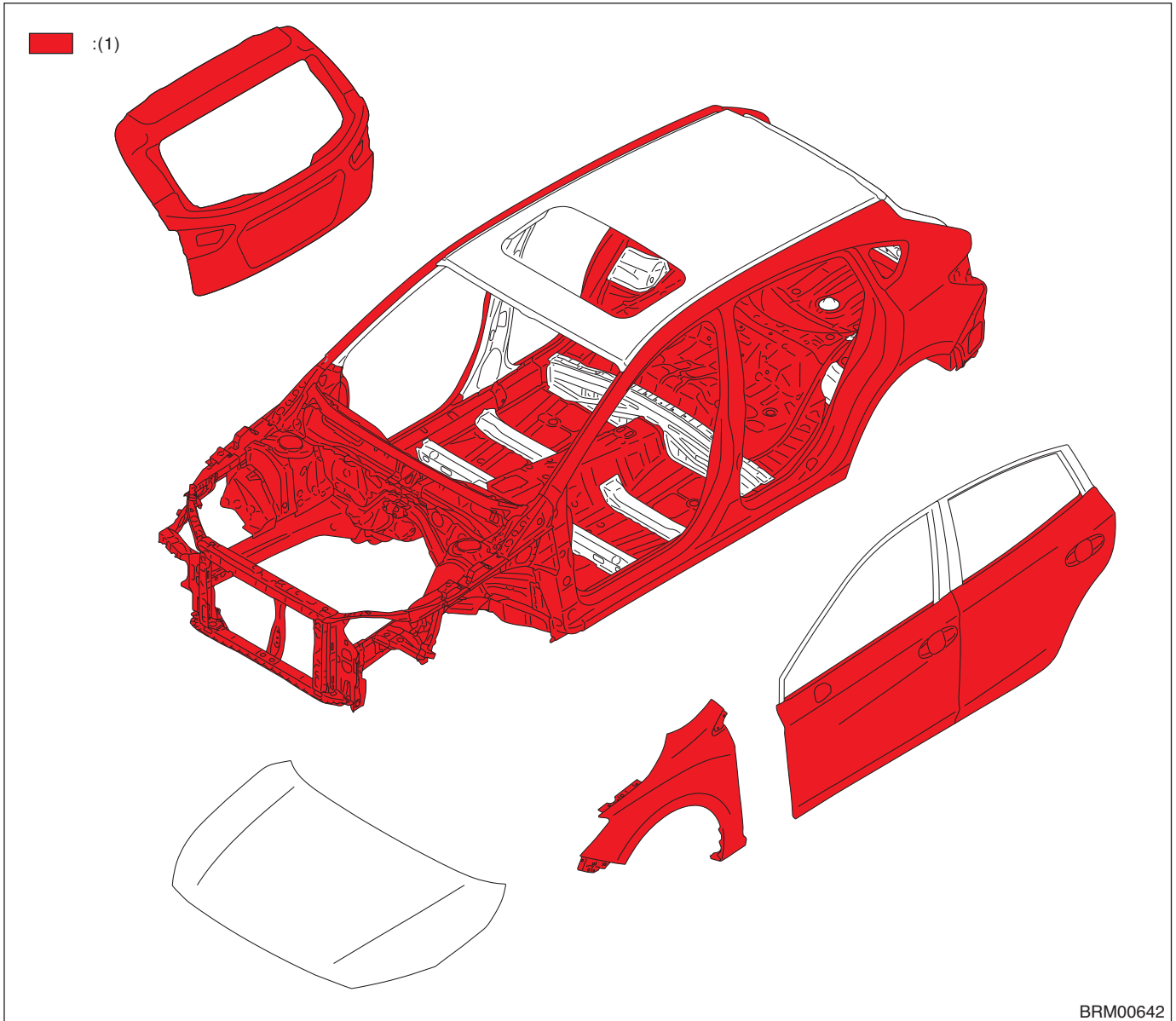


BS-08563

- (1) Galvanized sheet metal
(both sides)

The fuel flap is made of Galvanized Sheet Metal

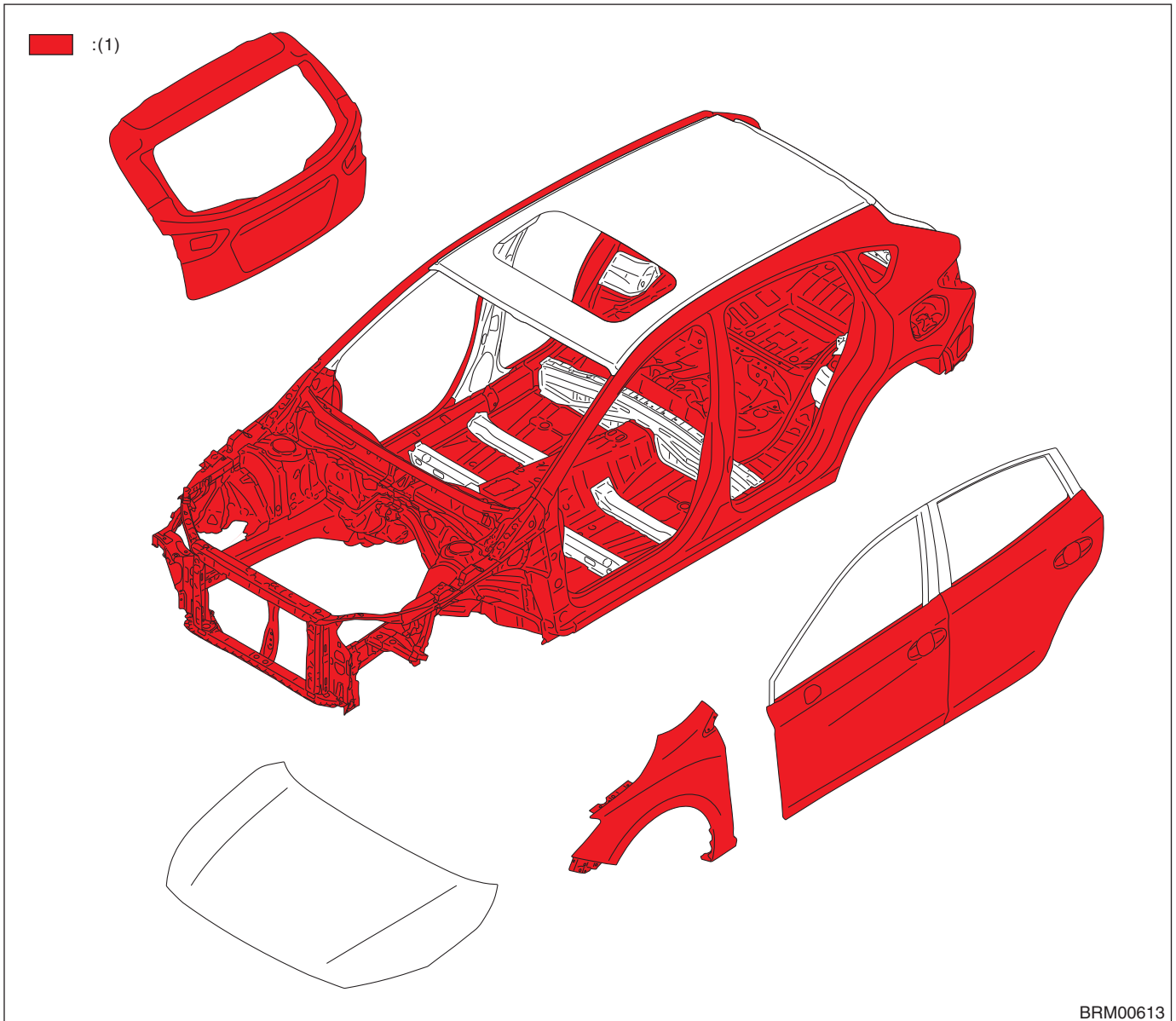
- **XV model**



(1) Galvanized sheet metal
(both sides)

The fuel flap is made of Galvanized Sheet Metal

- Hybrid model

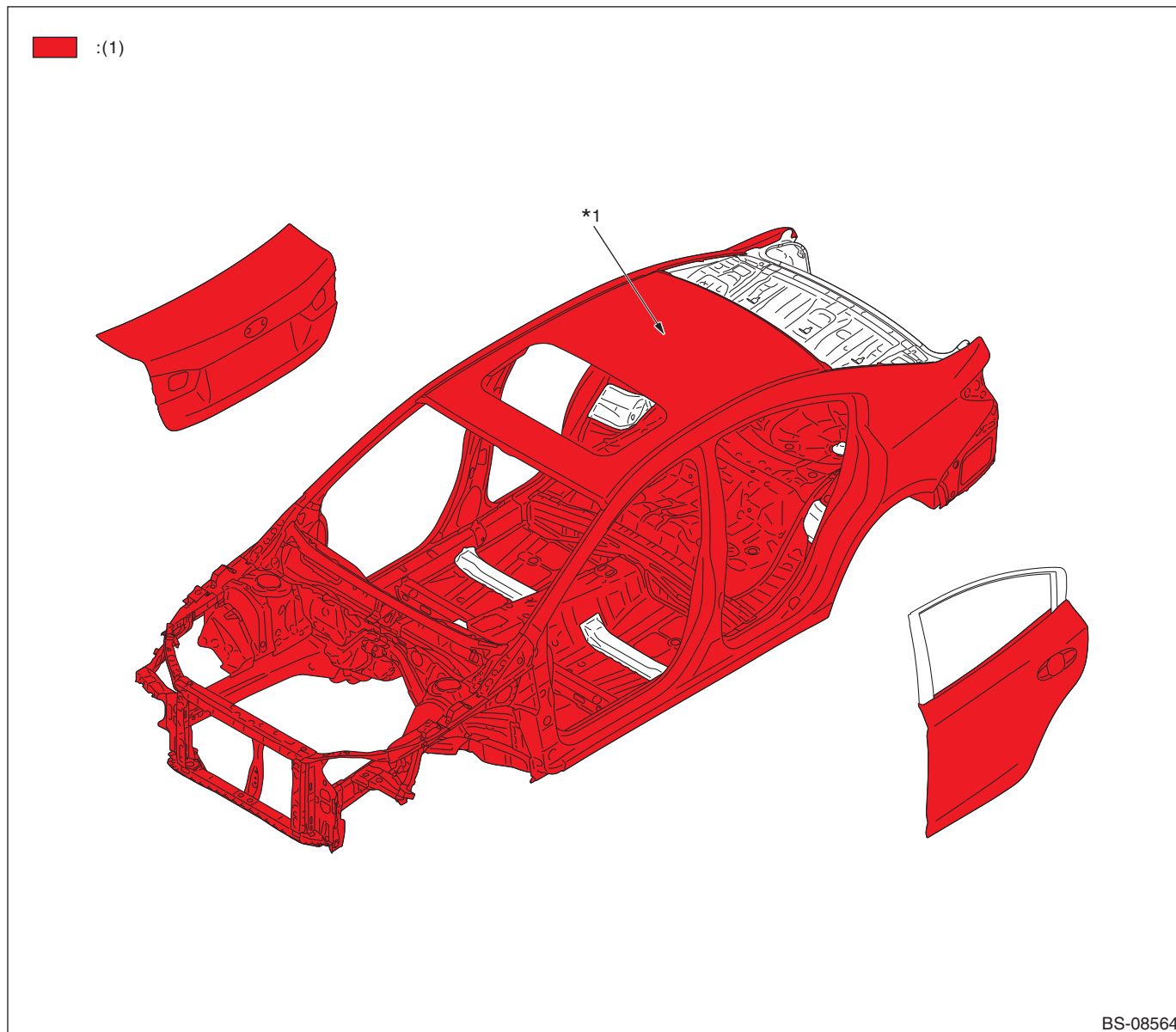


(1) Galvanized sheet metal
(both sides)

The fuel flap is made of Galvanized Sheet Metal

Galvanized Sheet Metal

• SPECIAL PARTS FOR 4 DOOR



(1) Galvanized sheet metal
(both sides)

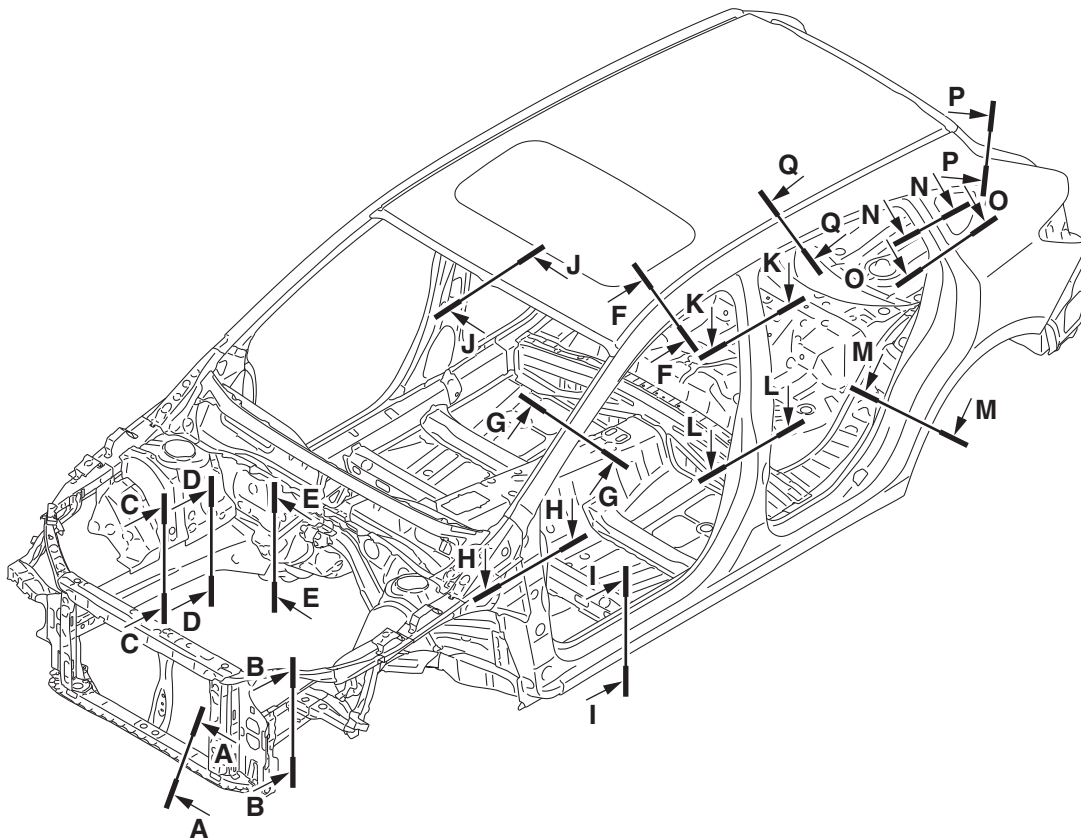
The fuel flap is made of Galvanized Sheet Metal

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

5. Body Construction

A: SPECIFICATIONS

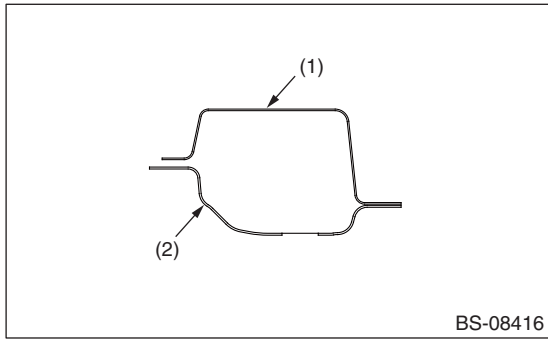
• COMMON PARTS FOR 5 DOOR AND 4 DOOR



BS-08414

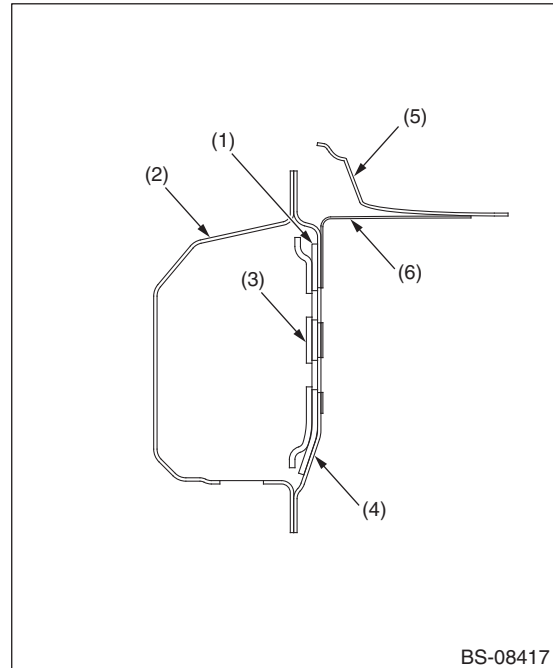
Body Construction

Cross section A — A



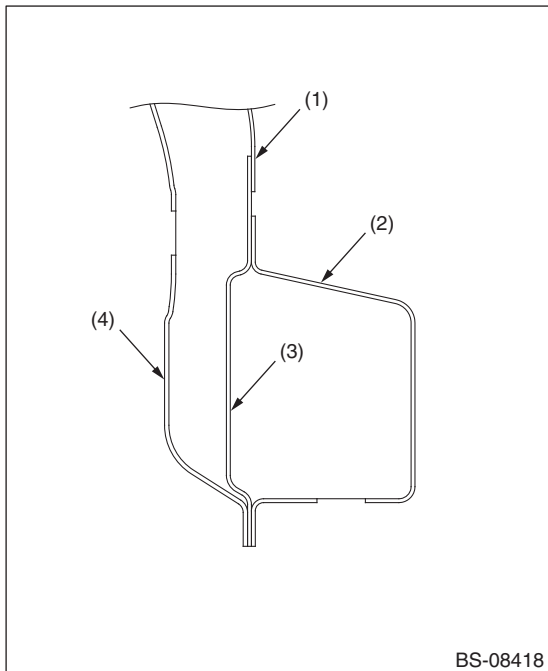
- (1) Frame lower A
- (2) Frame lower B

Cross section B — B



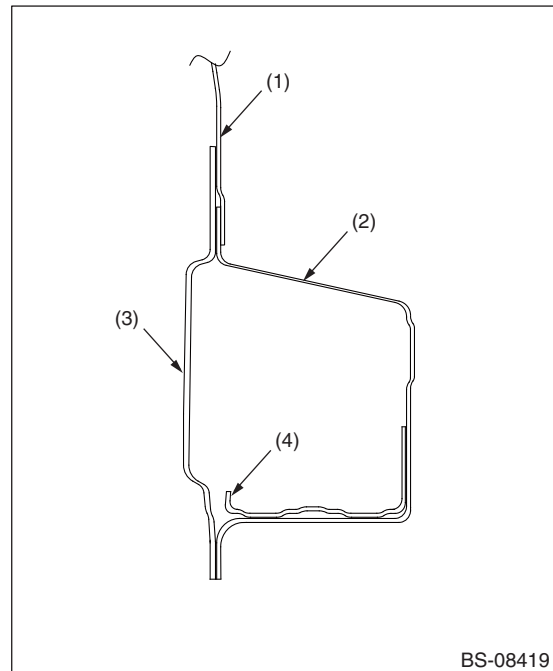
- (1) Plate closing plate FF
- (2) Frame side FF
- (3) Separator FF A
- (4) Closing plate FF
- (5) Battery gusset
- (6) Battery gusset lower

Cross section C — C



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

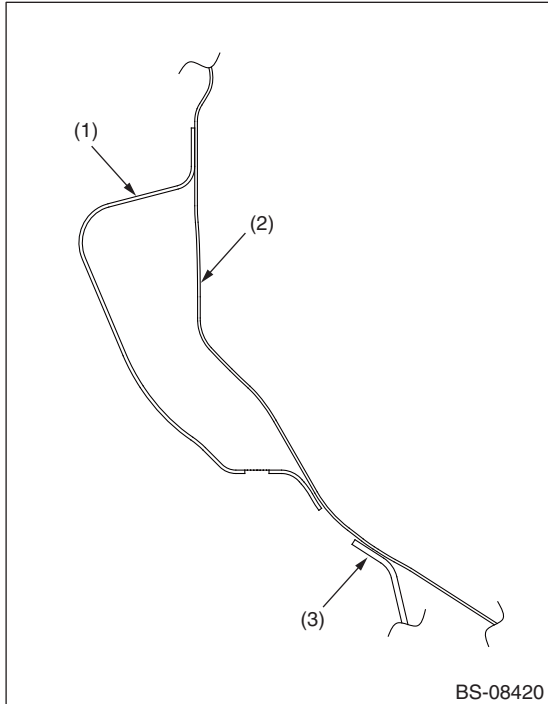
Cross section D — D



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

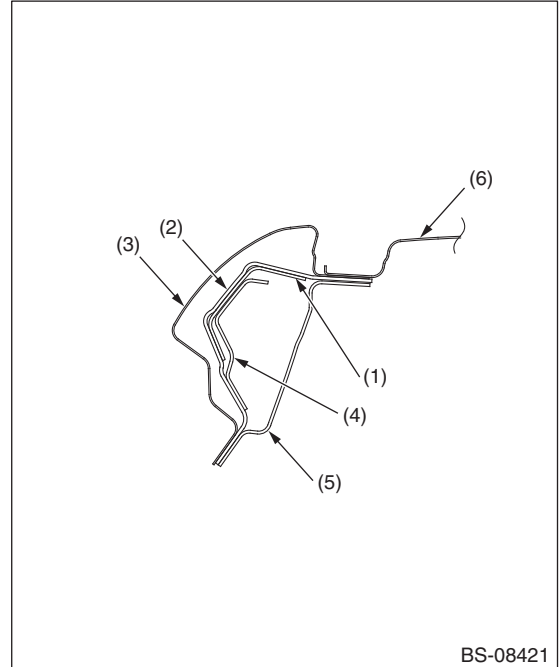
Body Construction

Cross section E — E



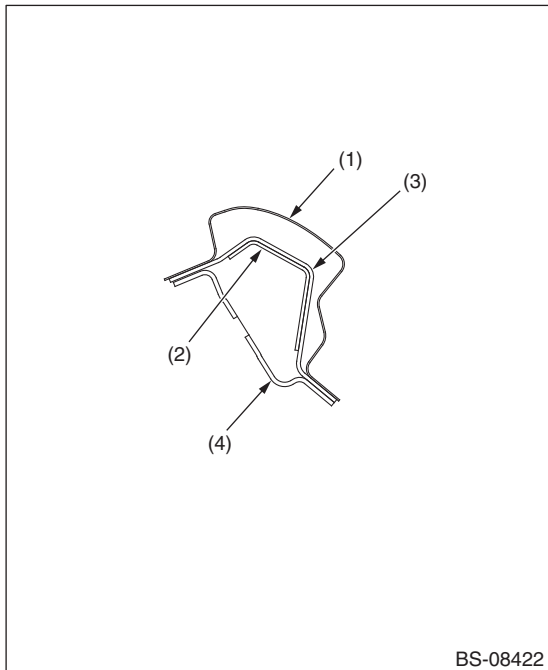
- (1) Crossmember toe board center
- (2) Toe board
- (3) Frame tunnel front

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 frontA
- (5) Rail side inner
- (6) Roof panel

Cross section G — G

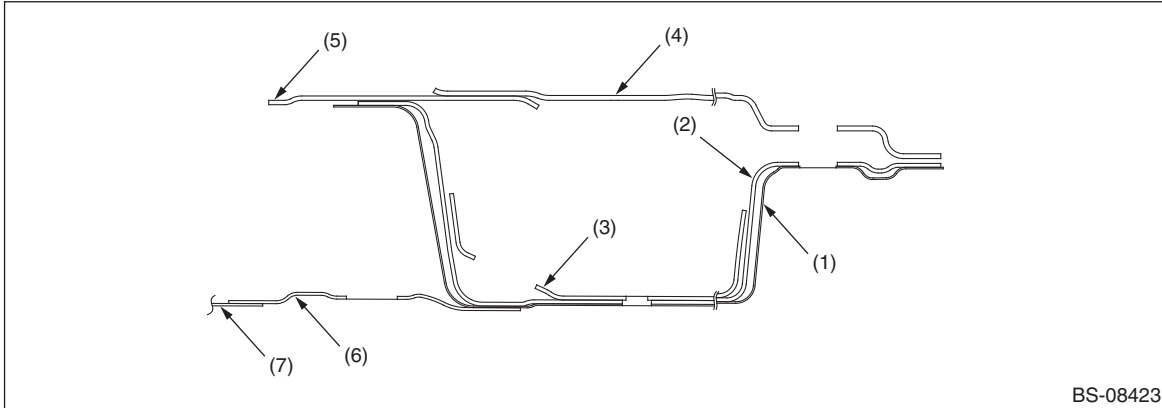


- (1) Panel side outer
- (2) Reinforcement rail side outer front A
- (3) Reinforcement rail side outer front
- (4) Pillar front inner upper

SUBARU.

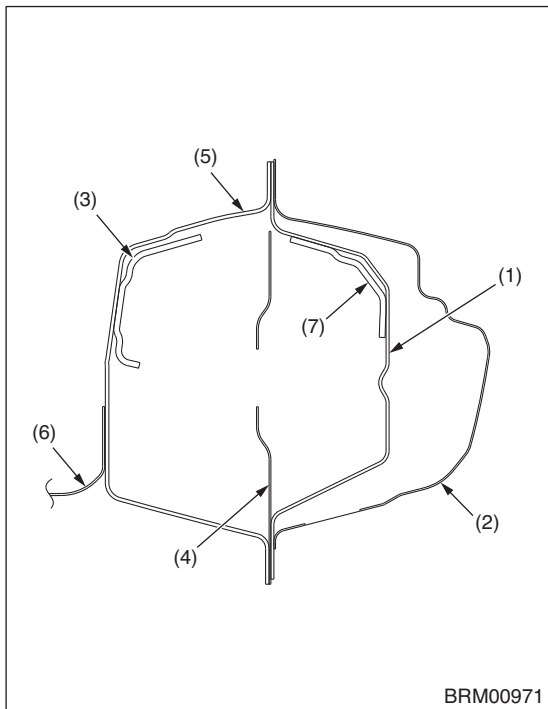
Body Construction

Cross section H — H



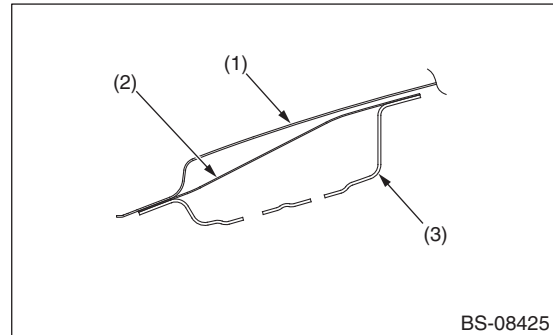
- (1) Panel side outer
- (2) Reinforcement pillar front outer
- (3) Reinforcement pillar front center
- (4) Pillar front inner lower
- (5) Pillar front inner center
- (6) Gusset frame side
- (7) Frame side upper

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

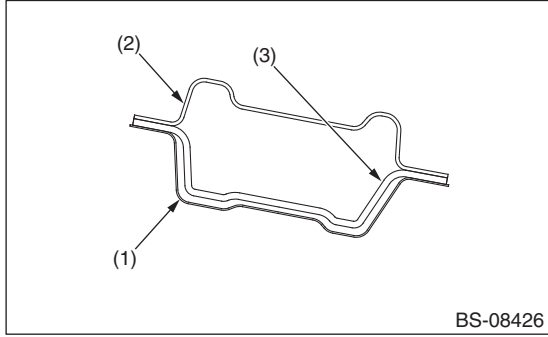
Cross section J — J



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

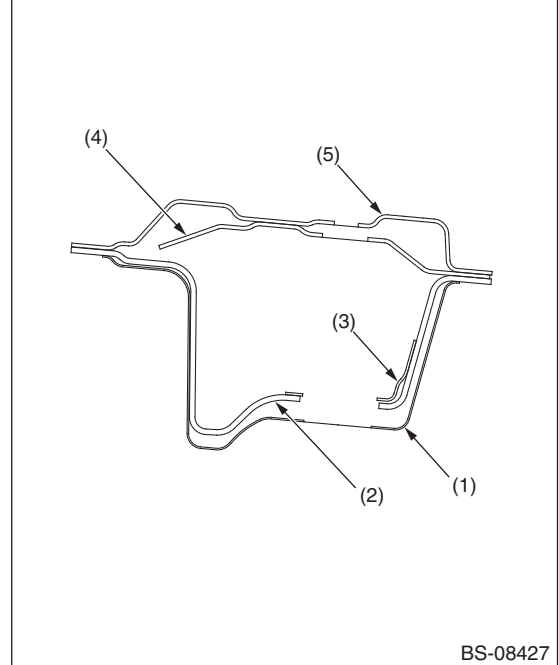
Body Construction

Cross section K—K



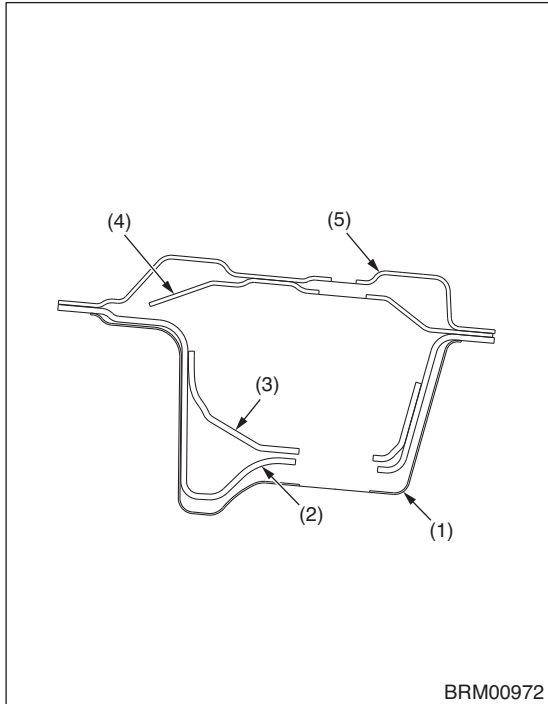
- (1) Panel side outer
- (2) Pillar center inner
- (3) Reinforcement pillar center outer

Cross section L — L (Gasoline model)



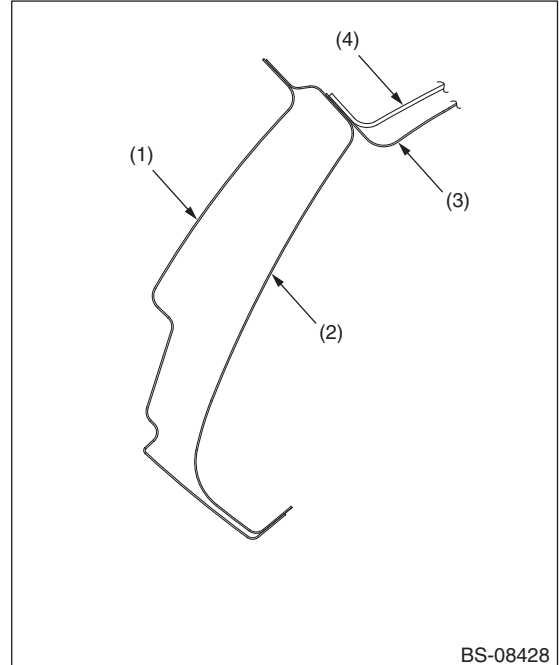
- (1) Panel side outer
- (2) Reinforcement pillar center outer
- (3) Reinforcement pillar center outer upper
- (4) Doubler pillar center
- (5) Pillar center inner

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

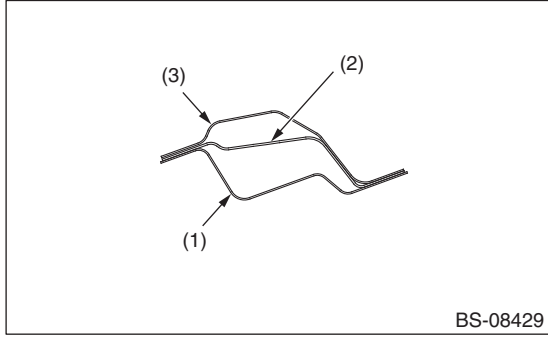
Cross section M —M



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

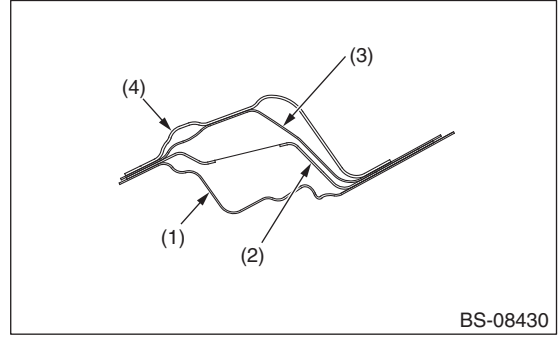
Body Construction

Cross section N — N



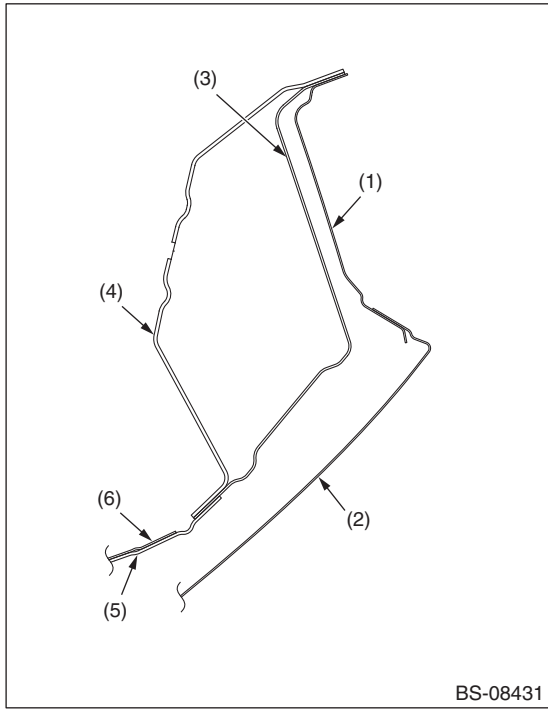
- (1) Panel side outer
- (2) Reinforcement C pillar outer
- (3) Quarter panel rear inner

Cross section O — O



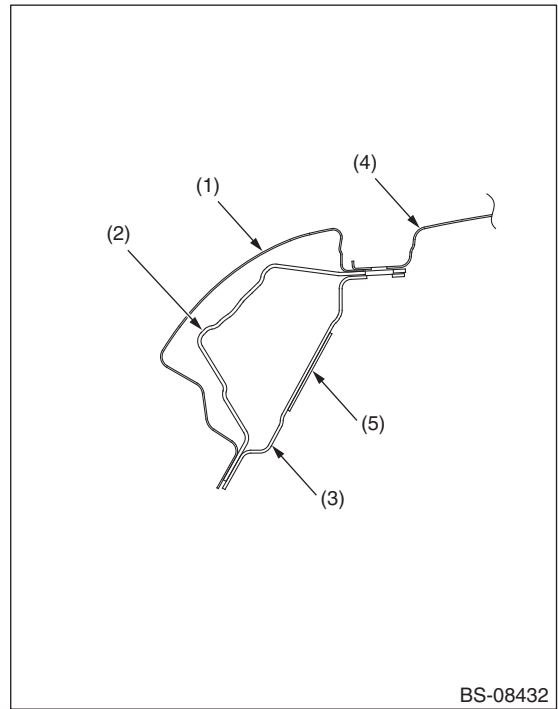
- (1) Panel side outer
- (2) Reinforcement C pillar outer
- (3) Quarter panel rear inner
- (4) Reinforcement rear apron

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

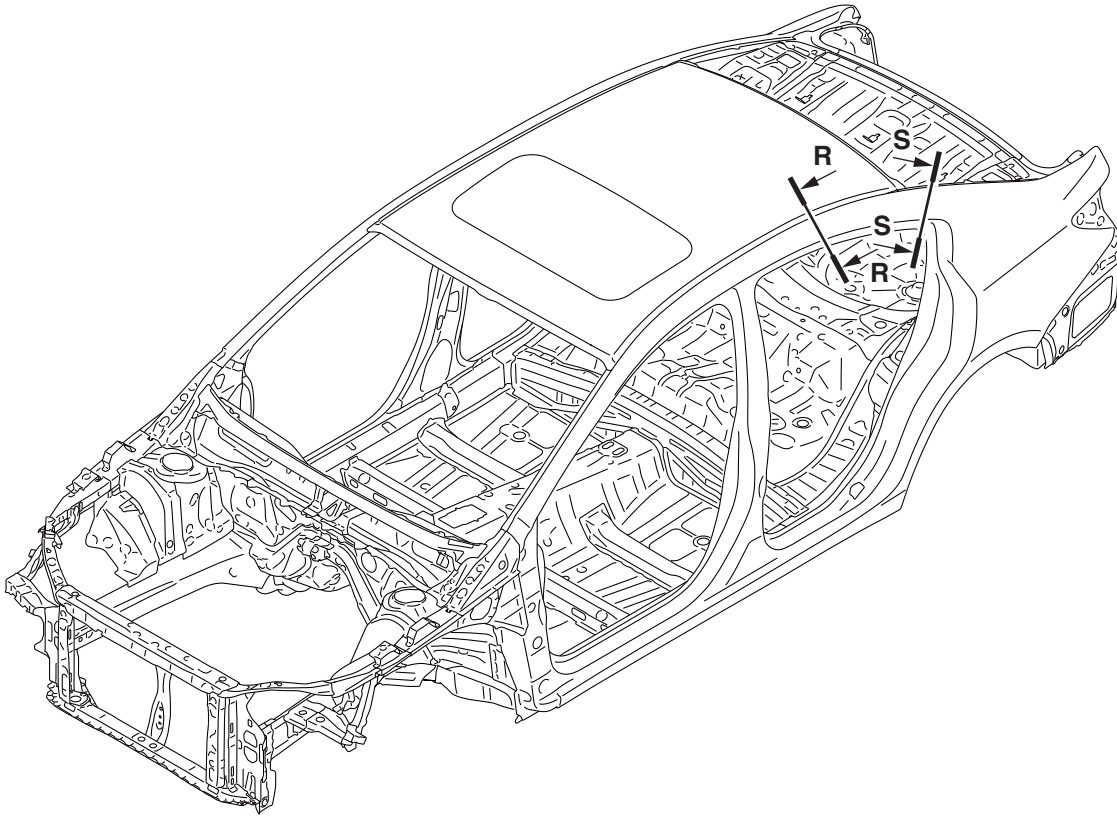
Cross section Q — Q



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

Body Construction

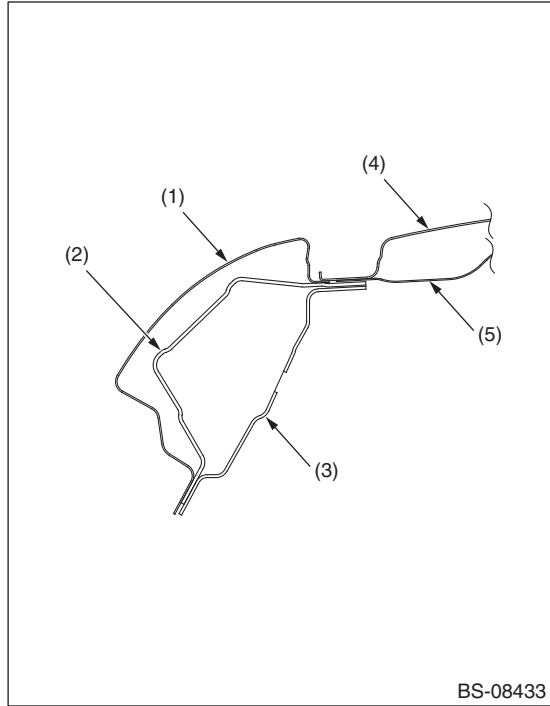
- SPECIAL 4 DOOR PARTS



BS-08415

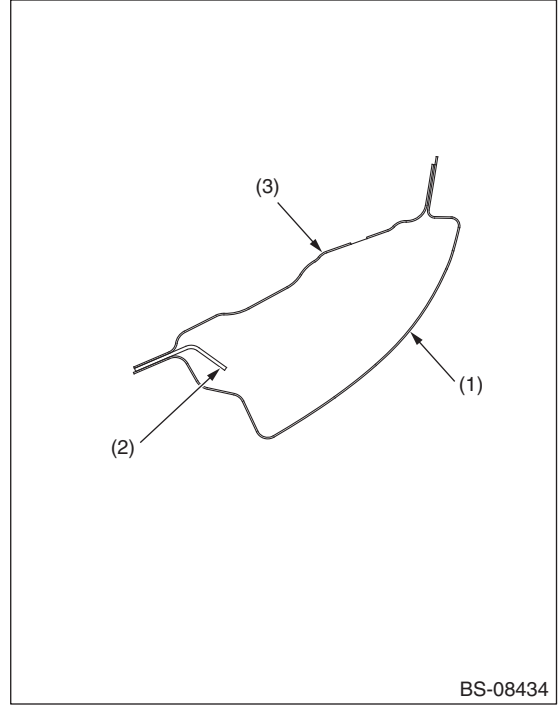
Body Construction

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



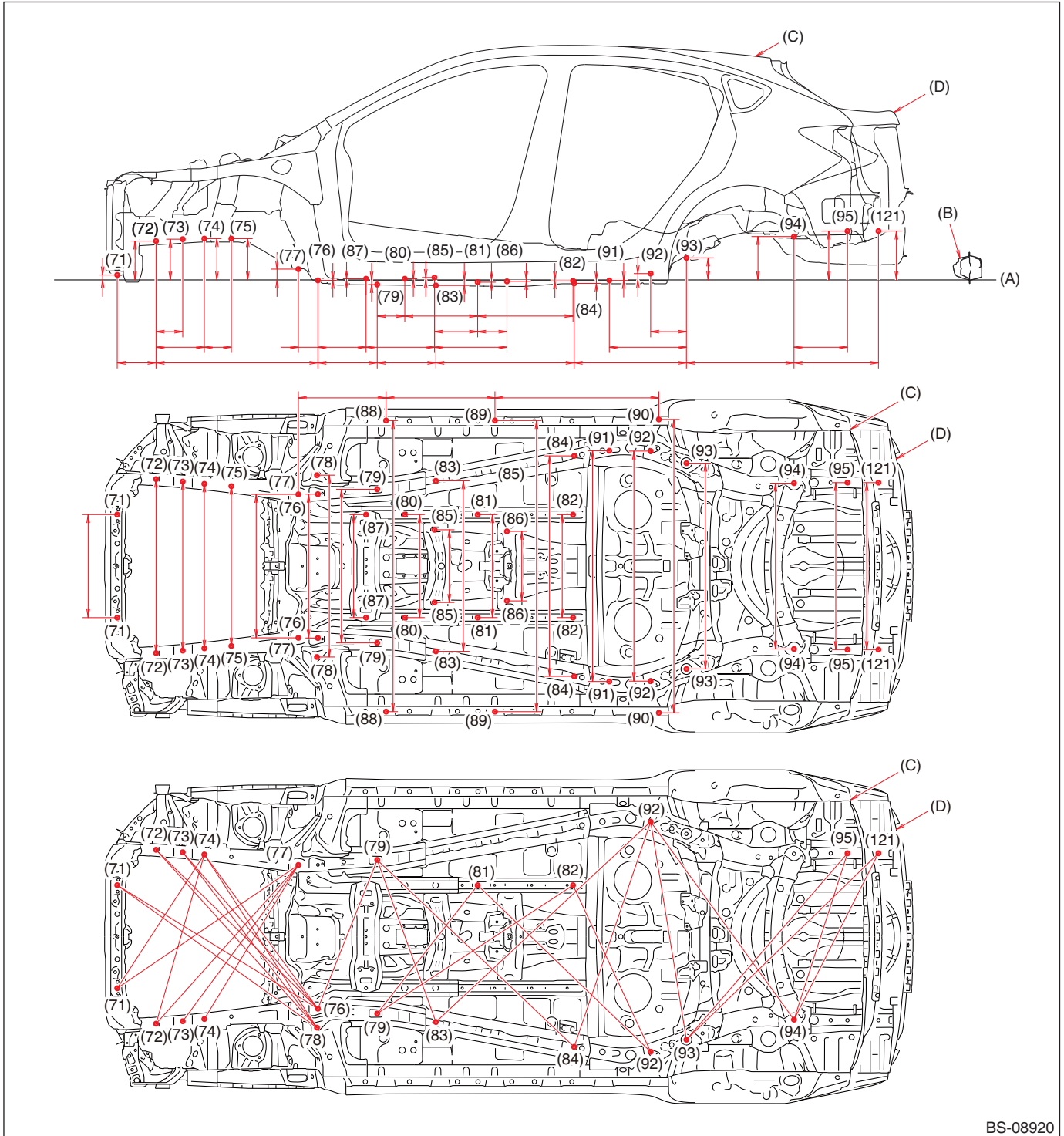
- (1) Panel side outer
- (2) Reinforcement rail side outer rear
- (3) Pillar rear inner

6. Body Reference Points

A: DIMENSIONS

1. LOWER SURFACE

• Gasoline model

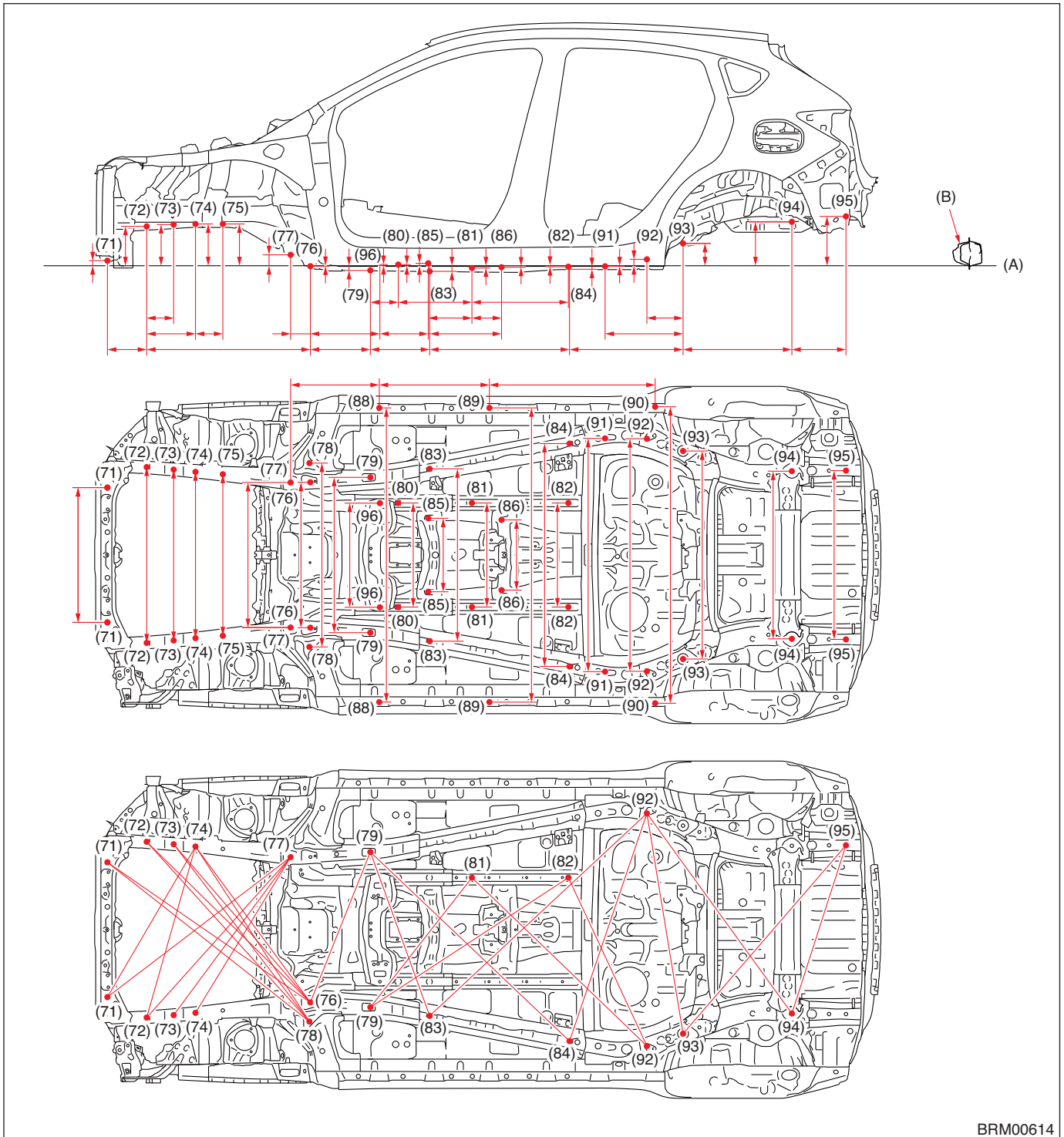


BS-08920

- 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
(B) Side sill outer panel

(C) 5 Door

(D) 4 Door

- | | | |
|---|---|---|
| (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 hole (symmetrical) | (94) Rear suspension crossmember mounting hole (symmetrical), rear |
| (77) Front suspension arm plate mounting hole (symmetrical) | (86) Exhaust cover mounting hole (symmetrical) | (95) Gauge hole (symmetrical) |
| (78) Front suspension plate mounting hole (symmetrical), outside | (87) * ¹ Crossmember upper mounting hole (symmetrical) | (96) * ² 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)	—
* ¹ 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)	—
* ² 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)	—
* ¹ (76) — (87)	257 (10.12)	—
* ² (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)	—
* ¹ (85) — (87)	365 (14.37)	—
* ² (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)	—

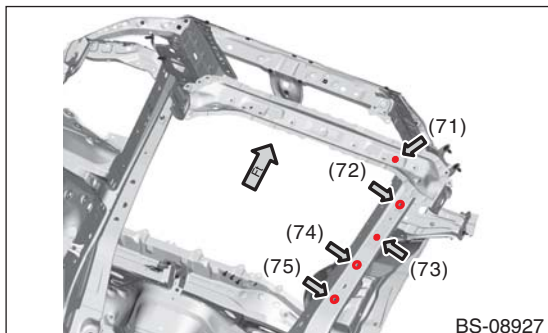
Body Reference Points

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)	—
* ¹ (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)	—
* ² (96)R — (96)L	548 (21.57)	—
(121)R — (121)L	889 (35.00)	—

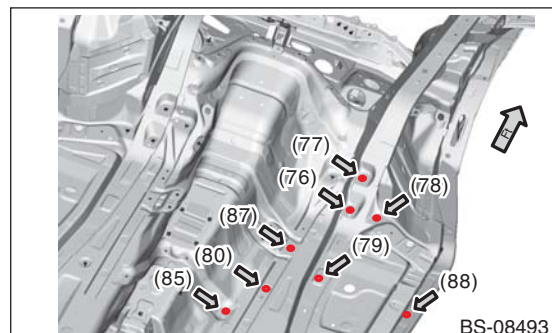
Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
(71)R — (74)L	878 (34.57)	856 (33.70)
(71)L — (76)R	1,260 (49.61)	1,260 (49.61)
(71)R — (77)L	1,172 (46.14)	1,172 (46.14)
(71)L — (78)R	1,312 (51.65)	1,312 (51.65)
(72)R — (74)L	937 (36.89)	937 (36.89)
(72)L — (76)R	1,226 (48.27)	1,208 (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)

*¹: Gasoline model

*²: Hybrid model

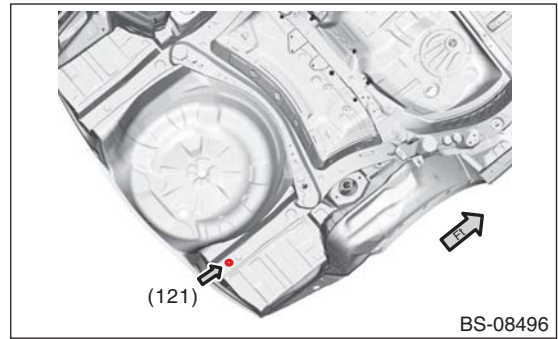
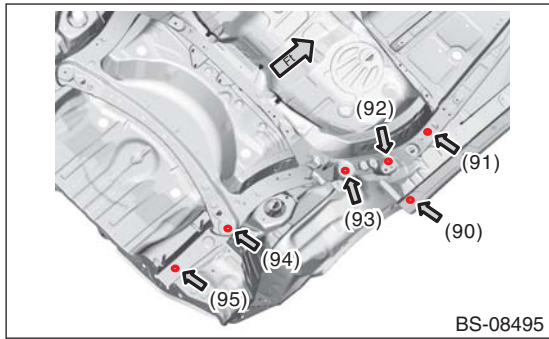
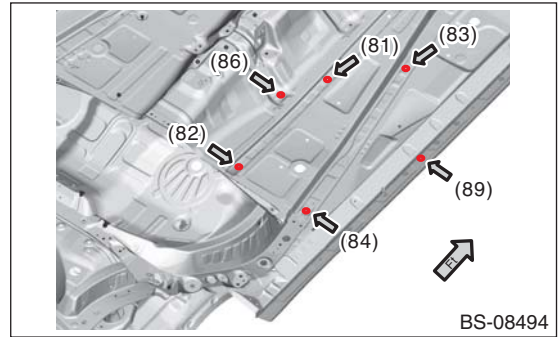
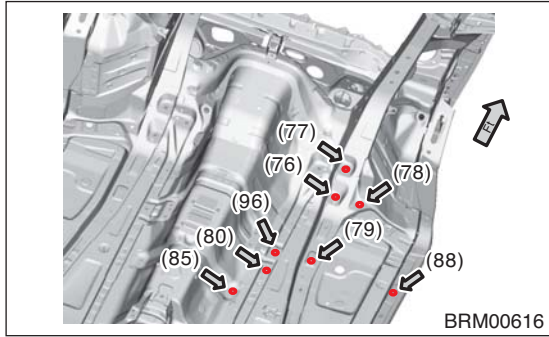


Gasoline model



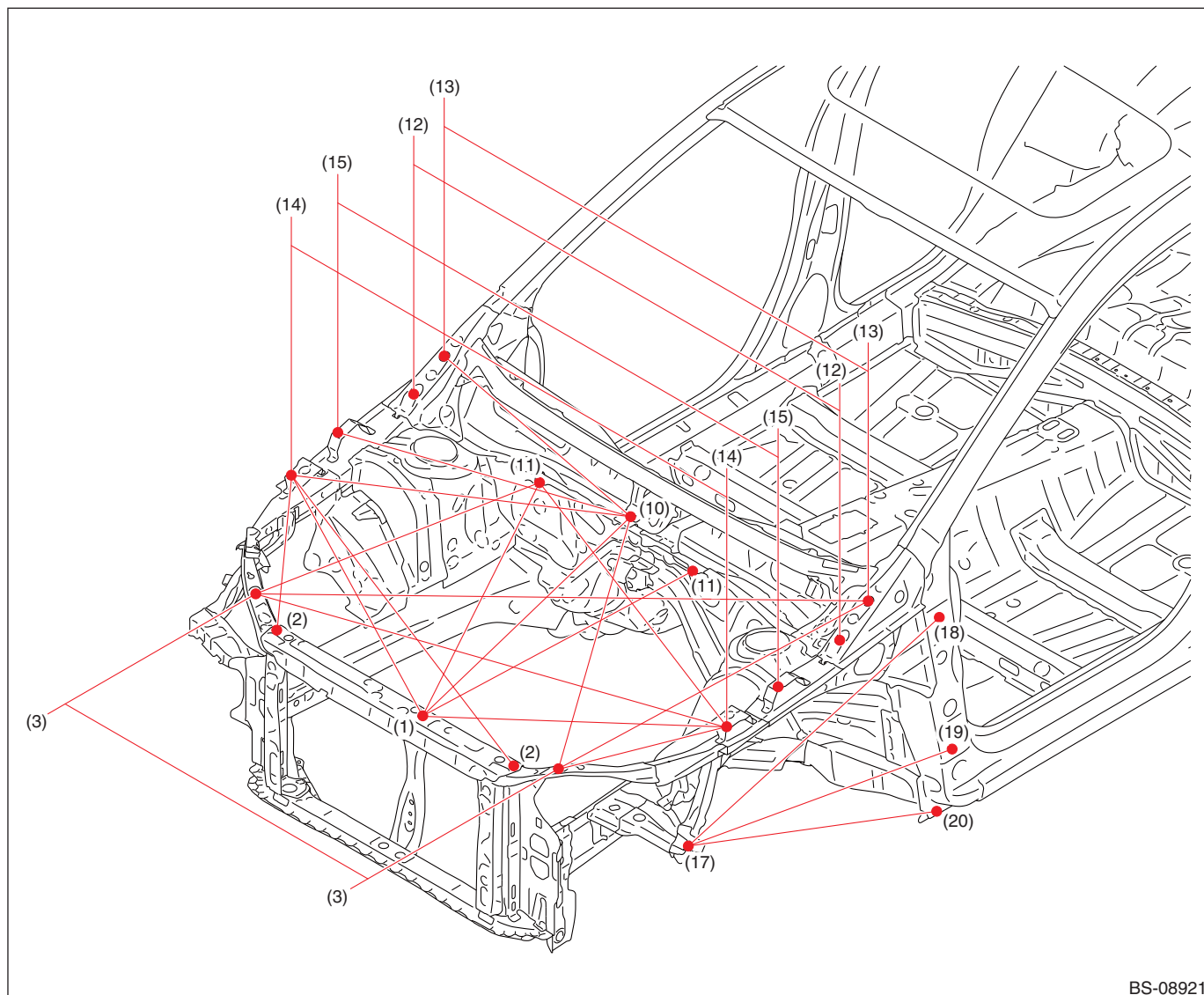
Body Reference Points

Hybrid model



Body Reference Points

2. FRONT 1



BS-08921

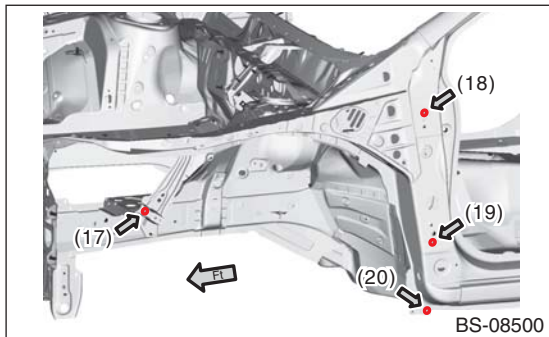
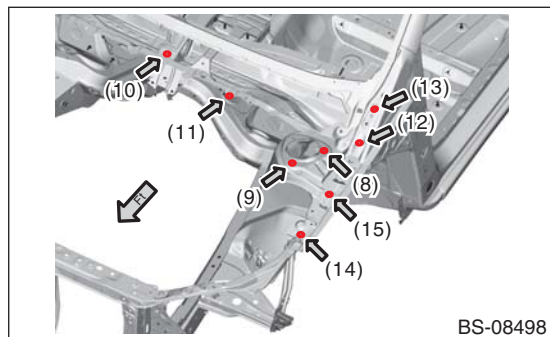
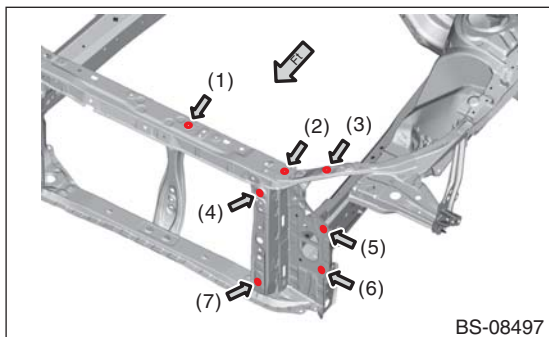
- | | | |
|--|--|---|
| (1) Cover upper mounting hole (left side) | (12) Gauge hole (symmetrical) | (18) Front door hinge upper mounting hole (symmetrical), upper side |
| (2) Radiator upper frame mounting hole (symmetrical) | (13) Hood hinge rear mounting hole (symmetrical) | (19) Front door hinge lower 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)

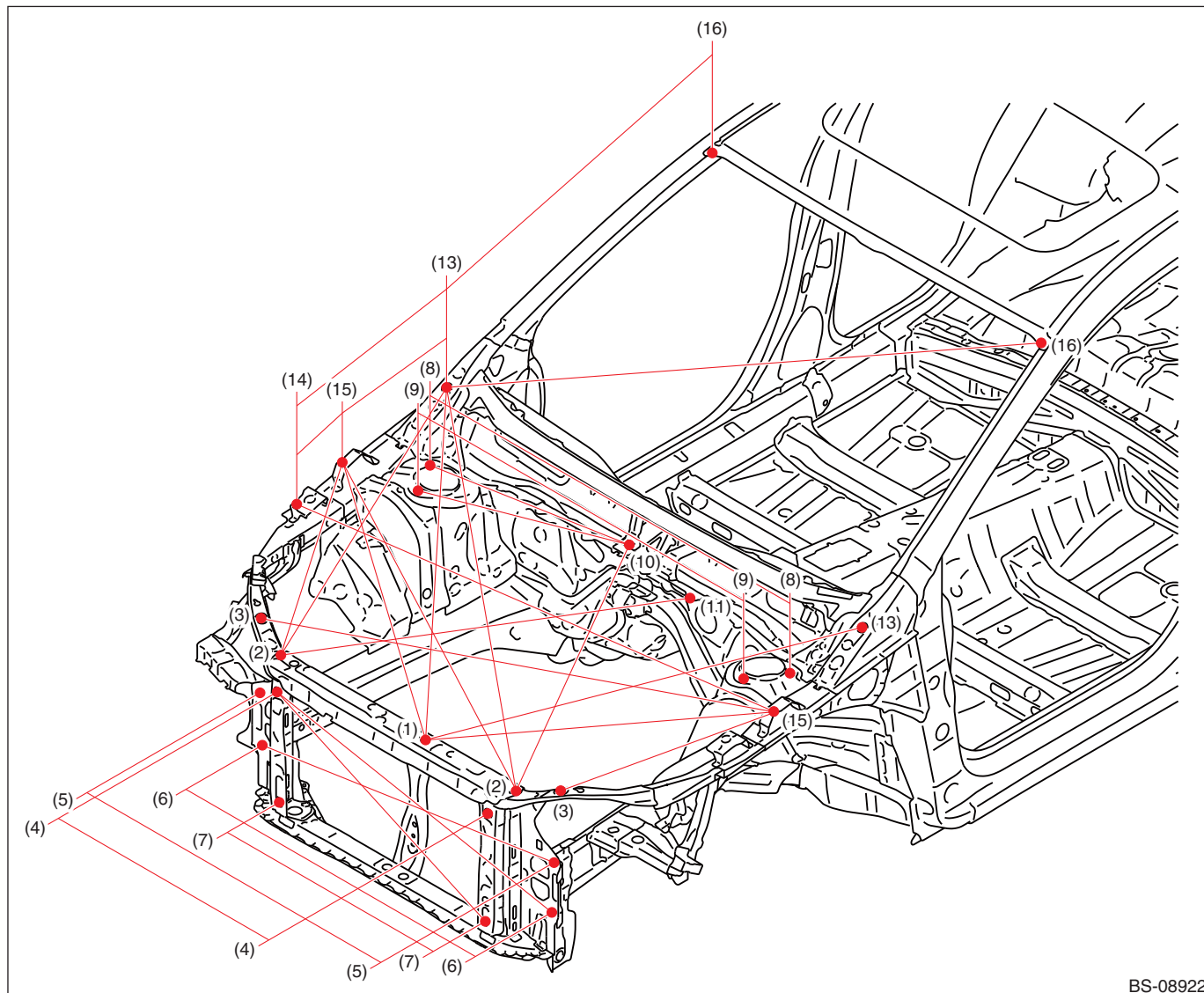
- Reference point (1) indicates a left side part. Reference point (10) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



SUBARU.

Body Reference Points

3. FRONT 2



BS-08922

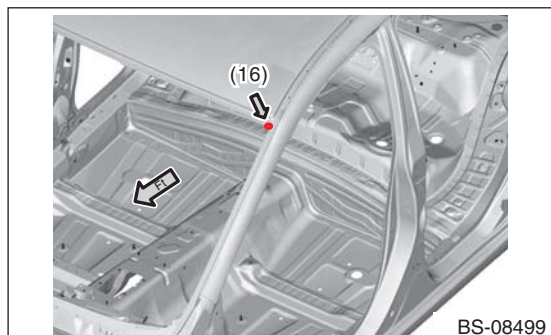
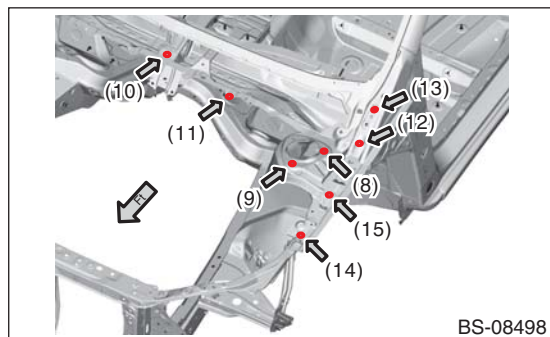
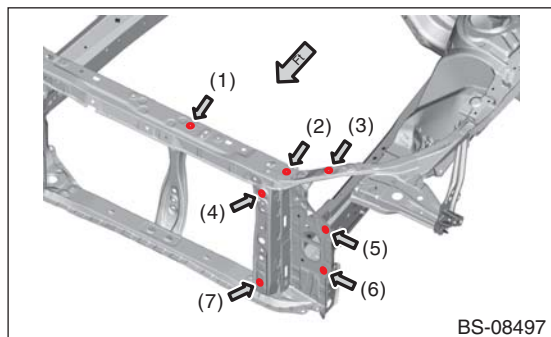
- | | | |
|---|--|--|
| (1) Cover upper mounting hole (left side) | (6) Bumper beam mounting hole (symmetrical), lower side | (11) Cowl panel mounting hole (symmetrical) |
| (2) Radiator upper frame mounting hole (symmetrical) | (7) Gauge hole (symmetrical) | (13) Hood hinge rear mounting hole (symmetrical) |
| (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.

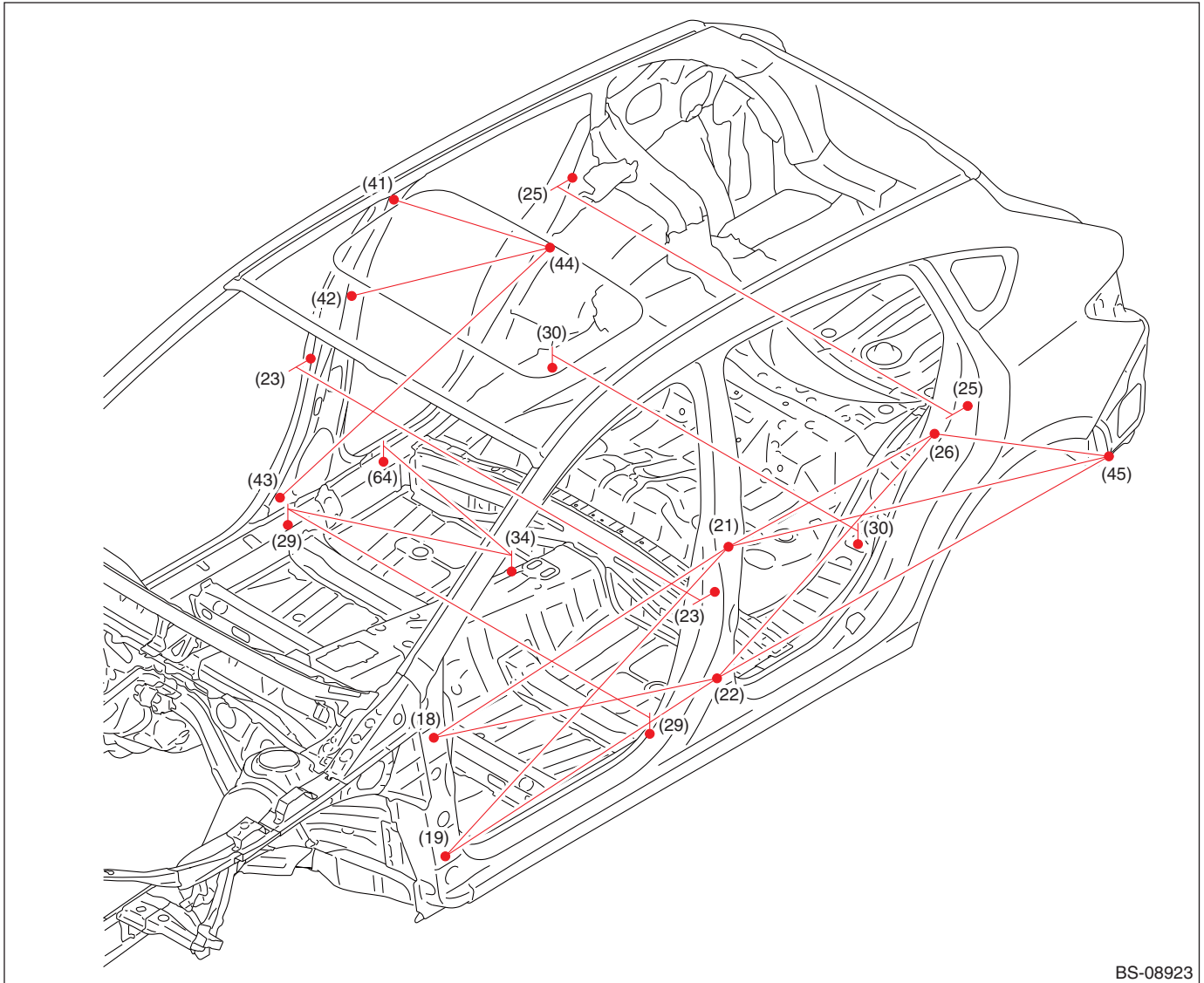


SUBARU.

Body Reference Points

4. INSIDE 1

• Common for 5 Door and 4 Door



BS-08923

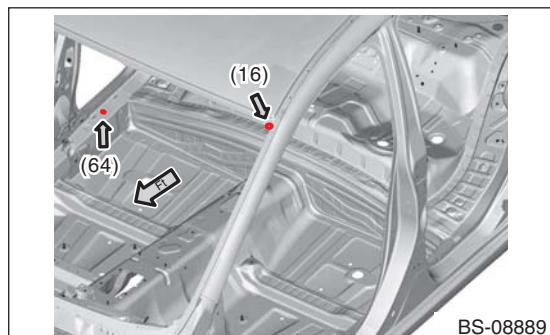
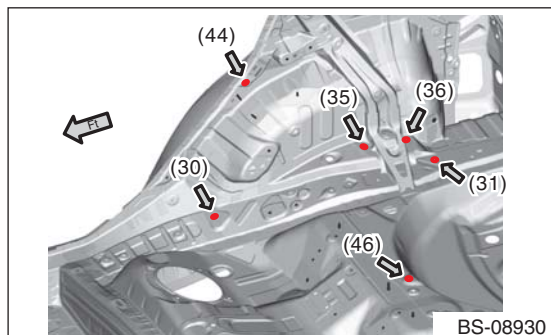
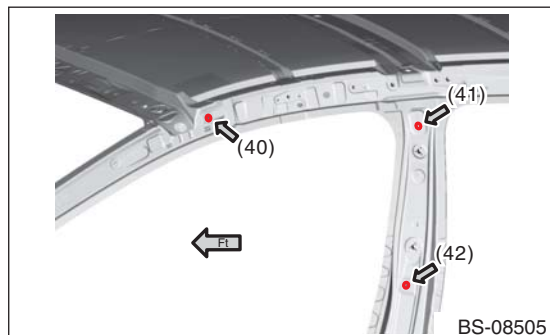
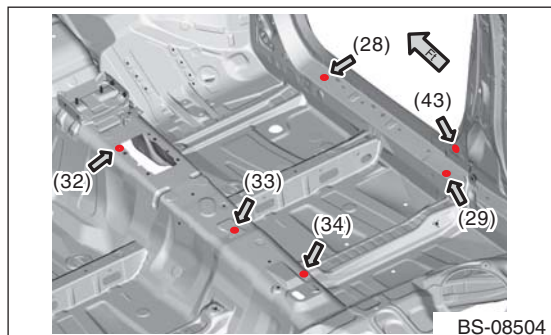
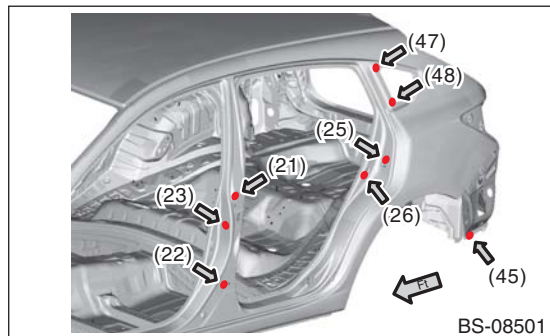
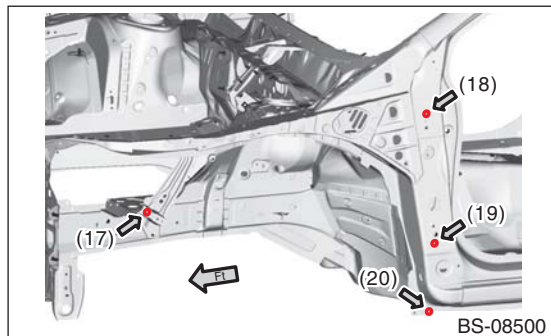
- | | | |
|---|---|---|
| (18) Front door hinge upper mounting hole (symmetrical), upper side | (26) Rear door switch mounting hole (symmetrical) | (43) Trim mounting hole (symmetrical) |
| (19) Front door hinge lower mounting hole (symmetrical), lower side | (29) Harness clip mounting hole (symmetrical) | (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)

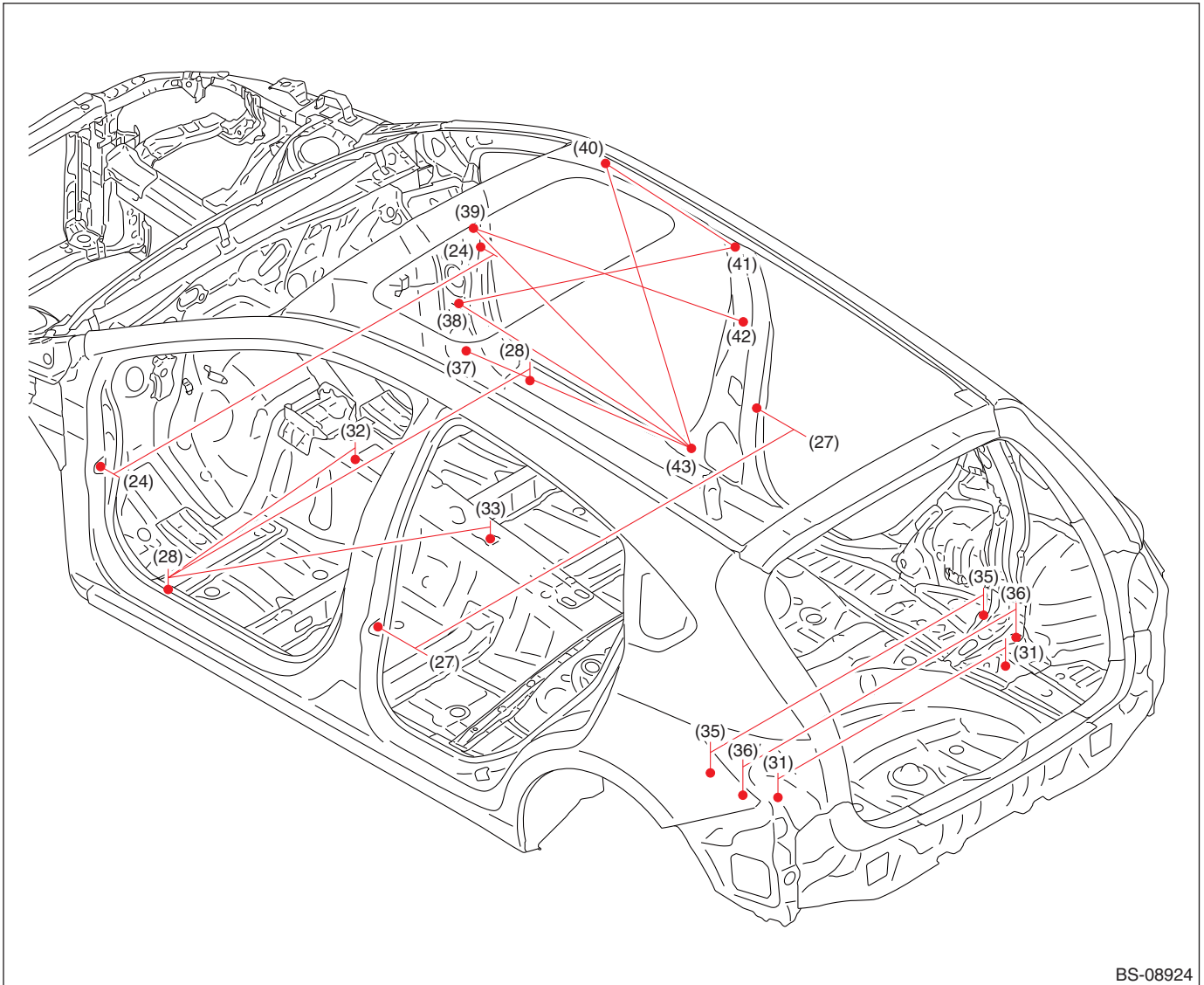
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

5. INSIDE 2

• Common for 5 Door and 4 Door



BS-08924

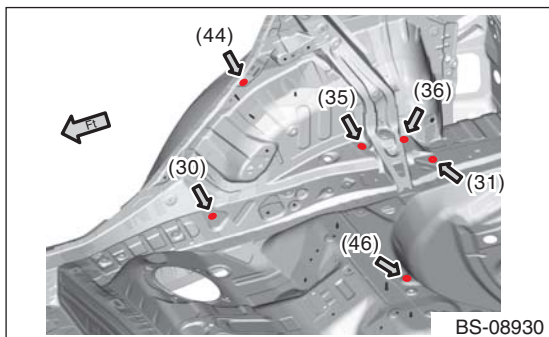
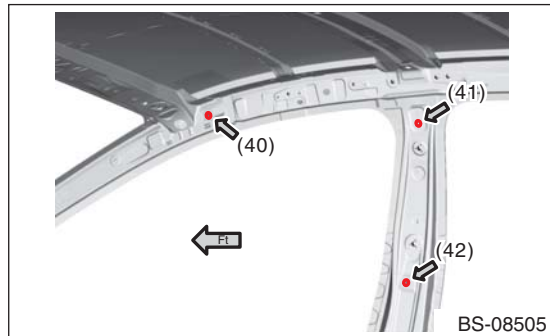
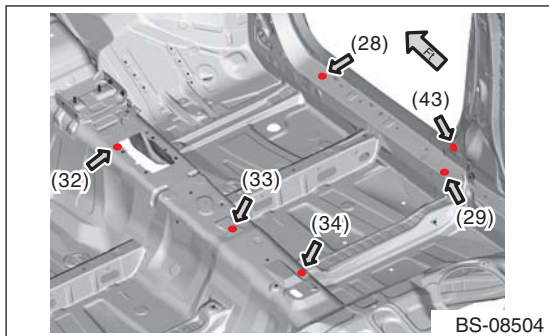
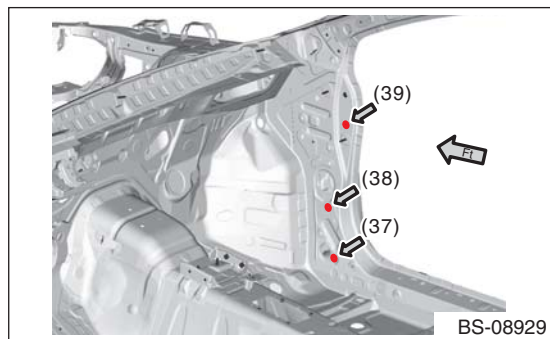
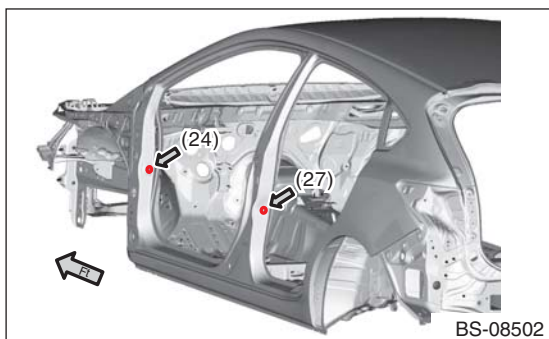
(24) Front door checker mounting hole (symmetrical)	(33) Hand brake mounting hole (body center)	(39) Steering beam mounting hole (symmetrical), lower side
(27) Rear door checker mounting hole (symmetrical)	(35) Rear suspension mounting hole (symmetrical), front	(40) Pad A pillar mounting hole (symmetrical)
(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.

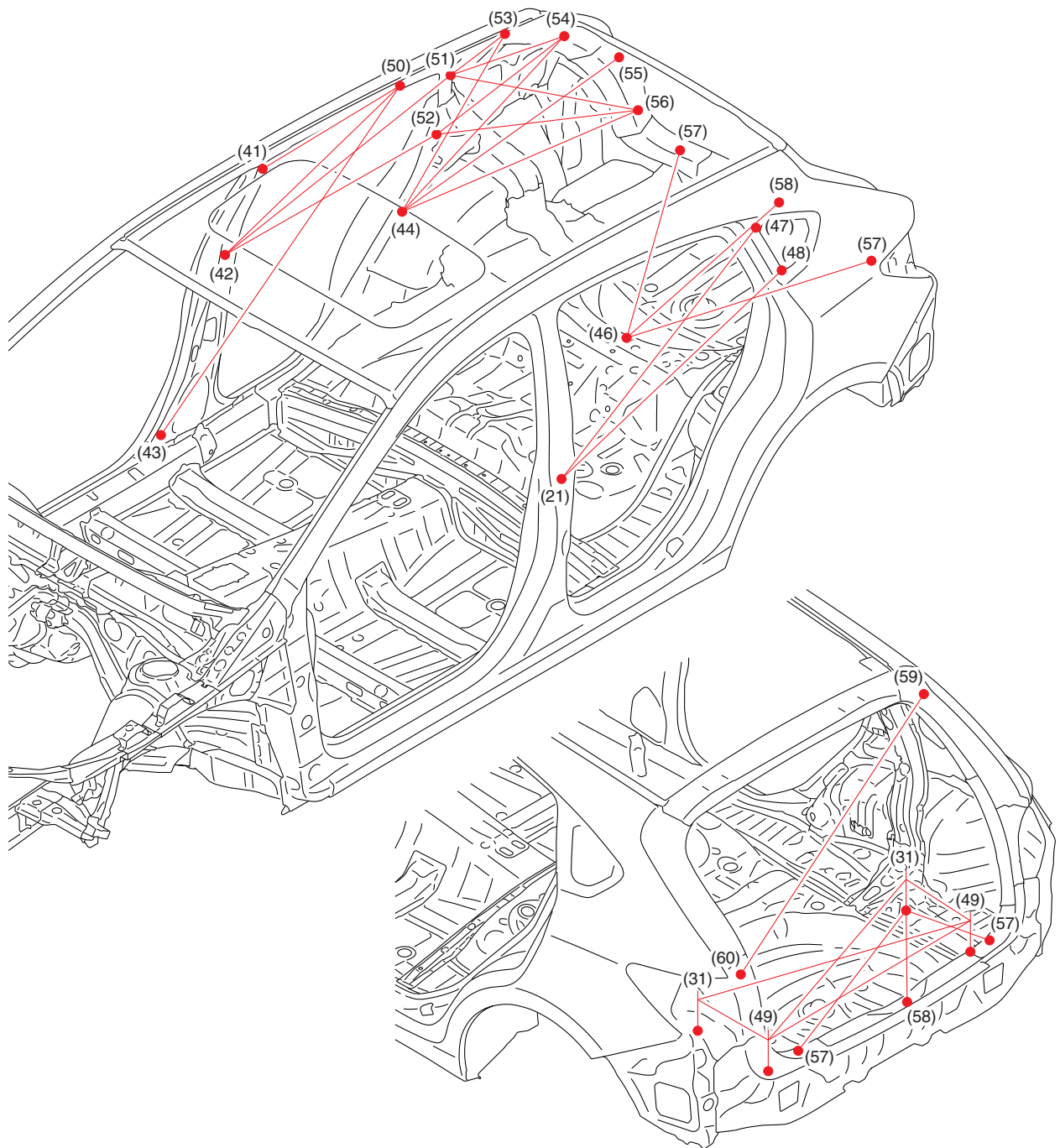


SUBARU.

Body Reference Points

6. INSIDE & REAR 1

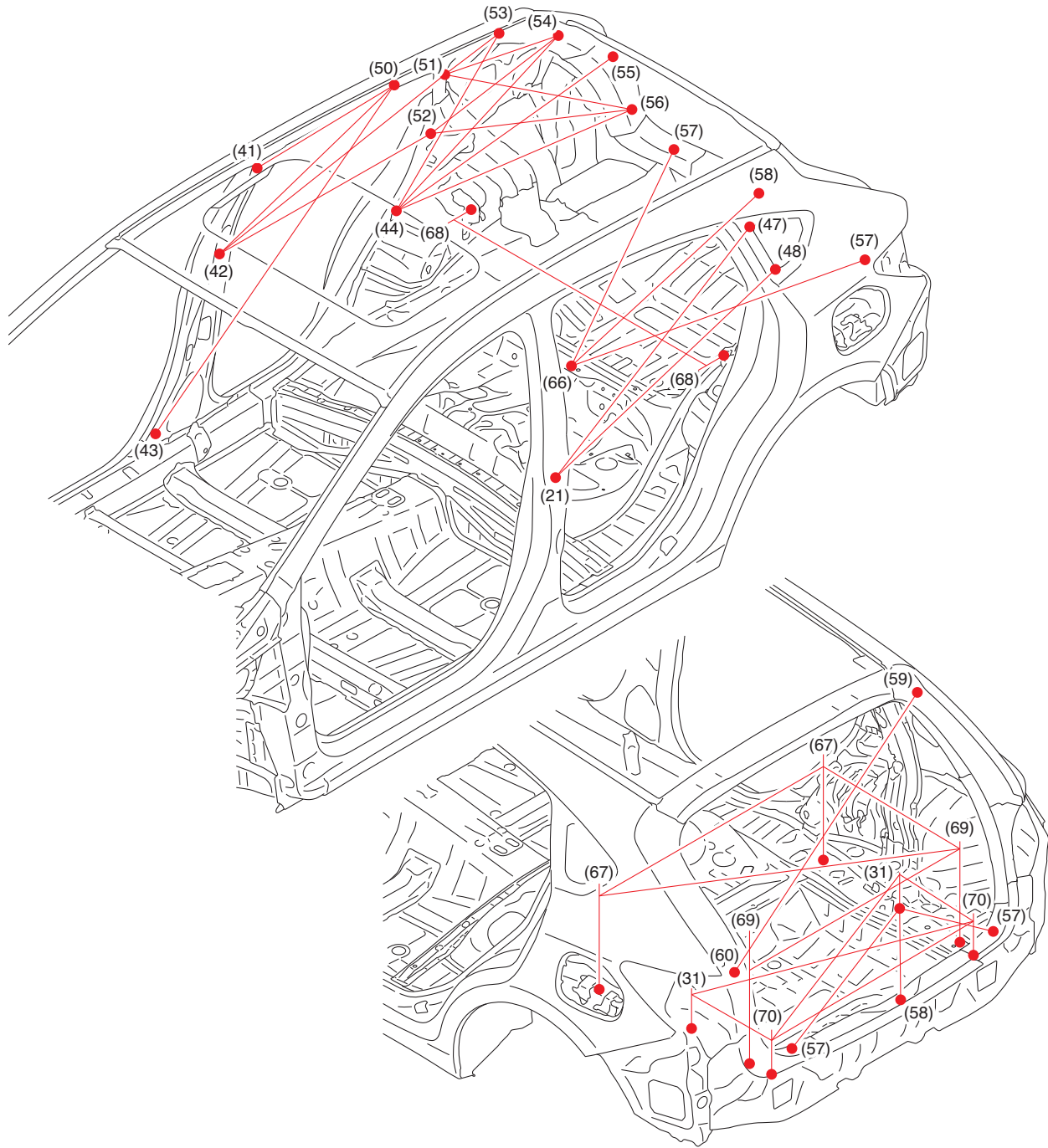
• SPECIAL PARTS FOR 5 DOOR (Gasoline model)



BS-08487

Body Reference Points

• SPECIAL PARTS FOR 5 DOOR (Hybrid model)



BRM00615

Body Reference Points

(21) Rear door hinge upper mounting hole (symmetrical), upper side	(49)L ^{*1} Gauge 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) ^{*2} R seat center hinge mounting hole (left side)
(42) Trim mounting hole (symmetrical)	(52) Apron trim mounting hole (symmetrical)	(67) ^{*2} Frame battery front mounting hole (symmetrical)
(43) Trim mounting hole (symmetrical)	(53) Gauge hole (symmetrical)	(68) ^{*2} Bracket bar rear front mounting hole (symmetrical)
(44) Apron trim mounting hole (symmetrical)	(54) Trim clip mounting hole (symmetrical)	(69) ^{*2} Bracket battery mounting hole (symmetrical)
(46) ^{*1} Spacer front mounting hole	(55) Trim clip mounting hole (symmetrical)	(70)R ^{*2} Gauge hole (right side)
(47) Rear quarter glass mounting hole (symmetrical), front upper side	(56) Gauge hole (symmetrical)	(70)L ^{*2} Gauge hole (left side)
(48) Rear quarter glass mounting hole (symmetrical), front lower side	(57) Trim mounting hole (symmetrical)	
(49)R ^{*1} Gauge 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)

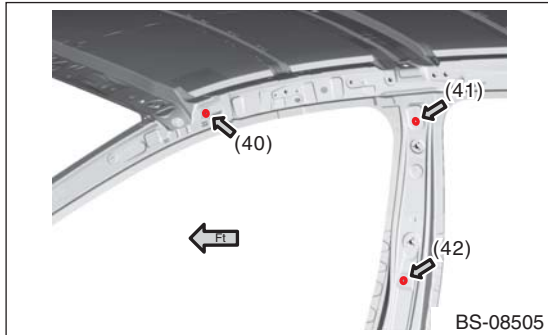
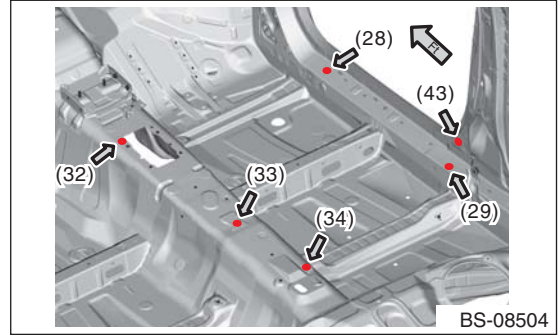
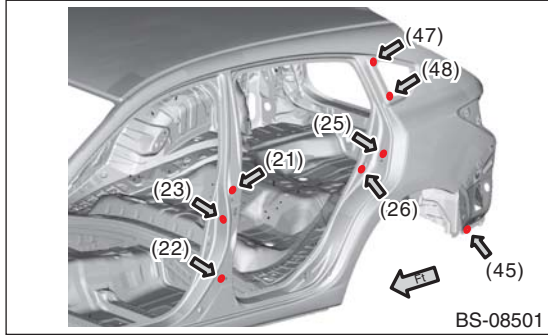
Measuring point	Datum dimension mm (in)
^{*1} (49)R — (49)L	889 (35.00)
(51)R — (53)R	218 (8.58)
(51)R — (54)R	410 (16.14)
(51)R — (56)R	862 (33.94)
(52)R — (54)R	496 (19.53)
(52)R — (56)R	760 (29.92)
(59)R — (60)L	1,244 (48.98)
^{*2} (31)R — (70)R	330 (12.99)
^{*2} (31)R — (70)L	960 (37.80)
^{*2} (31)L — (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

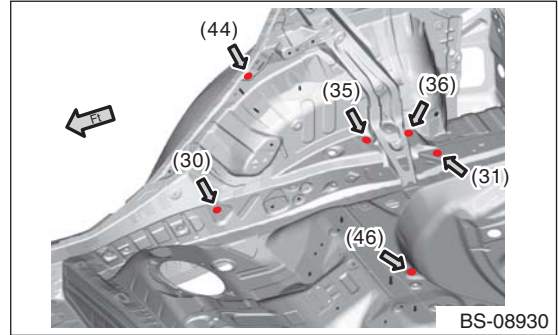
^{*2}: Hybrid model

- 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.

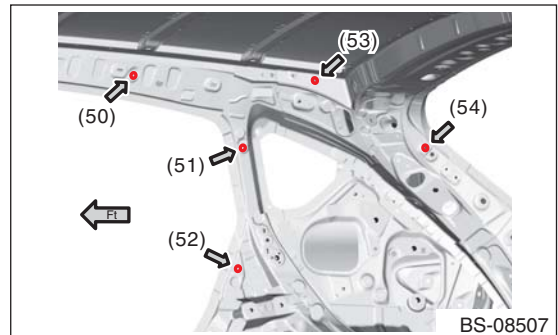
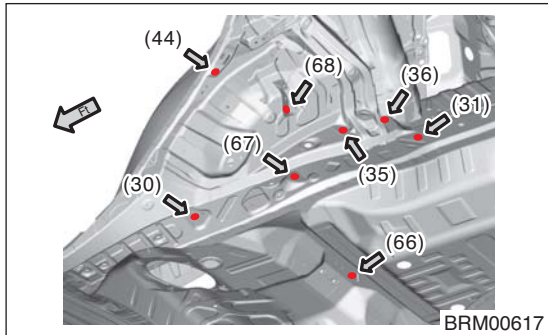
Body Reference Points



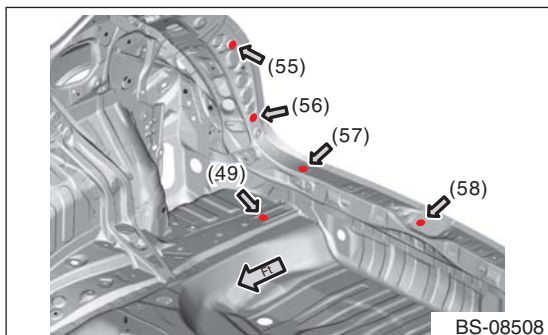
Gasoline model



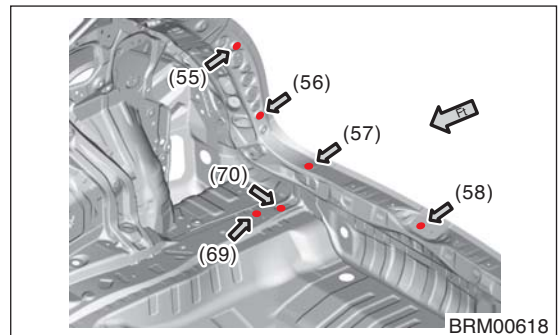
Hybrid model



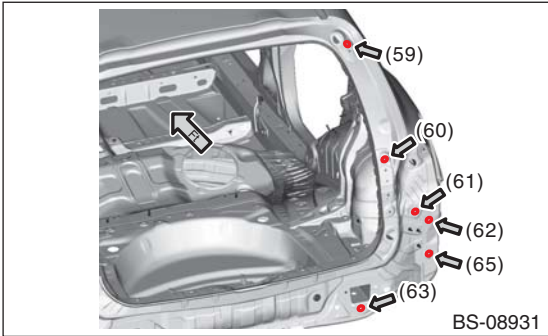
Gasoline model



Hybrid model



Body Reference Points

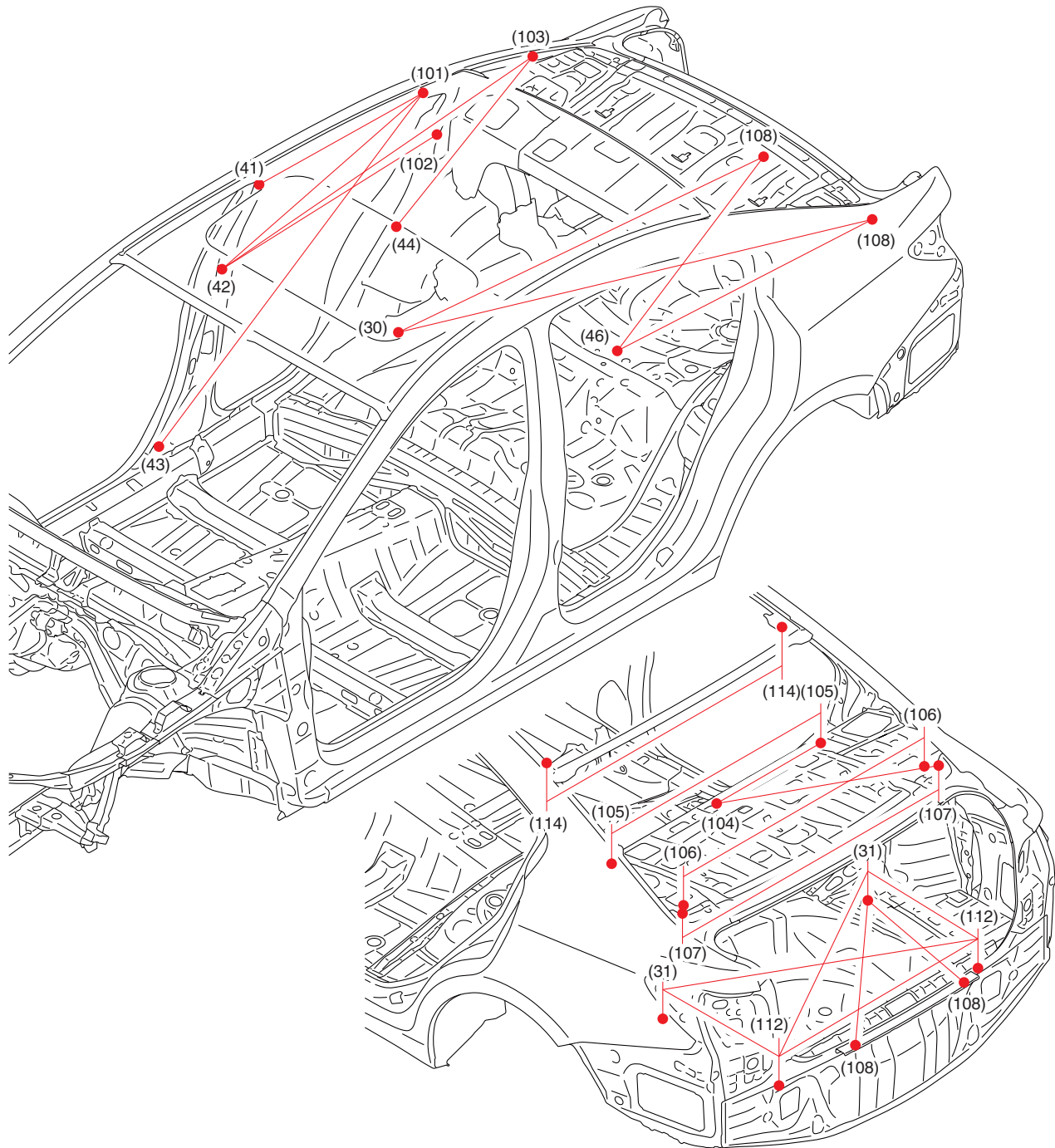


SUBARU.

Body Reference Points

7. INSIDE & REAR 2

• SPECIAL PARTS FOR 4 DOOR



BS-08488

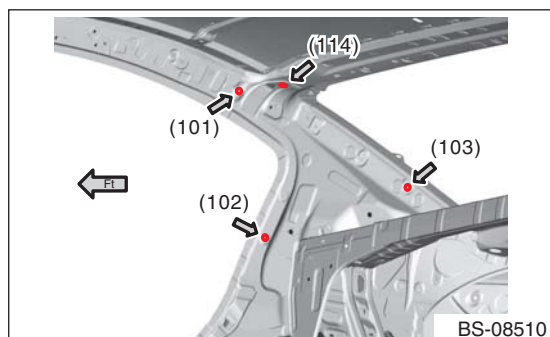
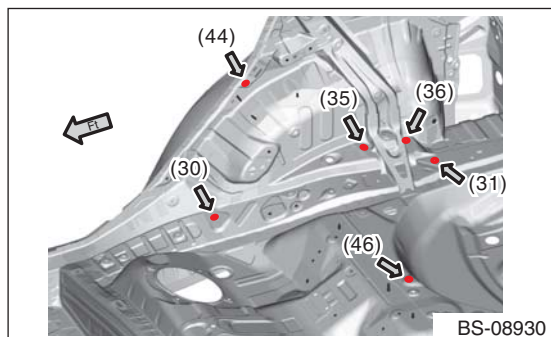
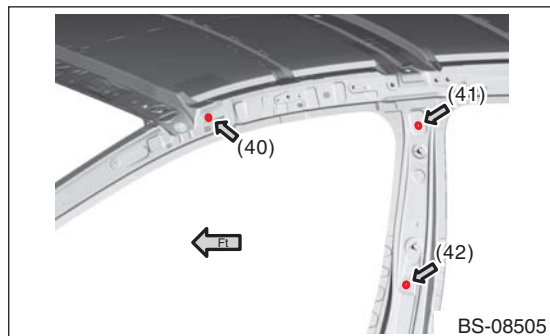
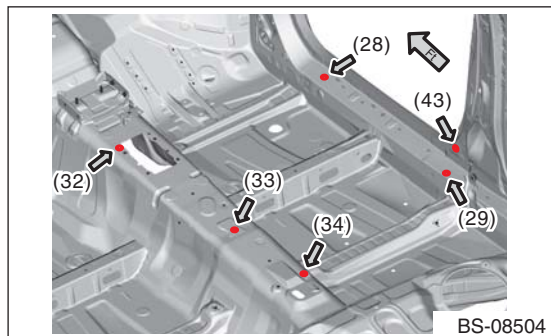
Body Reference Points

(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)

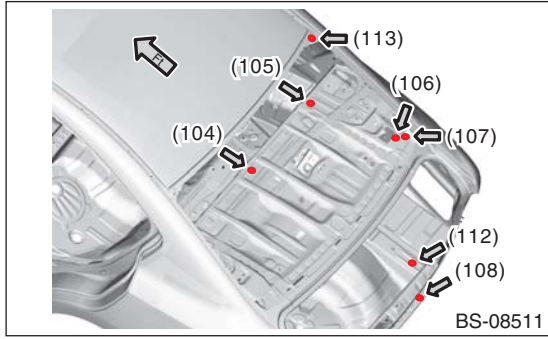
Measuring point	Datum dimension mm (in)
(30)R — (108)R	1,327 (52.24)
(30)R — (108)L	1,527 (60.12)
(31)R — (108)R	682 (26.85)
(31)R — (108)L	949 (37.36)
(31)R — (112)R	495 (19.49)
(31)L — (112)R	1,025 (40.35)
(31)R — (112)L	1,030 (40.55)
(31)L — (112)L	505 (19.88)
(41)R — (101)R	698 (27.48)
(42)R — (101)R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

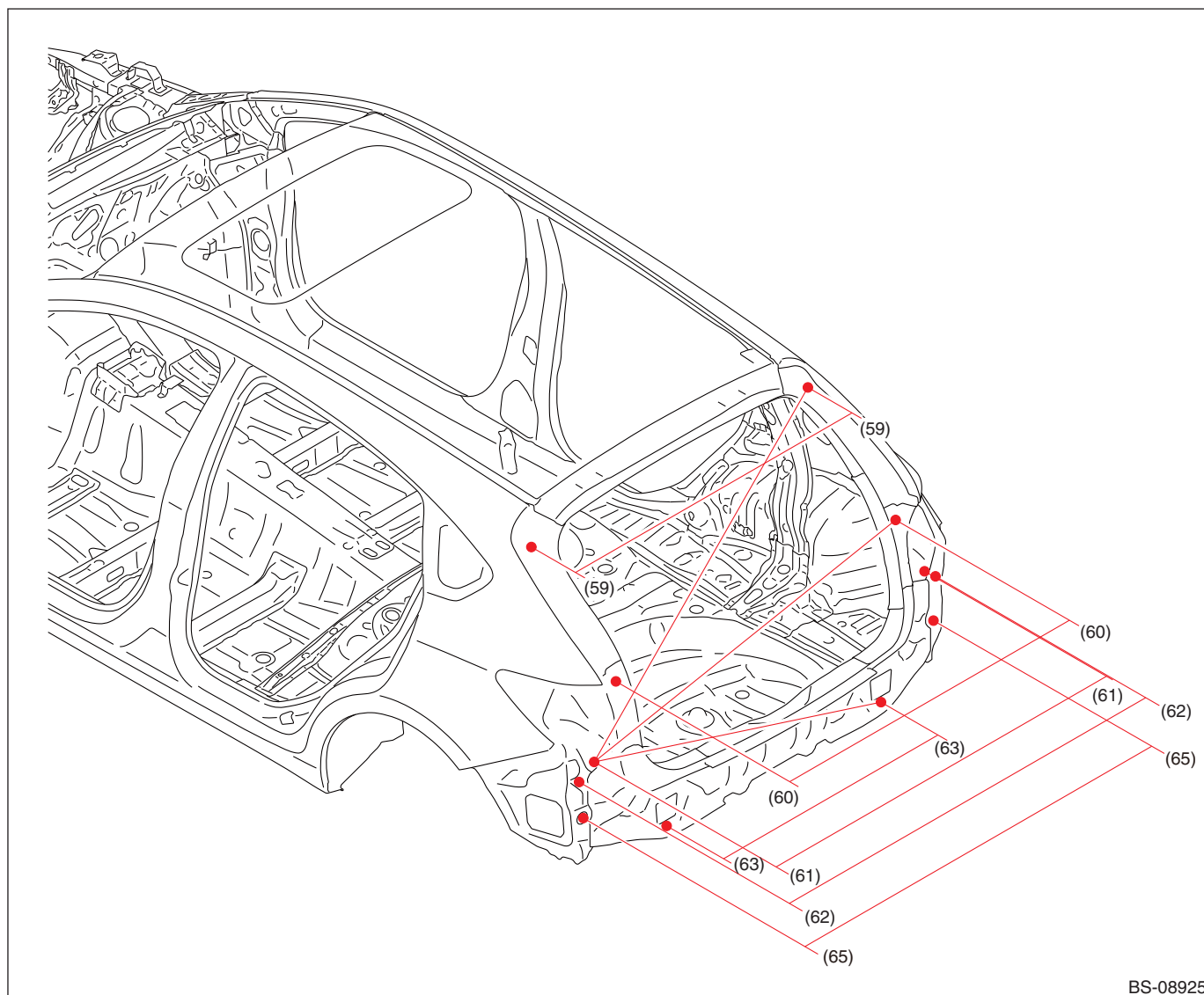


SUBARU.

Body Reference Points

8. REAR 1

• SPECIAL PARTS FOR 5 DOOR



BS-08925

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

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

(61) Rear bumper bracket mounting hole (symmetrical)

(62) Gauge hole (symmetrical)

(63) Bumper beam mounting hole (symmetrical)

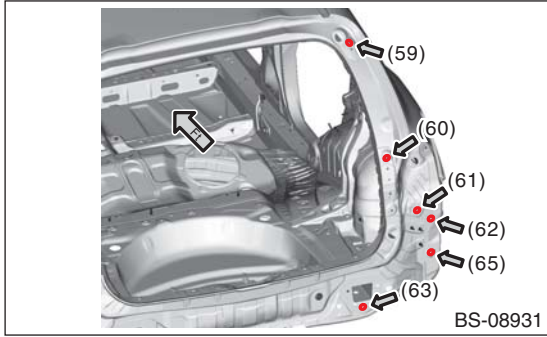
(65) Harness grommet mounting hole (symmetrical)

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

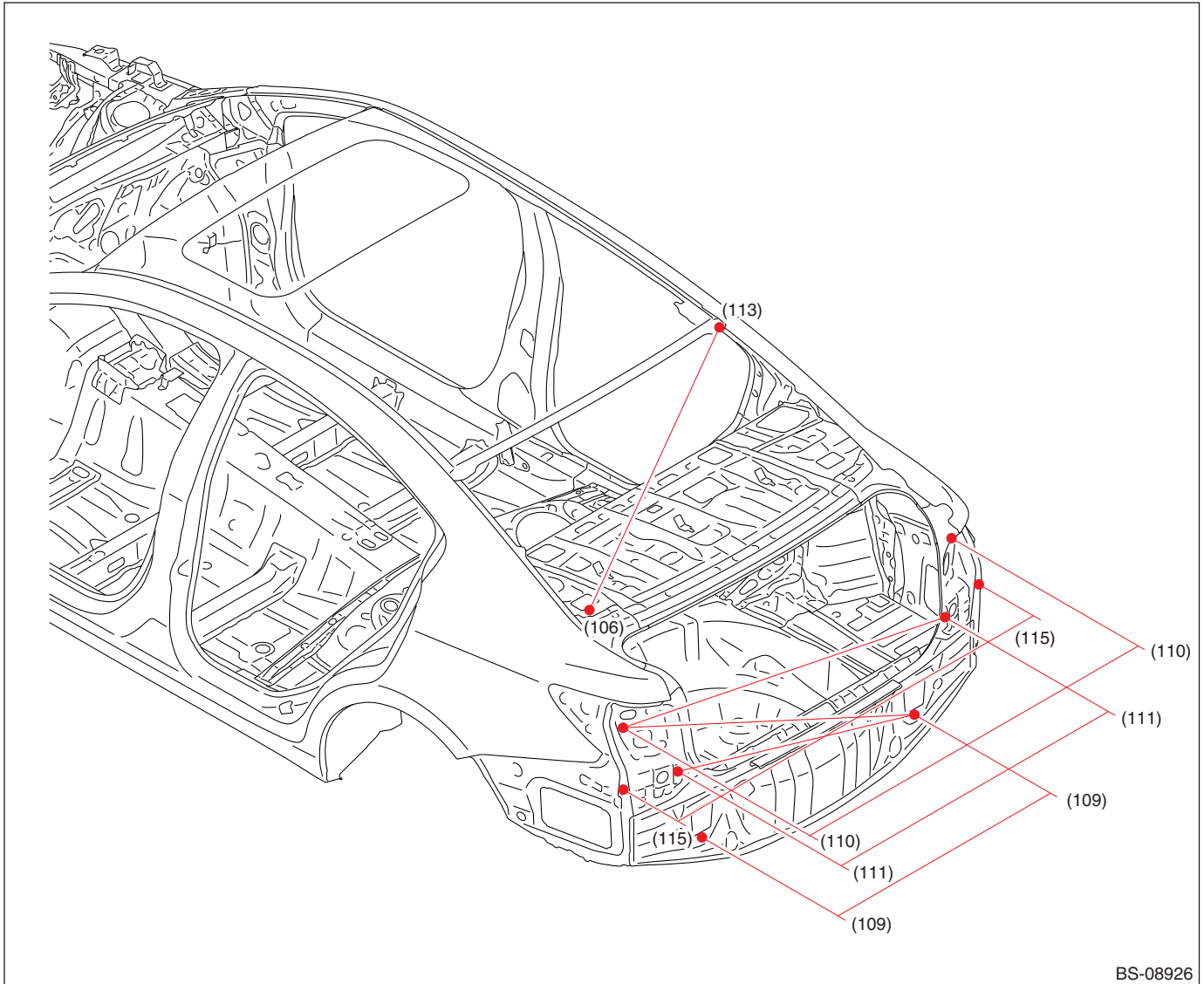


SUBARU.

Body Reference Points

9. REAR 2

• SPECIAL PARTS FOR 4 DOOR



(106) Trunk hinge mounting hole
(symmetrical)

(109) Bumper beam mounting hole
(symmetrical)

(110) Rear combination light mounting
hole (symmetrical), outside

(111) Bracket corner rear mounting hole
(symmetrical)

(113) Rear glass installation reference
hole (symmetrical)

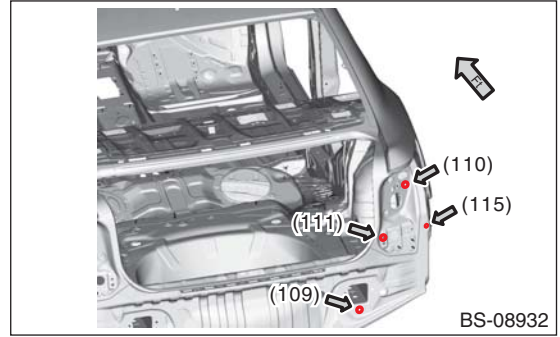
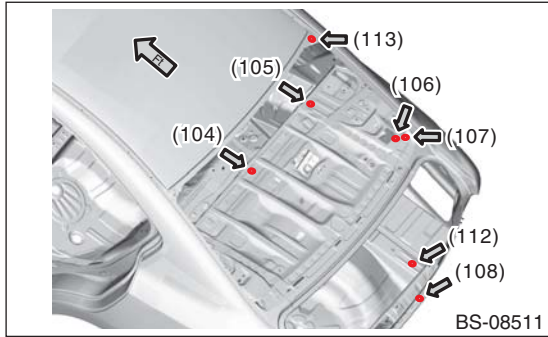
(115) Gauge hole (symmetrical)

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)

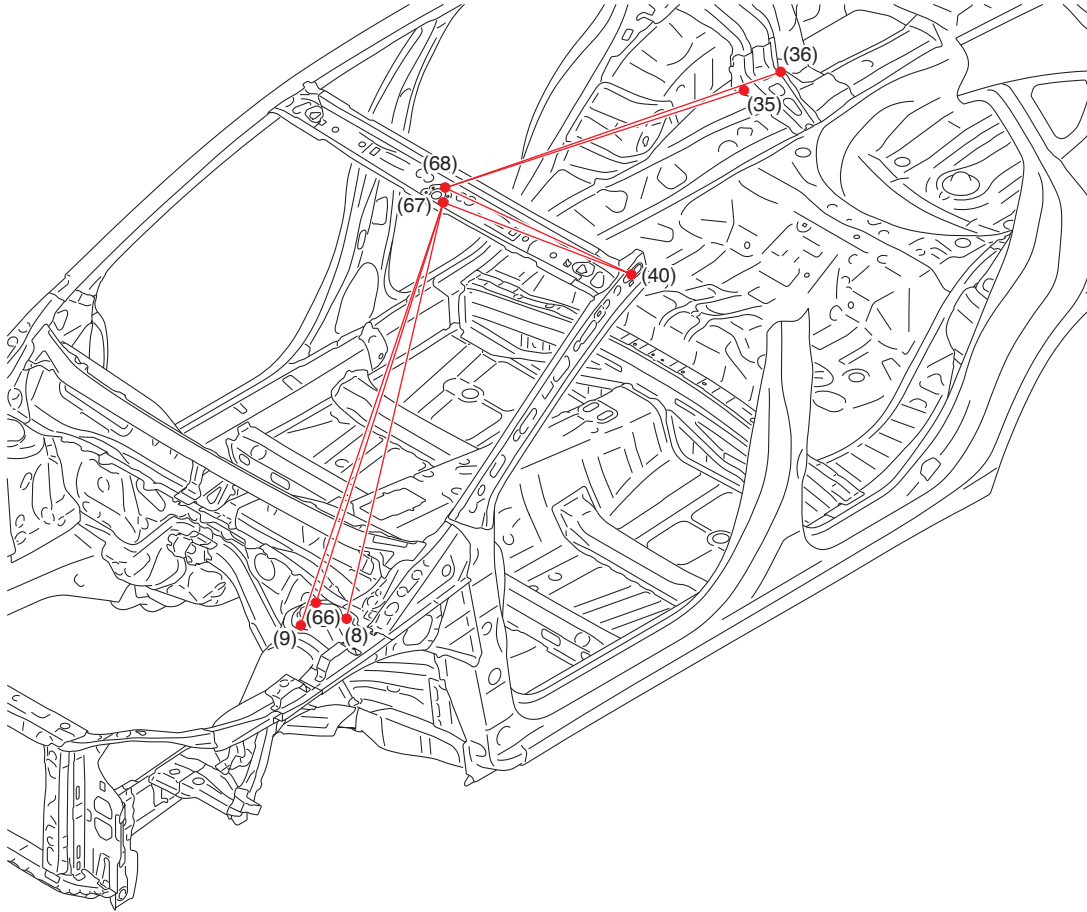
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

Body Reference Points



Body Reference Points

10.FRONT ROOF RAIL (CAMERA PLATE)



BRM01395

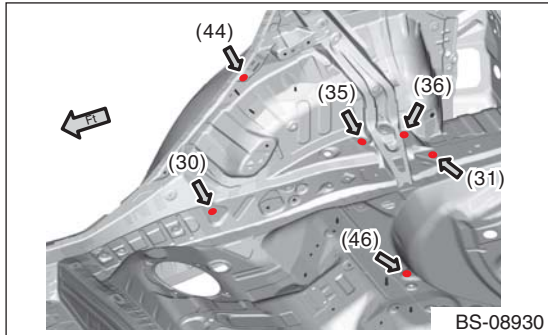
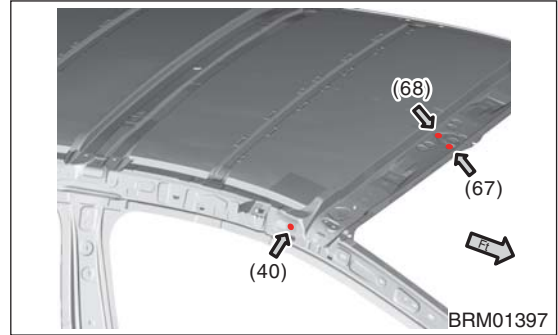
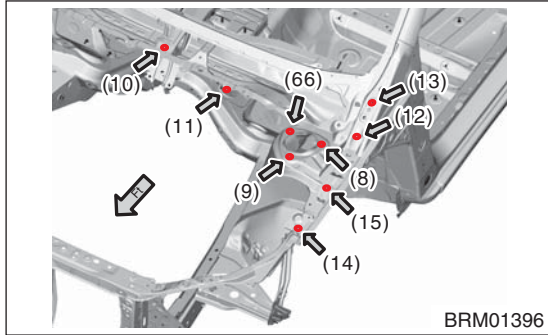
- | | | |
|--|--|---|
| (8) Front suspension mounting hole (symmetrical), rear outside | (36) Rear suspension mounting hole (symmetrical), rear | (67) Stereo camera (camera plate) mounting hole (symmetrical), front side |
| (9) Front suspension mounting hole (symmetrical), front | (40) Pad A pillar mounting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



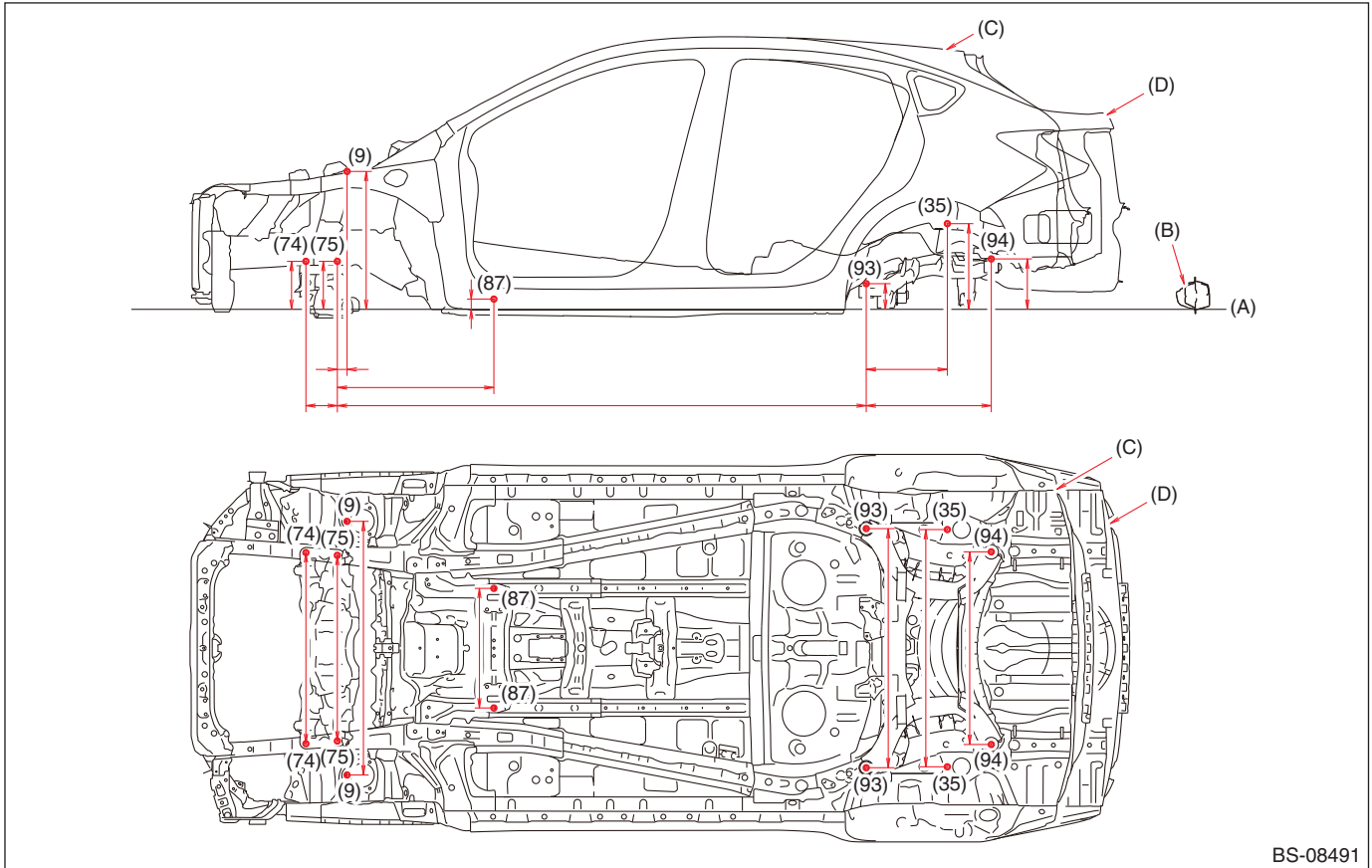
SUBARU.

7. Measurement for Combined Parts

A: DIMENSIONS

1. SUSPENSION MOUNT & ENGINE MOUNT

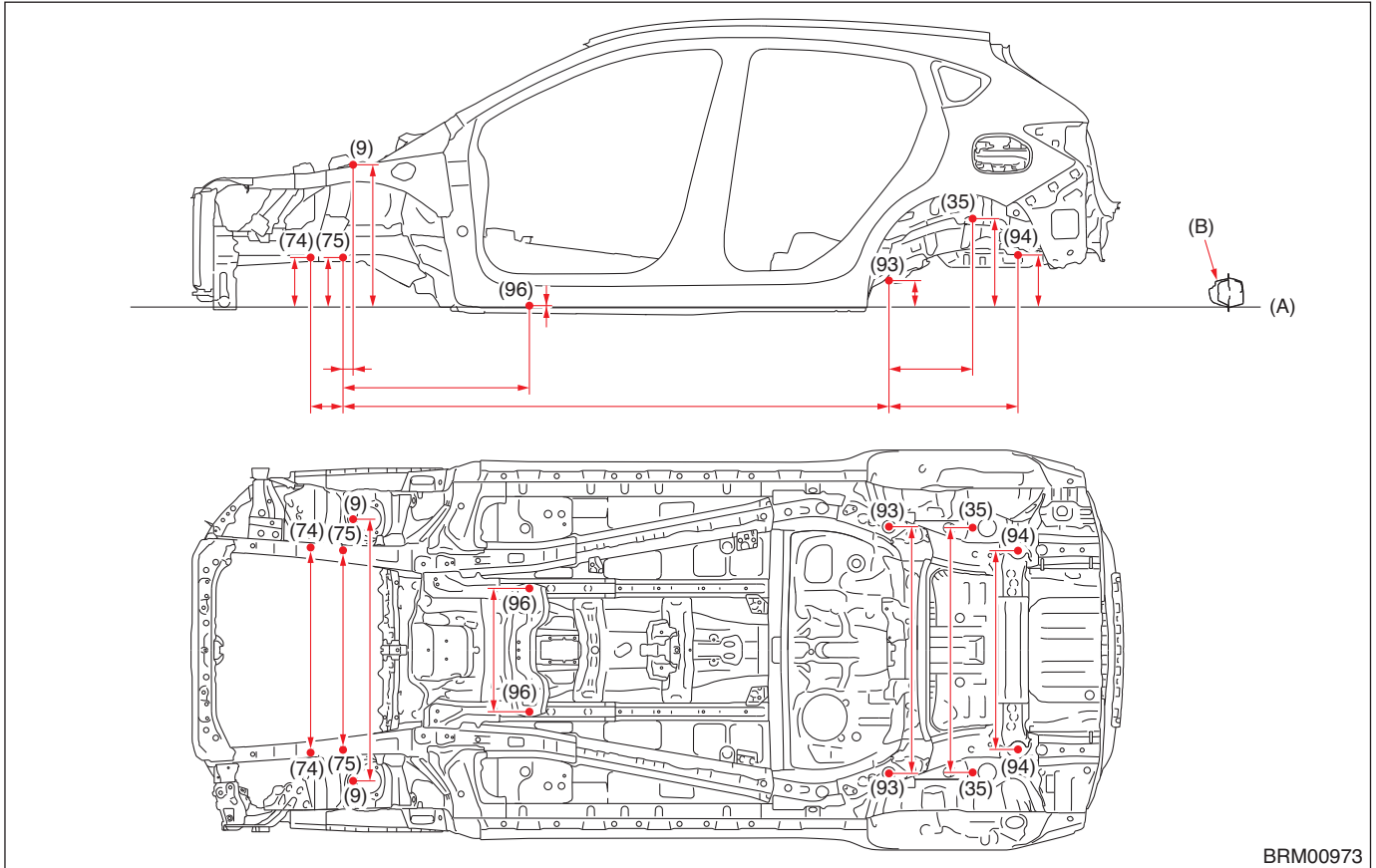
- Gasoline model



BS-08491

Measurement for Combined Parts

• Hybrid model



- 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)
* ¹ Datum line — (87)	6 (0.24)
Datum line — (93)	118 (4.65)
Datum line — (94)	231 (9.09)
* ² Datum line — (96)	6 (0.24)
(9) — (75)	45 (1.77)
(35) — (93)	372 (14.65)
(74) — (75)	144 (5.67)
* ¹ (75) — (87)	718 (28.27)

Measuring point	Datum dimension mm (in)
(75) — (93)	2,424 (95.43)
* ² (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)
* ¹ (87) — (87)	548 (21.57)
(93) — (93)	1,096 (43.15)
(94) — (94)	883 (34.76)
* ² (96) — (96)	548 (21.57)

*¹: Gasoline model

*²: 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.

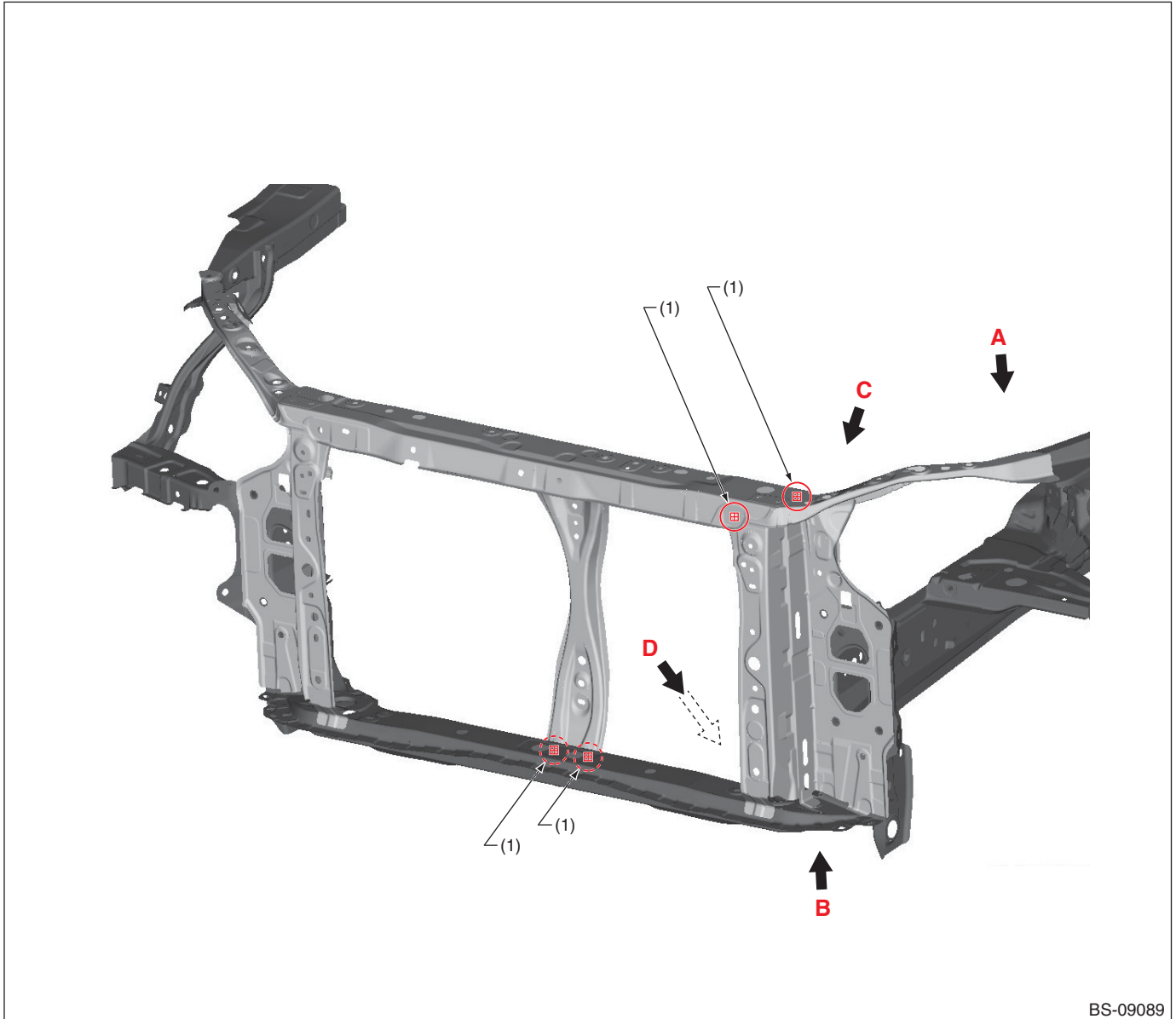
Except the reference points (9) and (35), refer to the figure "LOWER SURFACE, DIMENSIONS, Body Reference Points" on page 50.

8. Panel Replacement

8-1. Radiator Panel (total replacement)

A: REMOVAL

• Overall view



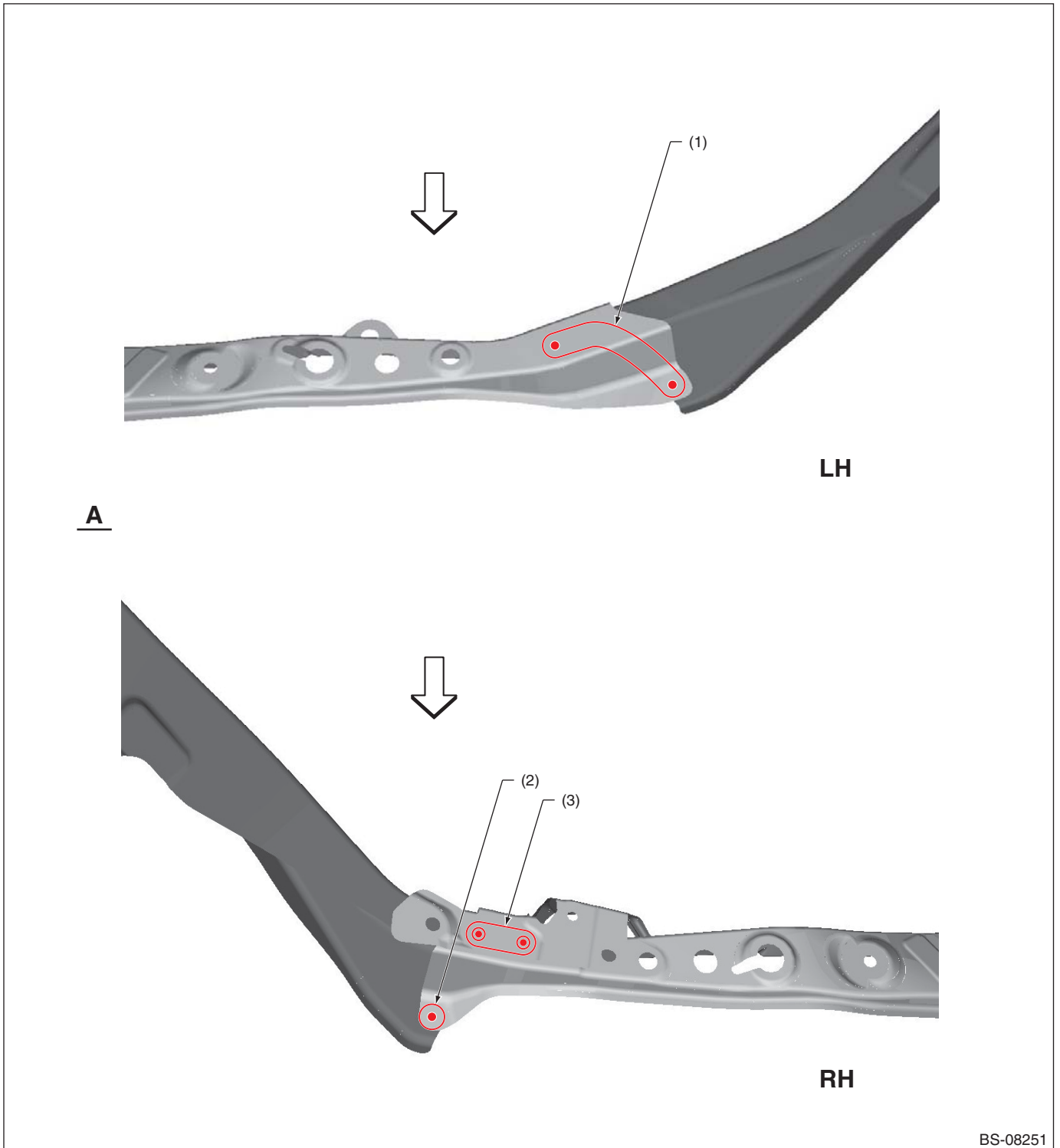
(1) 1 point (bolt)

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.

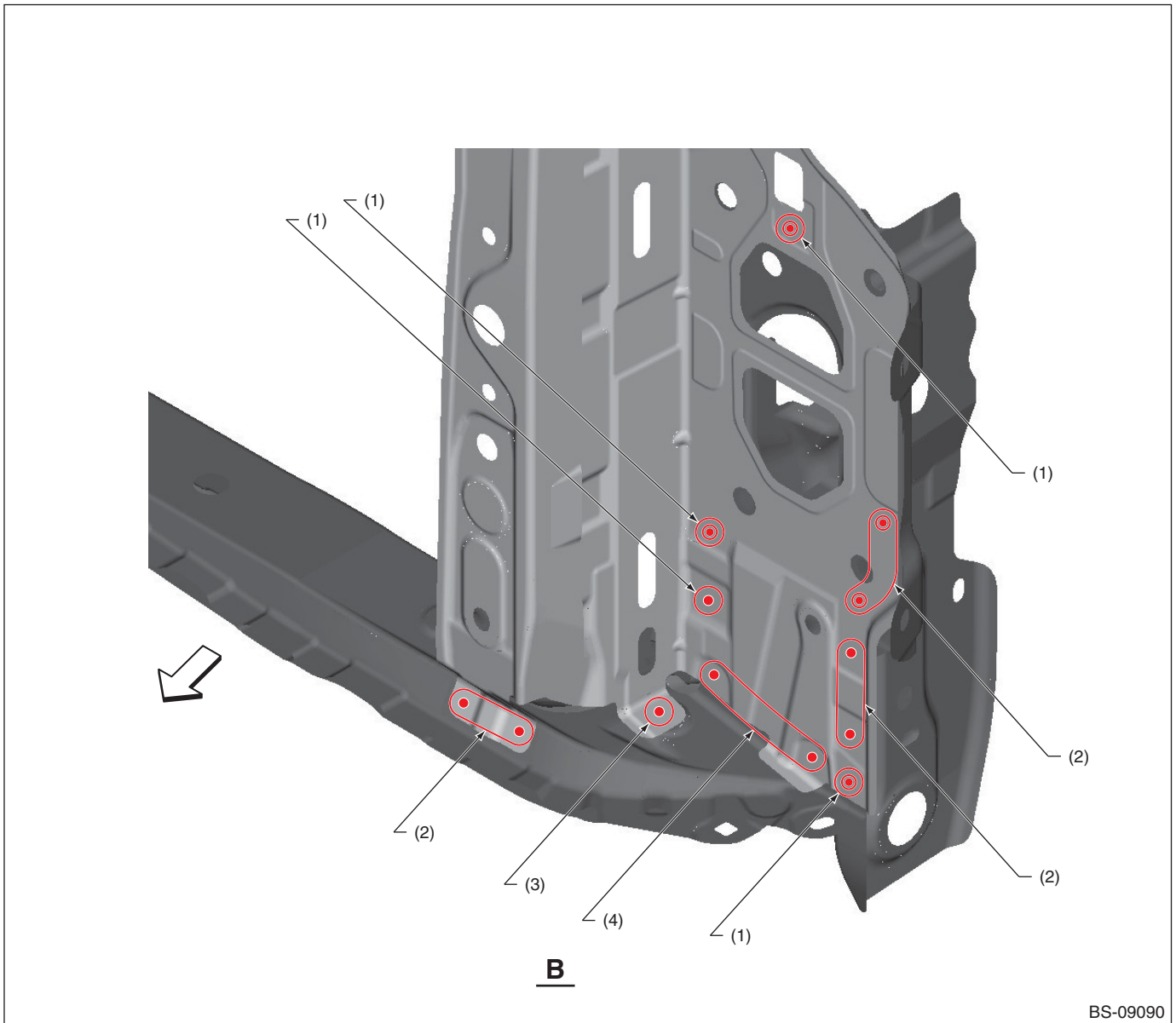
Panel Replacement

• Views A



Panel Replacement

• Views B



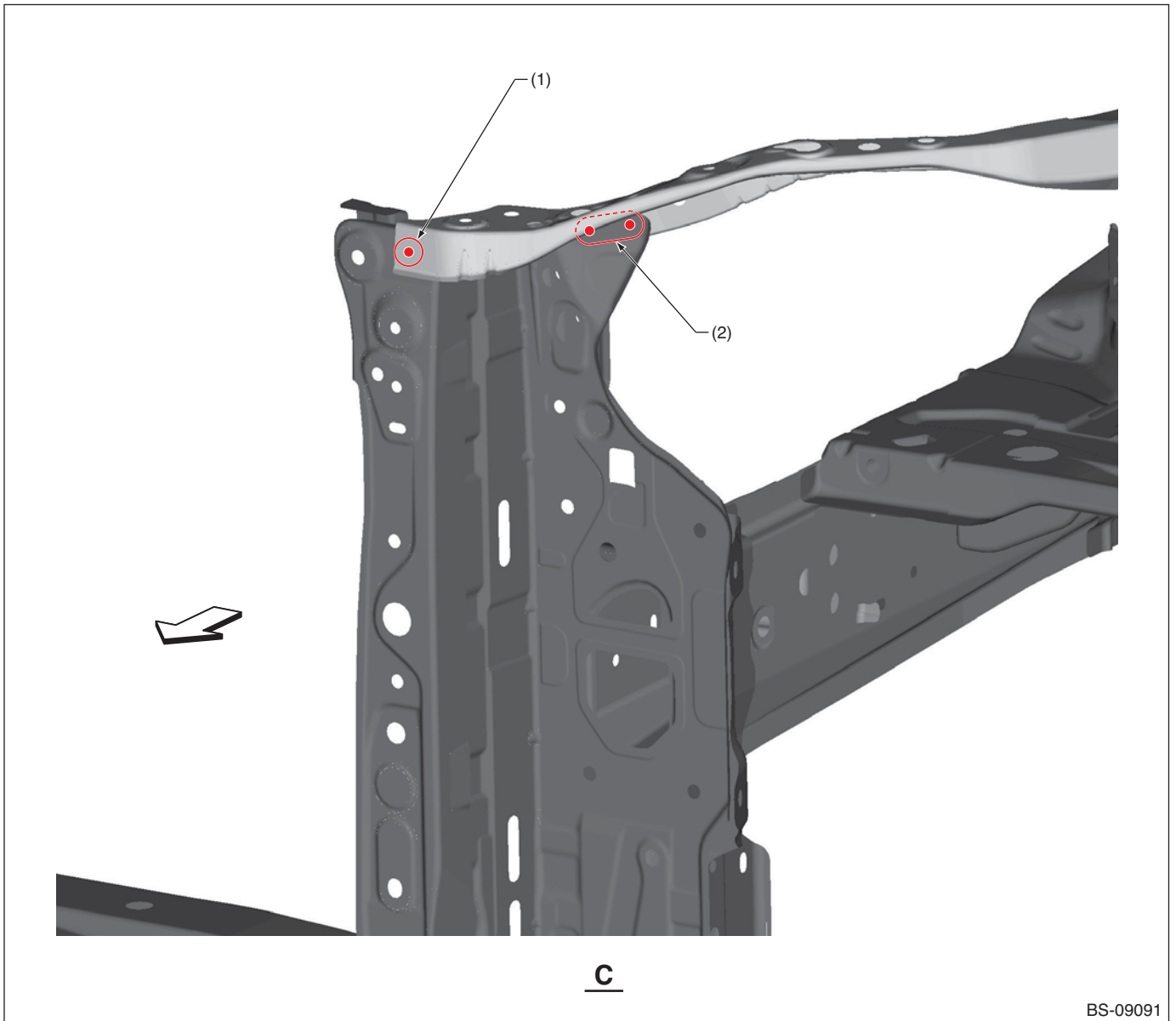
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 1 point (top · 1)

(4) 3 points (outside · 1)

Panel Replacement

• Views C

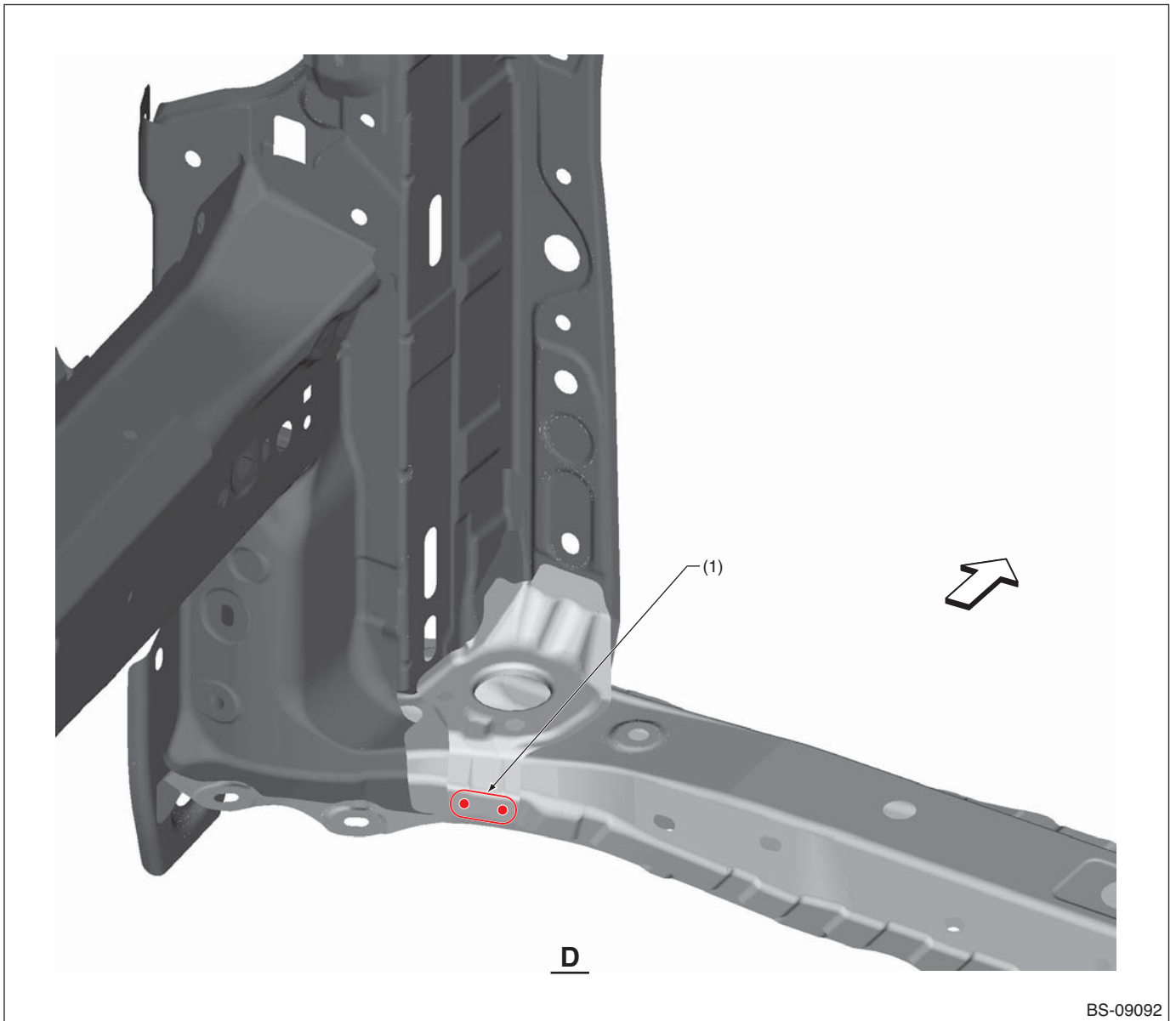


(1) 1 point (outside · 1)

(2) 2 points (inside · 1)

Panel Replacement

- Views D

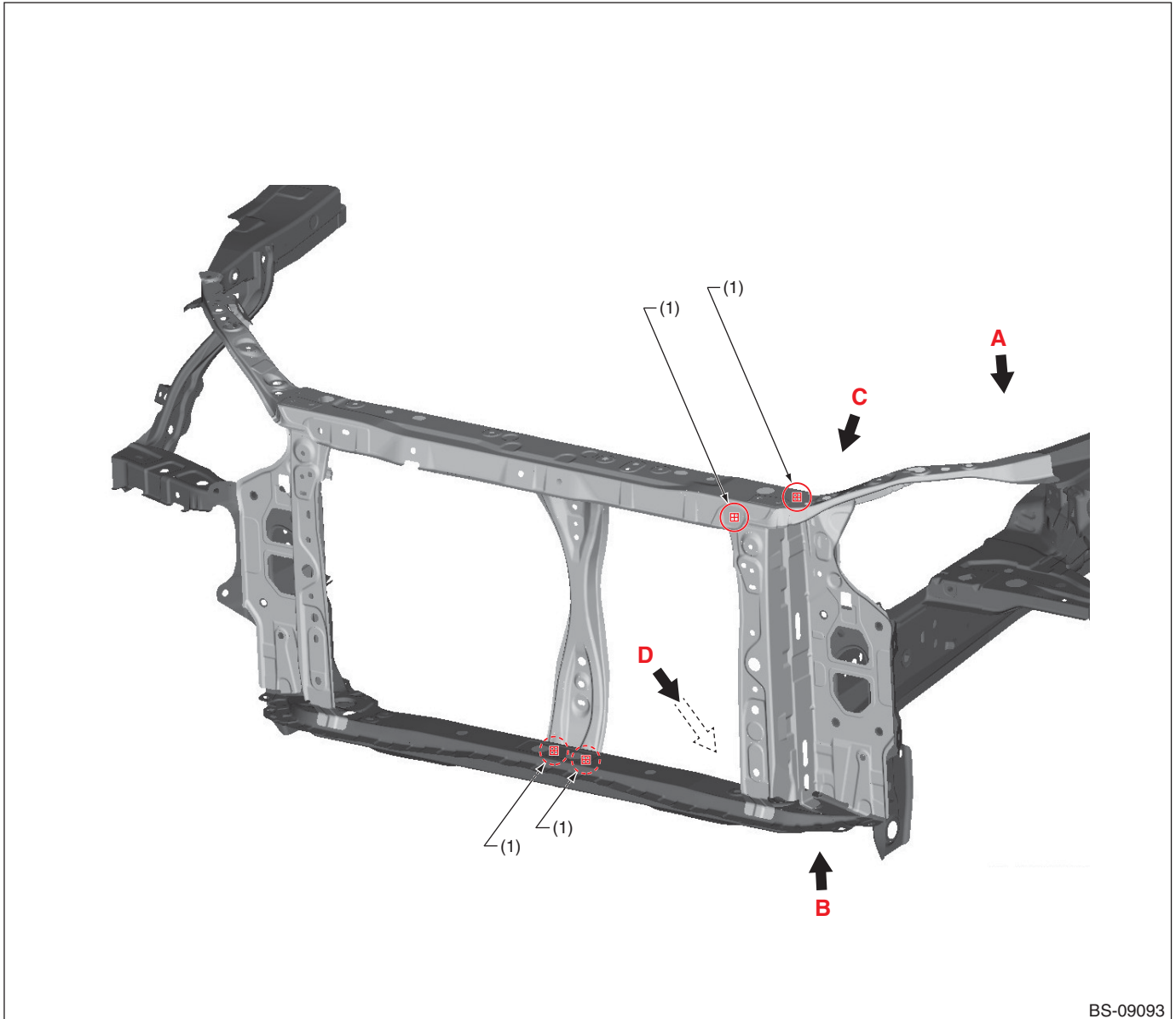


(1) 2 points (top - 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09093

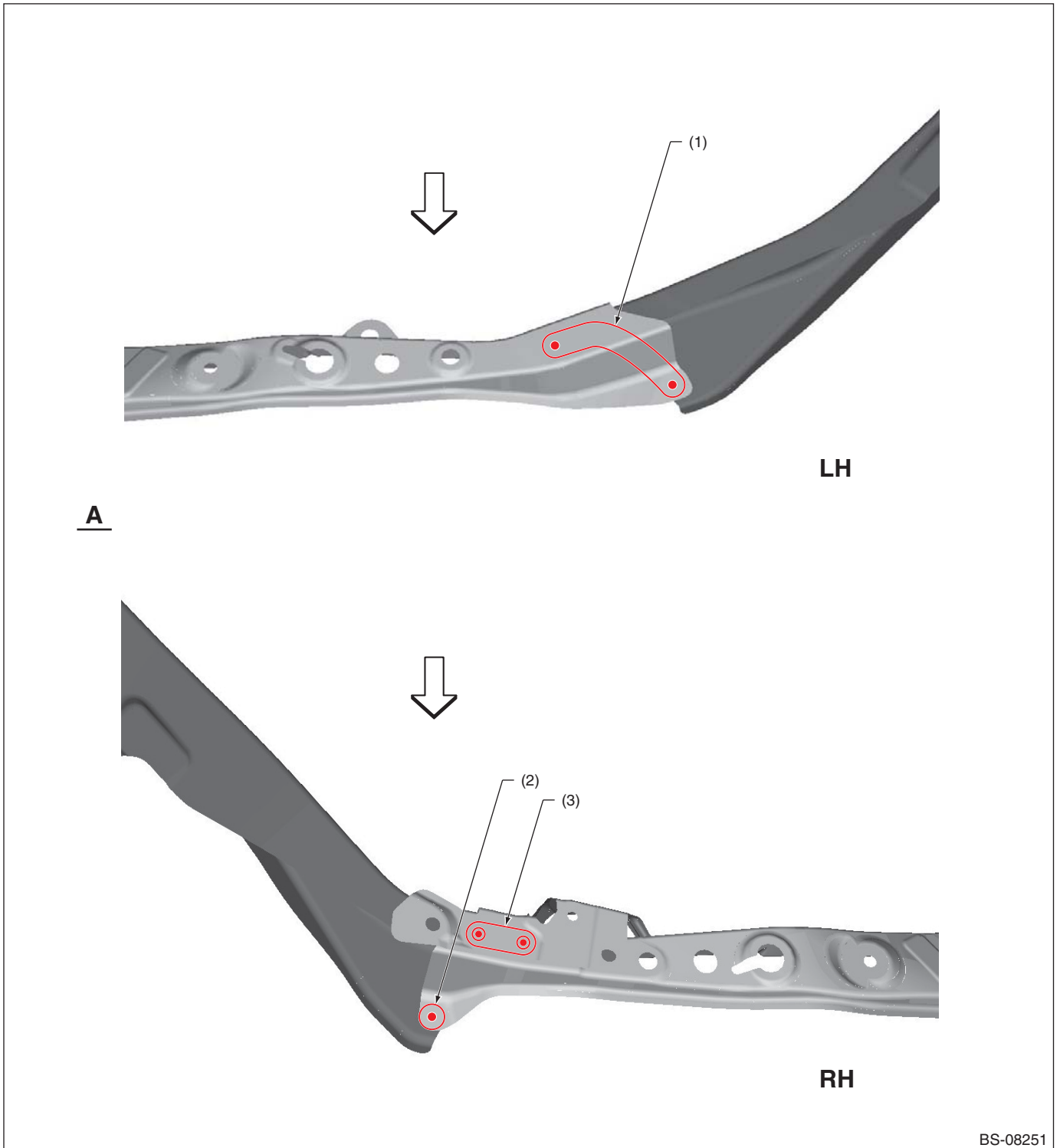
(1) 1 point (bolt)

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.

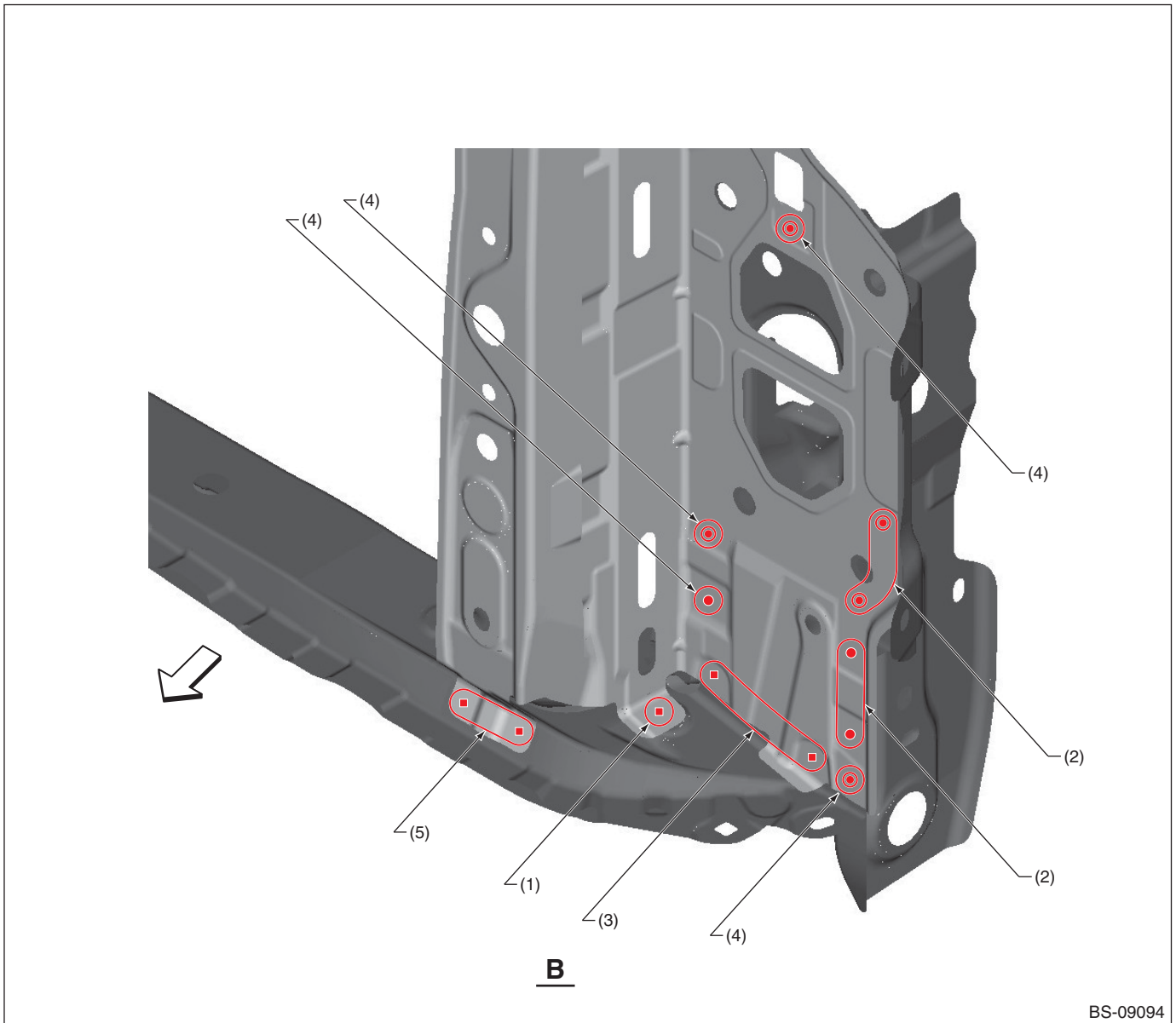
Panel Replacement

• Views A



Panel Replacement

• Views B



BS-09094

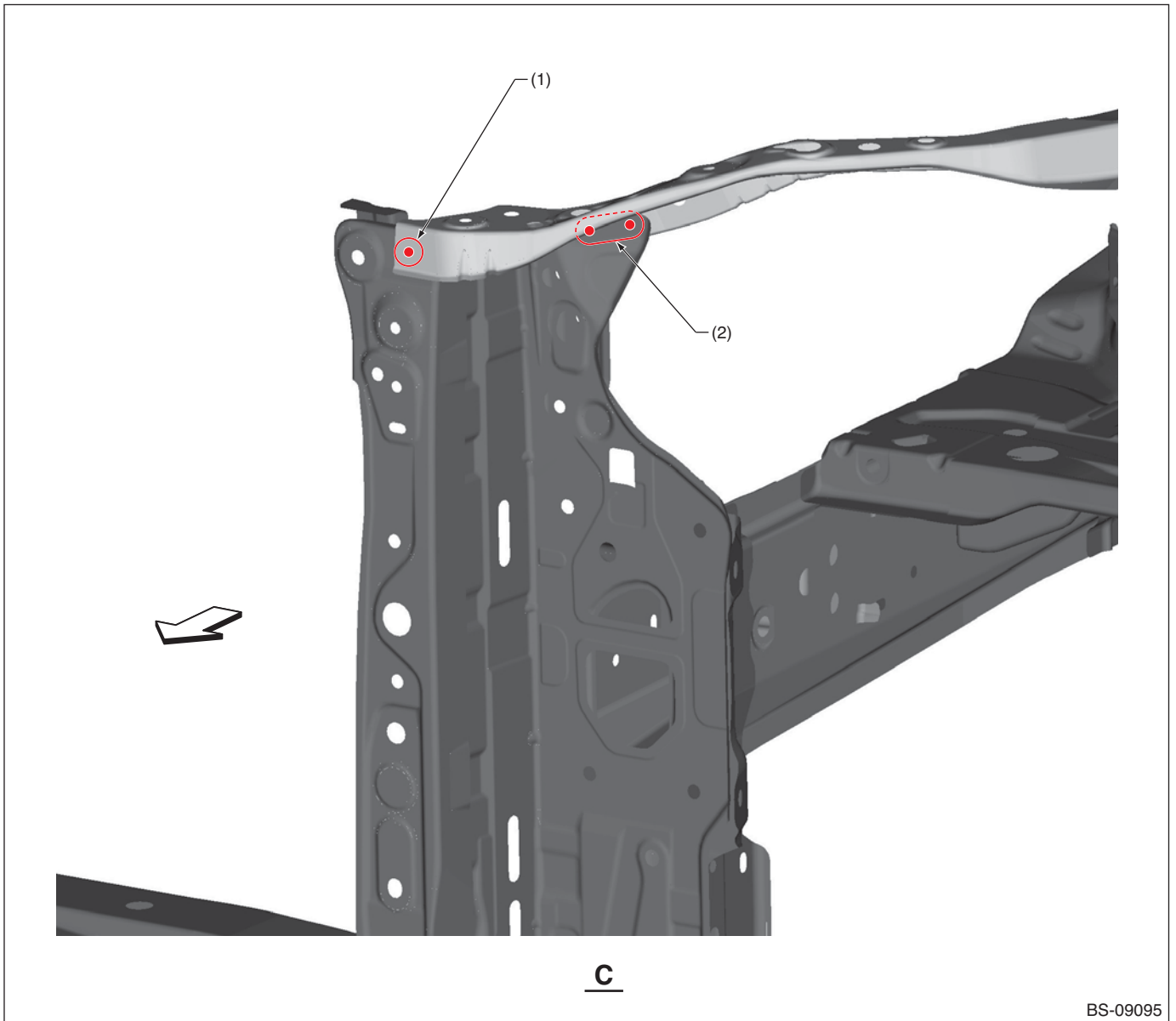
(1) 1 point (service)
(2) 2 points

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

(5) 2 points (service)

Panel Replacement

• Views C

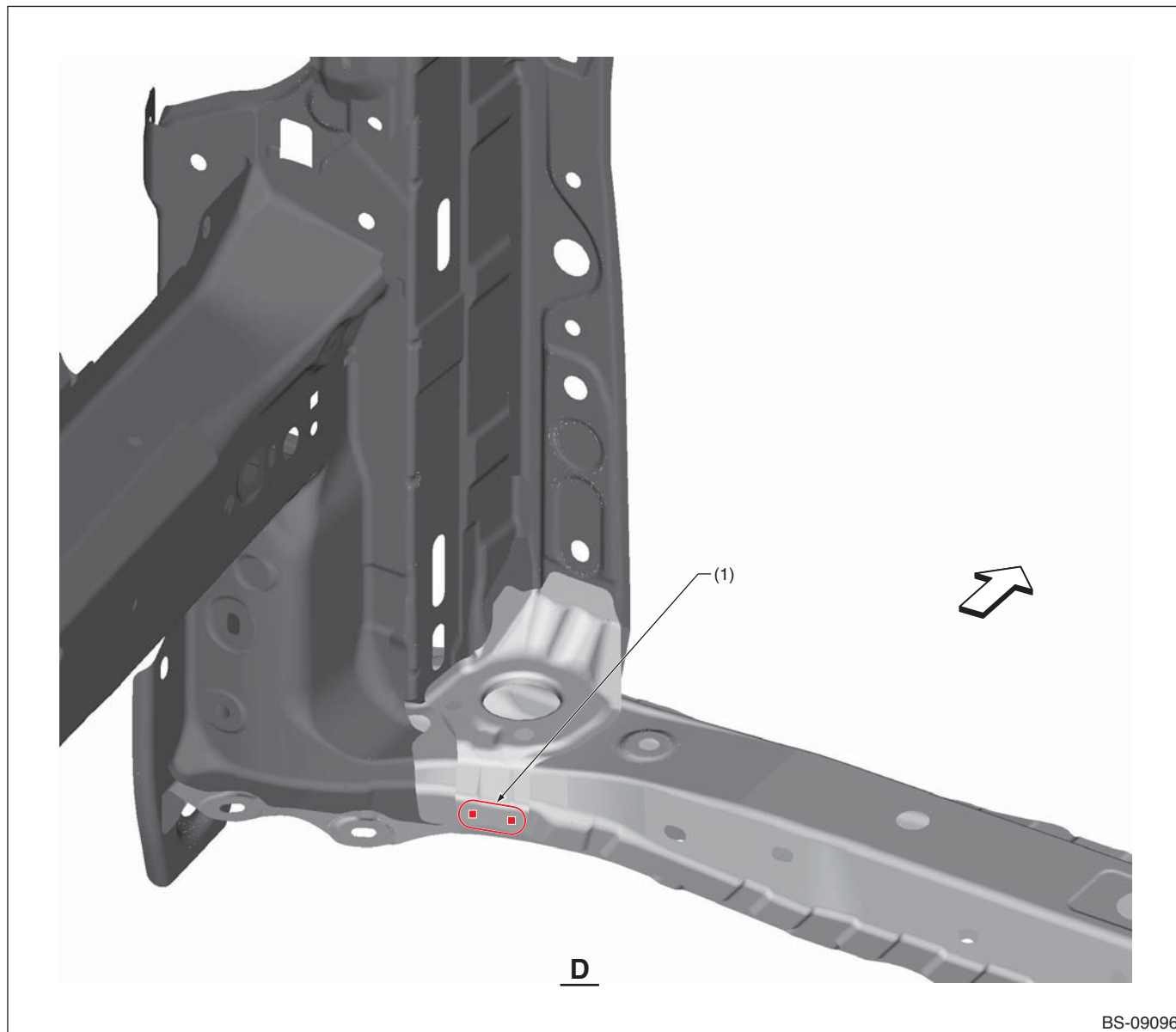


(1) 1 point

(2) 2 points

Panel Replacement

• Views D



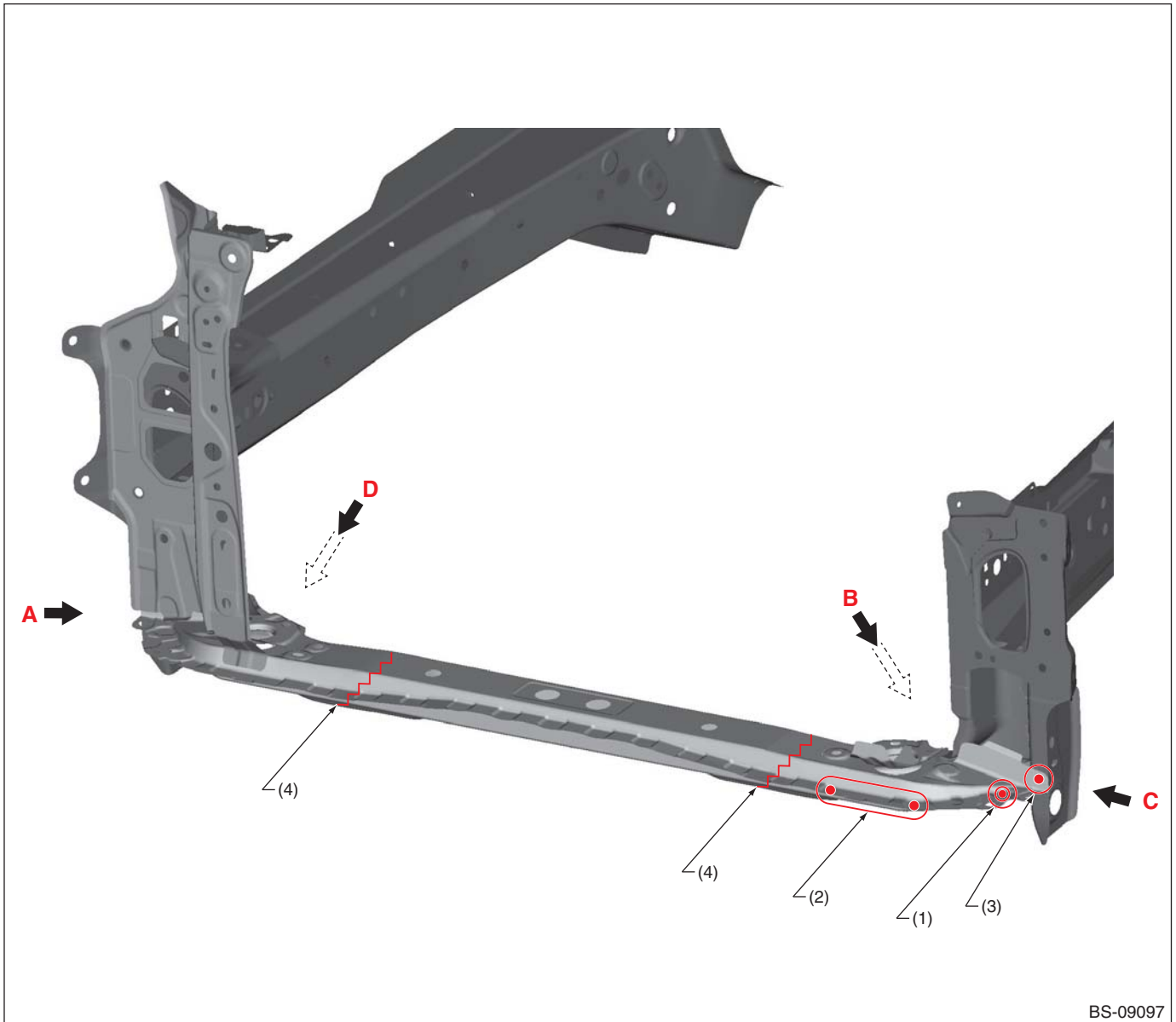
(1) 2 points (service)

Panel Replacement

8-2. Radiator Core Support (total replacement)

A: REMOVAL

• Overall view



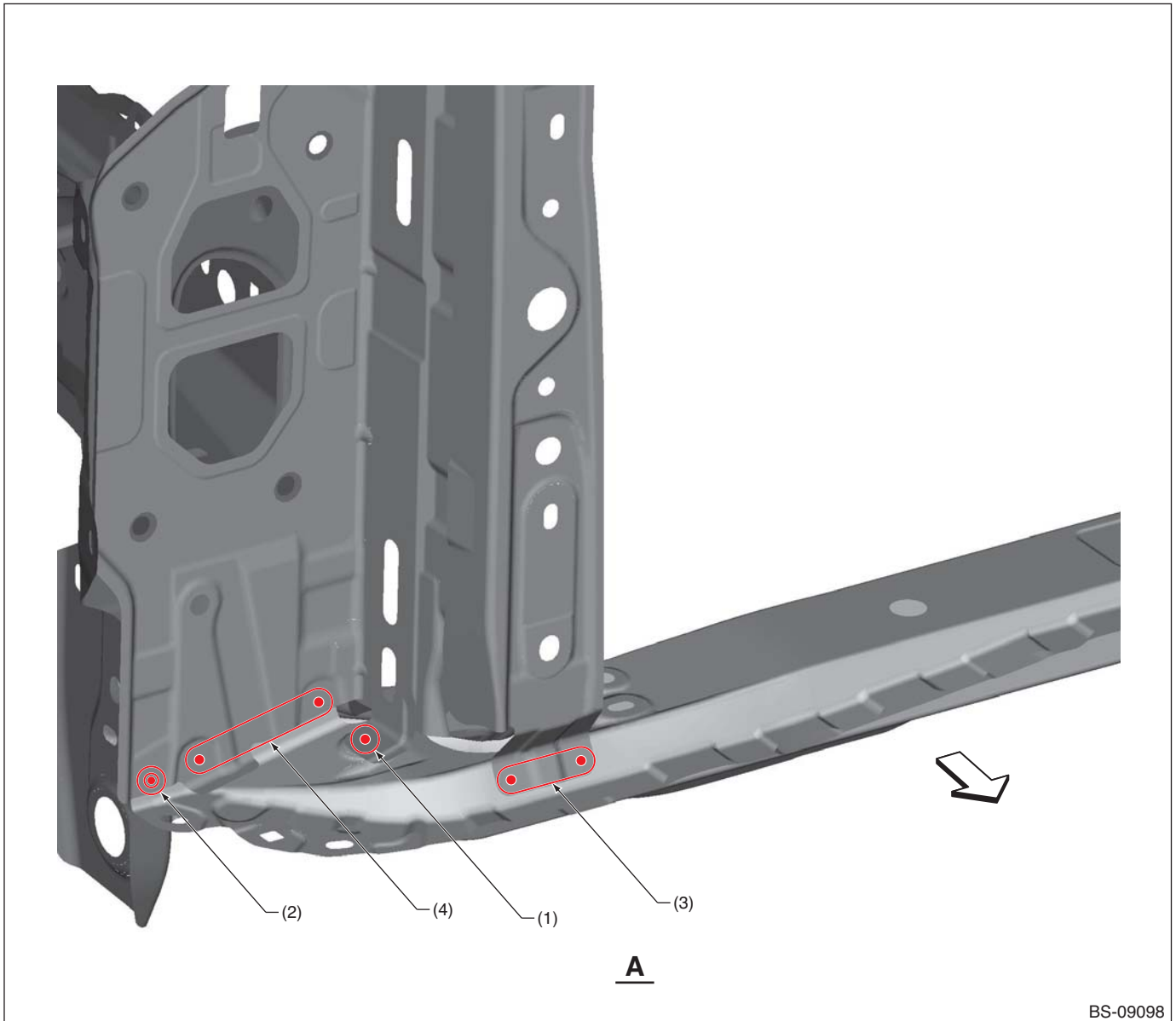
(1) 1 point (top · 1)
(2) 3 points (top · 1)

(3) 1 point (outside · 1)

(4) Rough cutting

Panel Replacement

• Views A



BS-09098

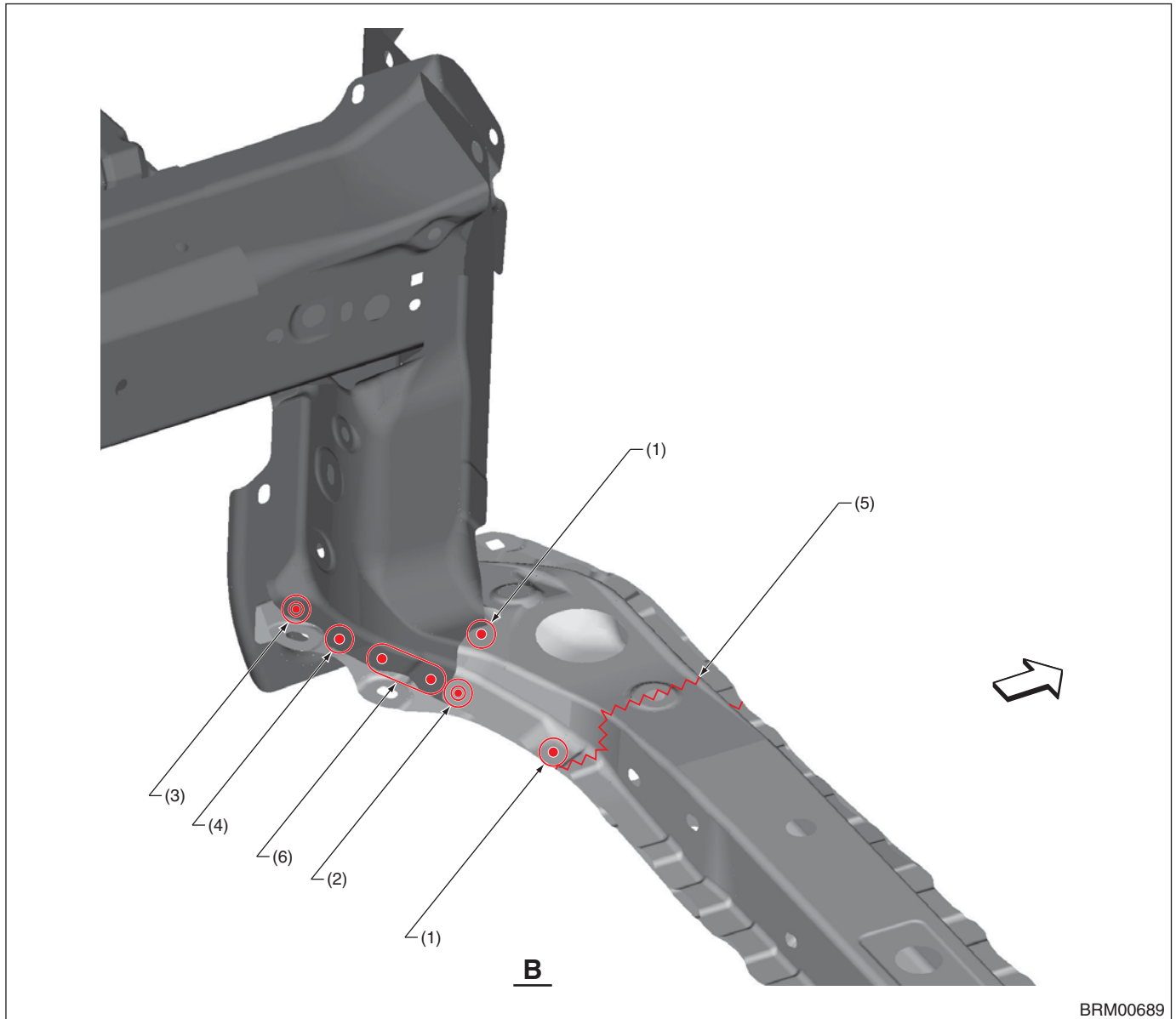
(1) 1 point (top · 1)
(2) 1 point (outside · 2)

(3) 2 points (outside · 1)

(4) 3 points (outside · 1)

Panel Replacement

• Views B

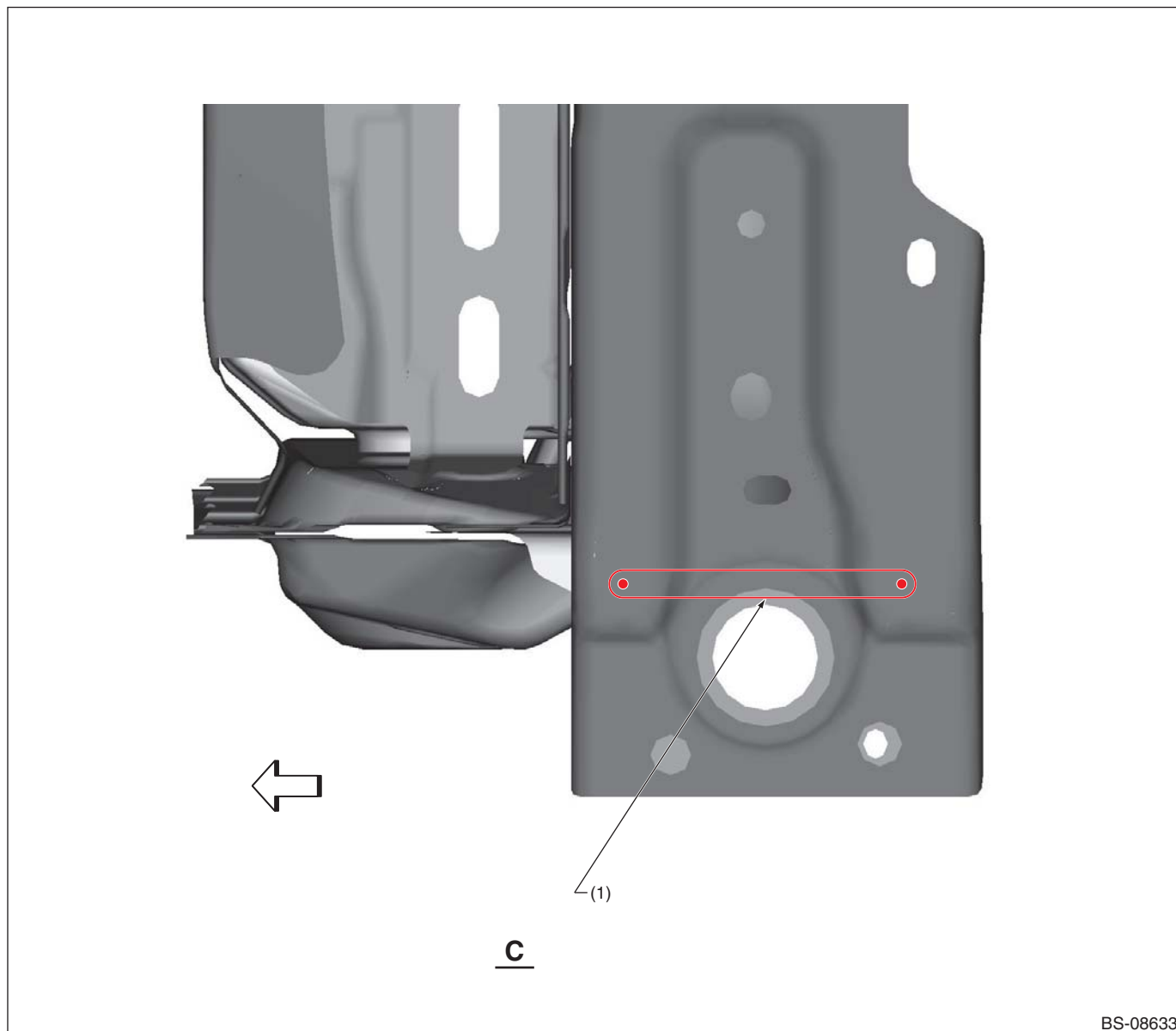


BRM00689

- | | | |
|-----------------------------------|-----------------------------------|---------------------------|
| (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

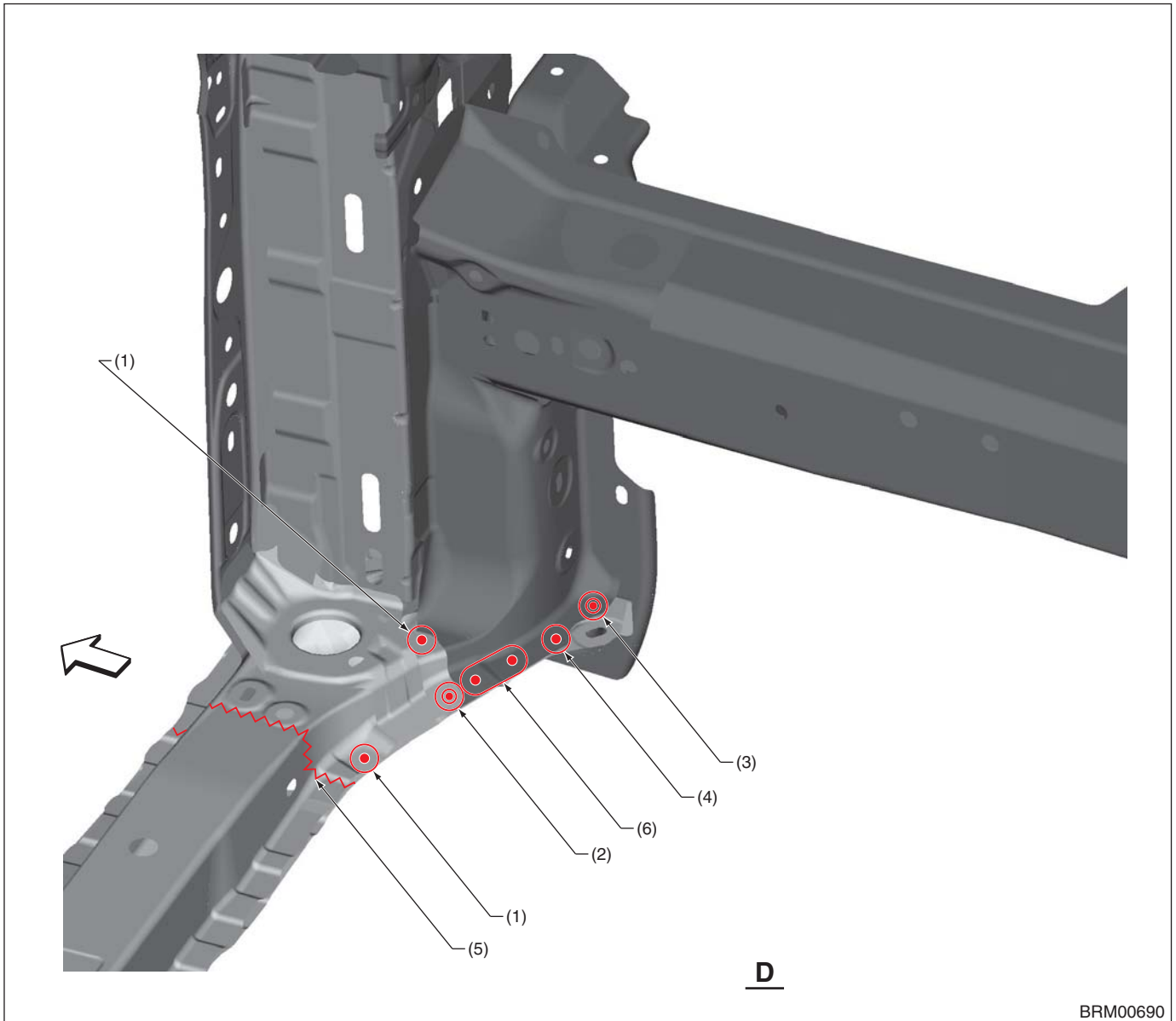
• Views C



(1) 2 points (outside · 1)

Panel Replacement

• Views D

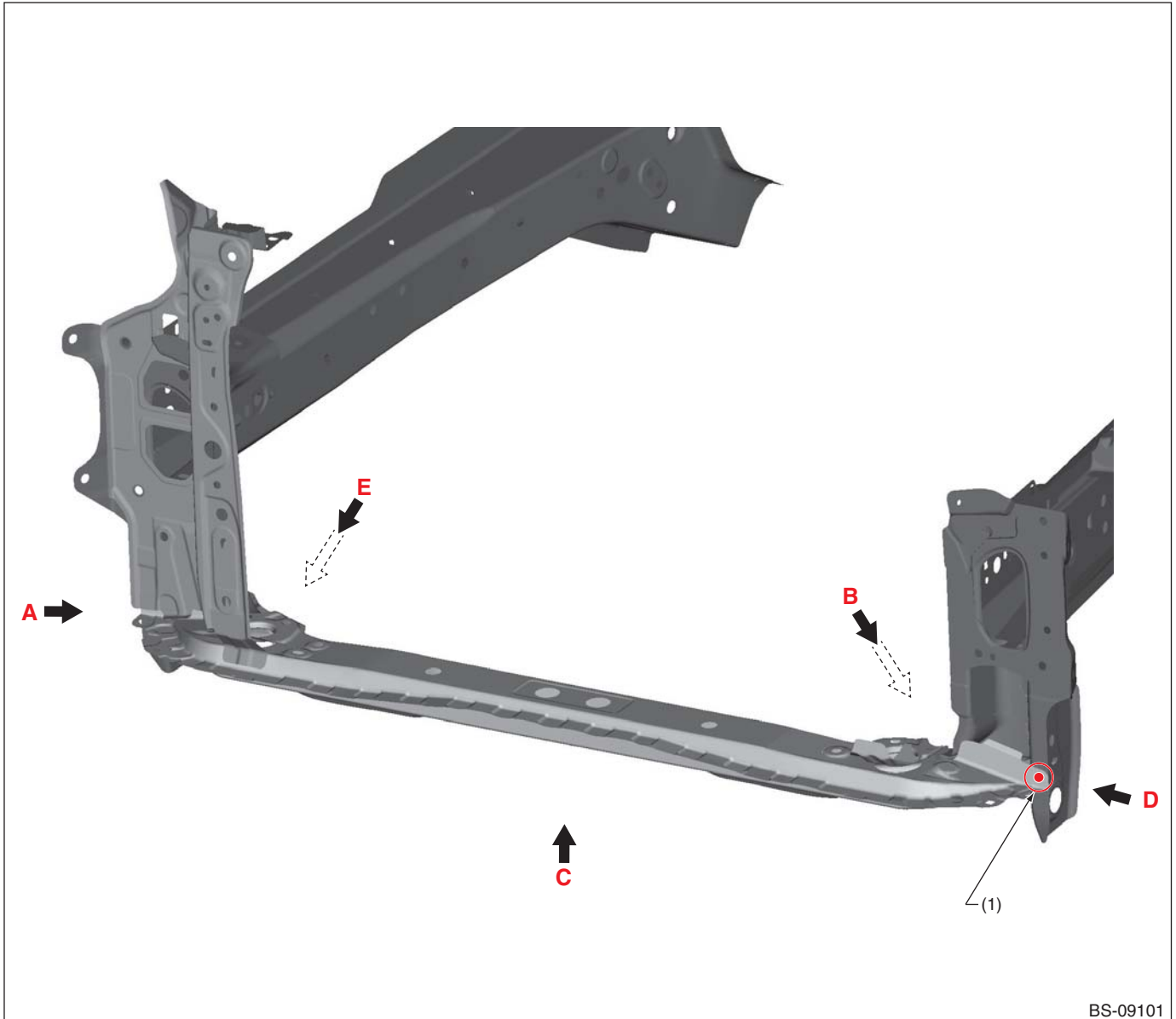


BRM00690

- | | | |
|-----------------------------------|-----------------------------------|---------------------------|
| (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) |

B: INSTALLATION

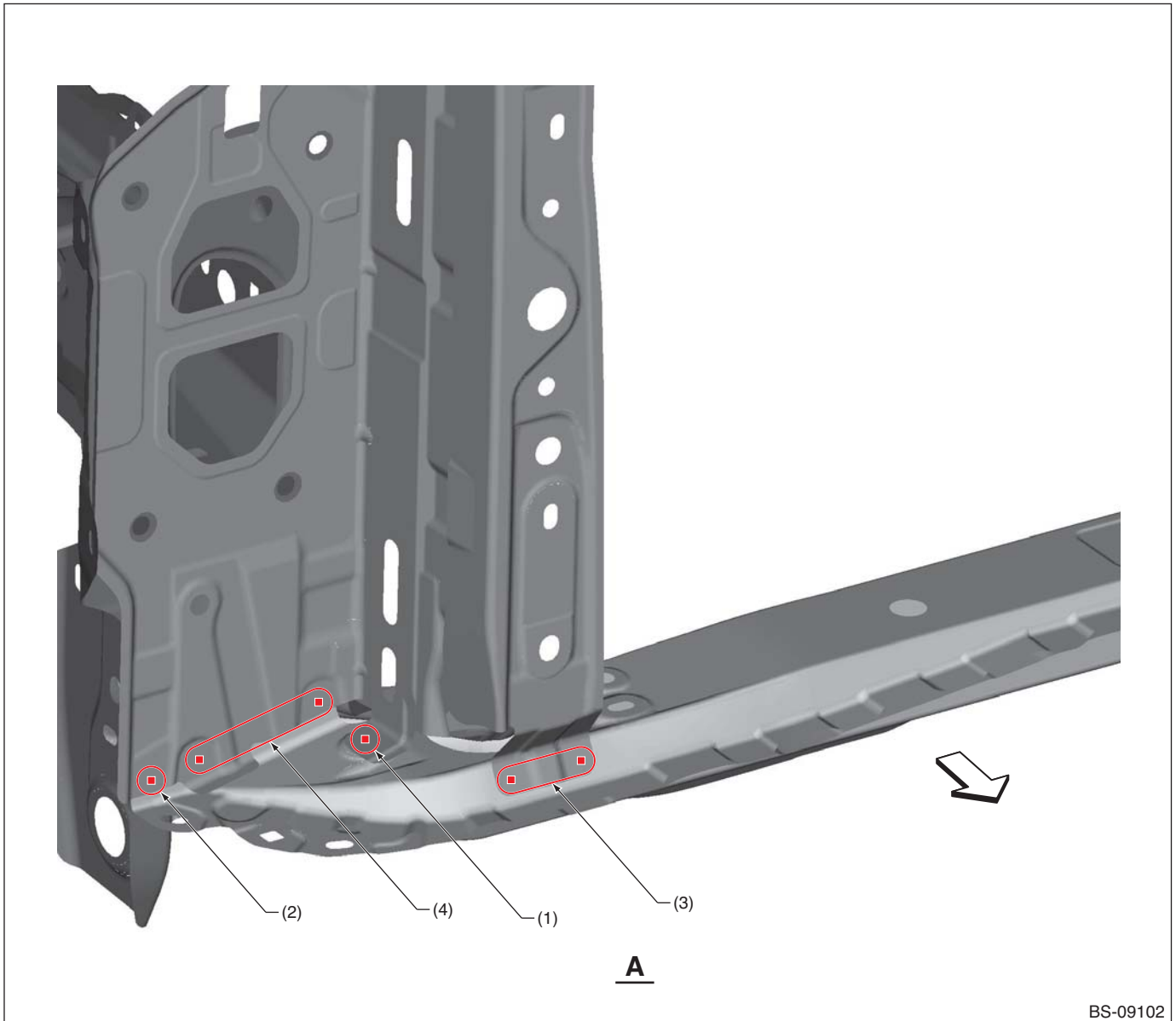
• Overall view



(1) 1 point

Panel Replacement

• Views A



BS-09102

(1) 1 point (service)

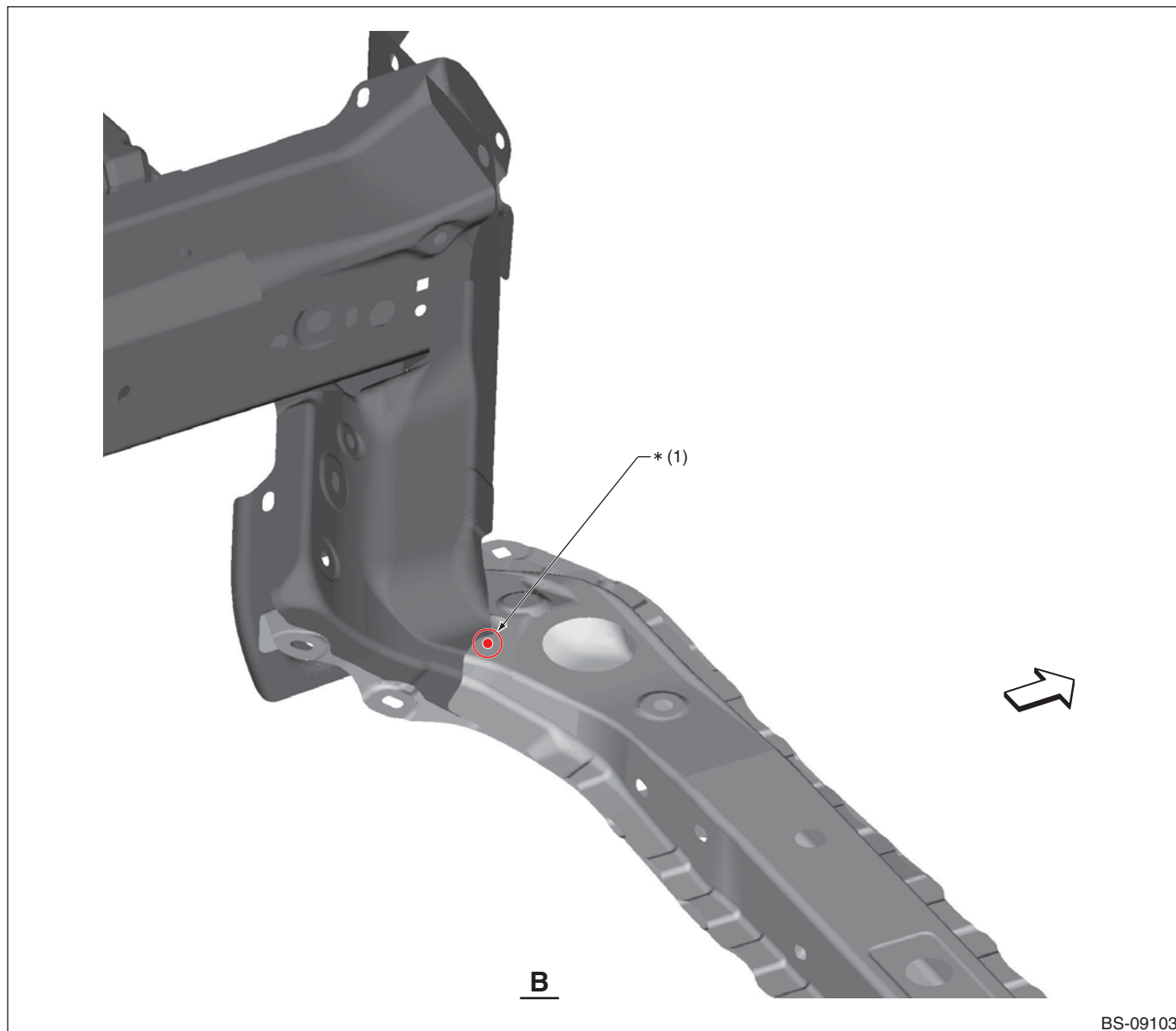
(3) 2 points (service)

(4) 3 points (service)

(2) 1 point (service · matching)

Panel Replacement

• Views B

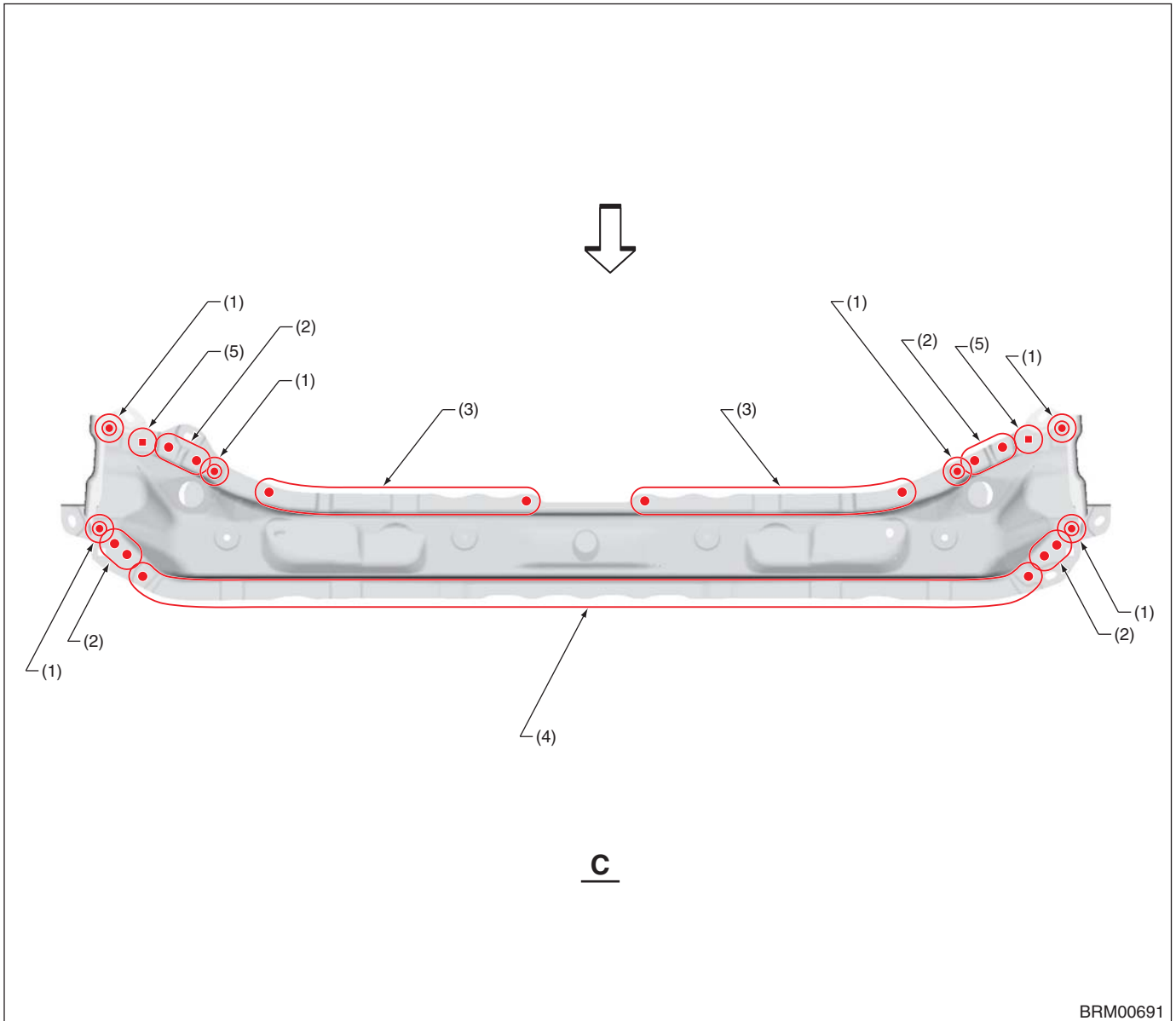


(1) 1 point

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

Panel Replacement

• Views C



BRM00691

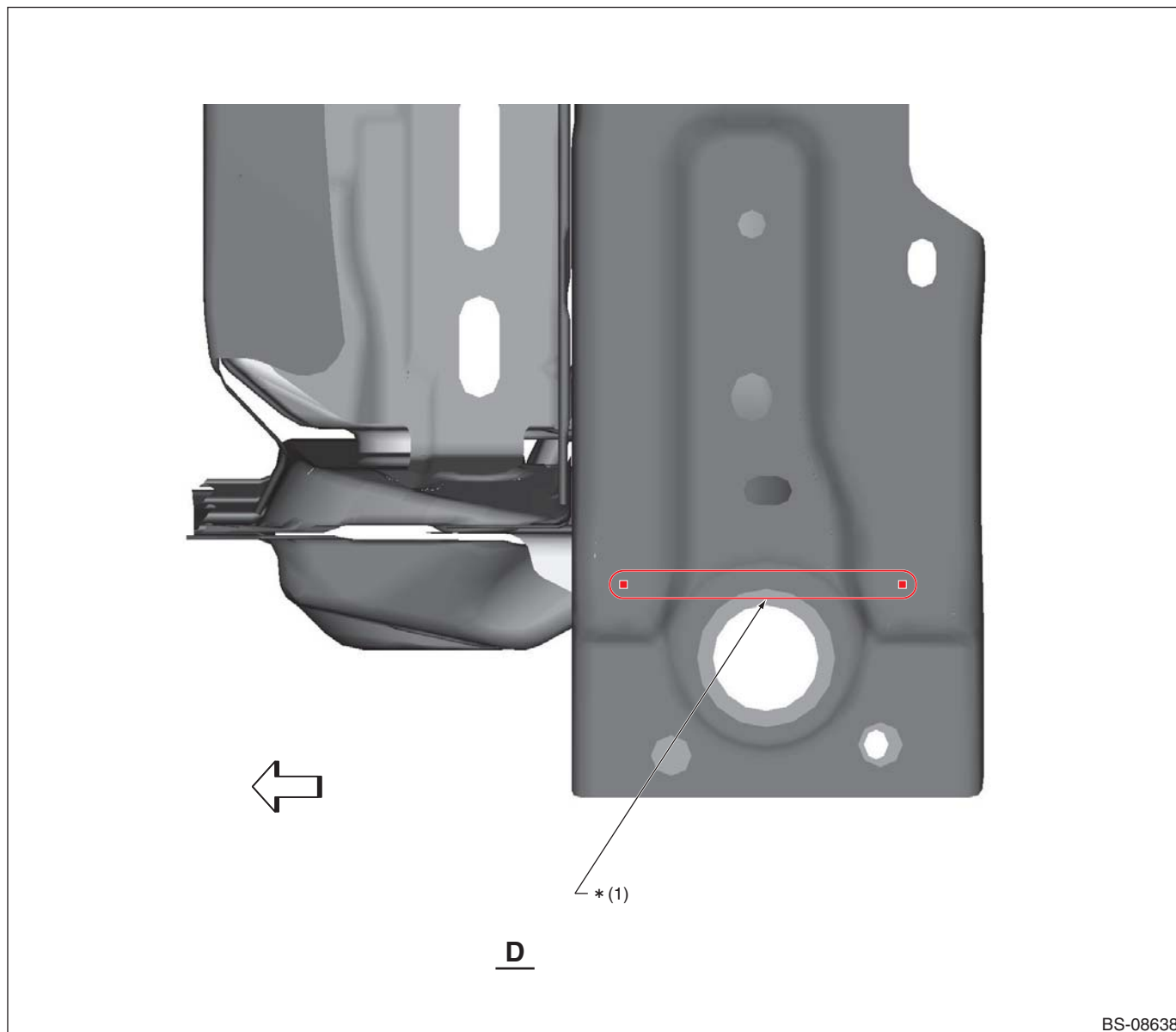
(1) 1 point
(2) 2 points

(3) 7 points
(4) 17 points

(5) 1 point (service)

Panel Replacement

• Views D

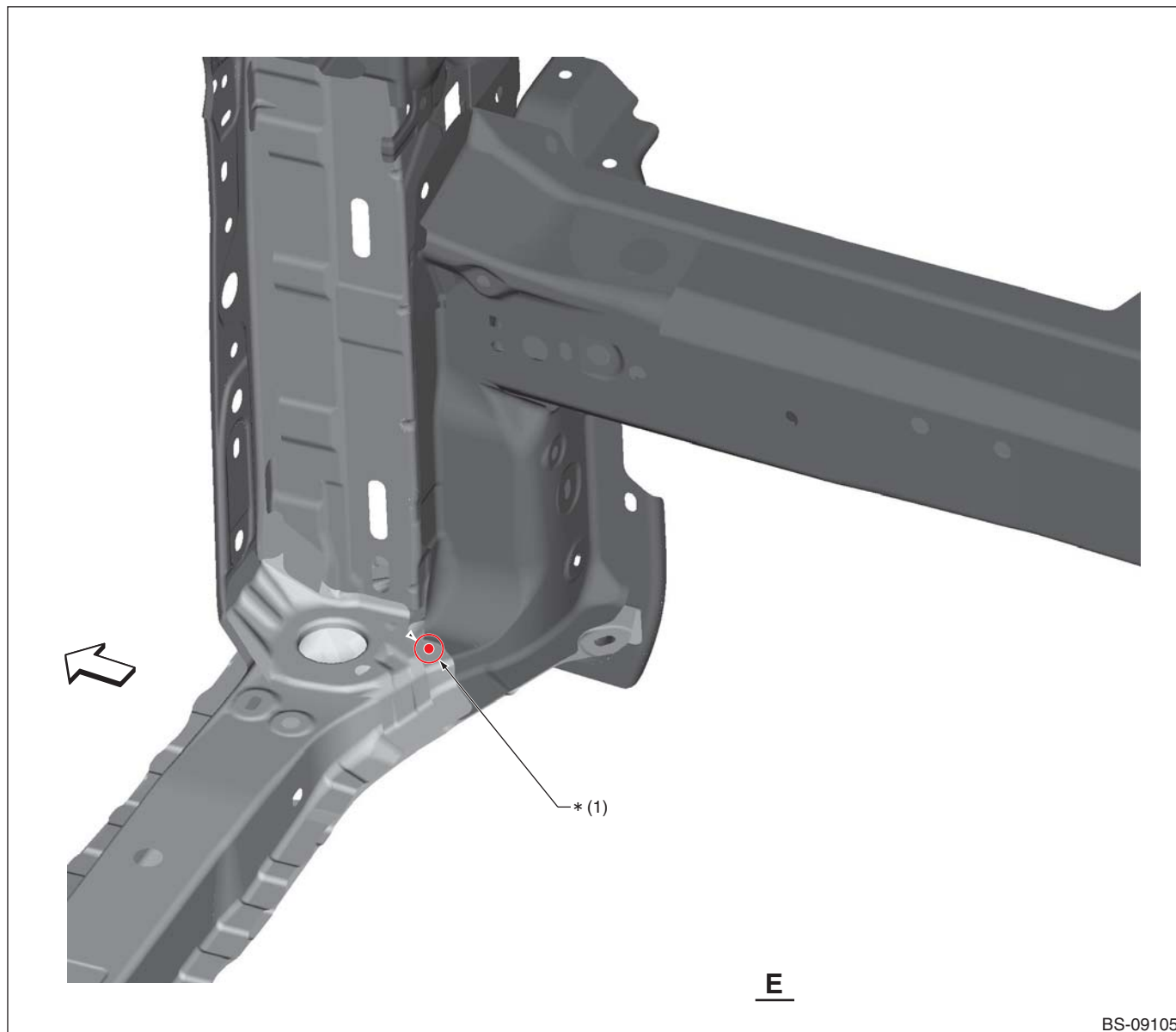


(1) 2 points

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

Panel Replacement

• Views E



BS-09105

(1) 1 point

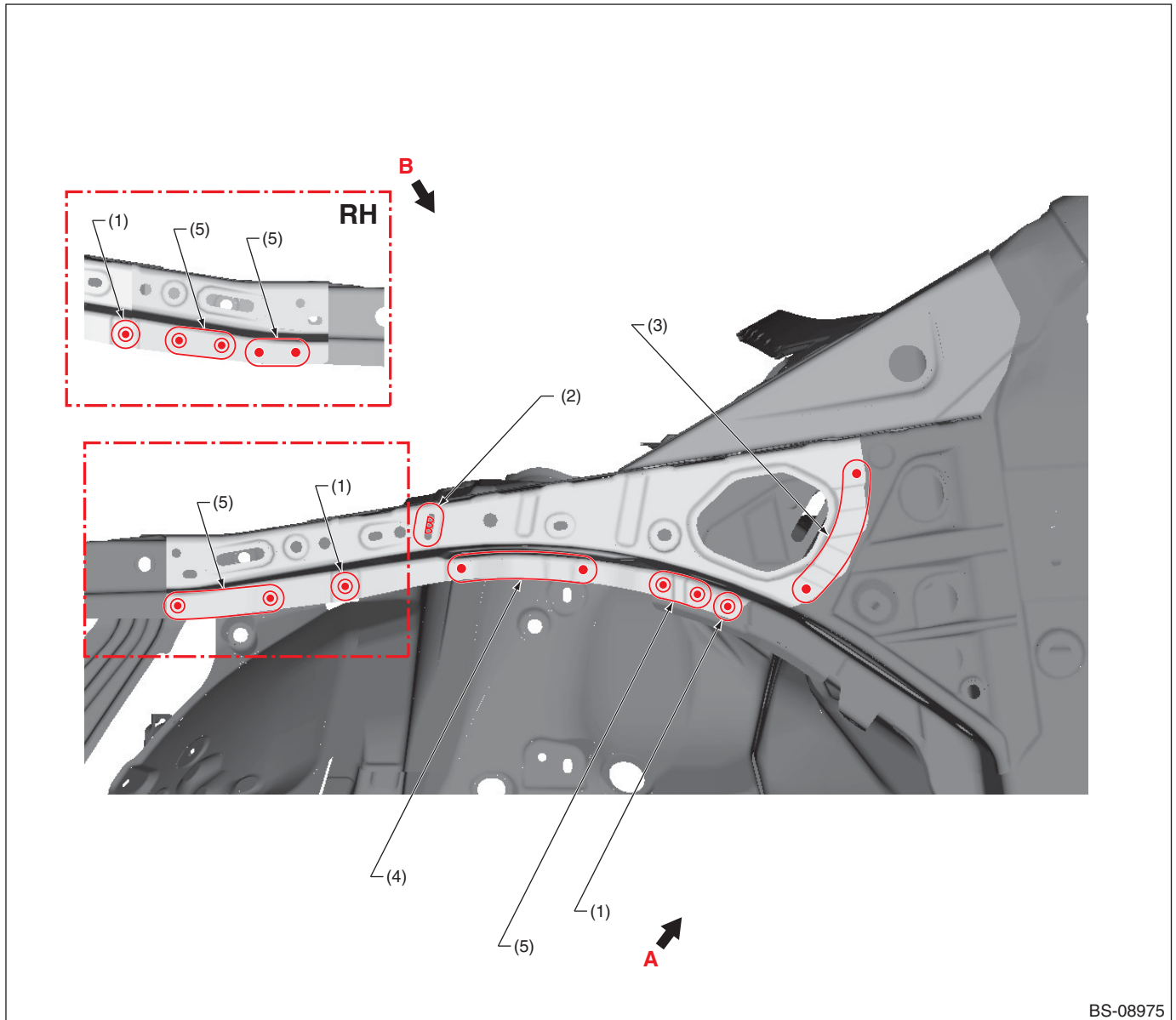
* : Before radiator B is installed, this point is welded.

Panel Replacement

8-3. Side Upper Frame (total replacement)

A: REMOVAL

• Overall view

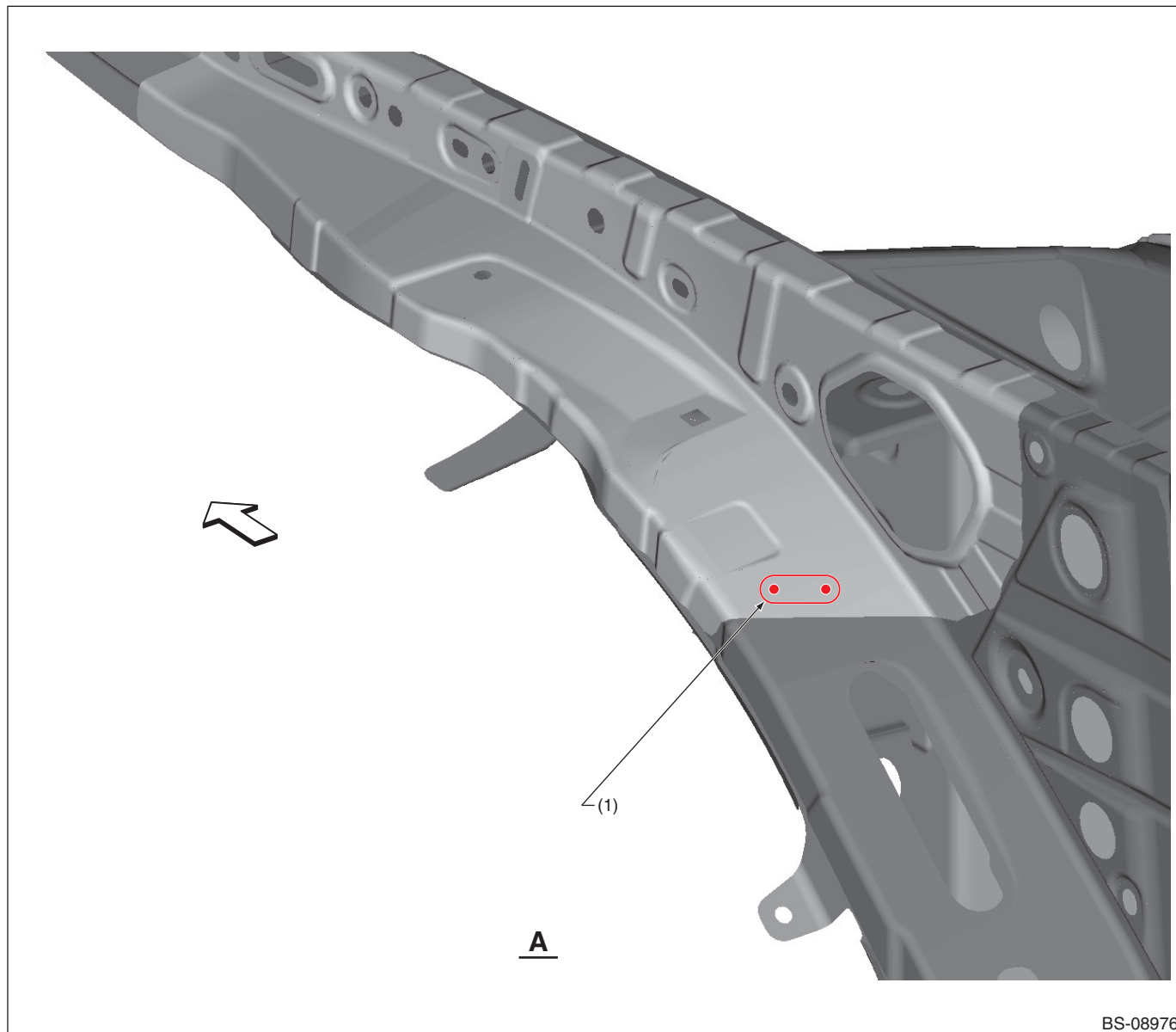


BS-08975

- | | | |
|---------------------------------------|----------------------------|----------------------------|
| (1) 1 point (outside - 2) | (3) 4 points (outside - 1) | (5) 2 points (outside - 1) |
| (2) 1 point (outside - 1 belt sander) | (4) 3 points (outside - 1) | |

Panel Replacement

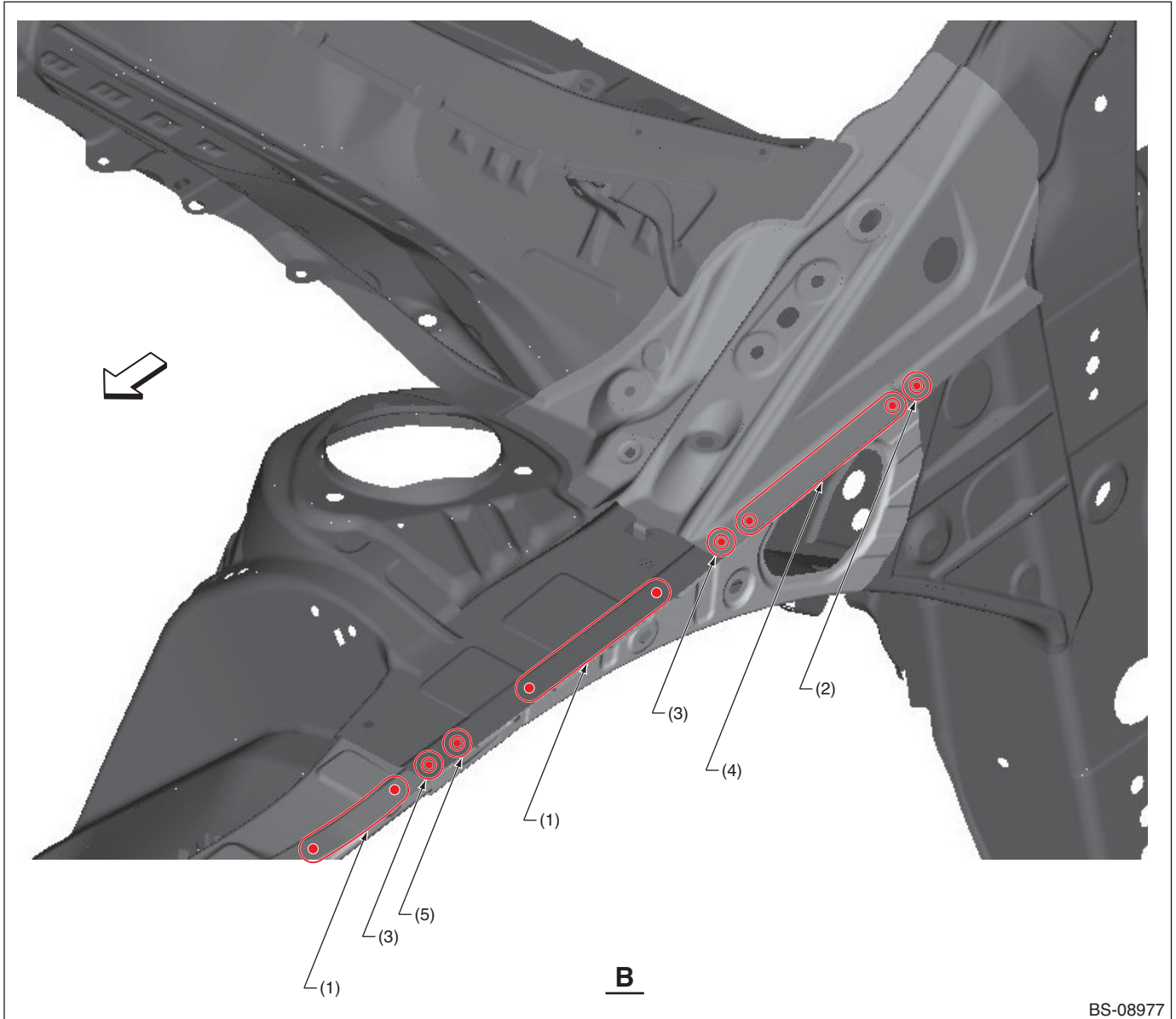
• Views A



(1) 2 points (outside · 1)

Panel Replacement

• Views B



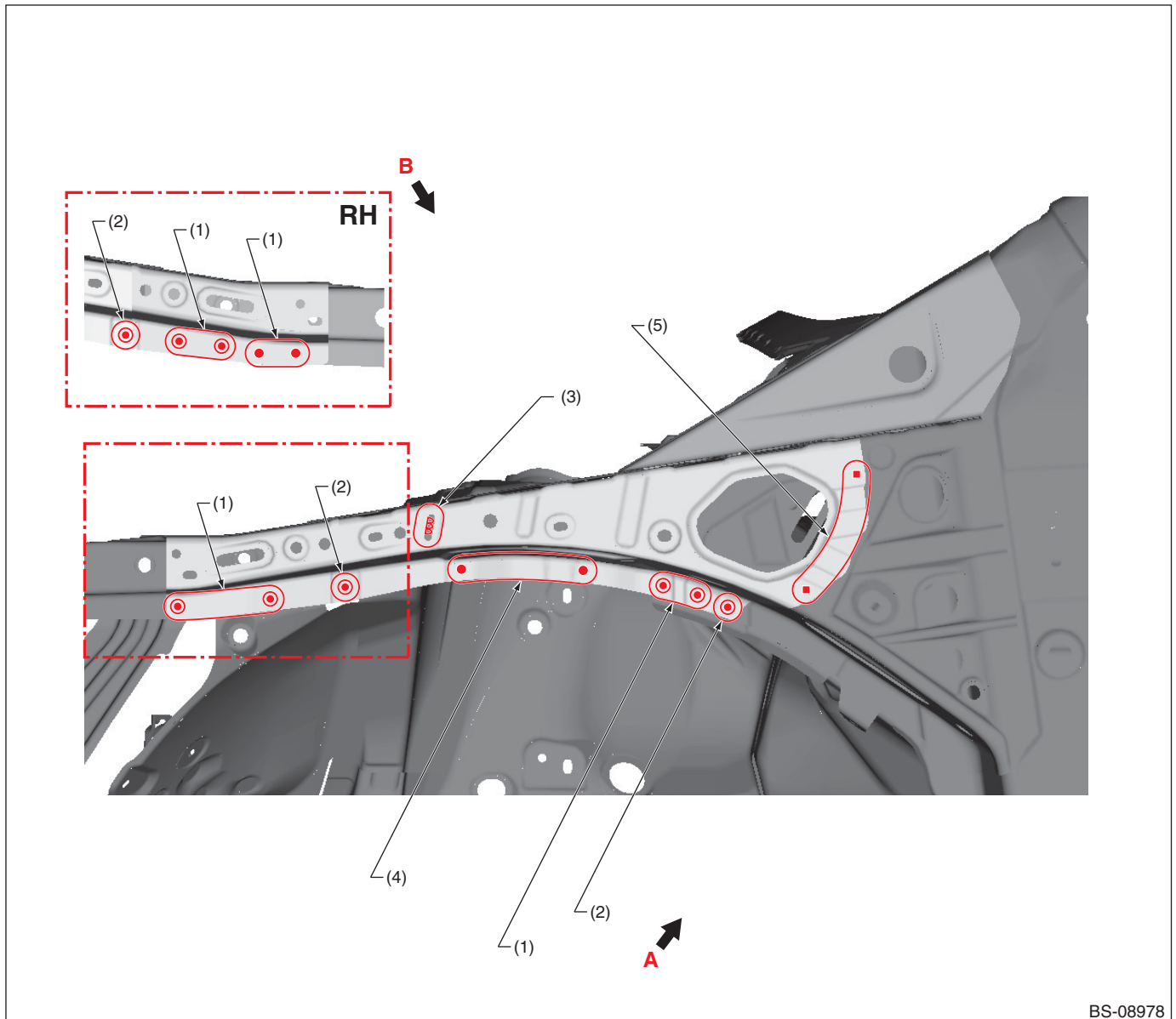
BS-08977

- | | | |
|--------------------------------------|---------------------------------------|--------------------------|
| (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



BS-08978

(1) 2 points

(2) 1 point

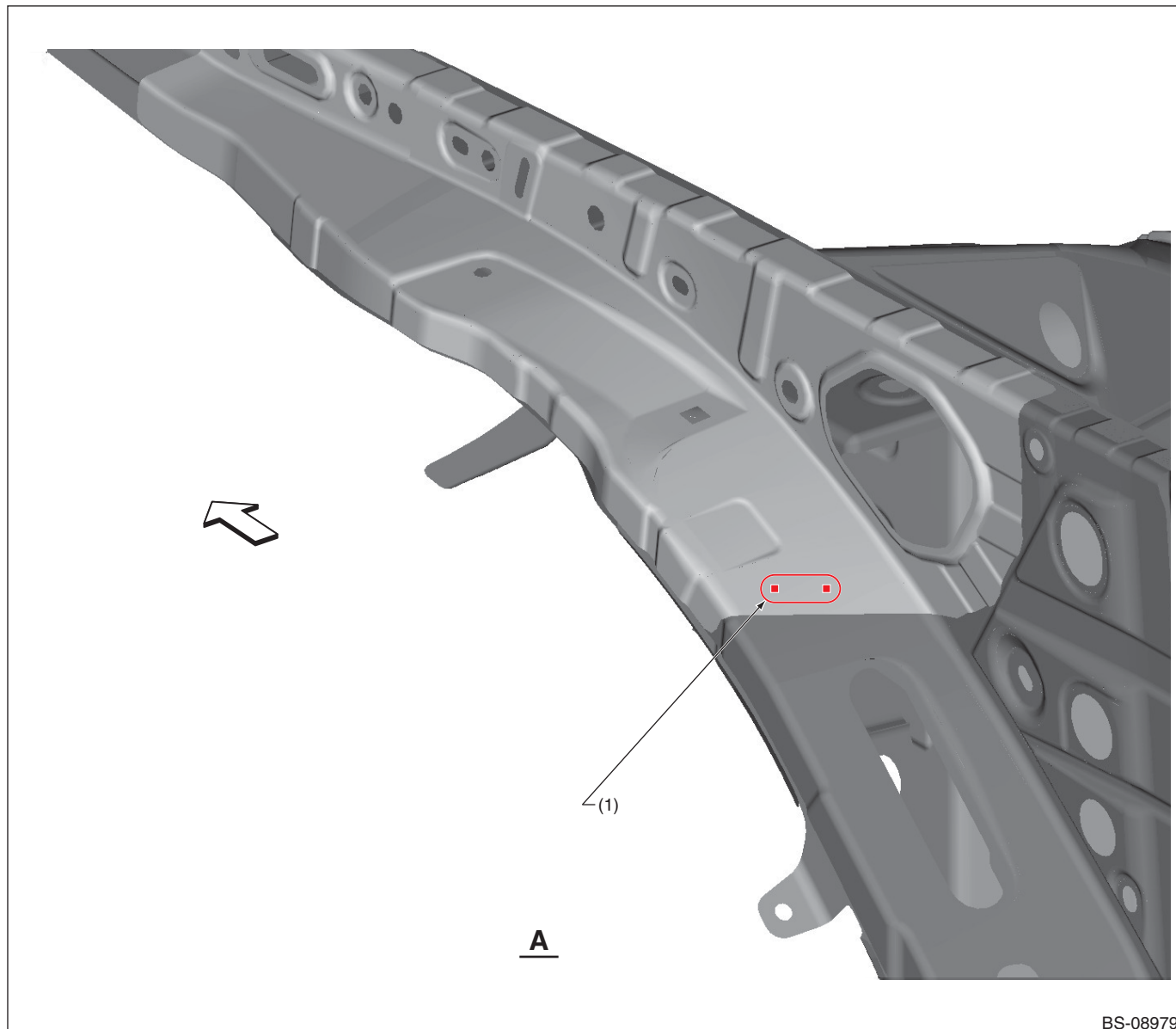
(3) 1 point (Continuous welding)
[20 mm (0.79 in)]

(4) 3 points

(5) 4 points (service)

Panel Replacement

• Views A

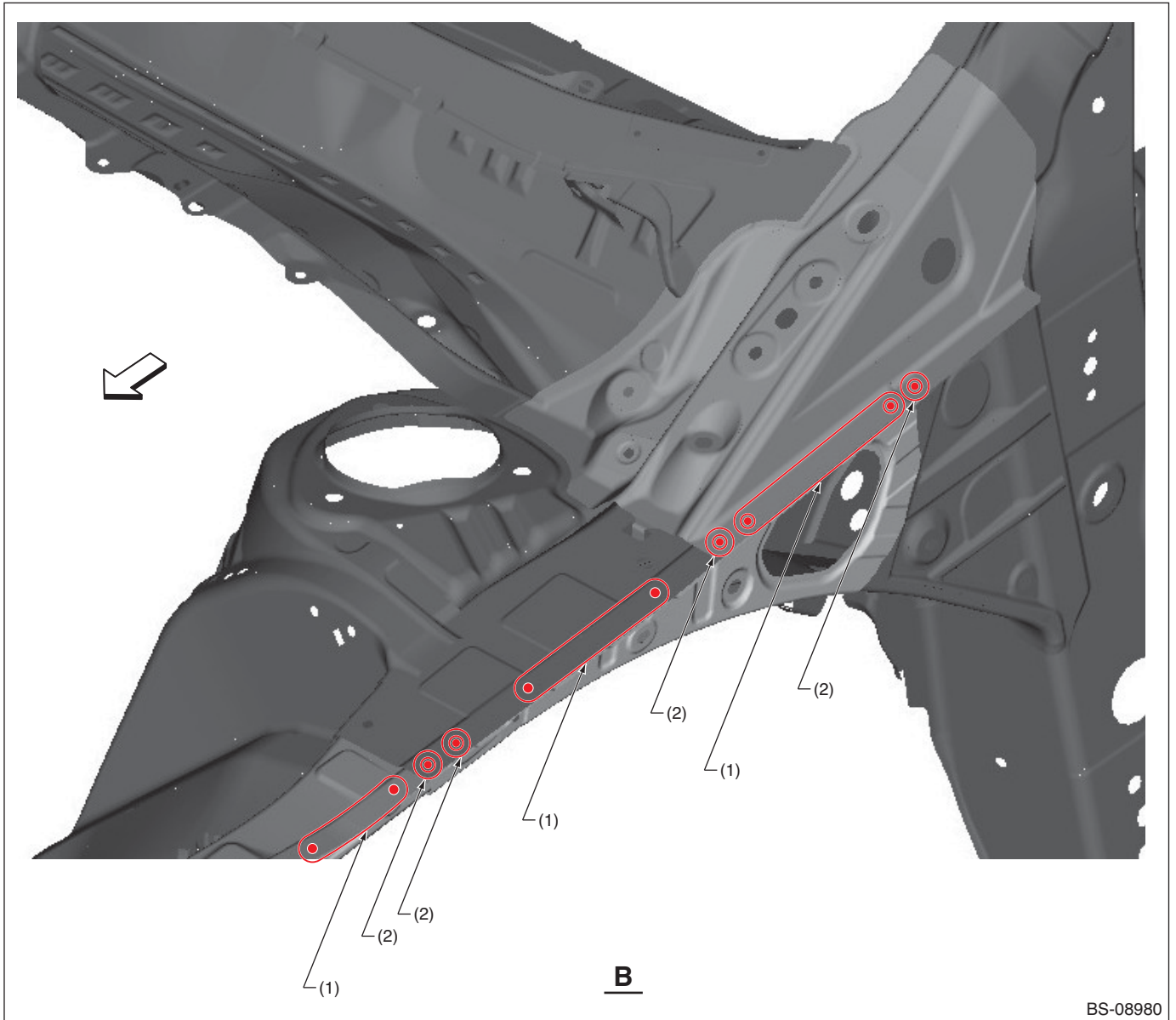


BS-08979

(1) 2 points (service)

Panel Replacement

• Views B



(1) 3 points

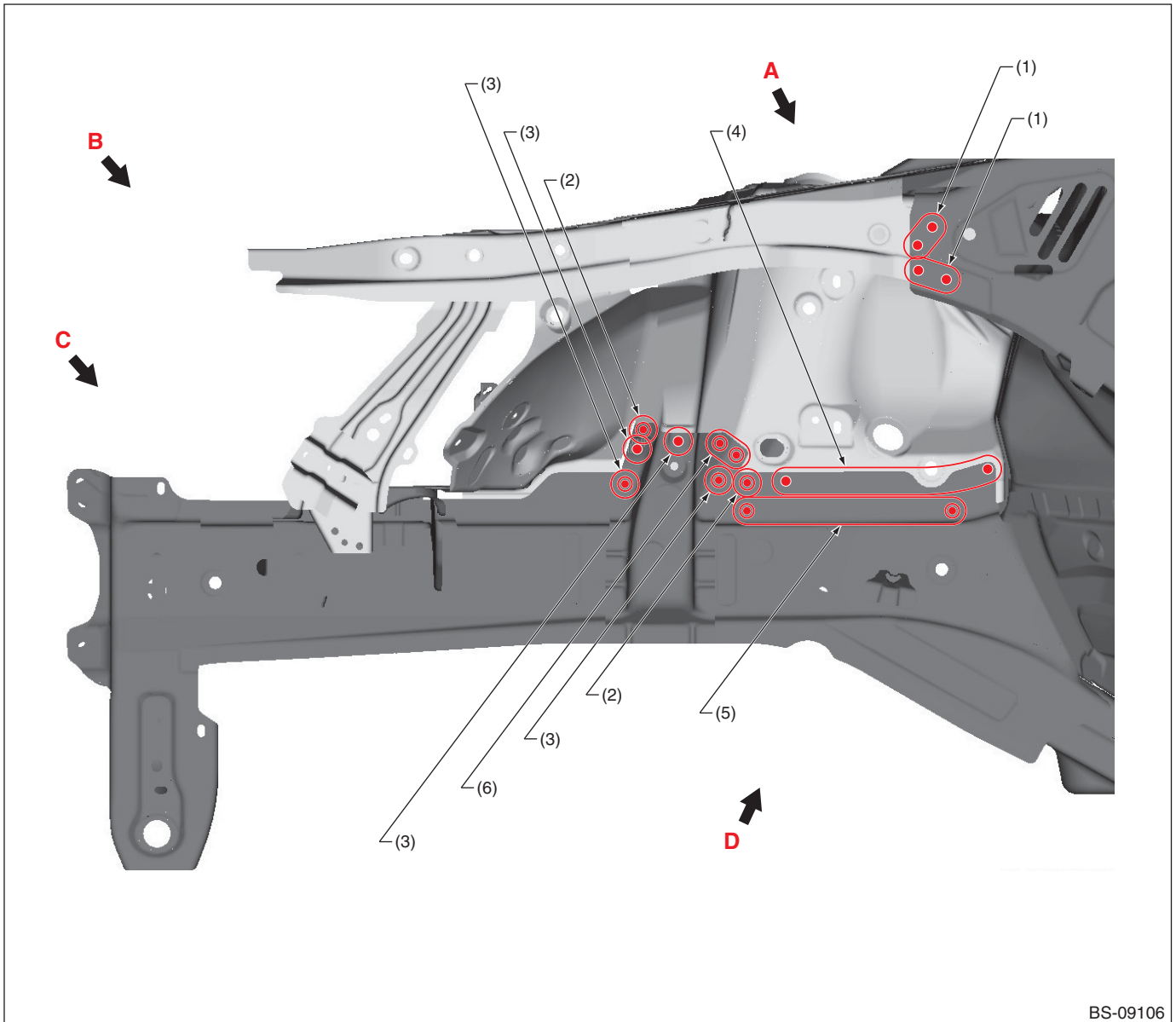
(2) 1 point

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)

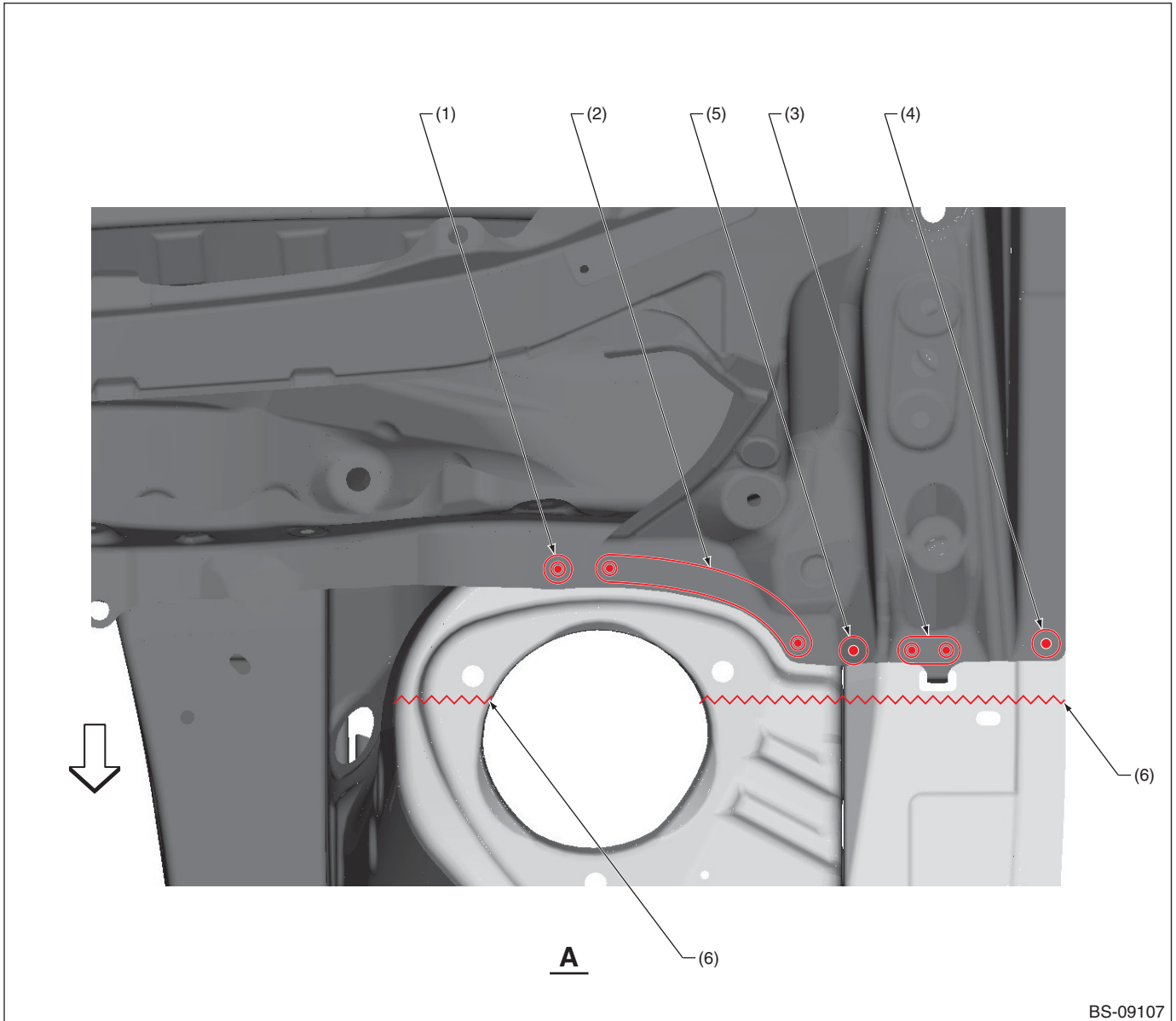
(4) 6 points (inside · 1)

(5) 4 points (inside · 1)

(6) 2 points (inside · 2)

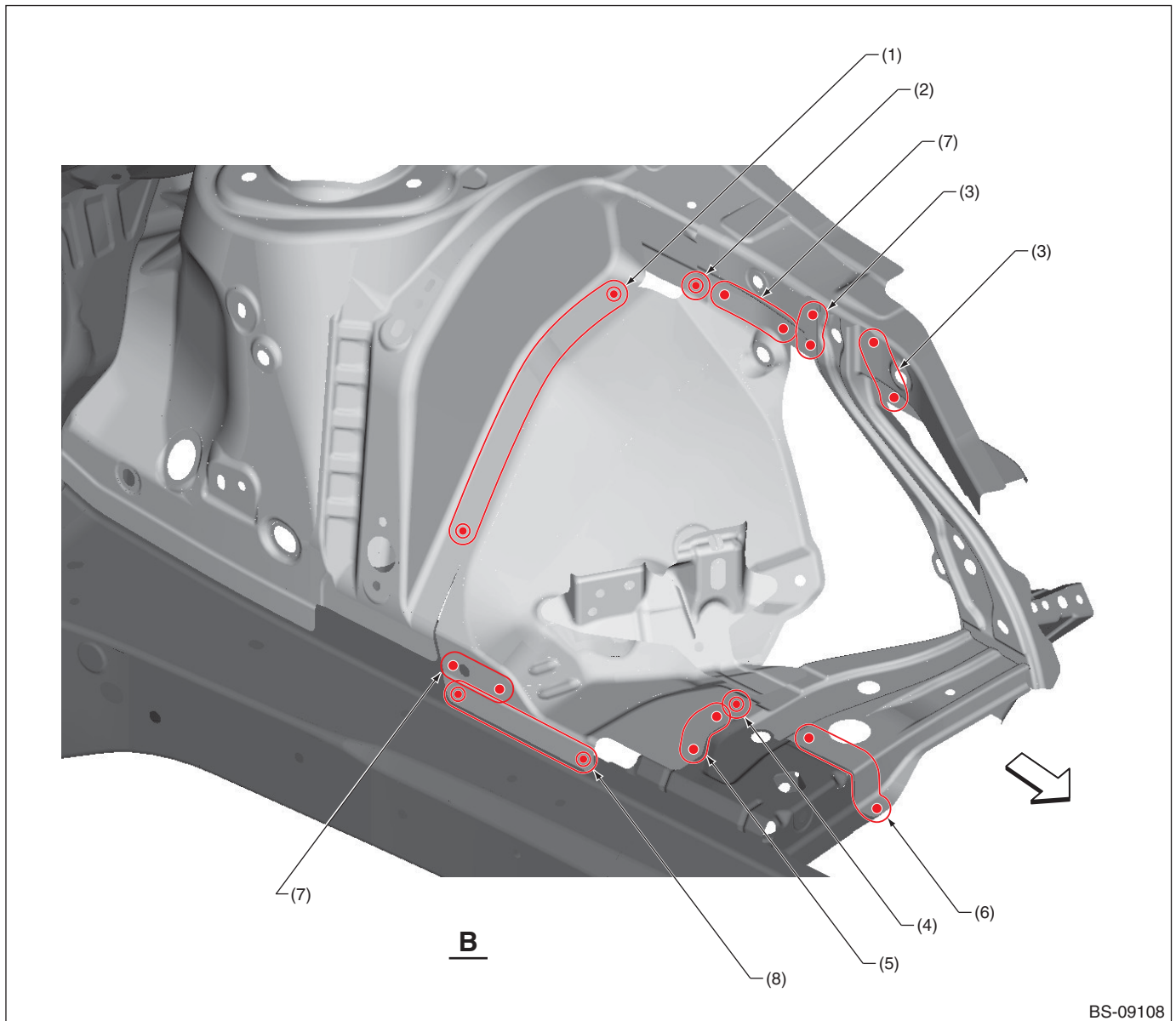
Panel Replacement

• Views A



Panel Replacement

• Views B (LH)



BS-09108

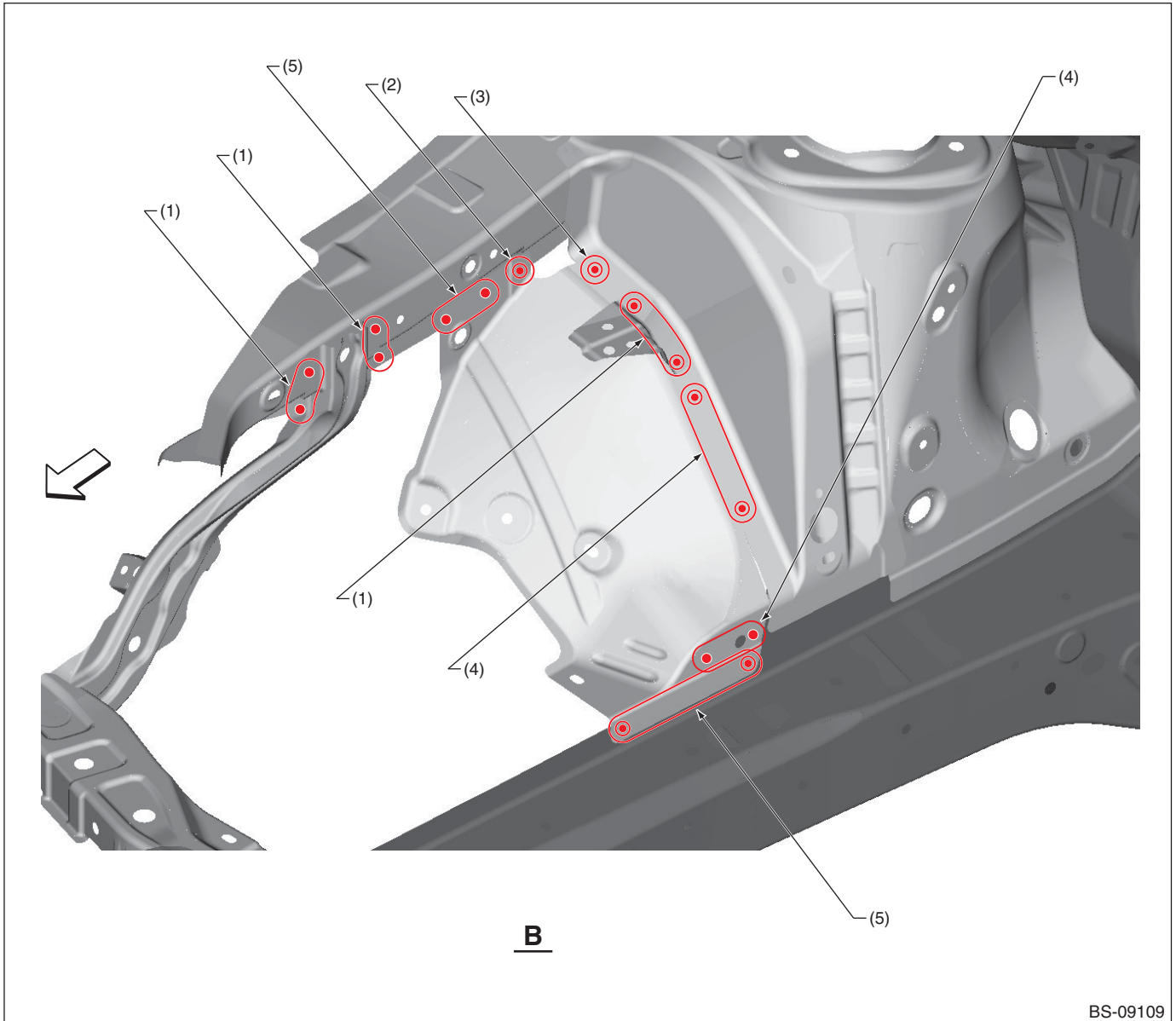
- (1) 5 points (top · 1)
- (2) 1 point (inside · 1)
- (3) 2 points (inside · 1)

- (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)



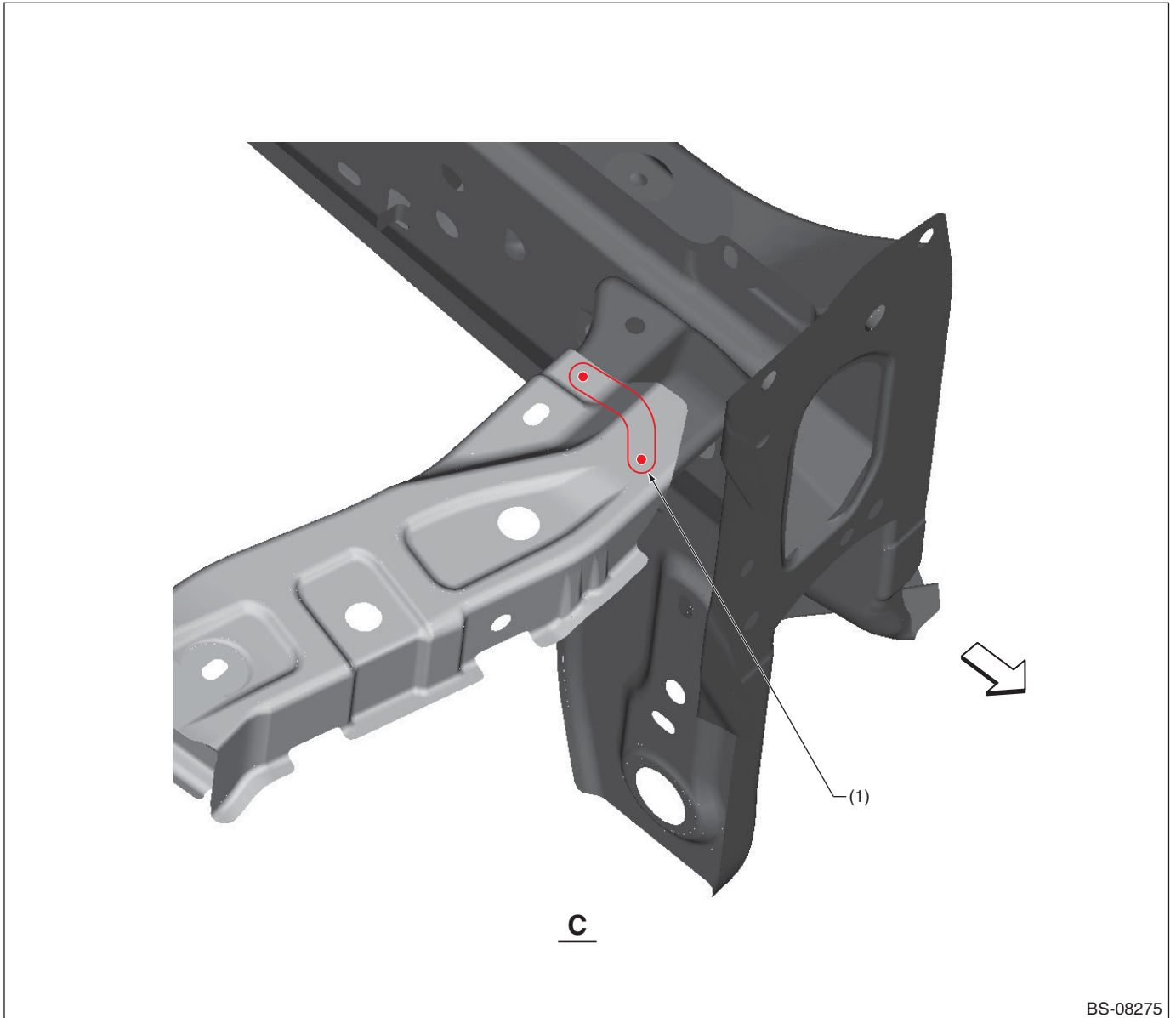
(1) 2 points (inside · 1)
(2) 1 point (inside · 1)

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

(5) 4 points (inside · 1)

Panel Replacement

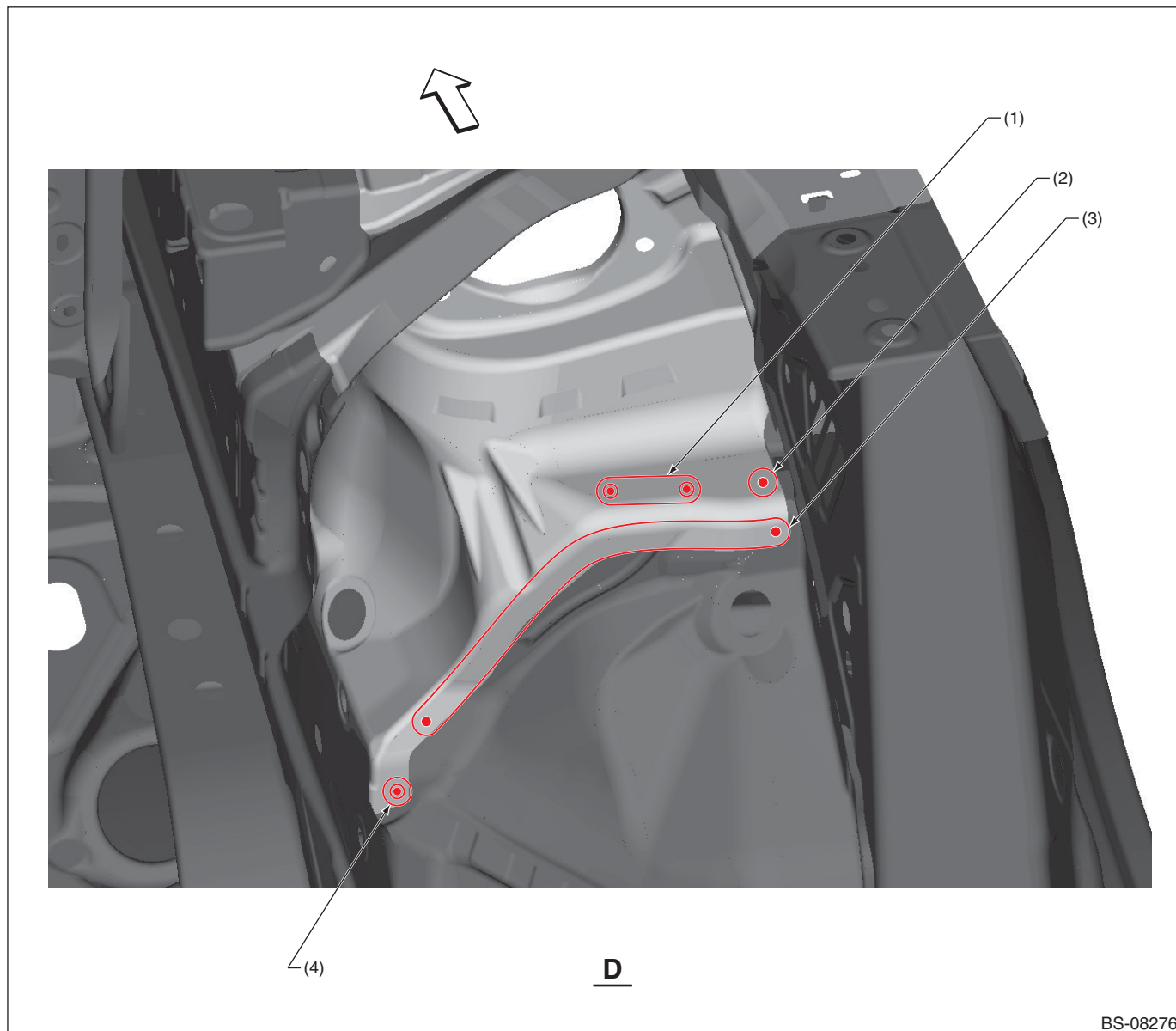
- Views C (RH only)



(1) 3 points (top - 1)

Panel Replacement

• Views D



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

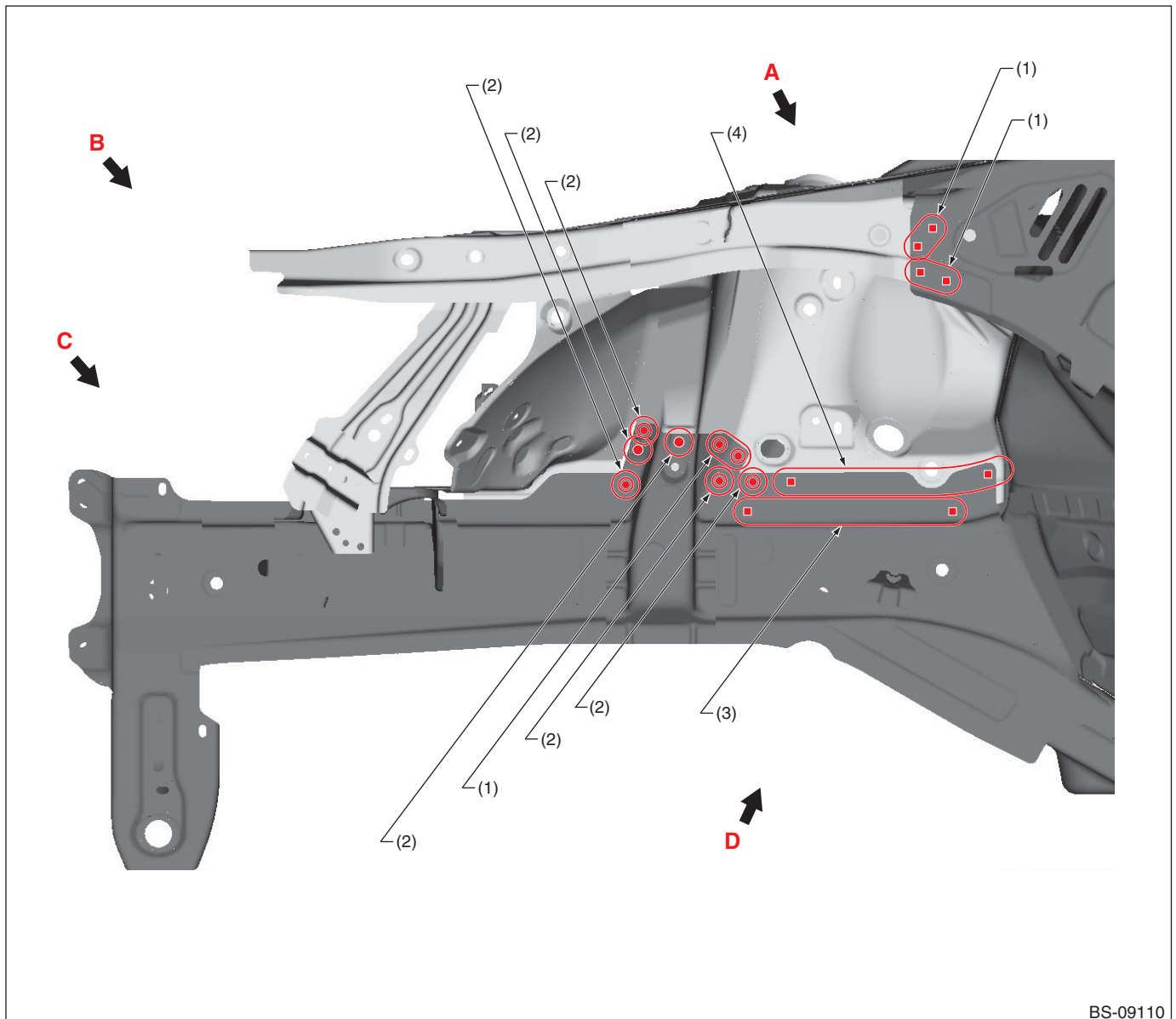
(3) 8 points (outside · 1)

(4) 1 point (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09110

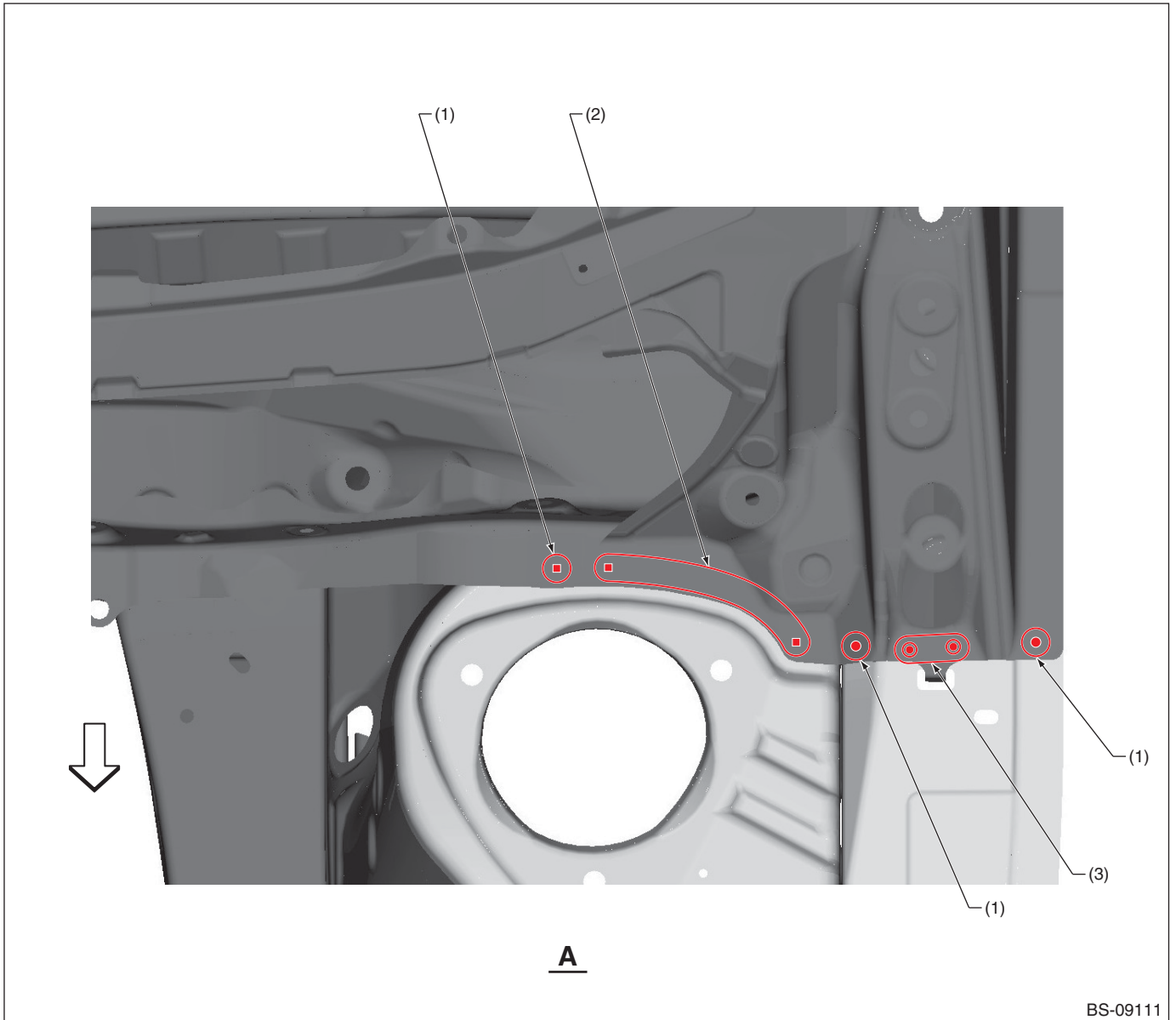
- (1) 2 points
- (2) 1 point

- (3) 4 points (service)

- (4) 6 points (service)

Panel Replacement

• Views A



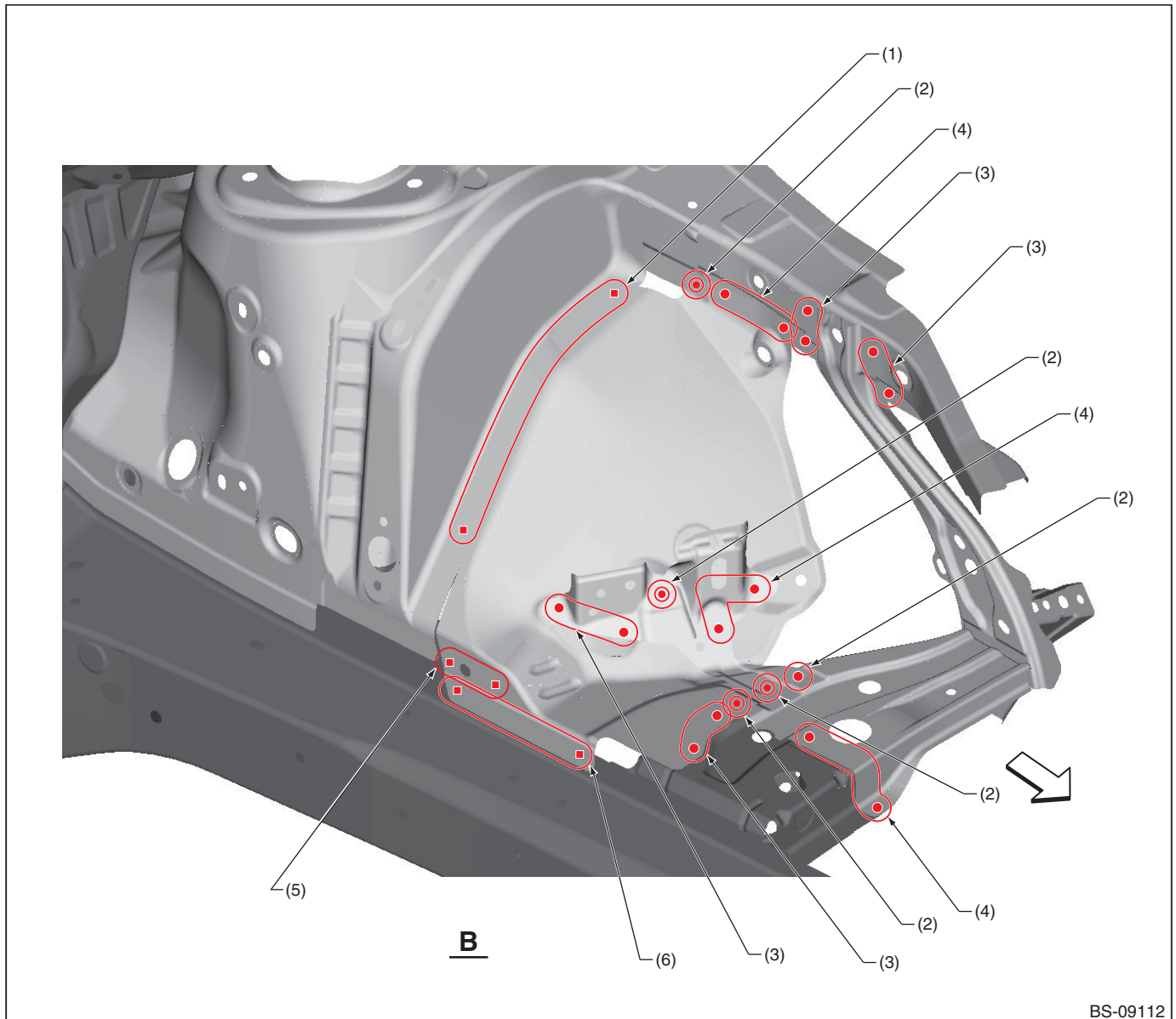
(1) 1 point

(2) 4 points

(3) 2 points

Panel Replacement

• Views B (LH)



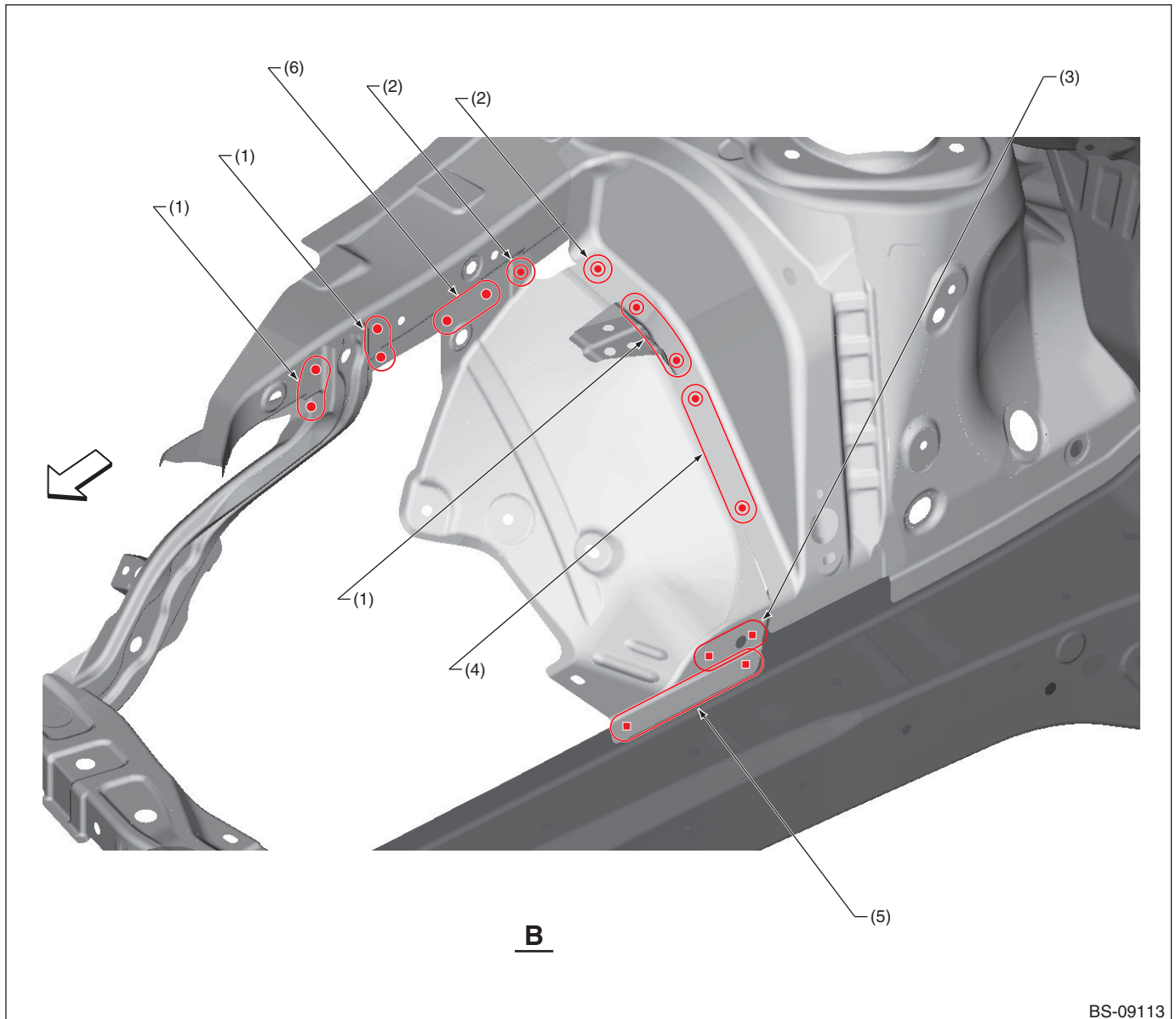
(1) 5 points (service)
(2) 1 point

(3) 2 points
(4) 3 points

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

Panel Replacement

• Views B (RH)



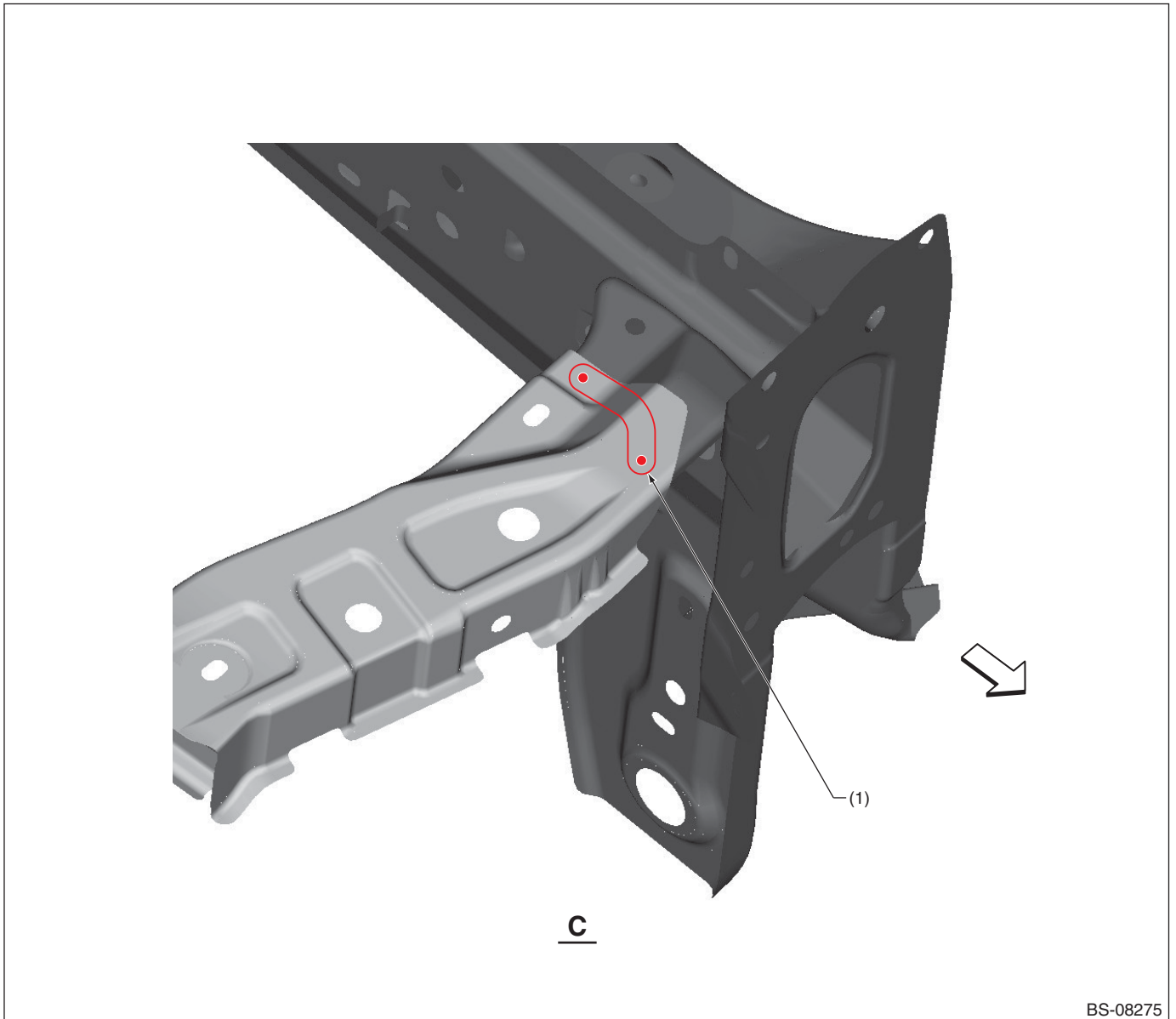
(1) 2 points
(2) 1 point

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

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

Panel Replacement

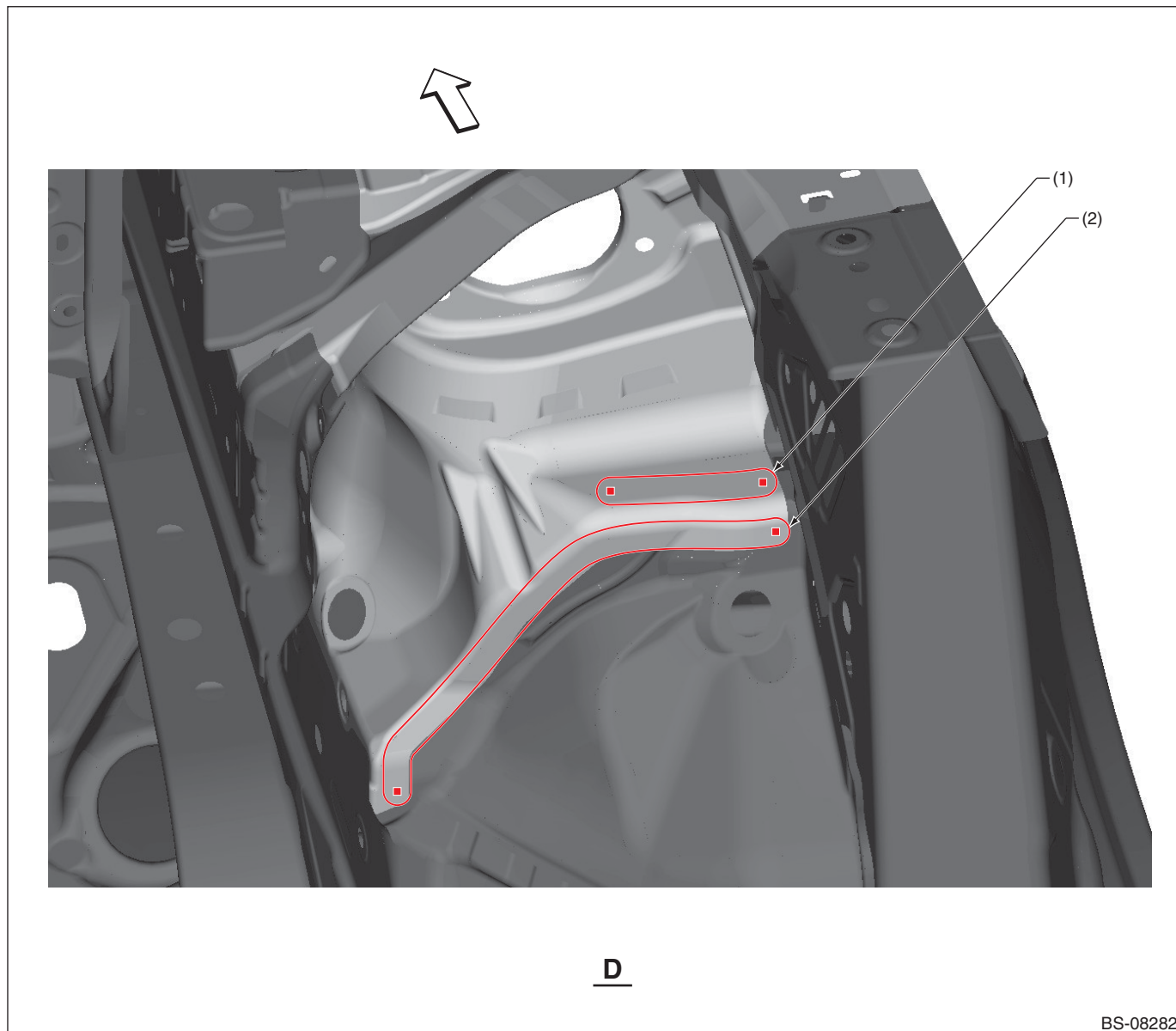
- Views C (RH)



(1) 3 points

Panel Replacement

• Views D



(1) 4 points (service)

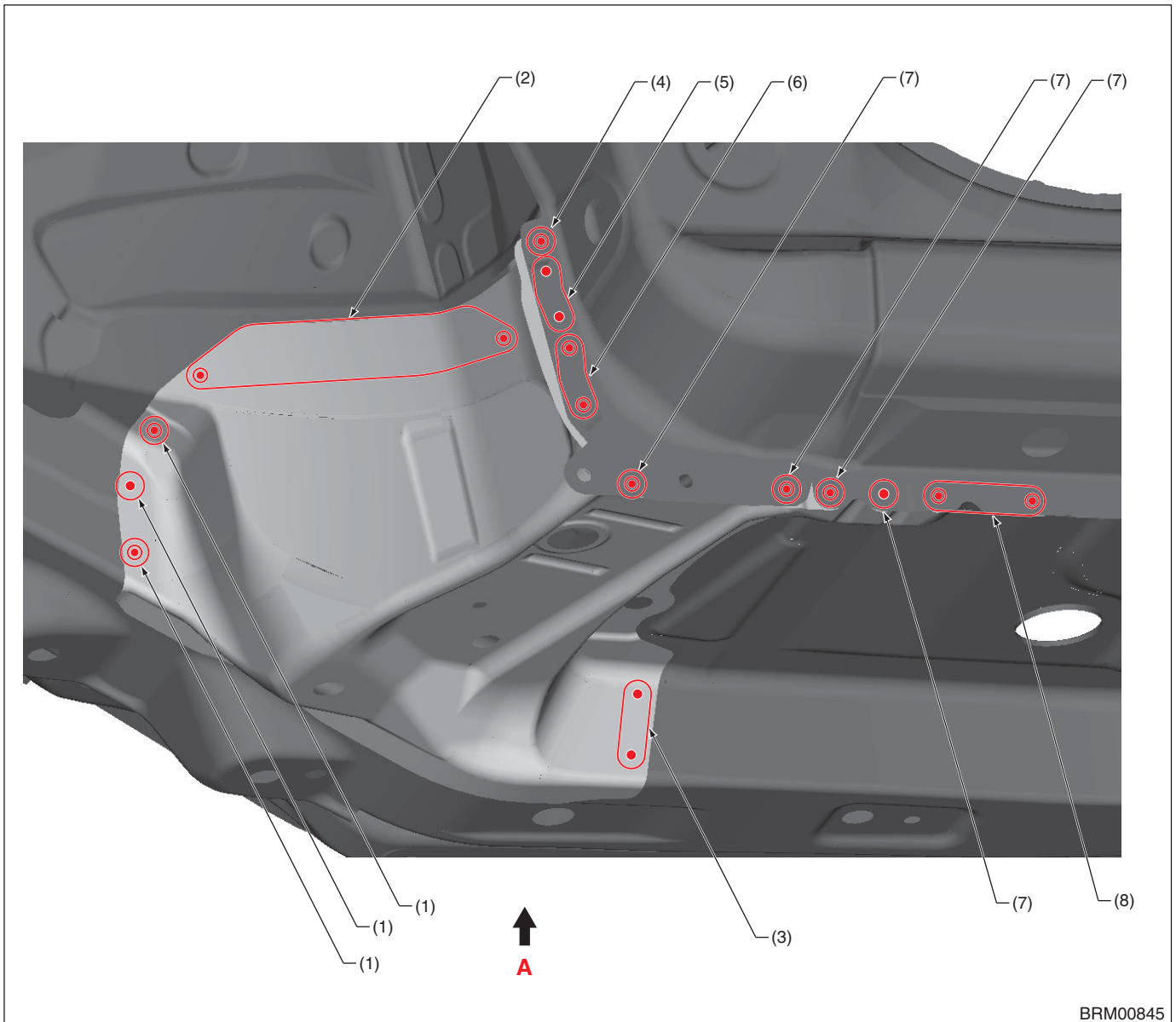
(2) 9 points (service)

Panel Replacement

8-5. Toe Board Reinforcement (total replacement)

A: REMOVAL

• Overall view (— '18MY)



BRM00845

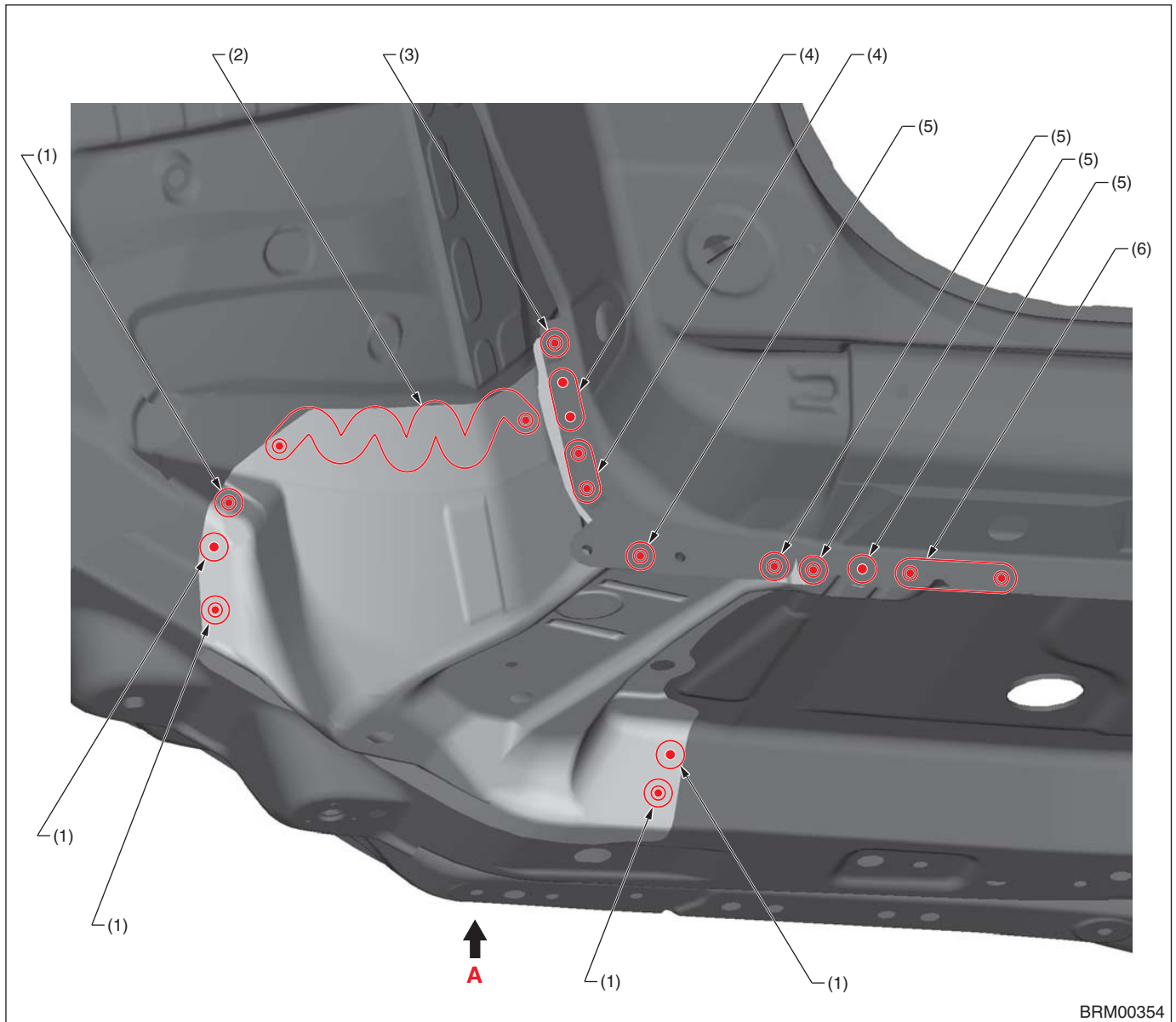
- (1) 1 point (outside · 1)
- (2) 9 points (outside · 1)
- (3) 2 points (outside · 1)

- (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

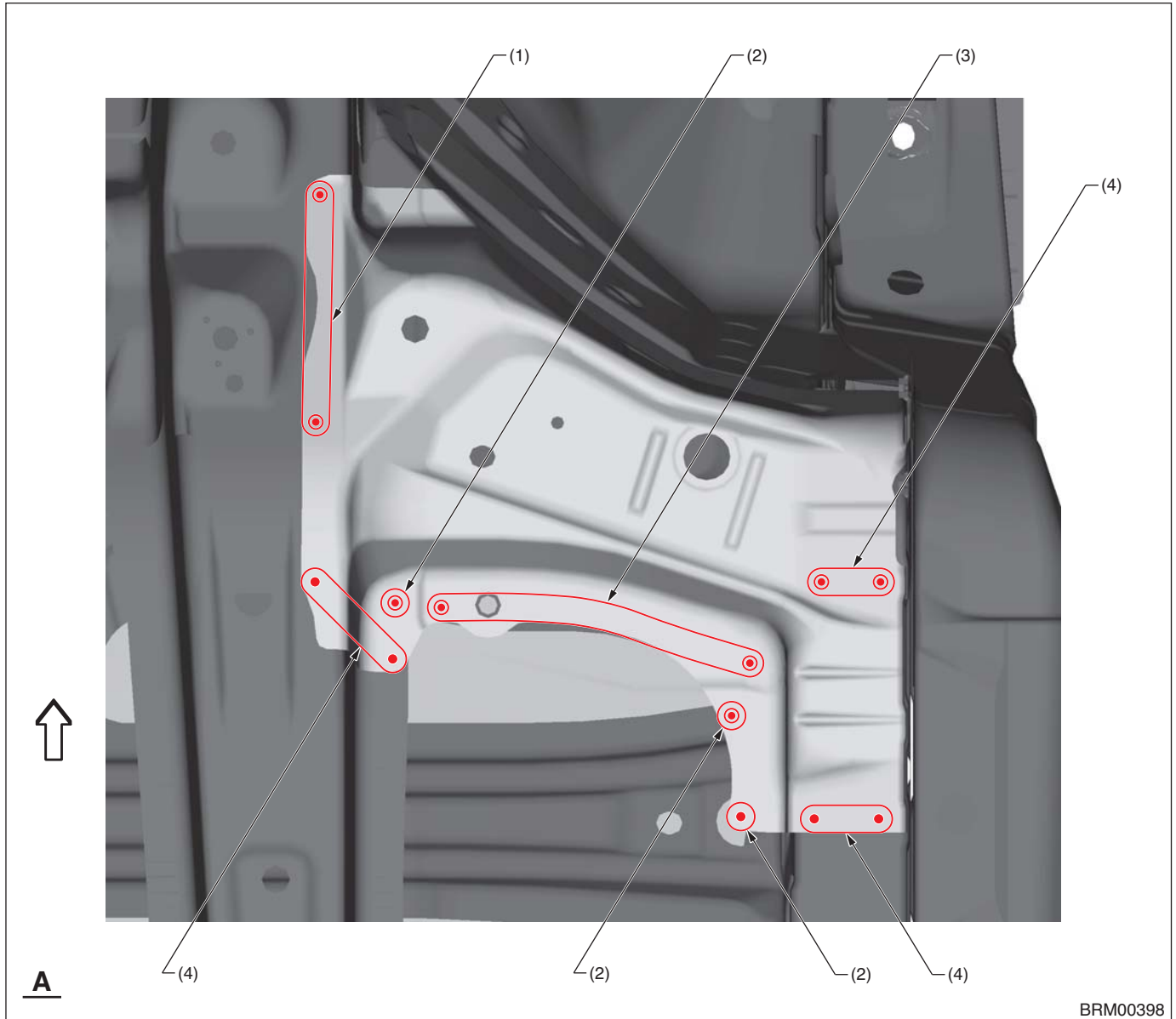
(1) 1 point (outside · 1)
(2) 9 points (outside · 1)

(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)

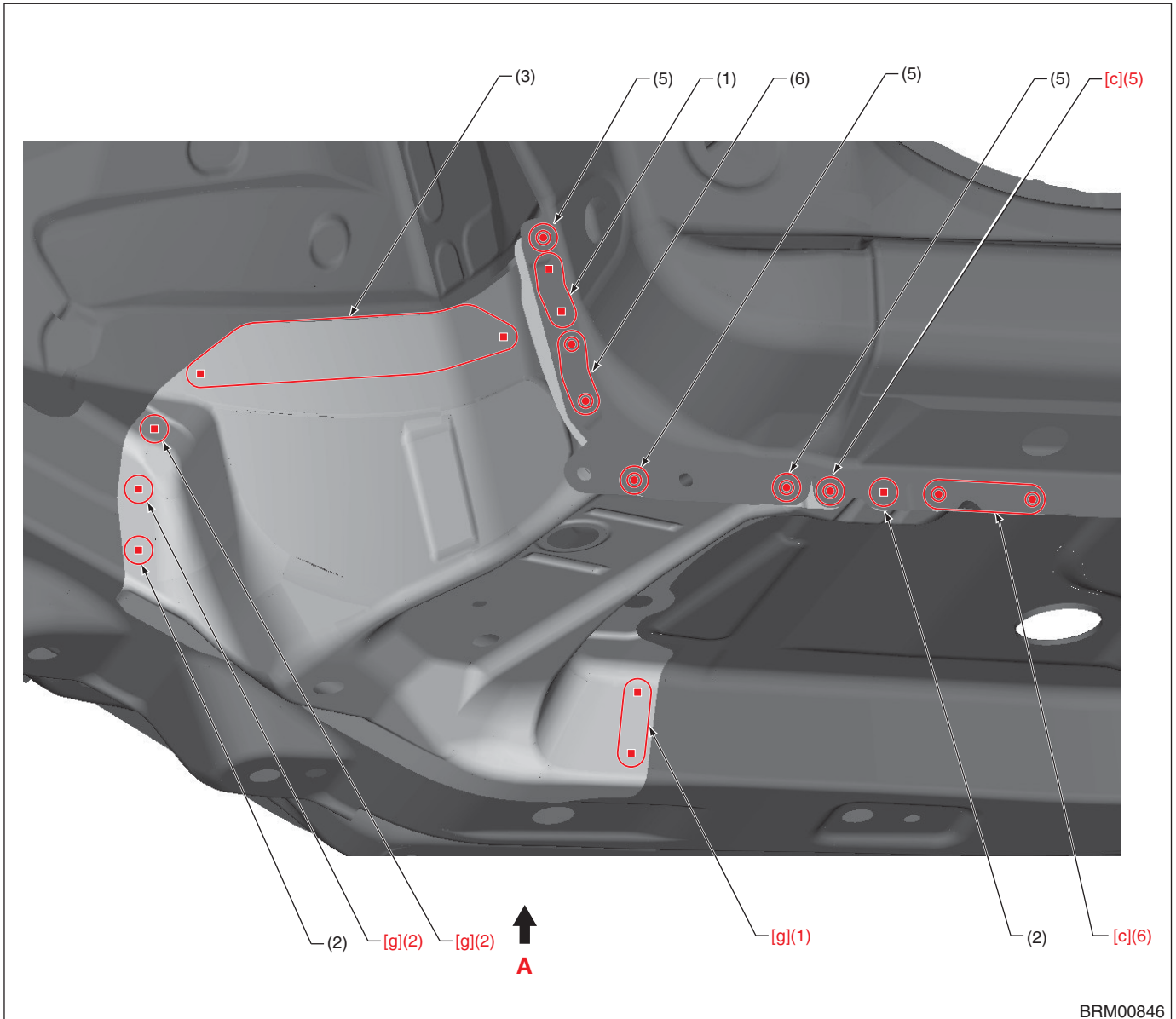
(3) 5 points (bottom · 1)

(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

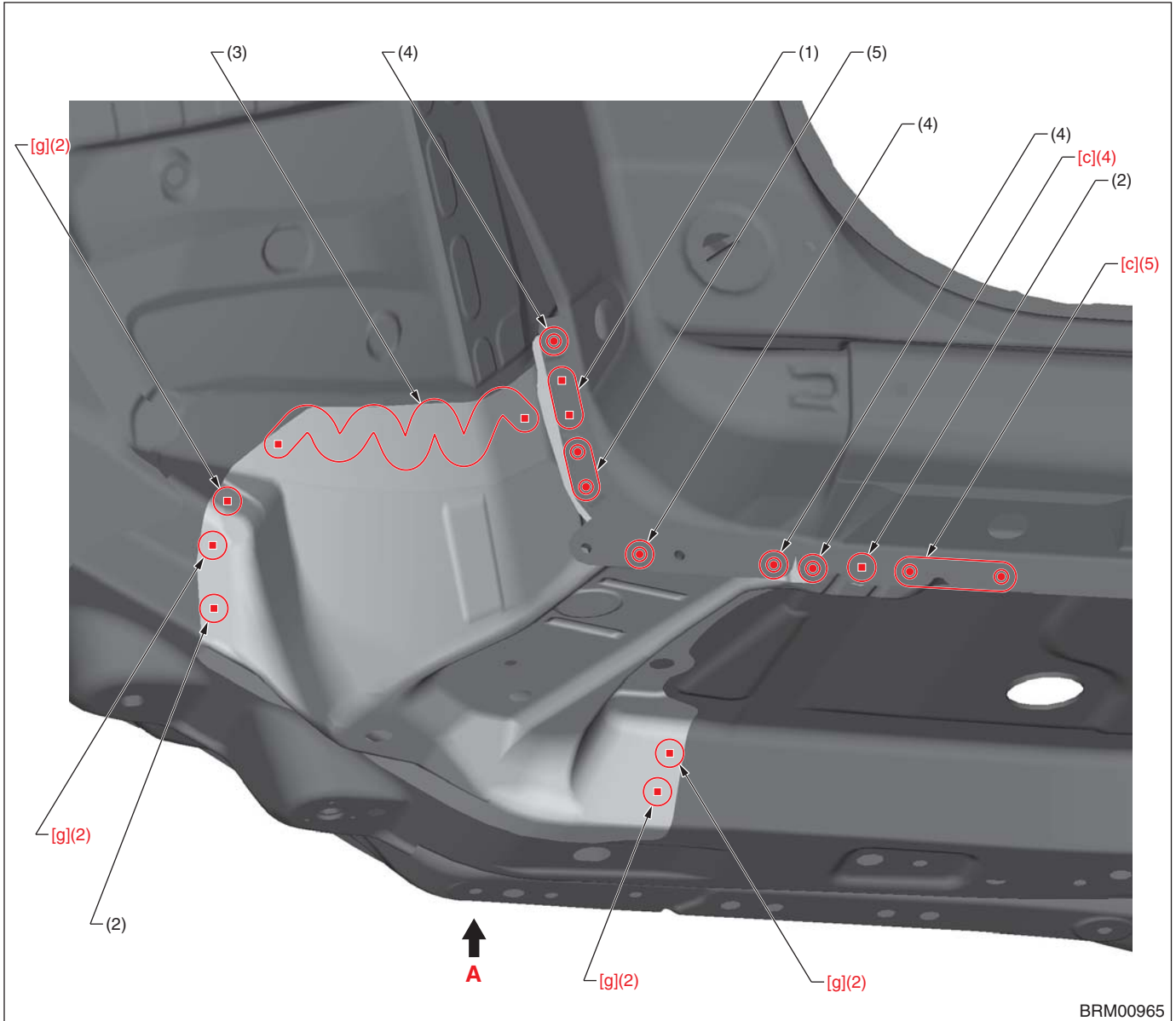
(5) 1 point

(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 —)



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

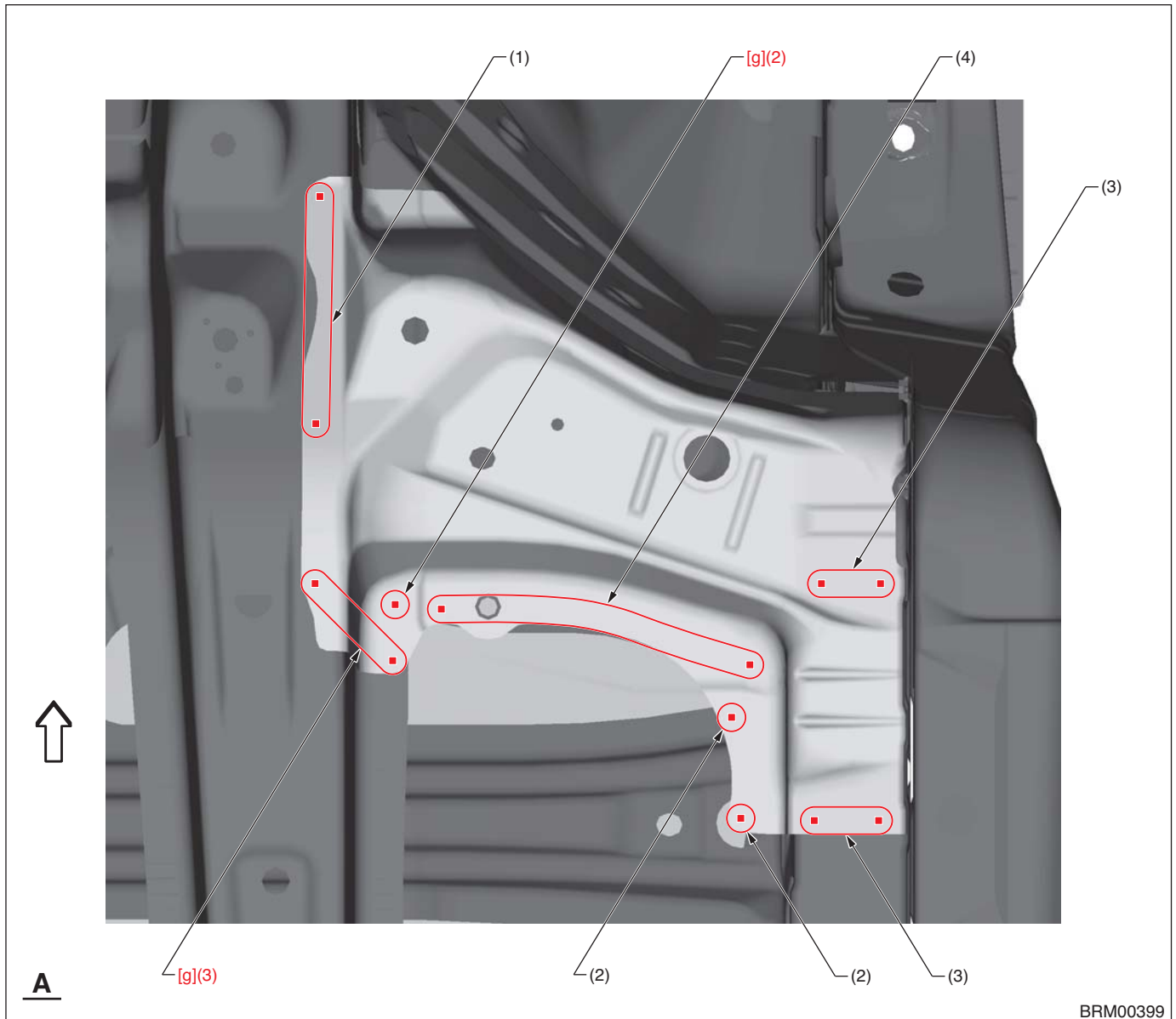
(3) 9 points (service)
(4) 1 point

(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: CO2

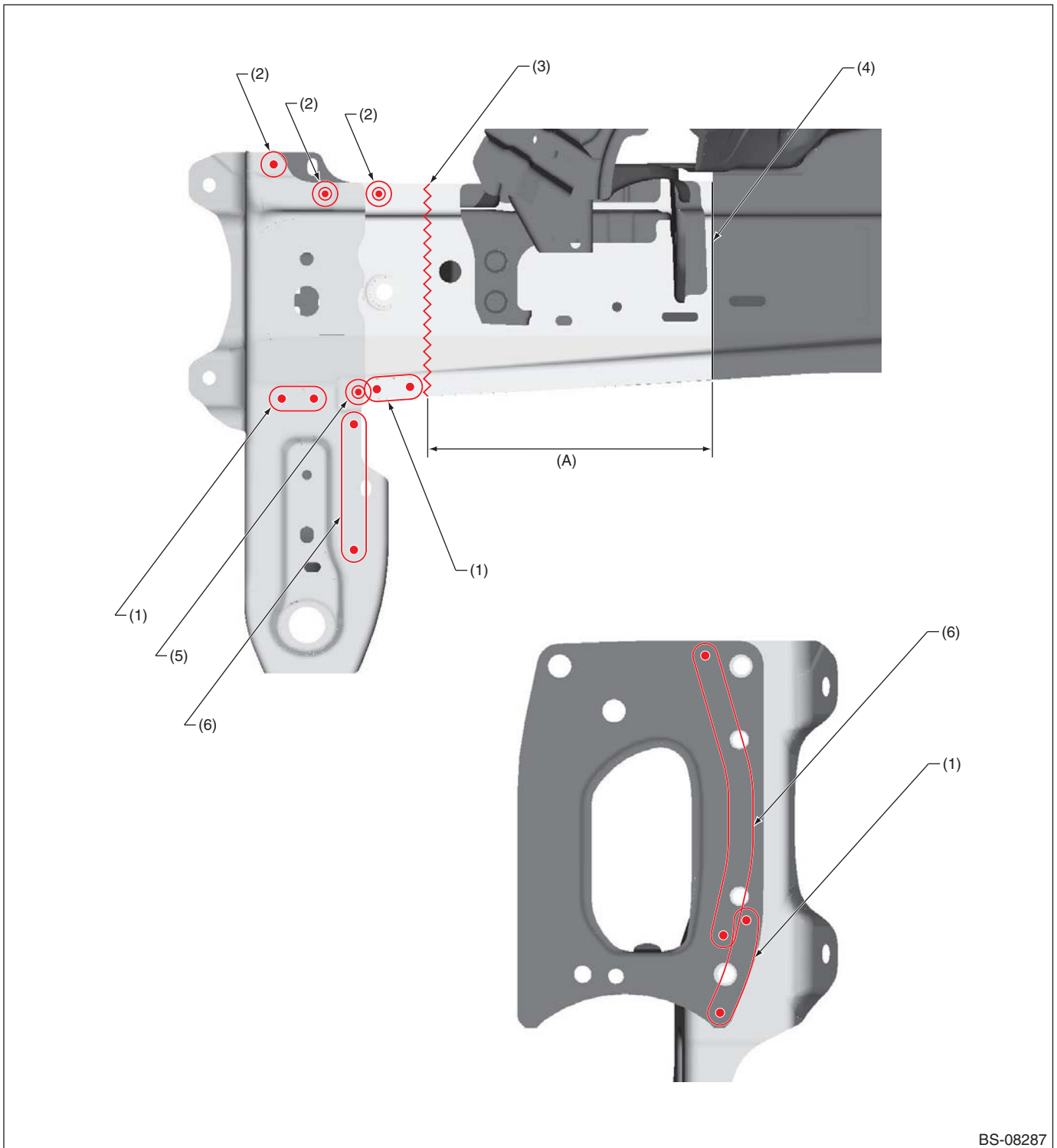
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

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

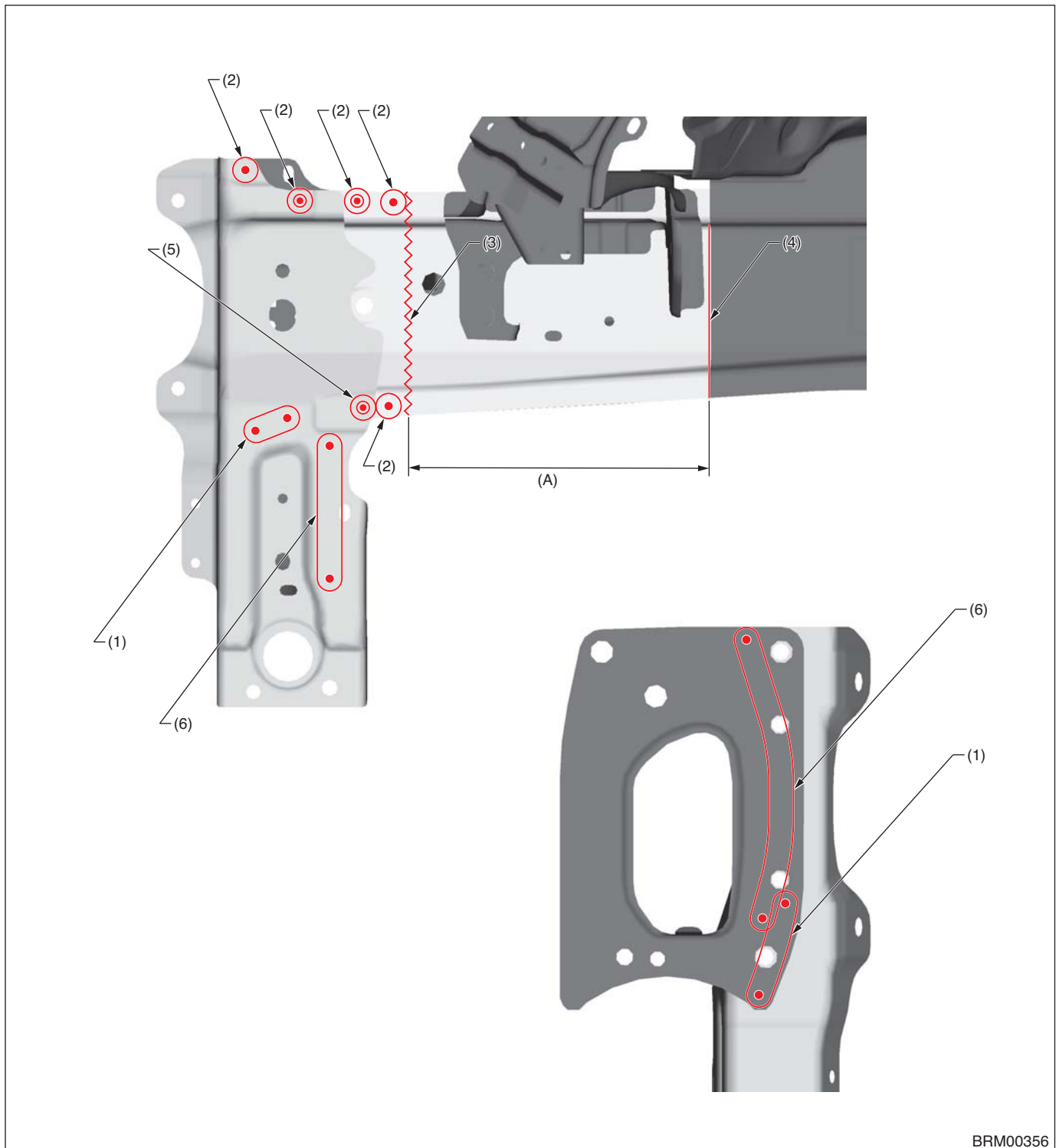
(4) Tailored line

(5) 1 point (outside - 2)

(6) 4 points (outside - 1)

Panel Replacement

• Overall view (Hybrid model)



BRM00356

(A) 210 mm [8.27 in]

(1) 2 points (outside · 1)

(2) 1 point (outside · 1)

(3) Cut position

(4) Tailored line

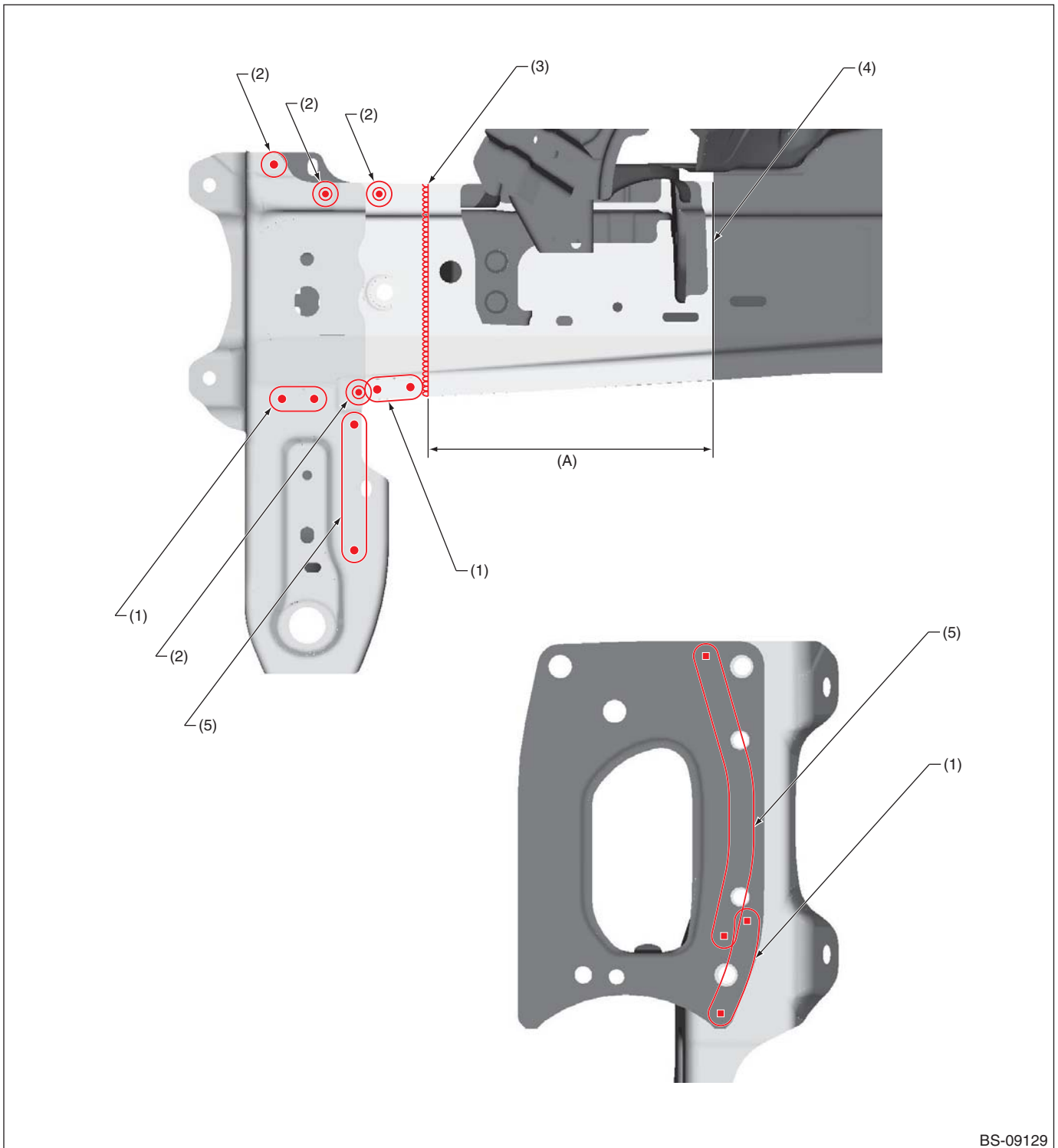
(5) 1 point (outside · 2)

(6) 4 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view (Gasoline model)



BS-09129

(A) 210 mm [8.27 in]

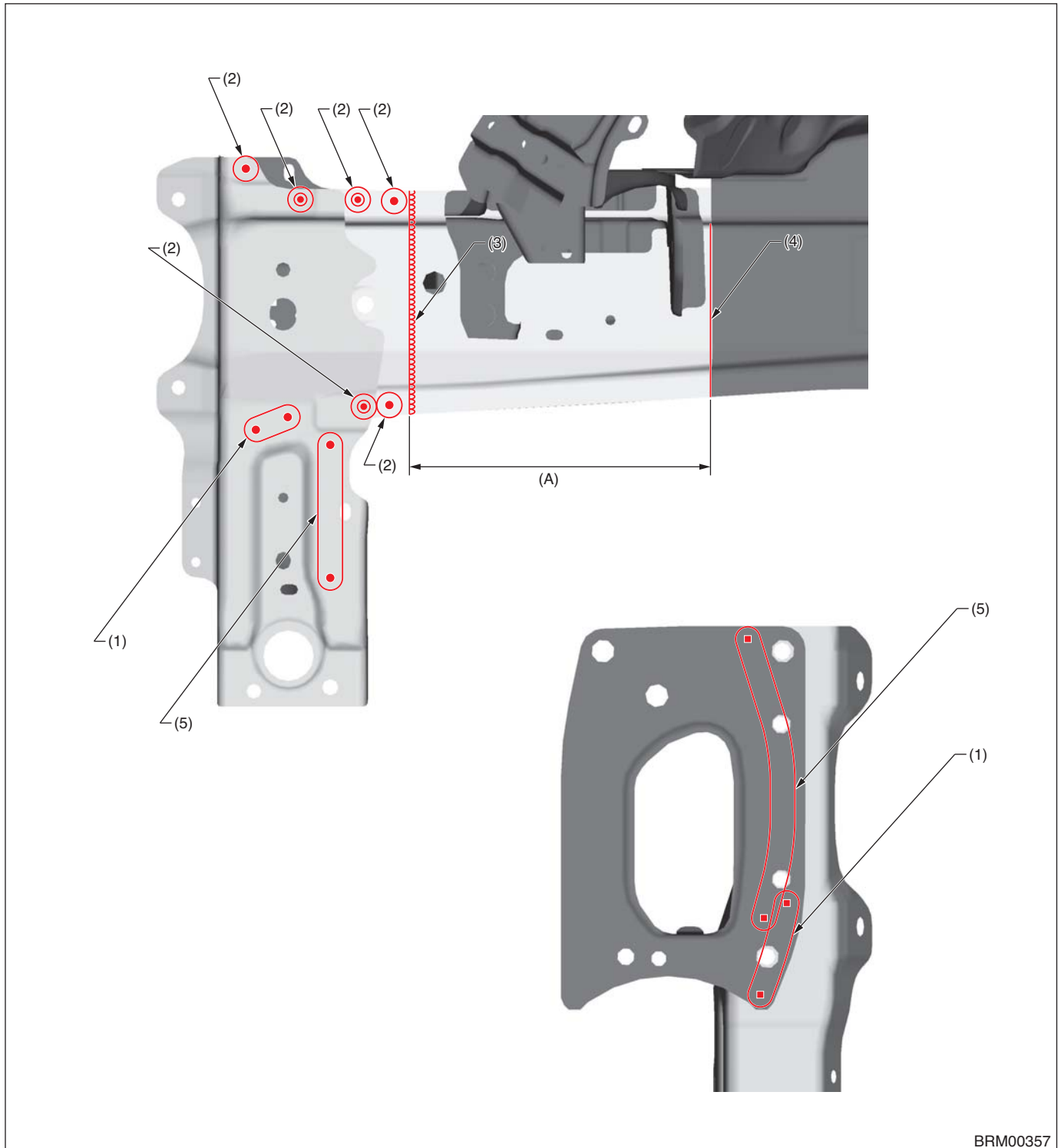
(1) 2 points
(2) 1 point

(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

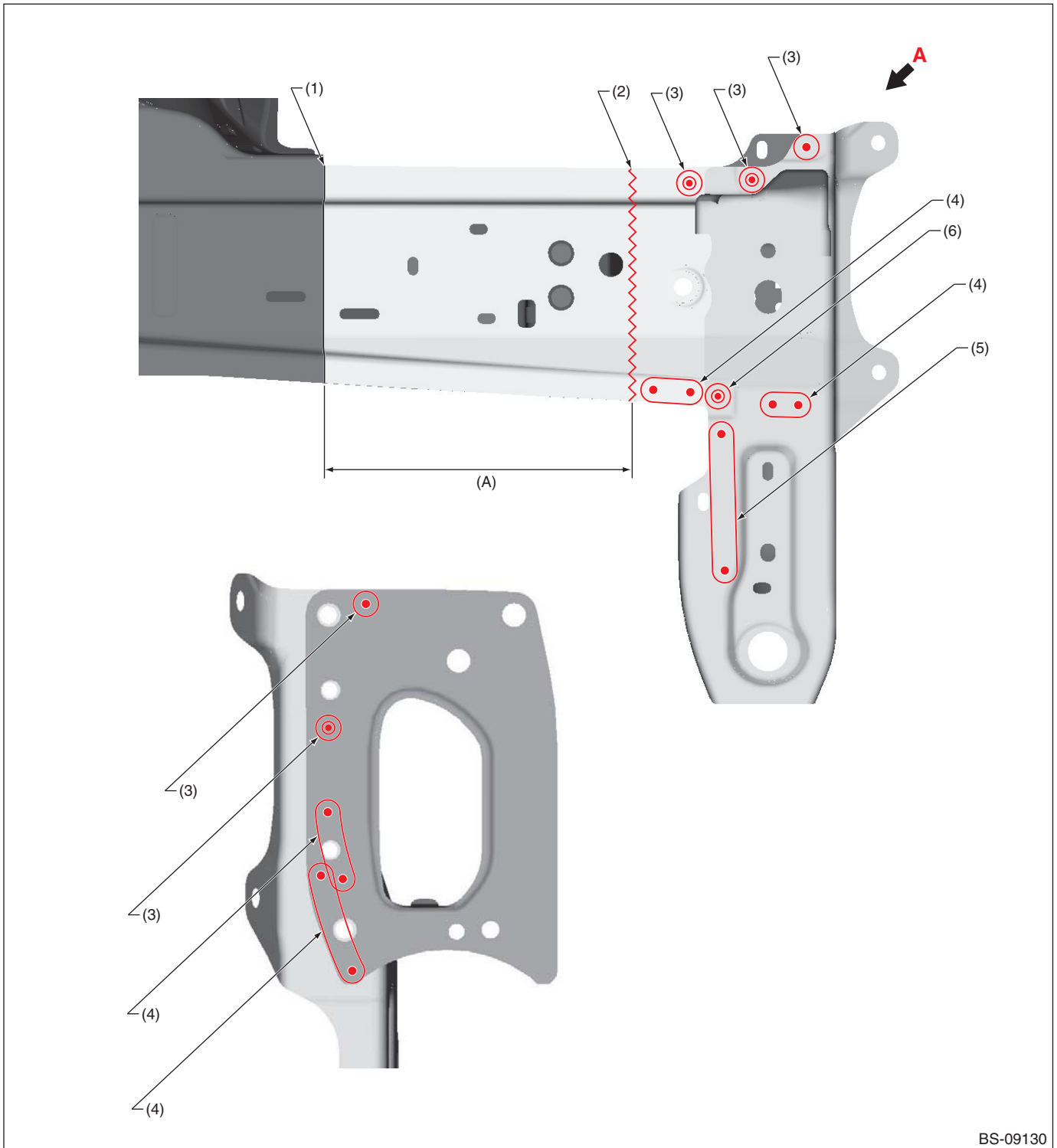
(5) 4 points

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]

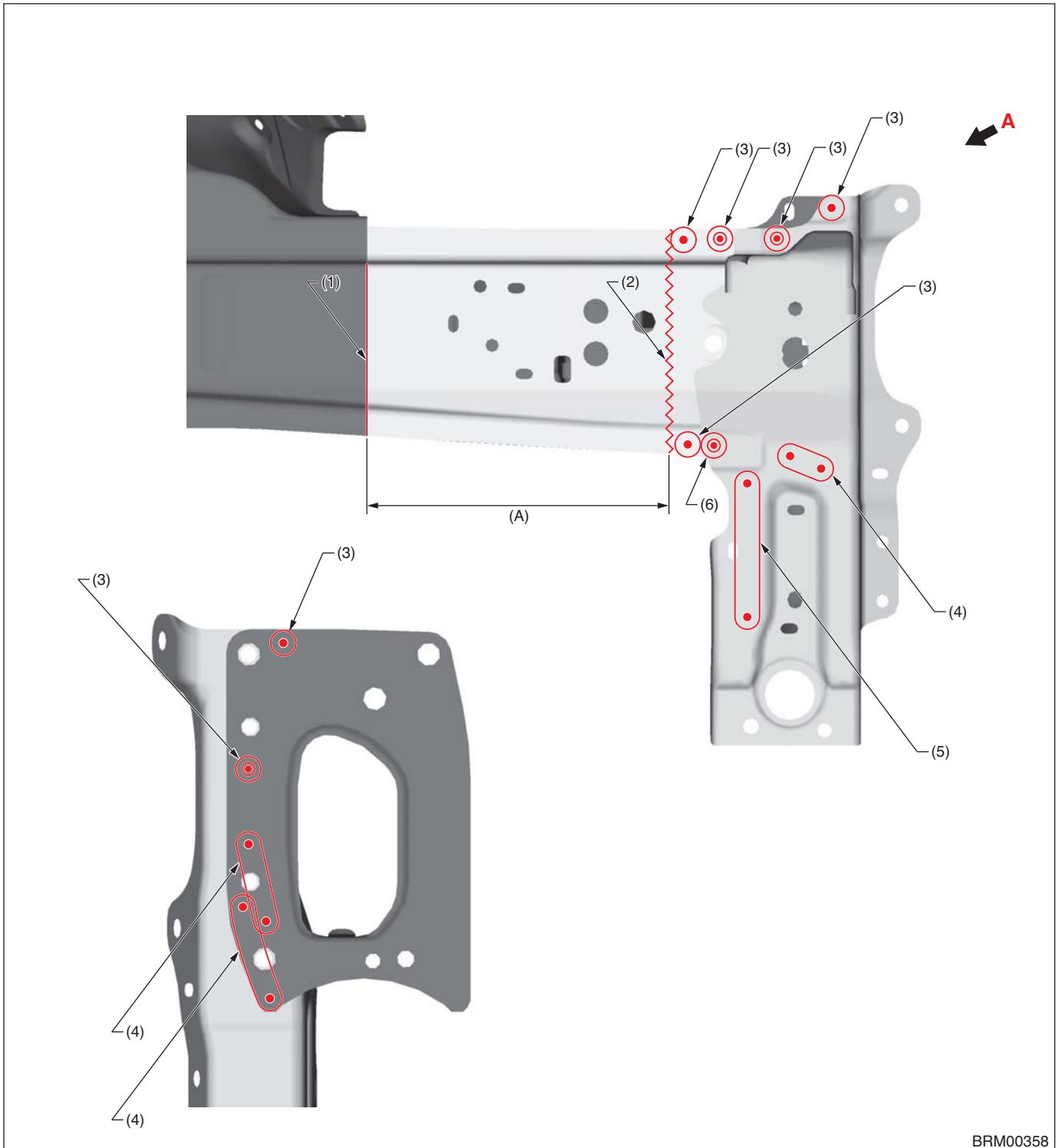
- (1) Tailored line
- (2) Cut position

- (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]

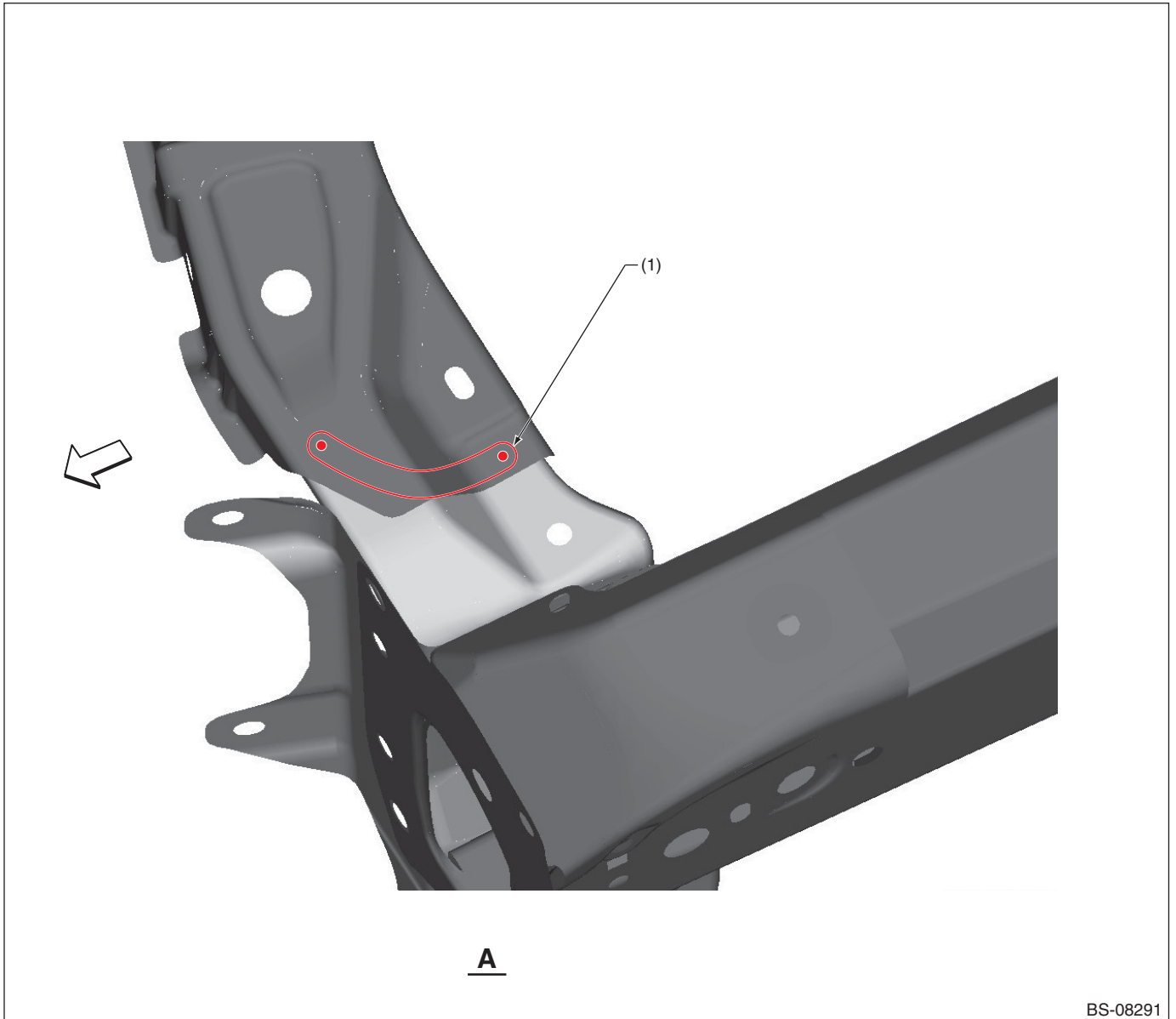
(1) Tailored line
(2) Cut position

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

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

Panel Replacement

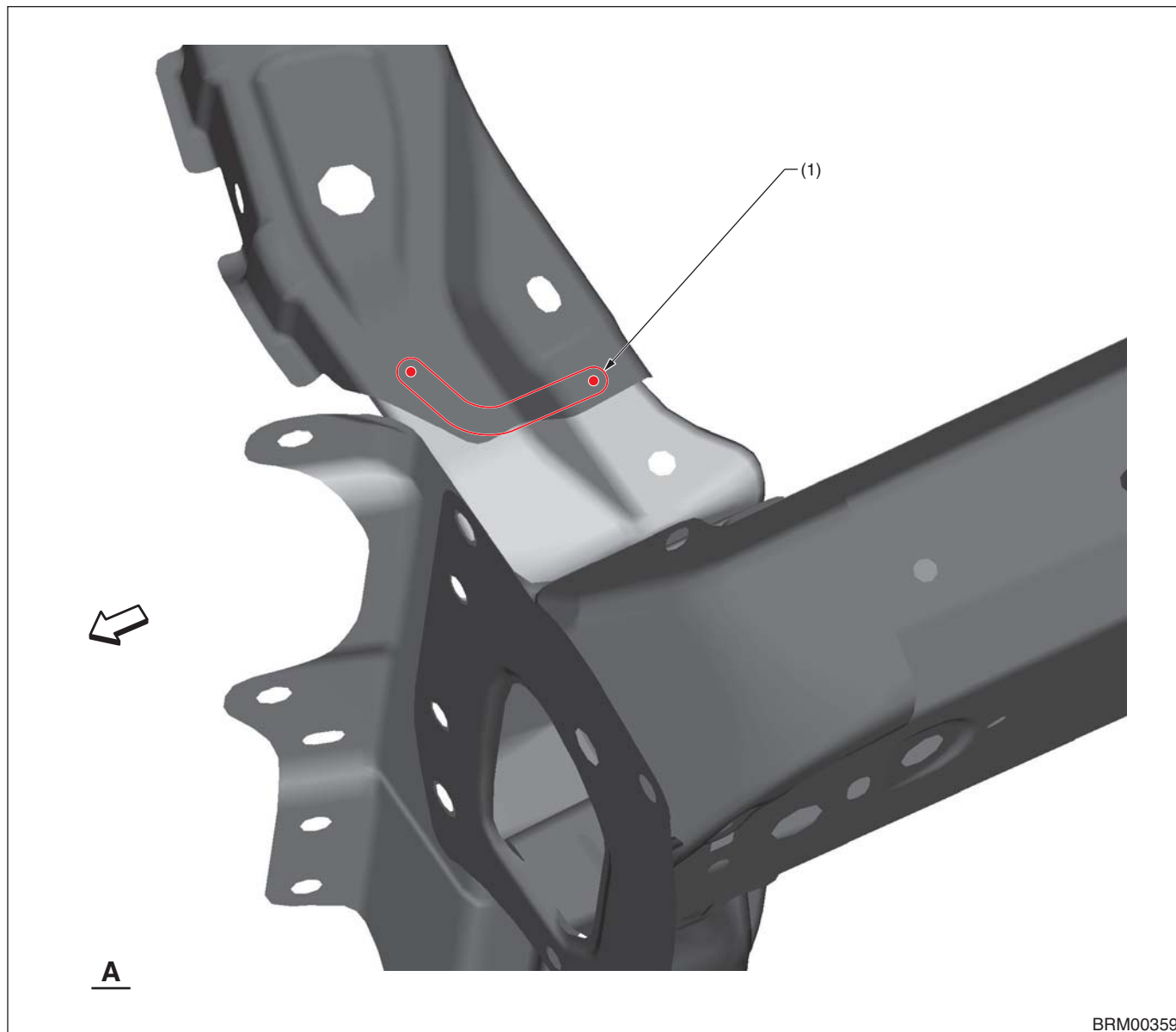
- Views A (Gasoline model)



(1) 3 points (top · 1)

Panel Replacement

- Views A (Hybrid model)

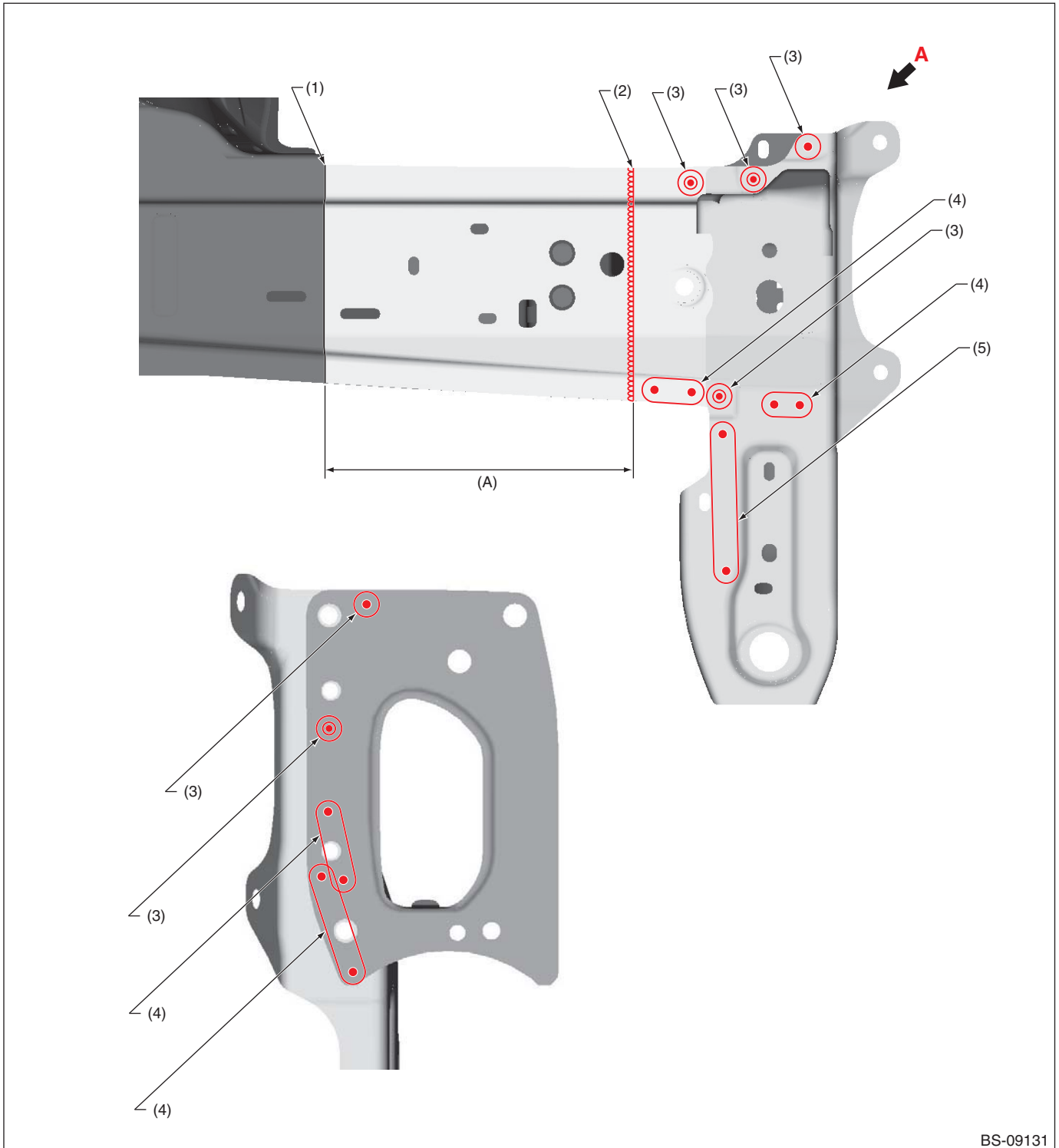


(1) 3 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view (Gasoline model)



BS-09131

(A) 210 mm [8.27 in]

(1) Tailored line

(2) 1 point (Continuous welding)

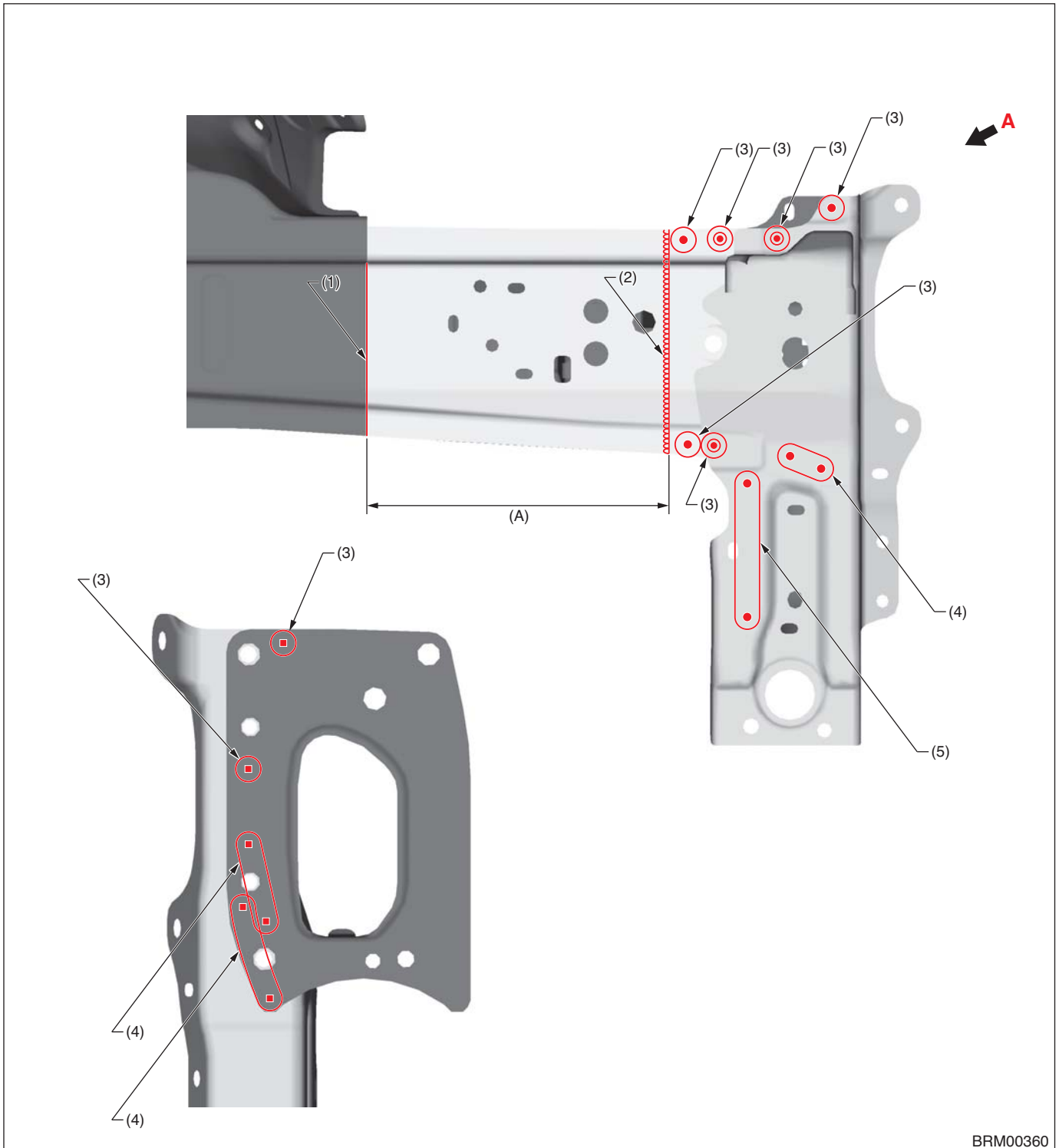
(3) 1 point

(4) 2 points

(5) 4 points

Panel Replacement

• Overall view (Hybrid model)



BRM00360

(A) 210 mm [8.27 in]

(1) Tailored line

(2) 1 point (Continuous welding)

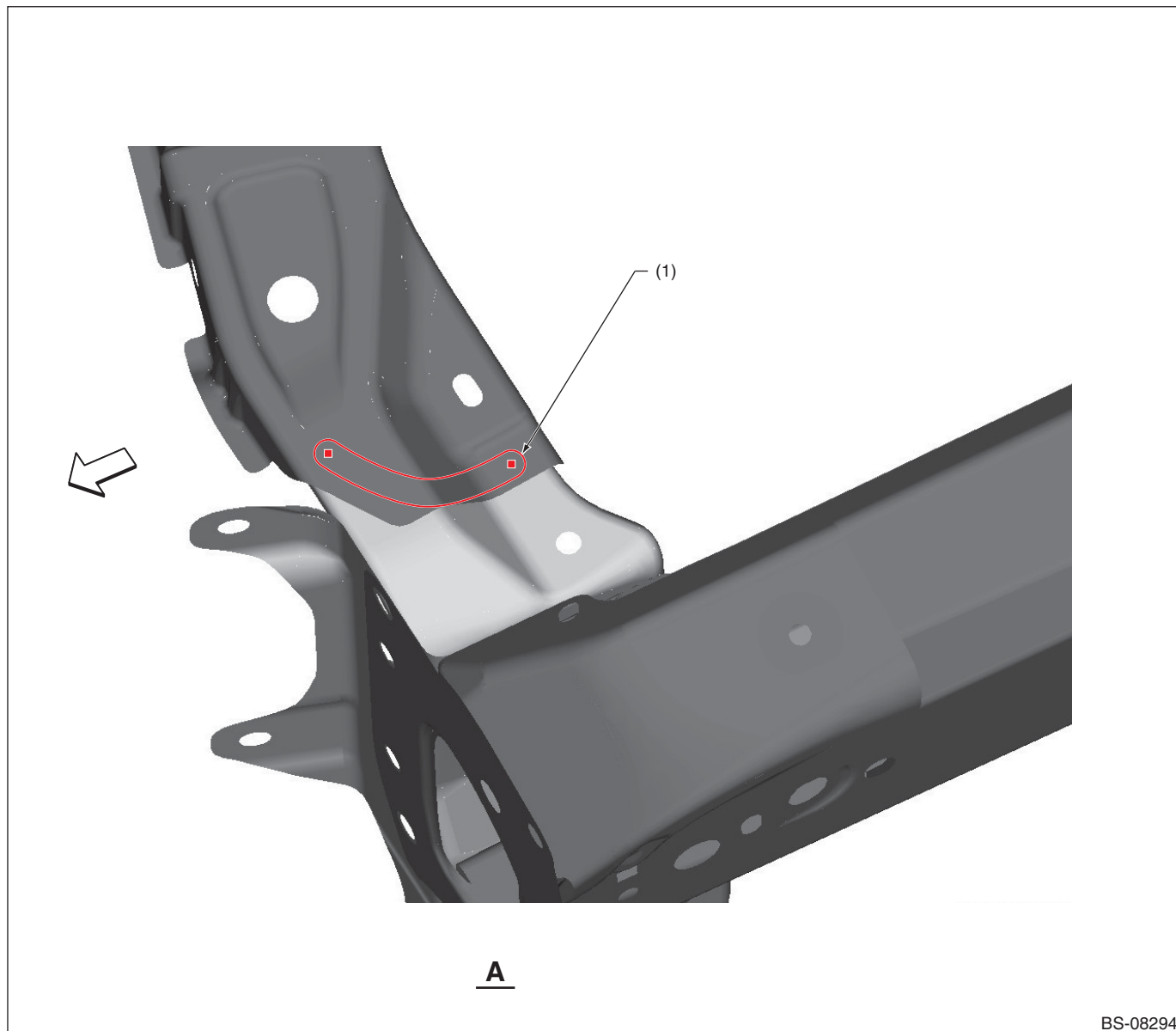
(3) 1 point

(4) 2 points

(5) 4 points

Panel Replacement

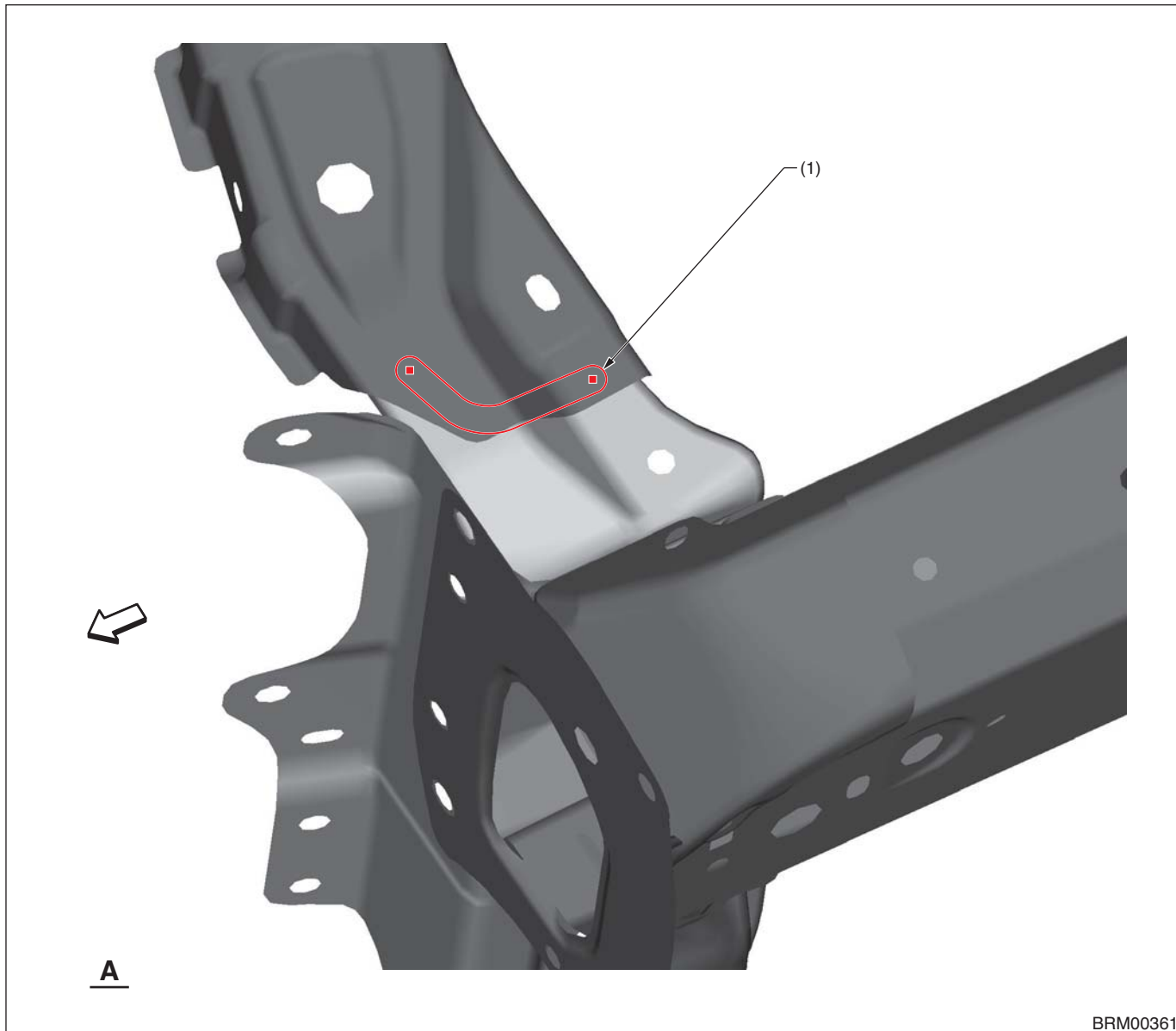
- Views A (Gasoline model)



(1) 3 points

Panel Replacement

- Views A (Hybrid model)



BRM00361

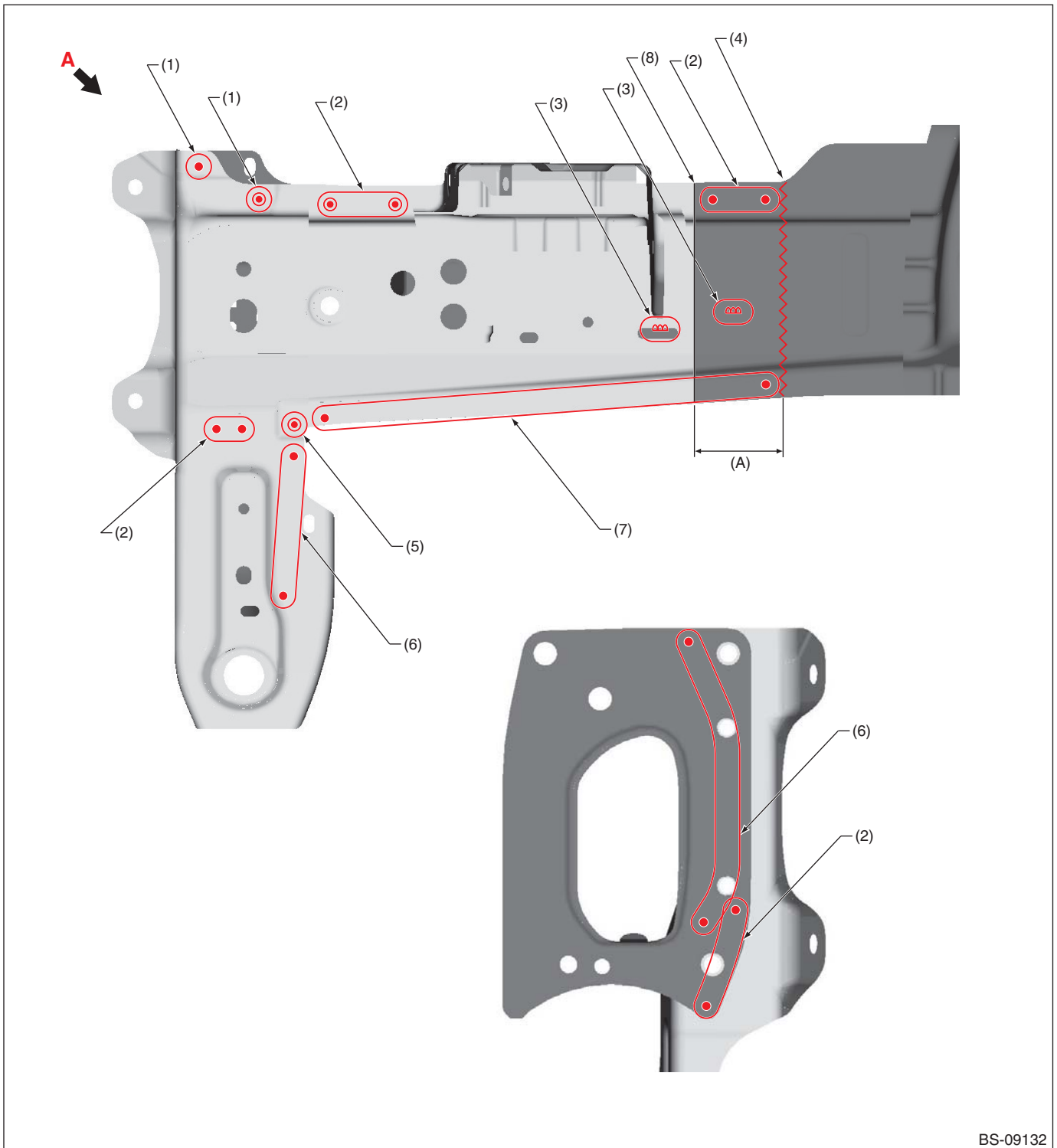
(1) 3 points

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.)



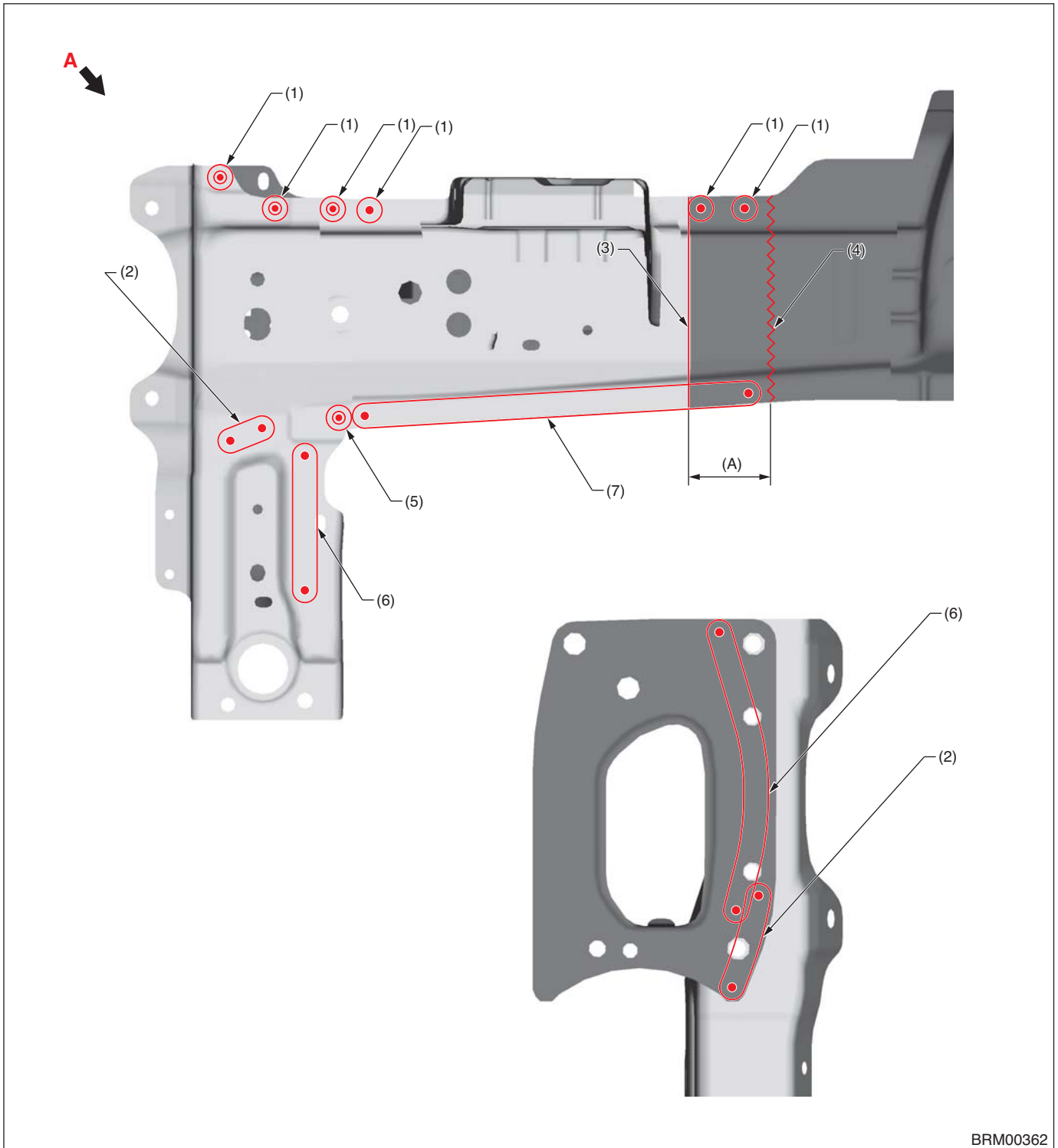
BS-09132

(A) 55 mm [2.17 in]

- | | | |
|---------------------------------------|----------------------------|-----------------------------|
| (1) 1 point (outside · 1) | (4) Cut position | (7) 12 points (outside · 1) |
| (2) 2 points (outside · 1) | (5) 1 point (outside · 2) | (8) Tailored line |
| (3) 1 point (outside · 1 belt sander) | (6) 4 points (outside · 1) | |

Panel Replacement

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



BRM00362

(A) 55 mm [2.17 in]

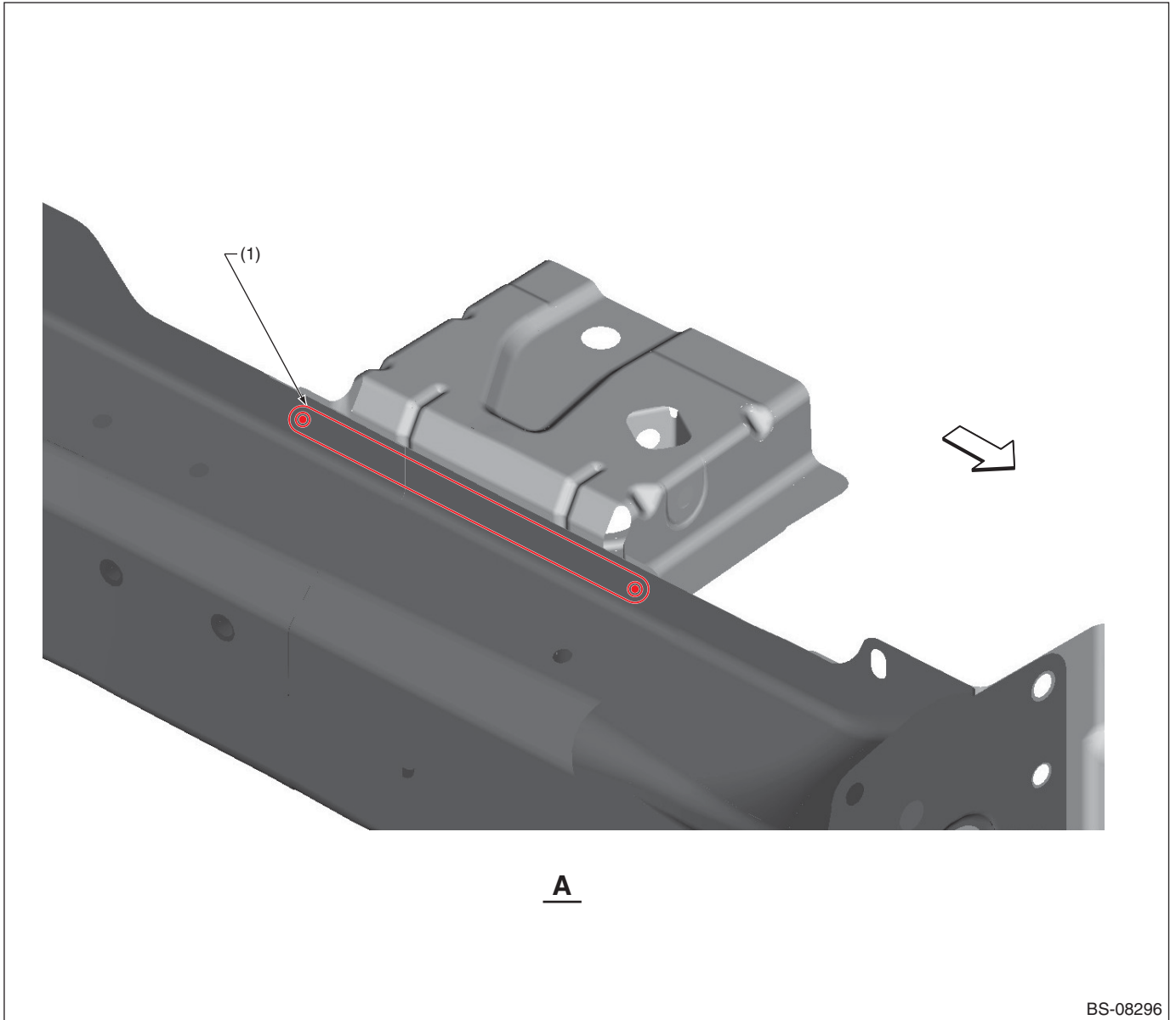
- (1) 1 point (outside · 1)
- (2) 2 points (outside · 1)
- (3) Tailored line

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

- (7) 11 points (outside · 1)

Panel Replacement

• Views A

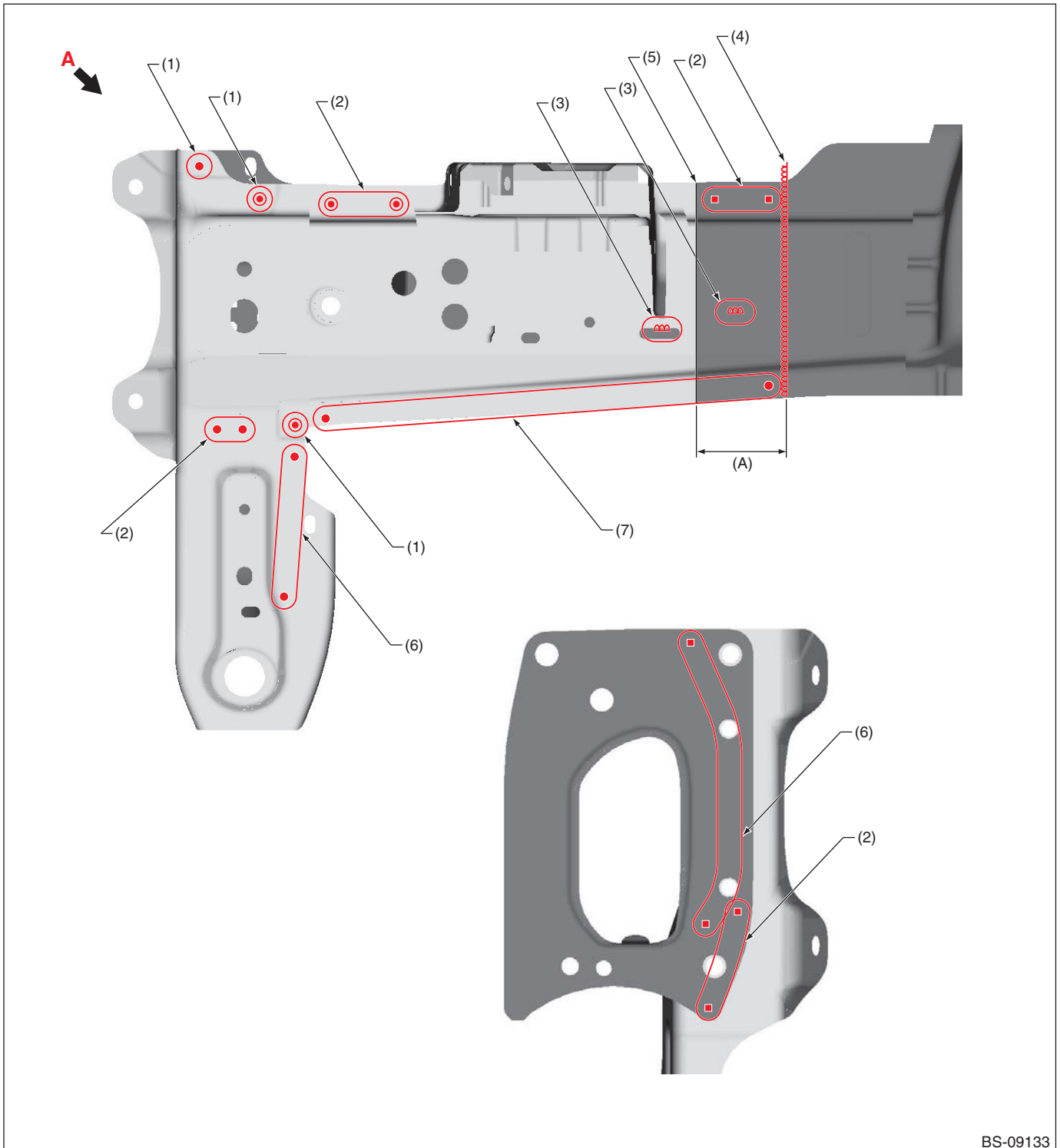


(1) 6 points (inside · 1)

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)

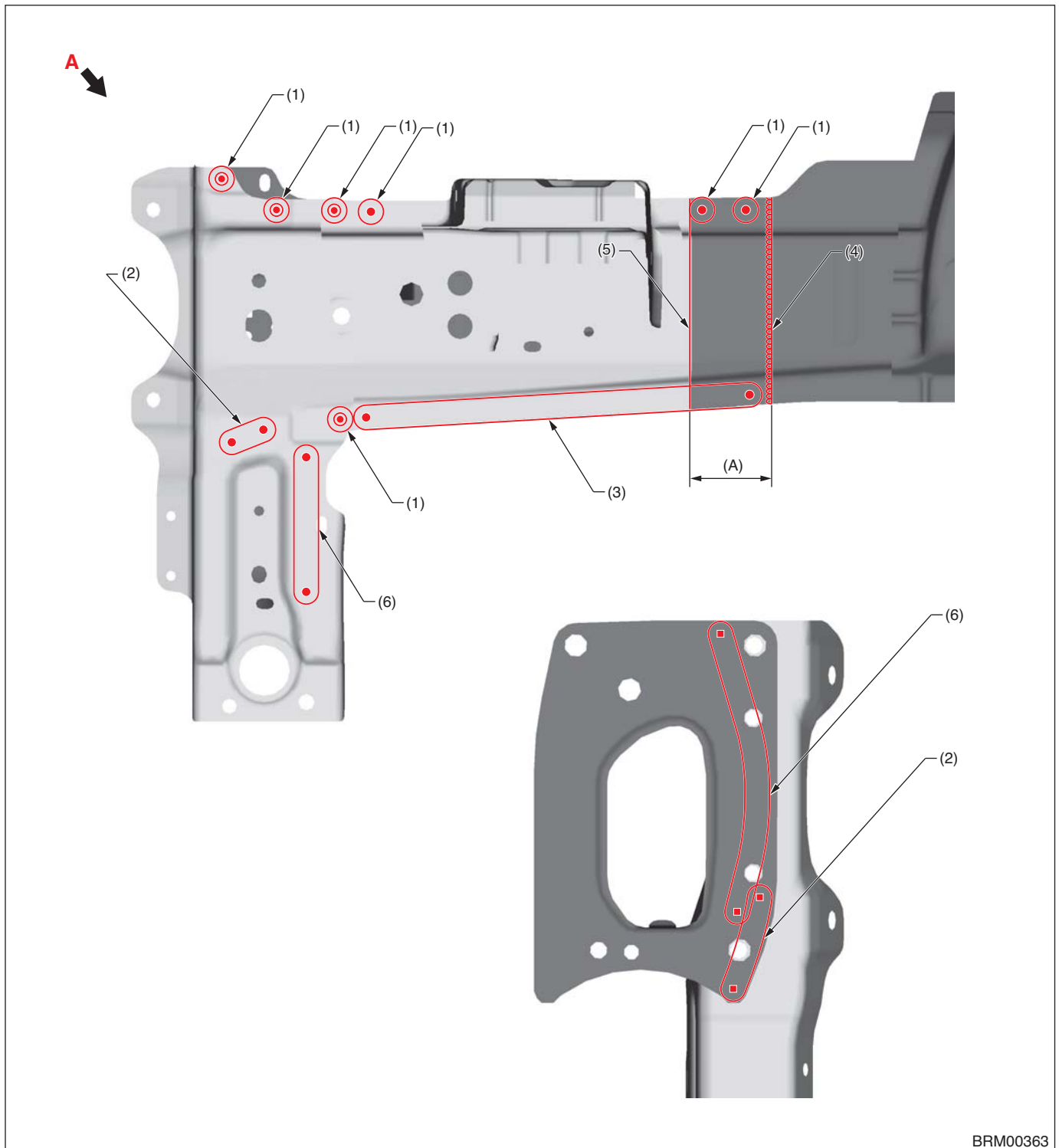
(5) Tailored line

(6) 4 points

(7) 12 points

Panel Replacement

• Overall view (Hybrid model)



(A) 55 mm [2.17 in]

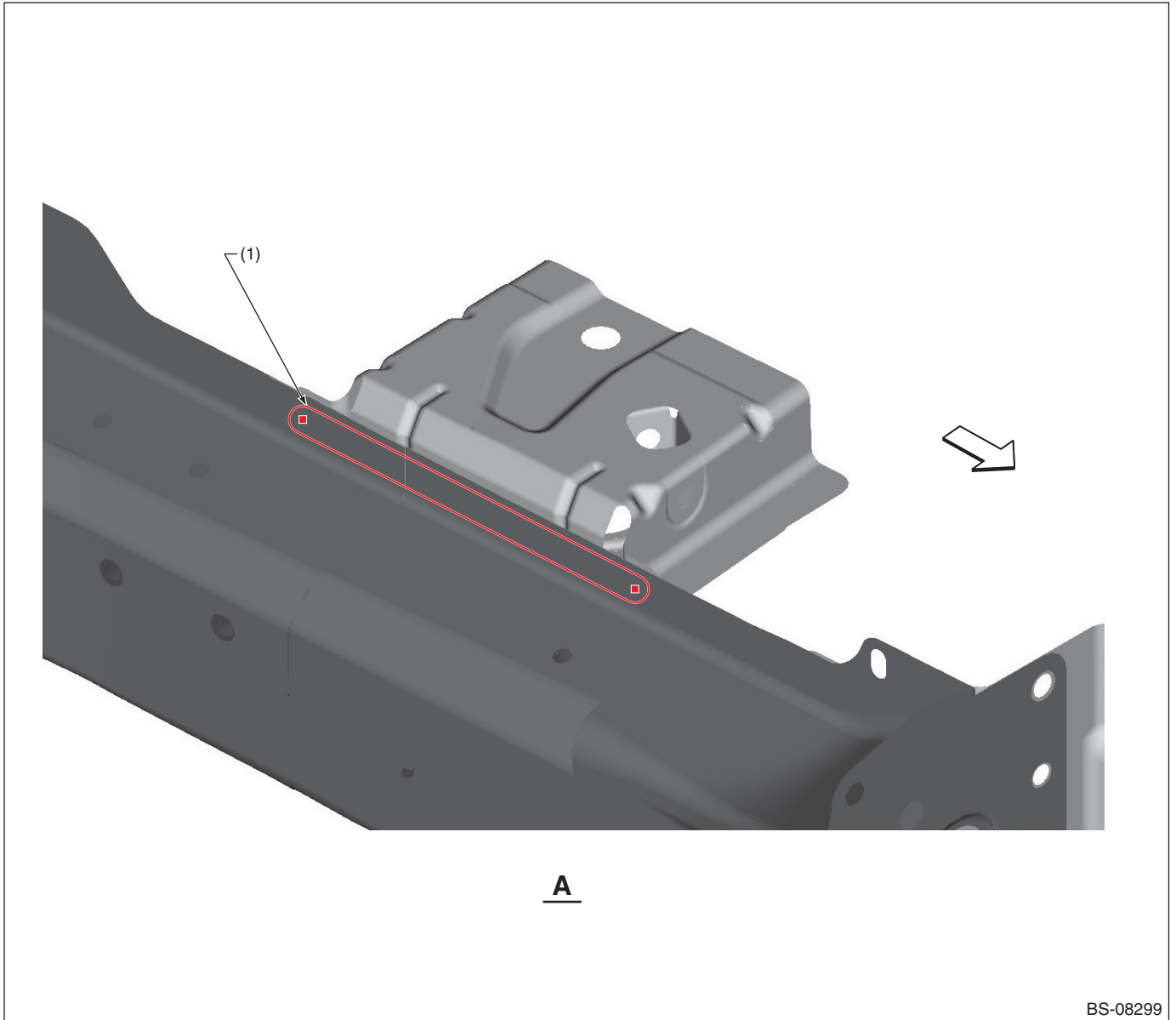
(1) 1 point
(2) 2 points

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

(5) Tailored line
(6) 4 points

Panel Replacement

• Views A



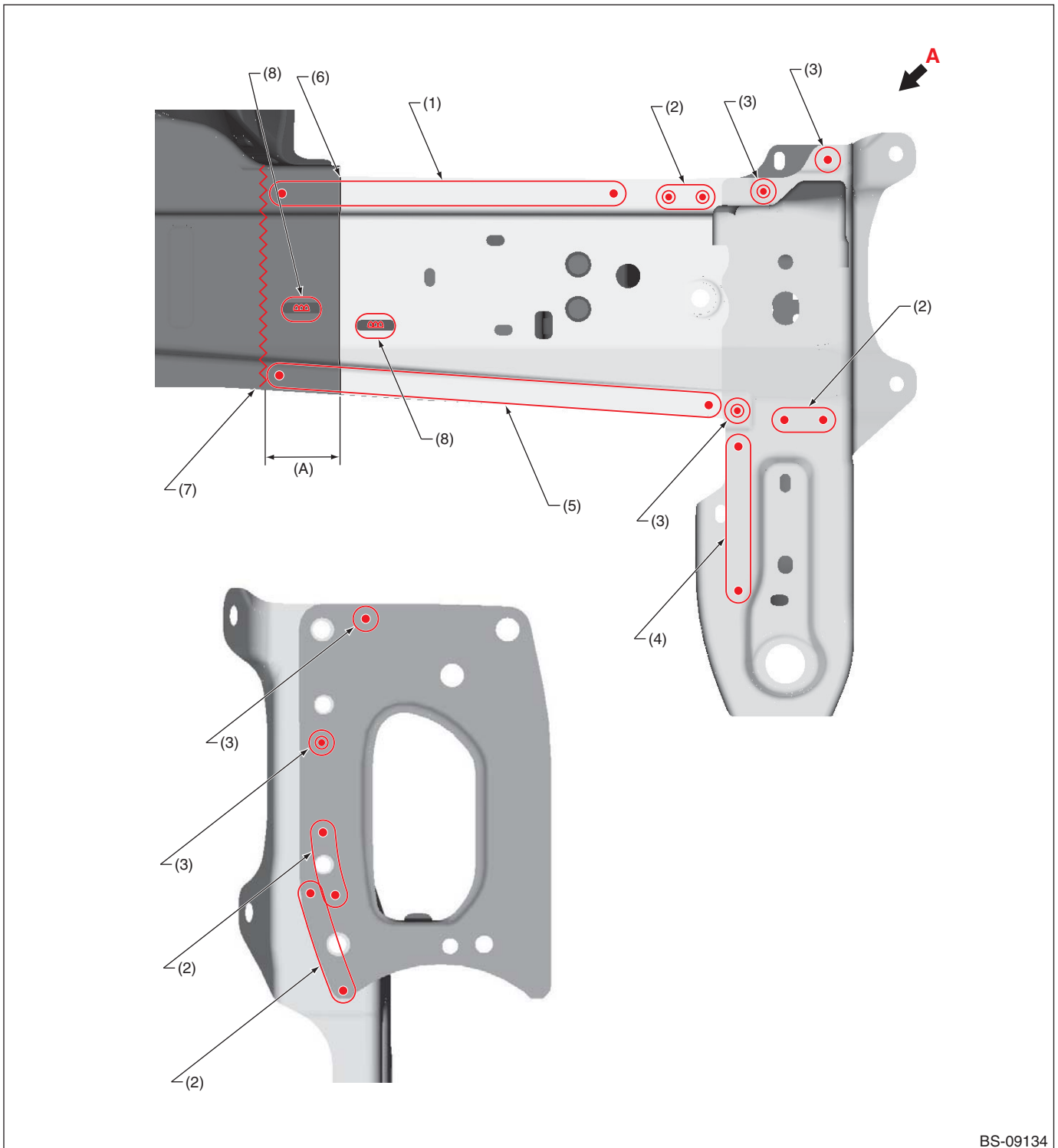
(1) 6 points (service)

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]

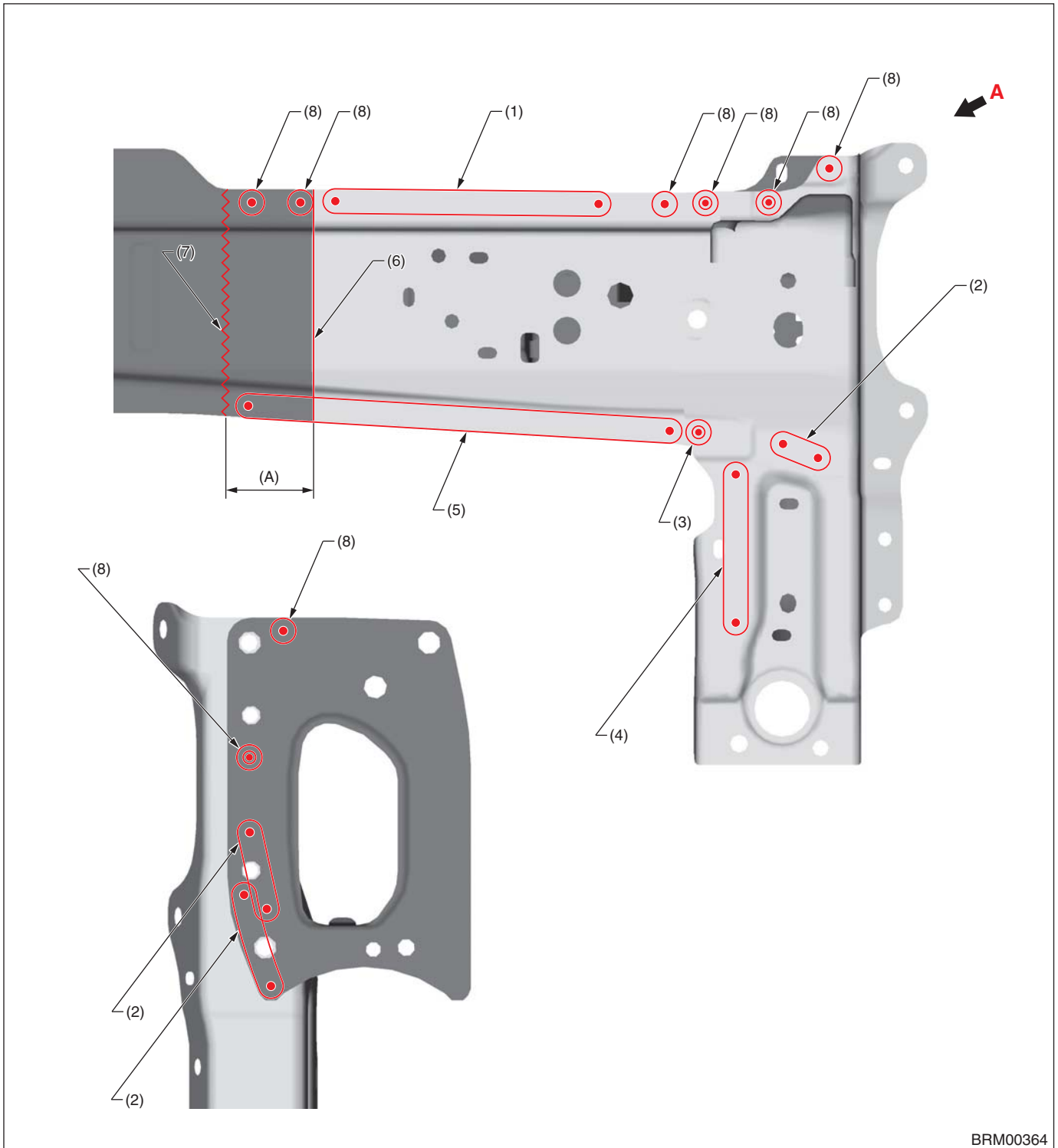
- (1) 8 points (outside · 1)
- (2) 2 points (outside · 1)
- (3) 1 point (outside · 2)

- (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)

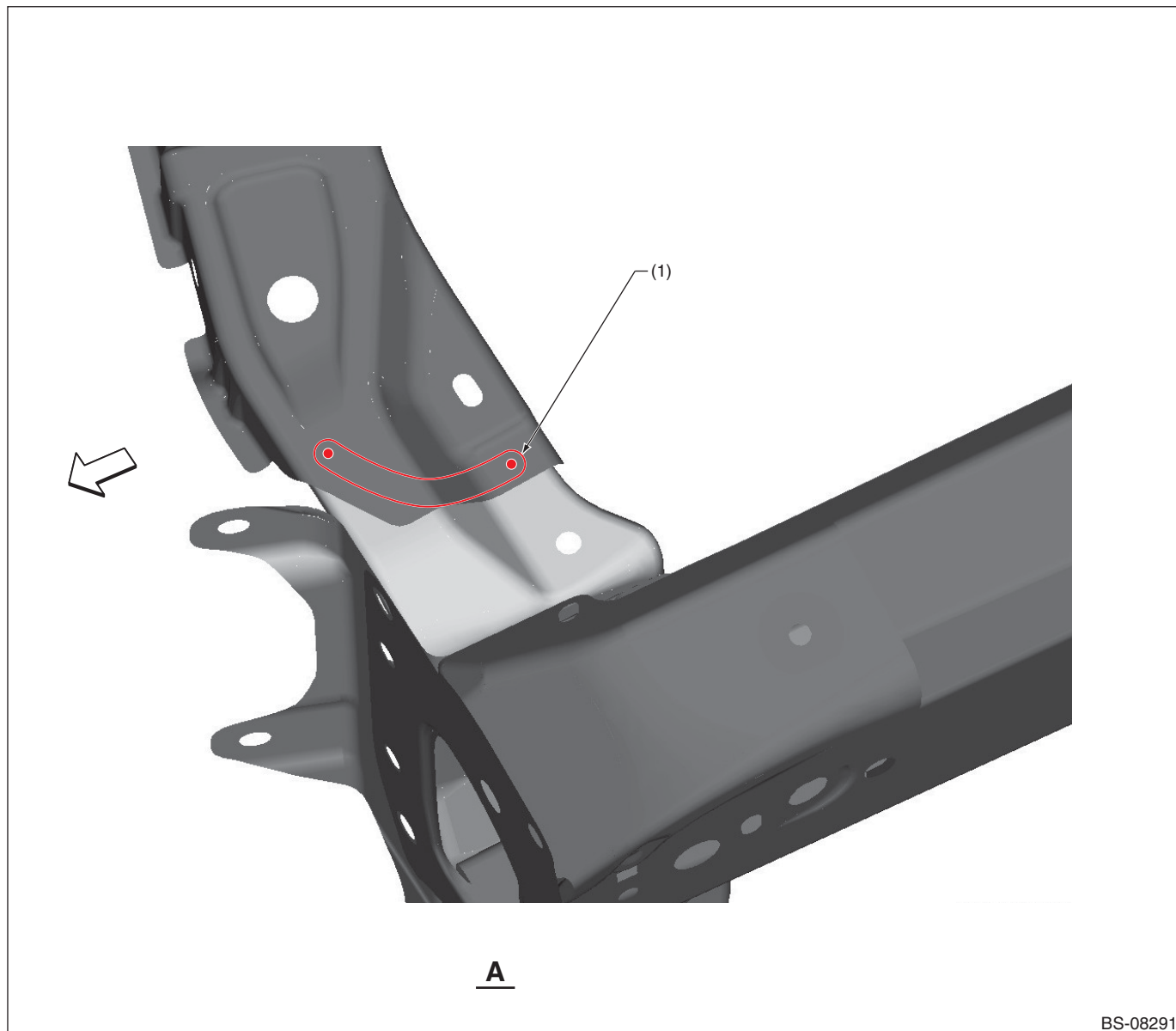
(6) Tailored line

(7) Cut position

(8) 1 point (outside · 1)

Panel Replacement

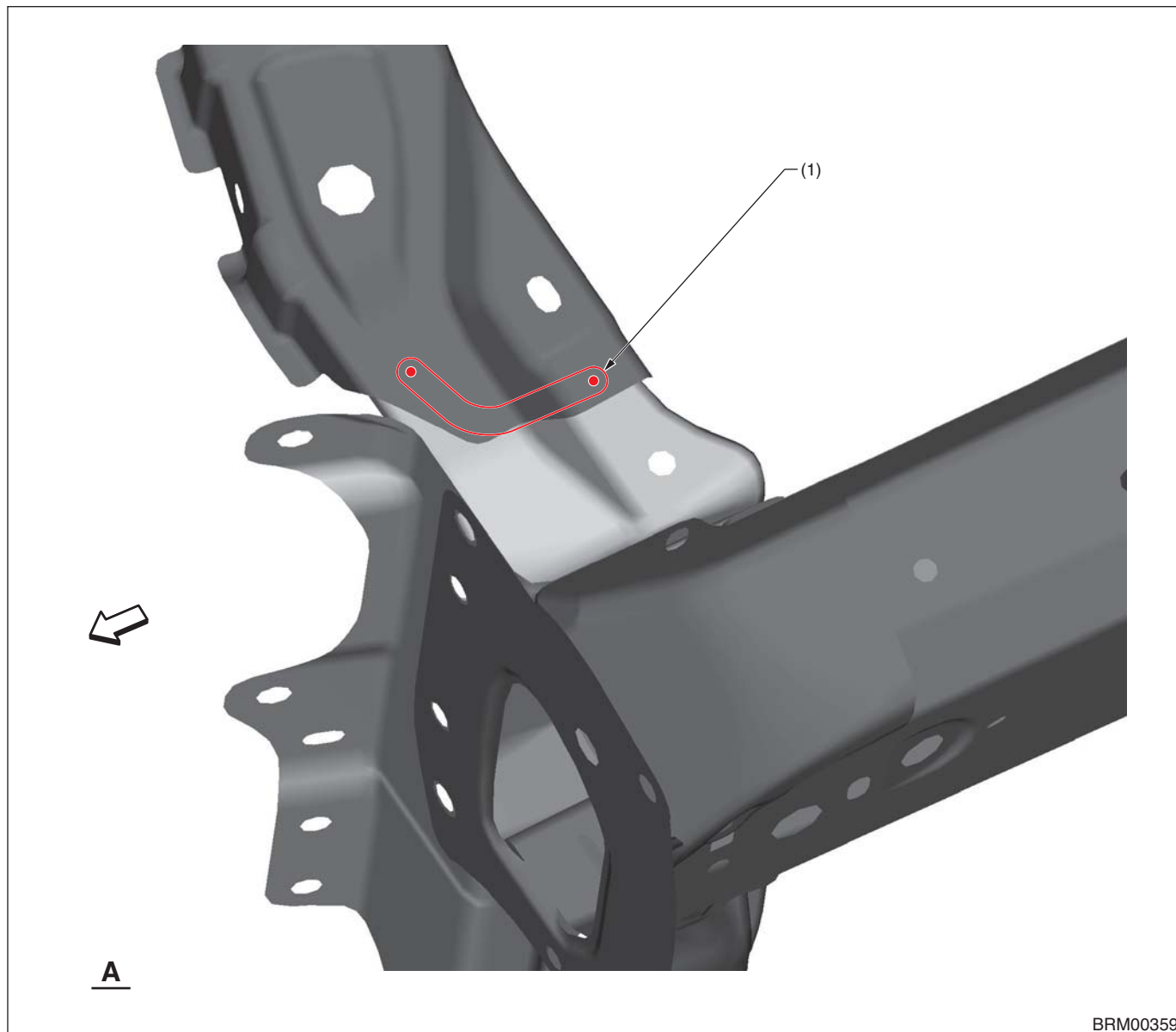
- Views A (Gasoline model)



(1) 3 points (top · 1)

Panel Replacement

- Views A (Hybrid model)



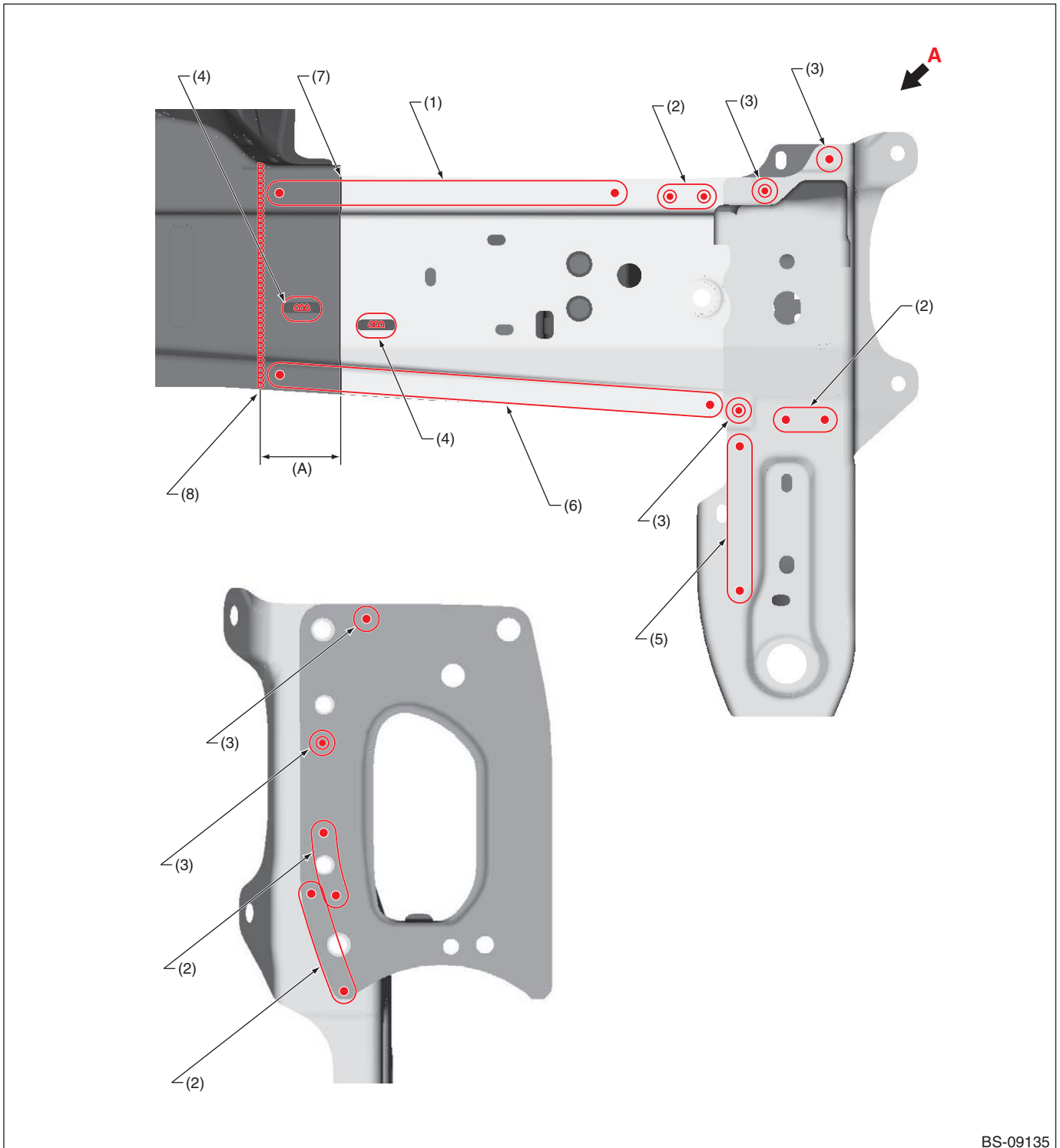
BRM00359

(1) 3 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view (Gasoline model)



BS-09135

(A) 55 mm [2.17 in]

(1) 8 points

(2) 2 points

(3) 1 point

(4) 1 point (Continuous welding)
(10 mm [0.39 in])

(5) 4 points

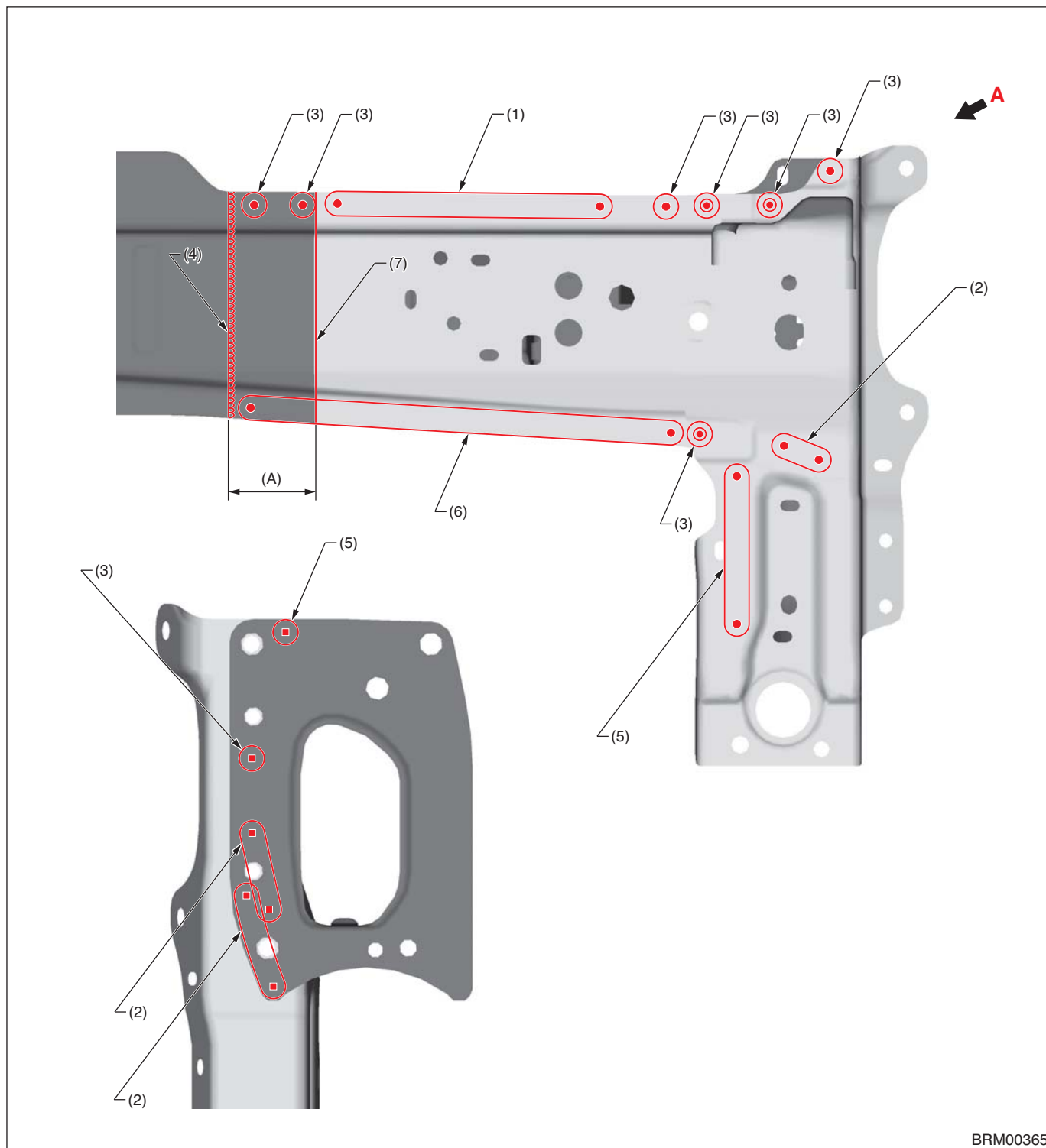
(6) 12 points

(7) Tailored line

(8) 1 point (Continuous welding)

Panel Replacement

• Overall view (Hybrid model)



BRM00365

(A) 55 mm [2.17 in]

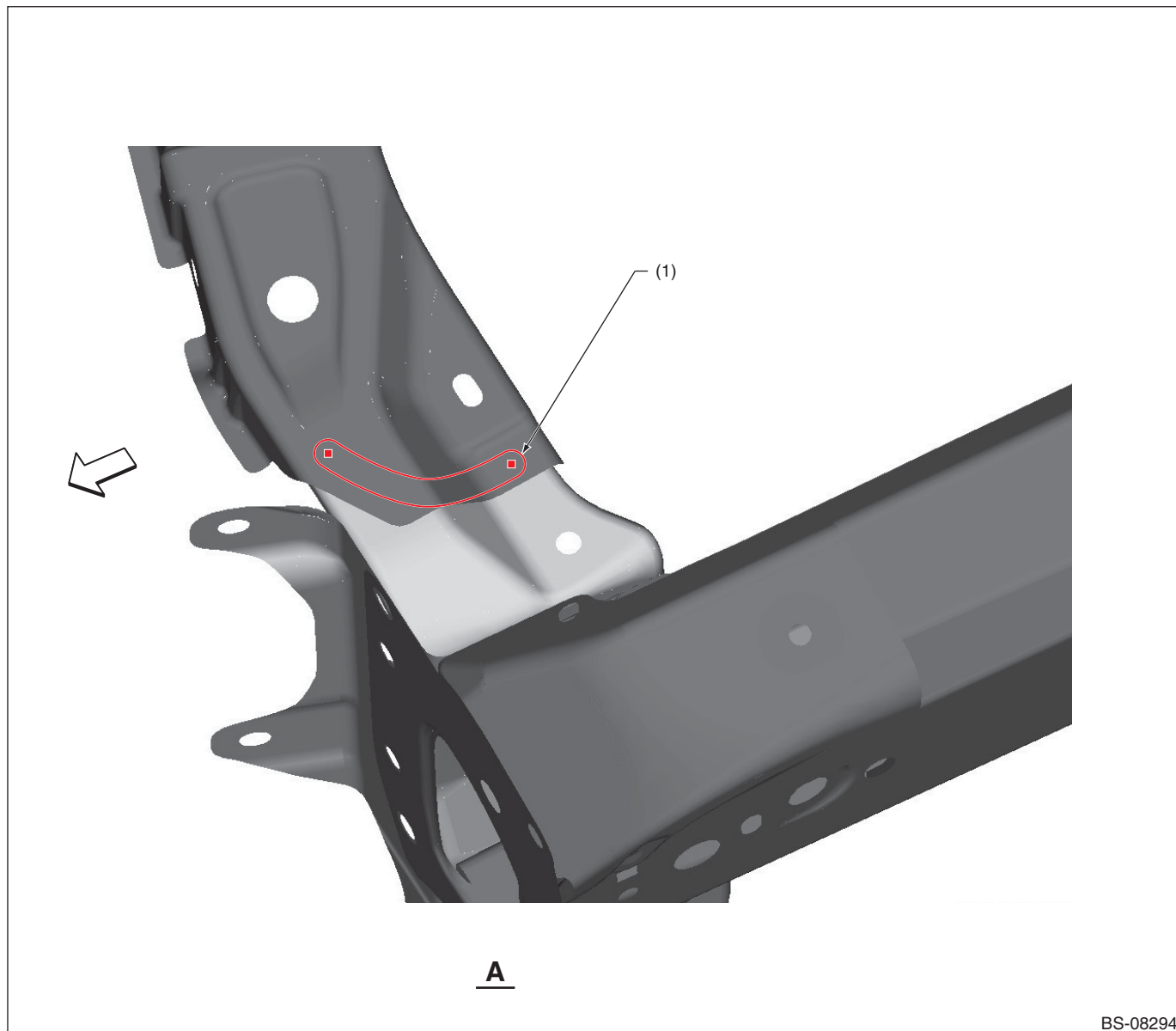
- (1) 6 points
- (2) 2 points
- (3) 1 point

- (4) 1 point (Continuous welding)
- (5) 4 points
- (6) 11 points

- (7) Tailored line

Panel Replacement

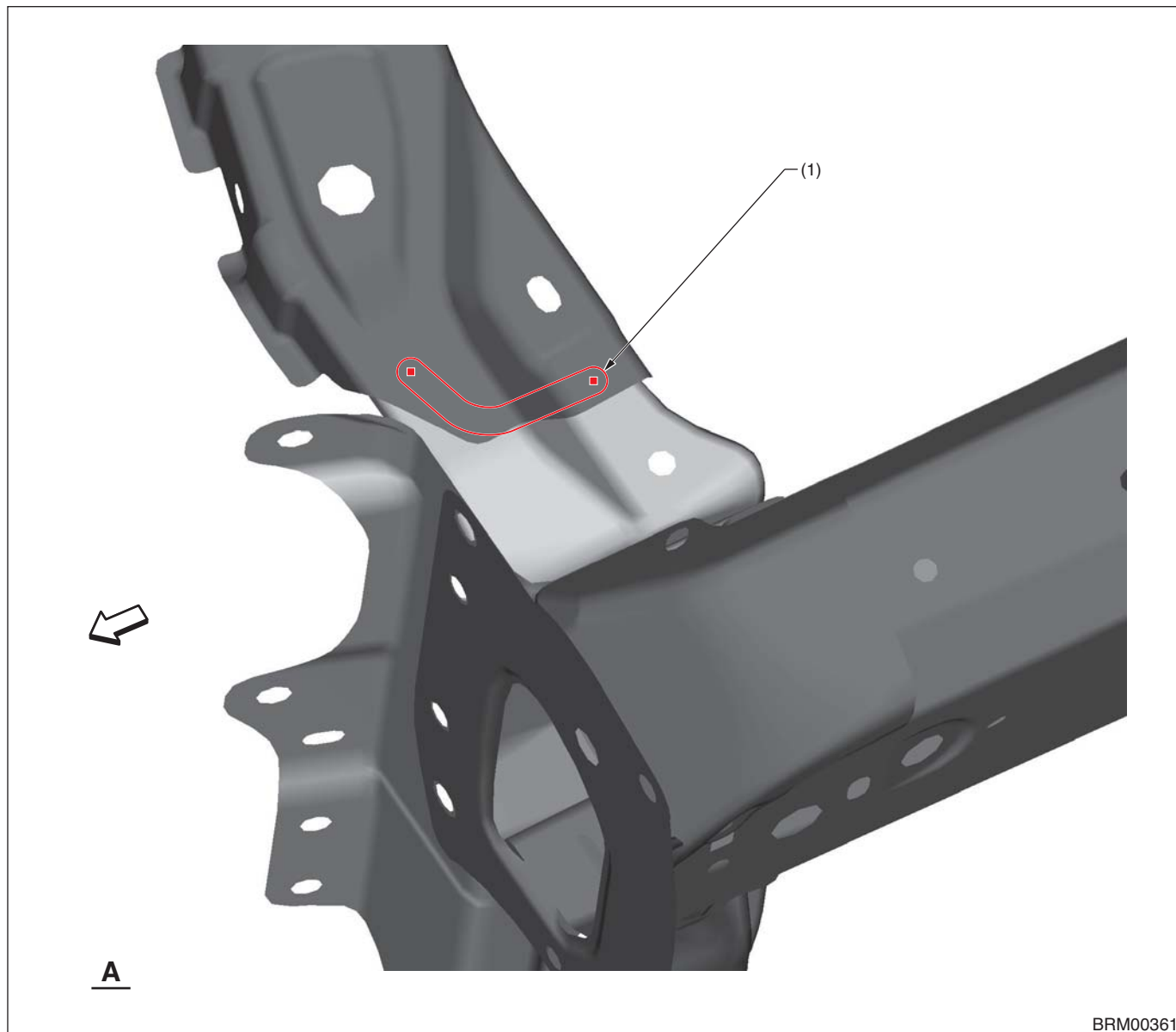
- Views A (Gasoline model)



(1) 3 points

Panel Replacement

- Views A (Hybrid model)



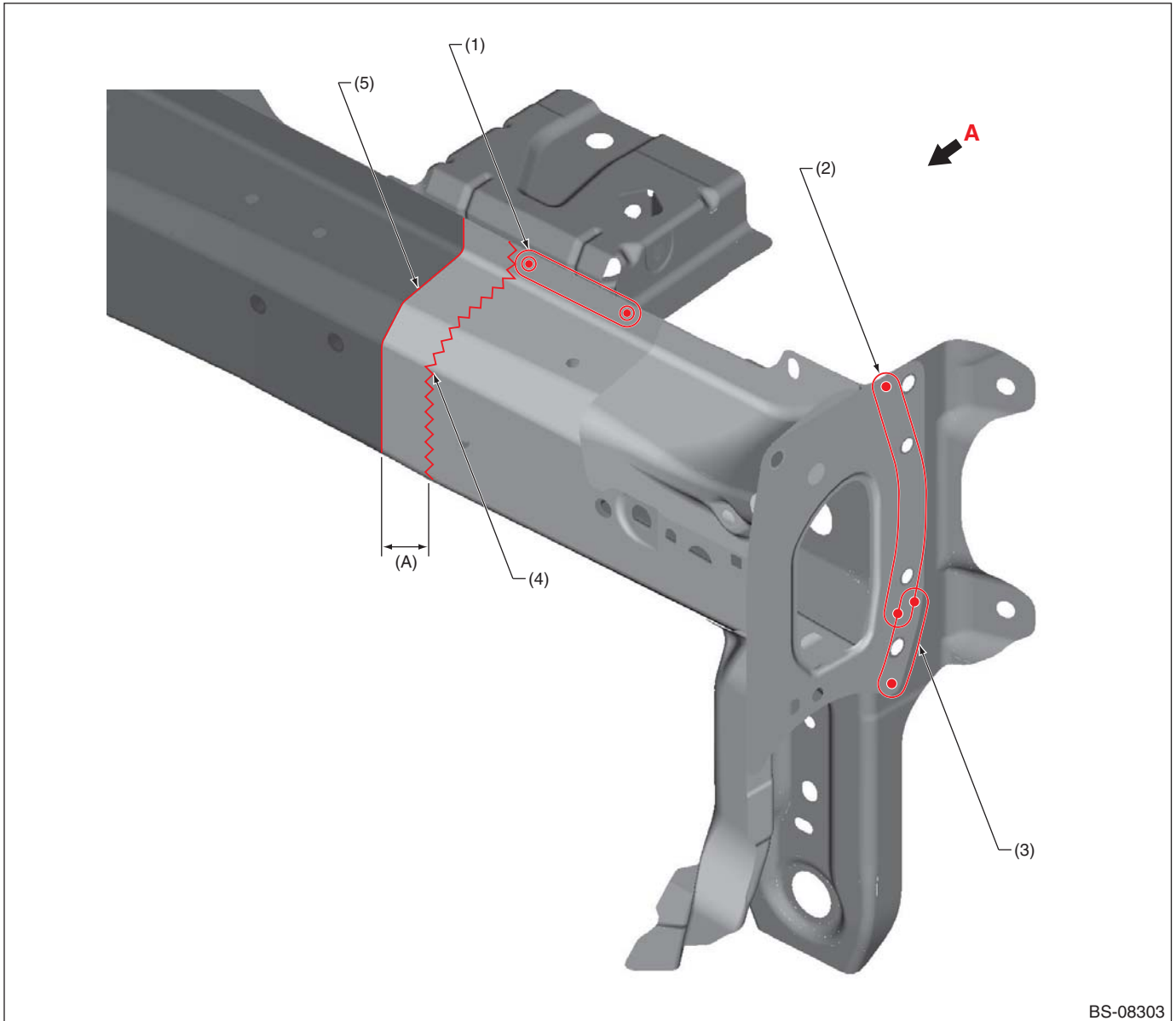
BRM00361

(1) 3 points

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)

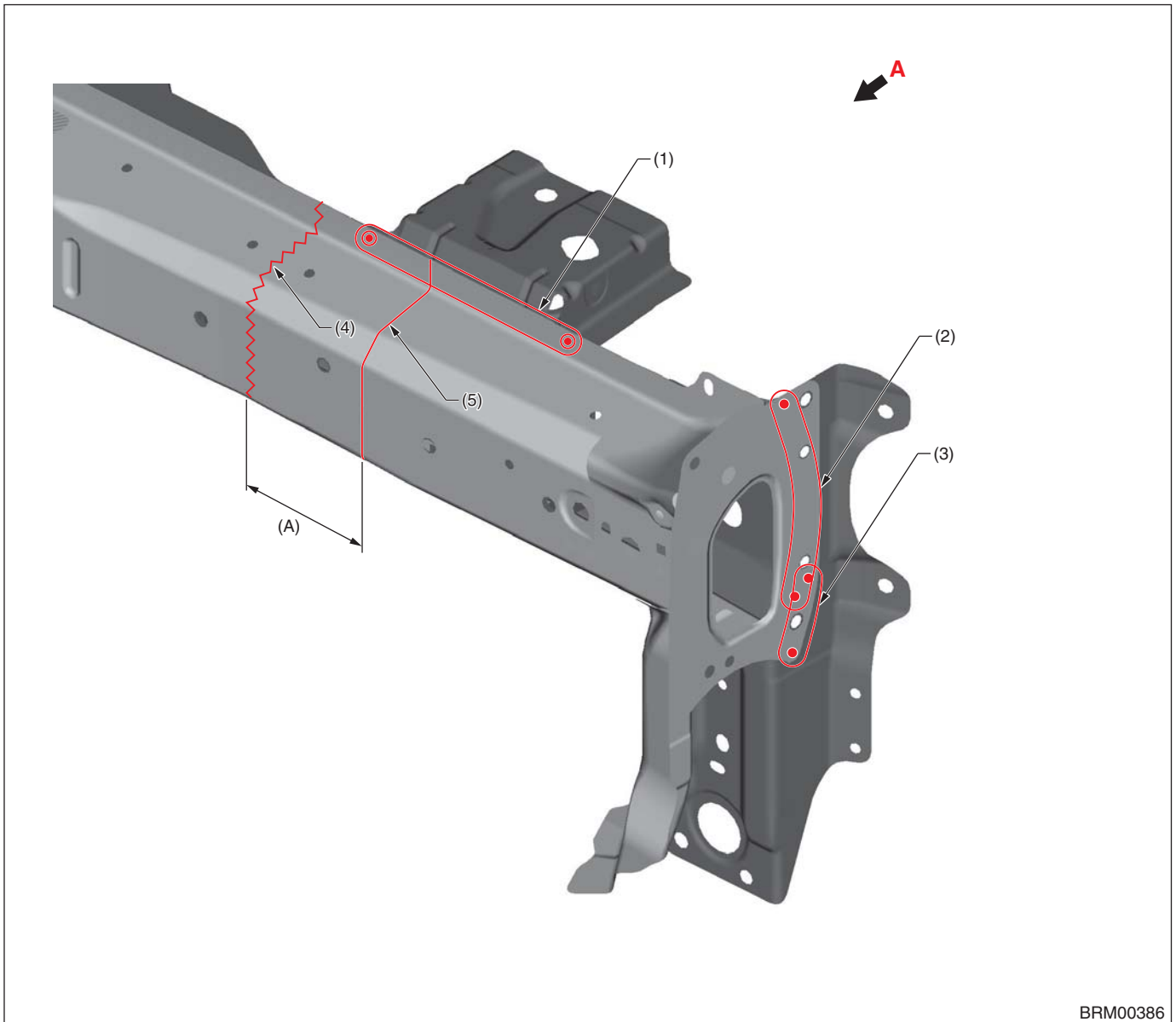
(3) 2 points (outside · 1)

(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.)



(A) 90 mm [3.54 in]

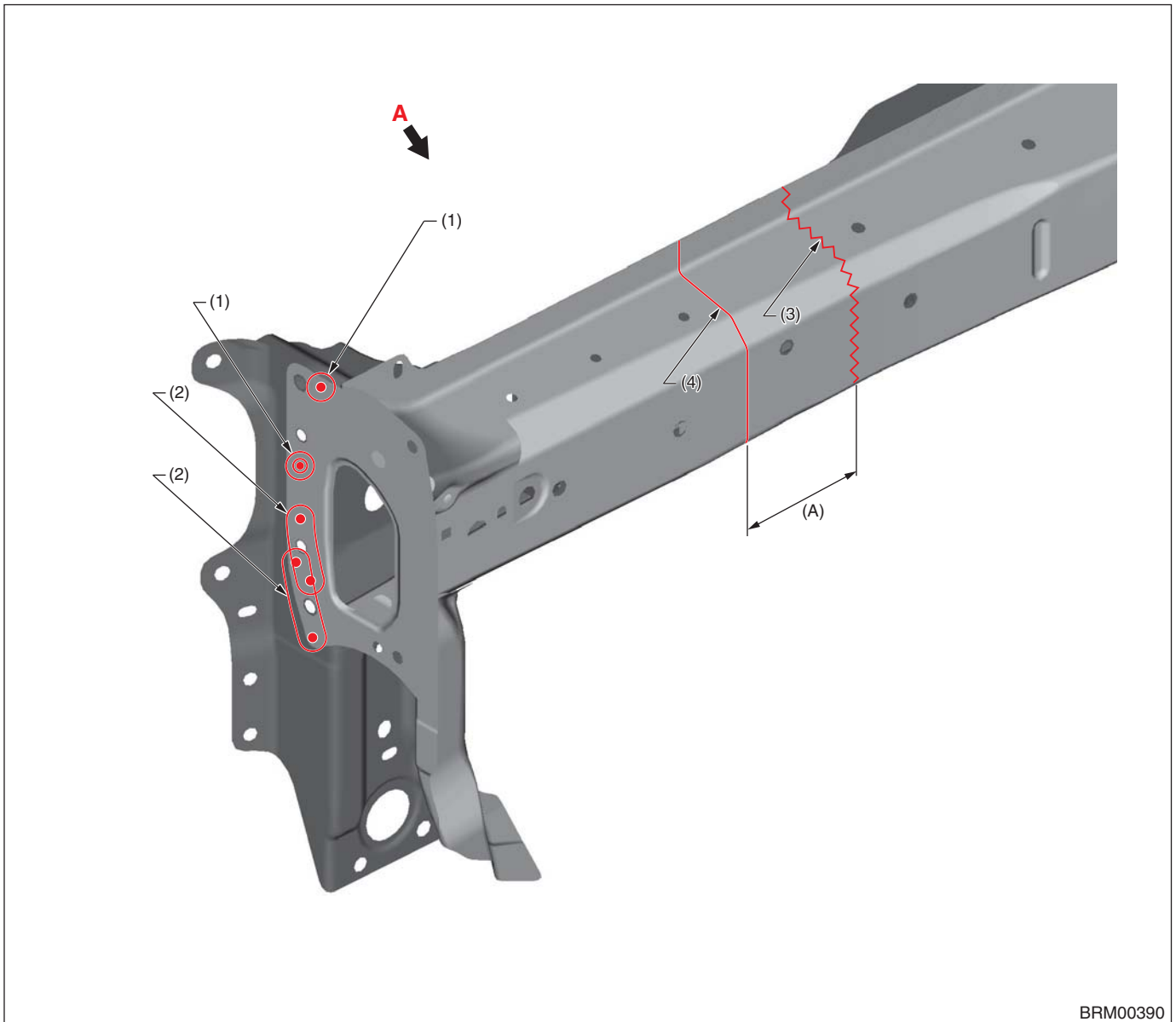
(1) 6 points (inside · 1)
(2) 4 points (outside · 1)

(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]

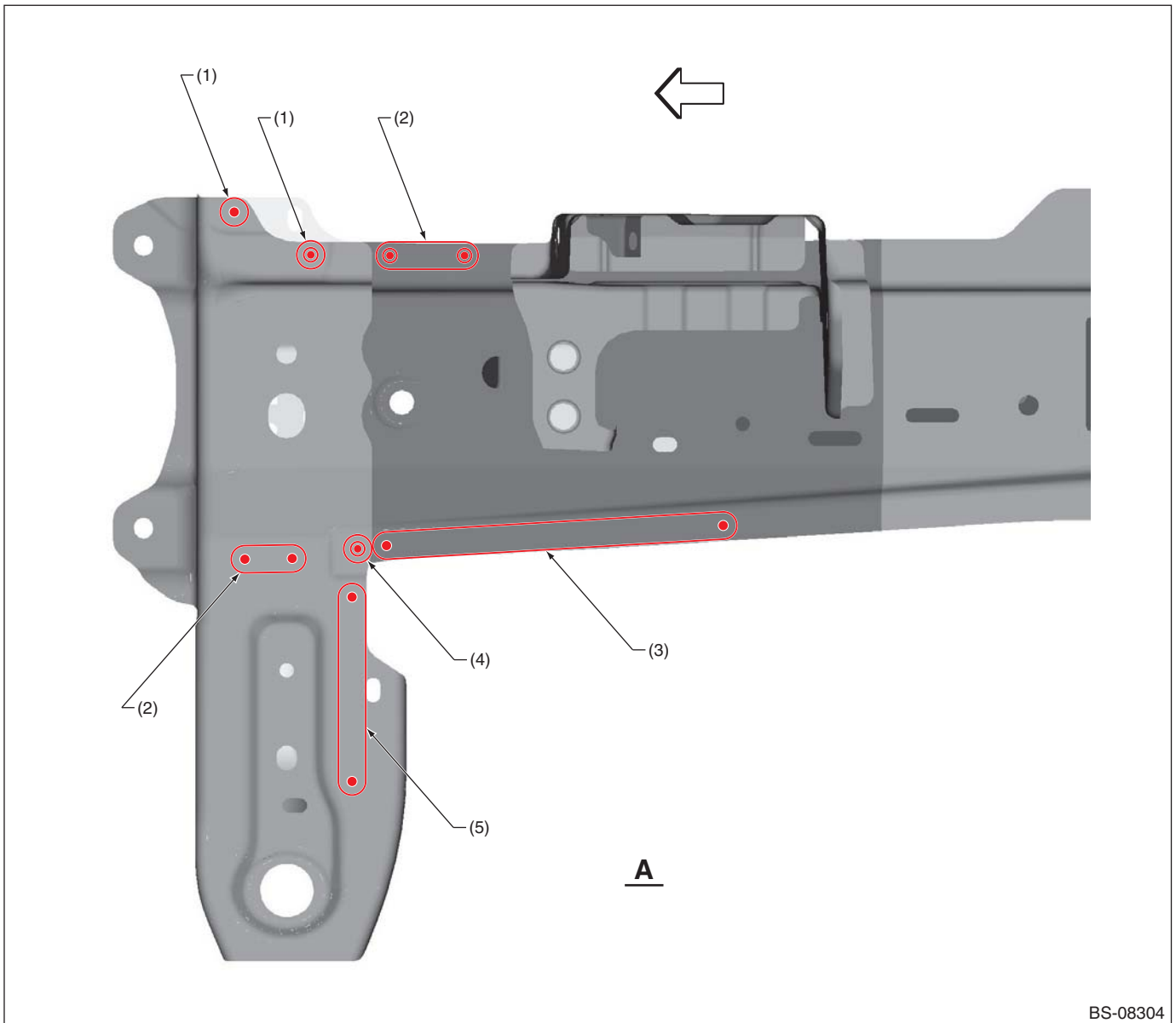
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) Cut position

(4) Tailored line

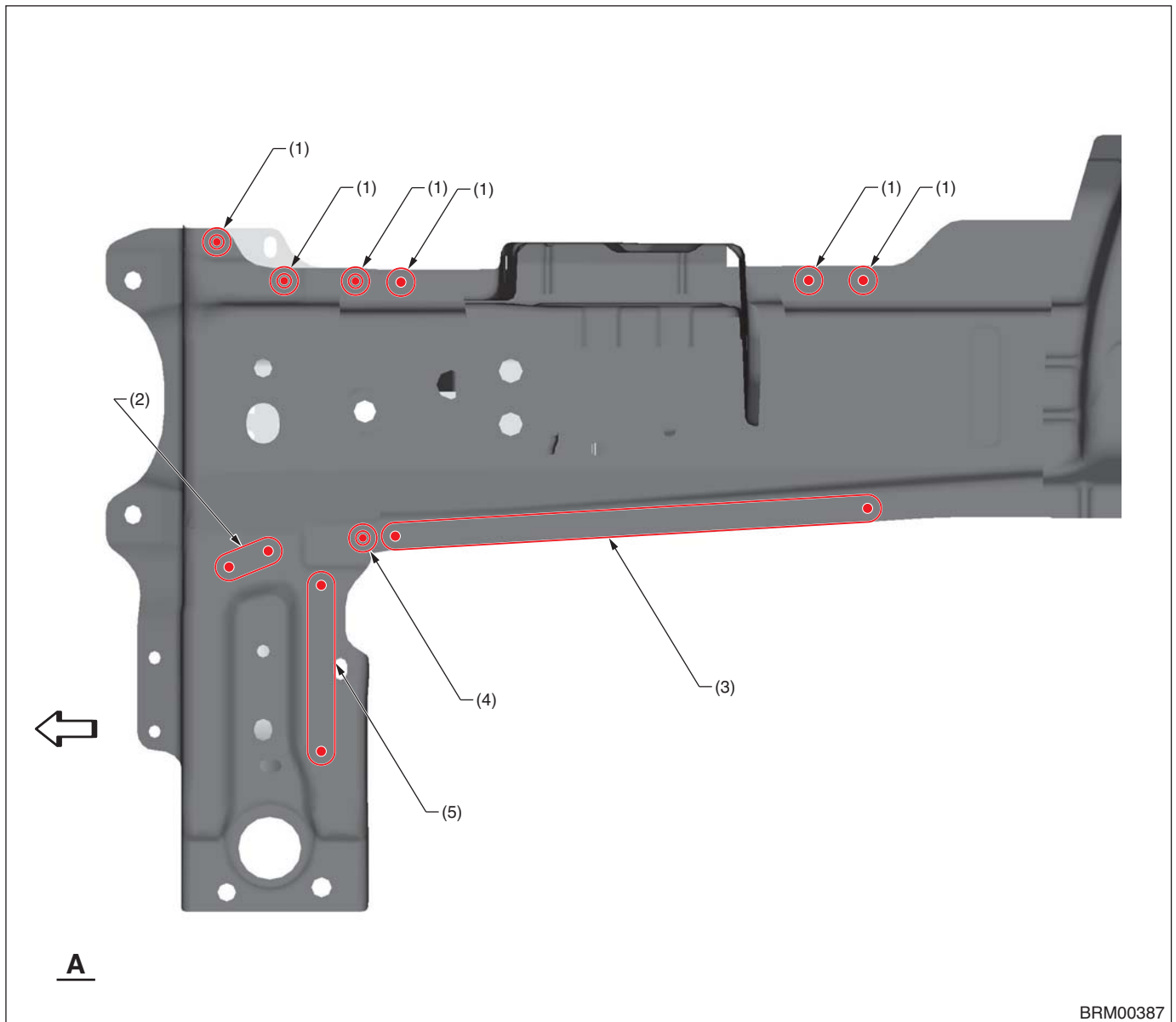
Panel Replacement

• Views A (Gasoline model)



Panel Replacement

• Views A (LH) (Hybrid model)



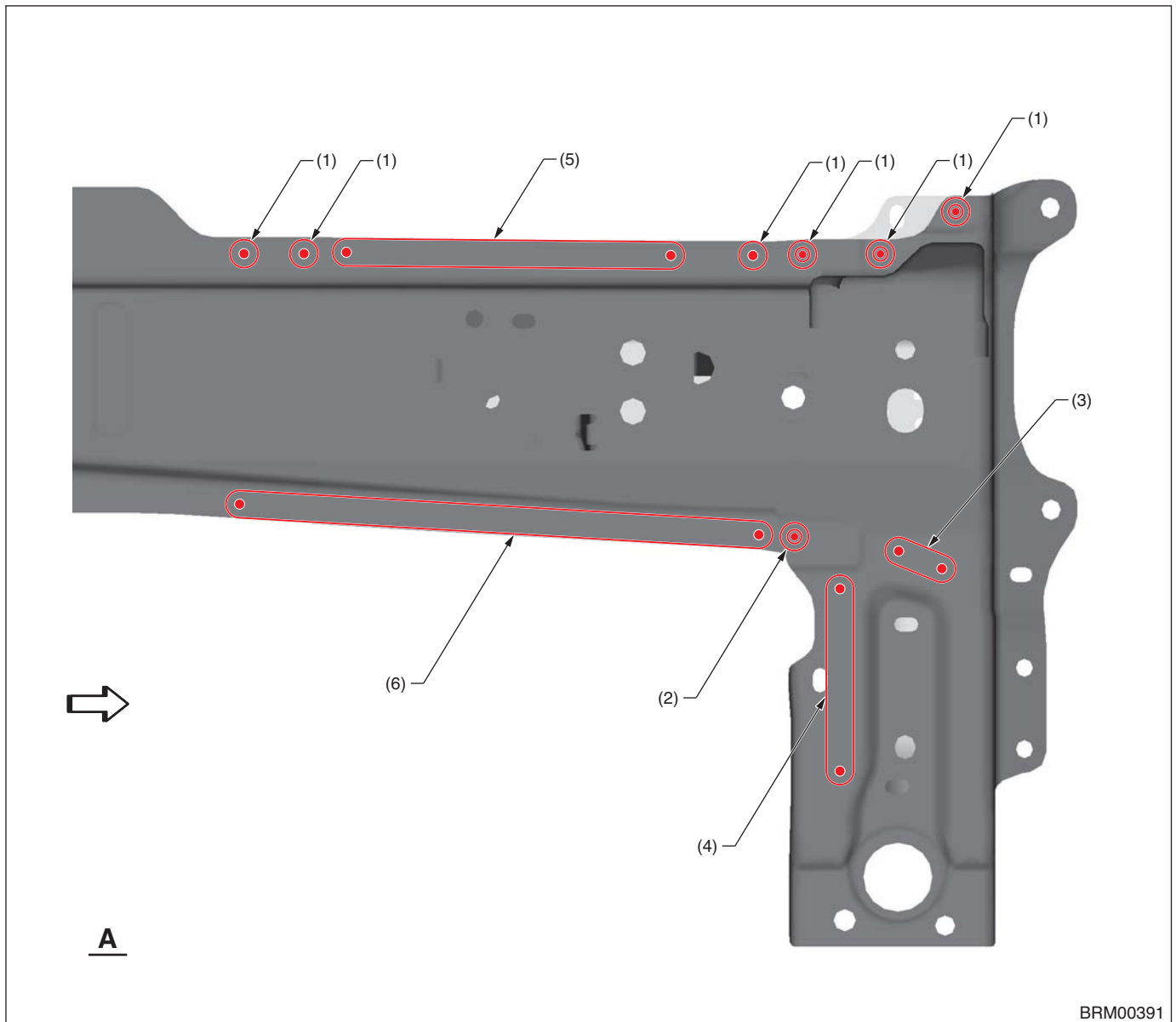
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(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)

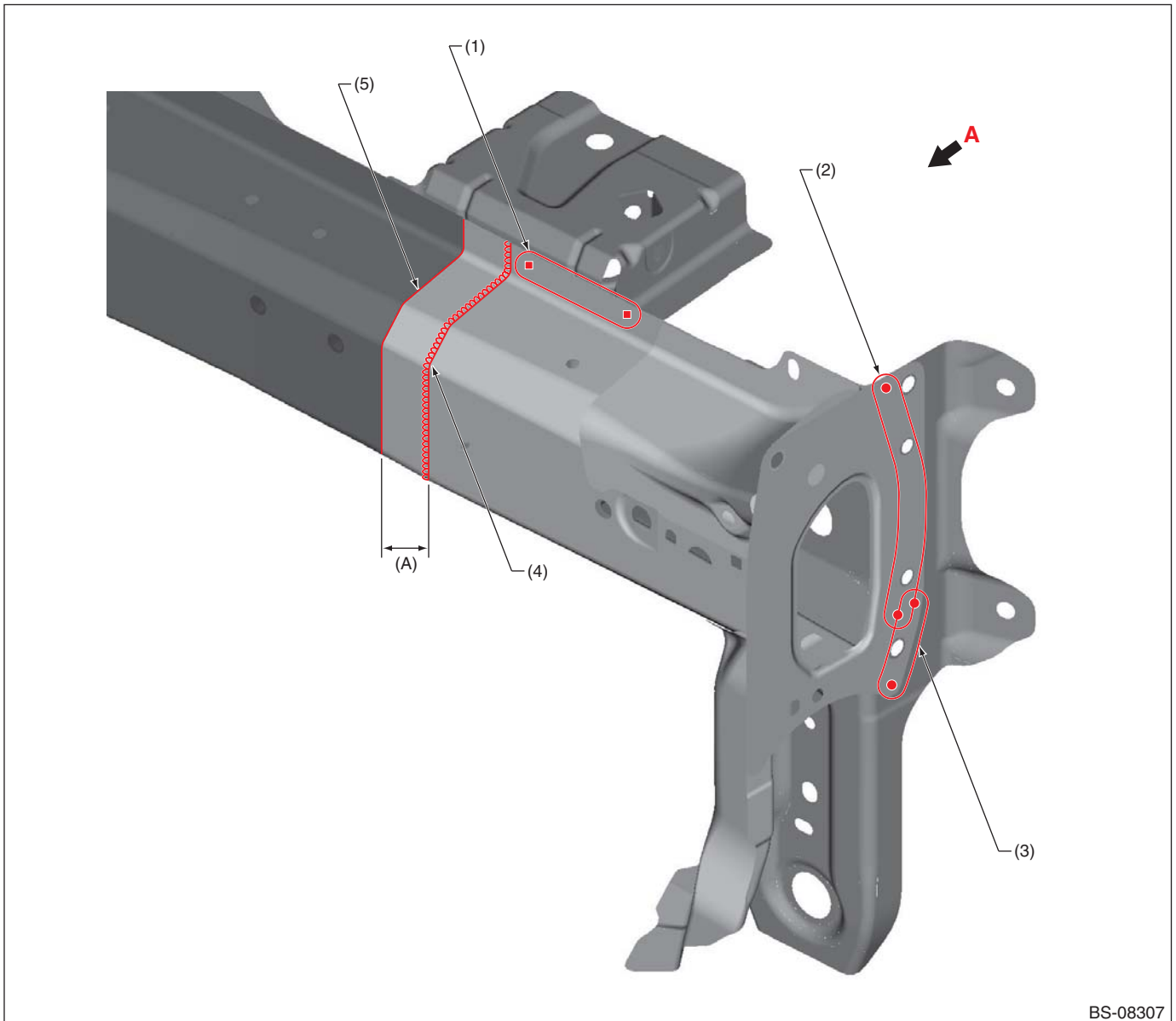
(5) 6 points (outside · 1)

(6) 11 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view (Gasoline model)



BS-08307

(A) 35 mm [1.38 in]

(1) 3 points (service)

(2) 4 points

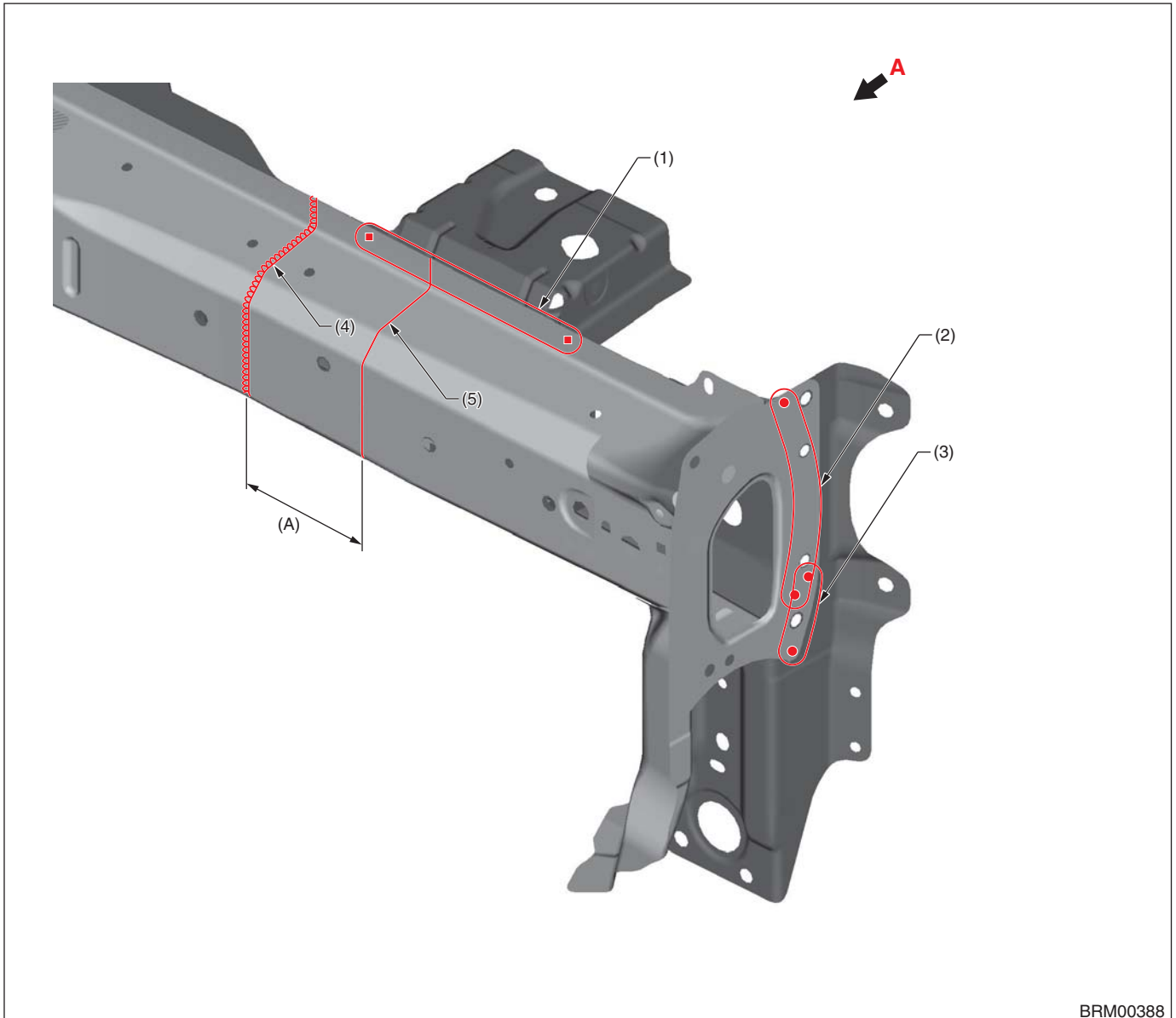
(3) 2 points

(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

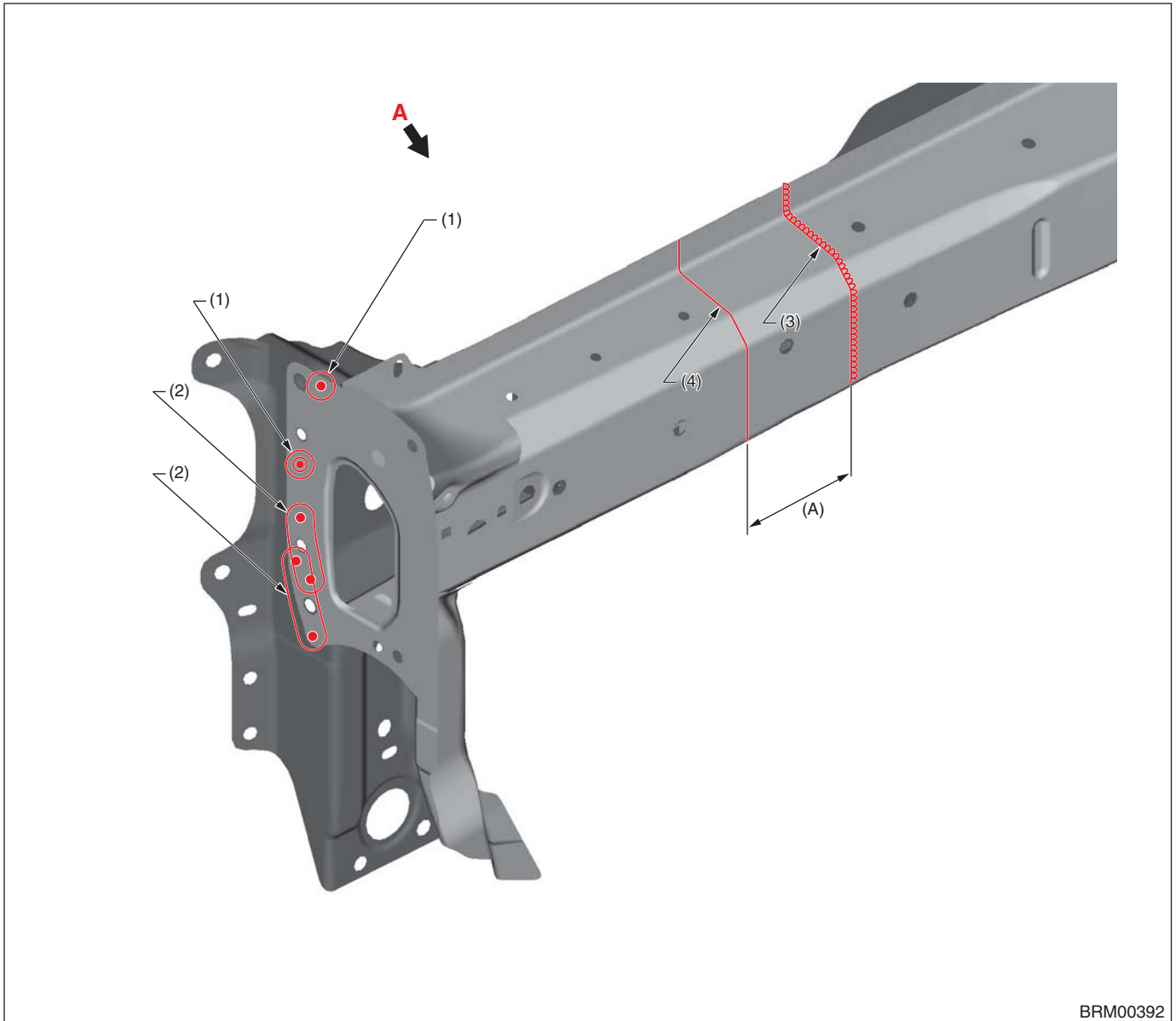
(3) 2 points

(4) 1 point (Continuous welding)

(5) Tailored line

Panel Replacement

- Overall view (RH) (Hybrid model)



BRM00392

(A) 90 mm [3.54 in]

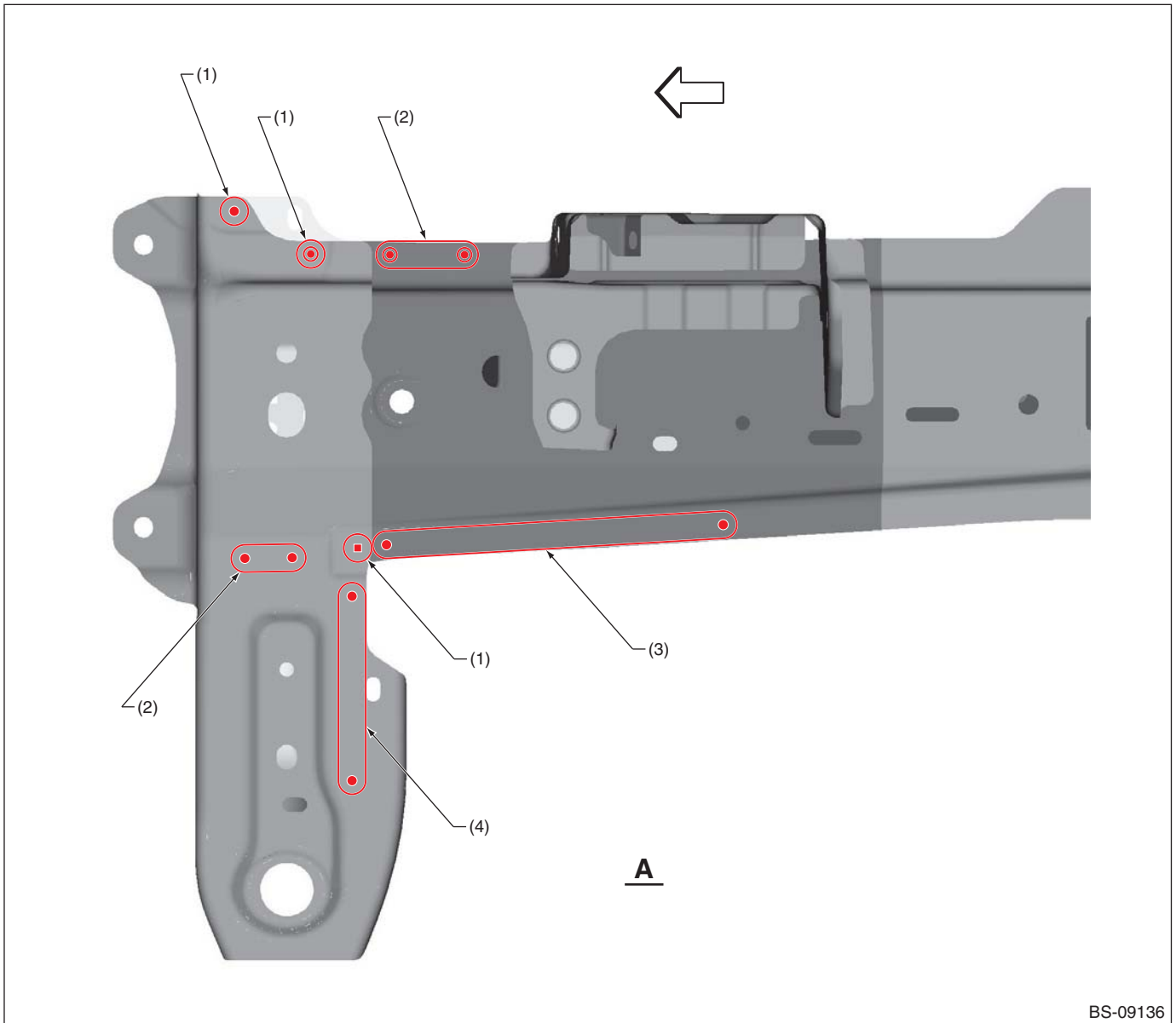
(1) 1 point
(2) 2 points

(3) 1 point (Continuous welding)

(4) Tailored line

Panel Replacement

• Views A (Gasoline model)



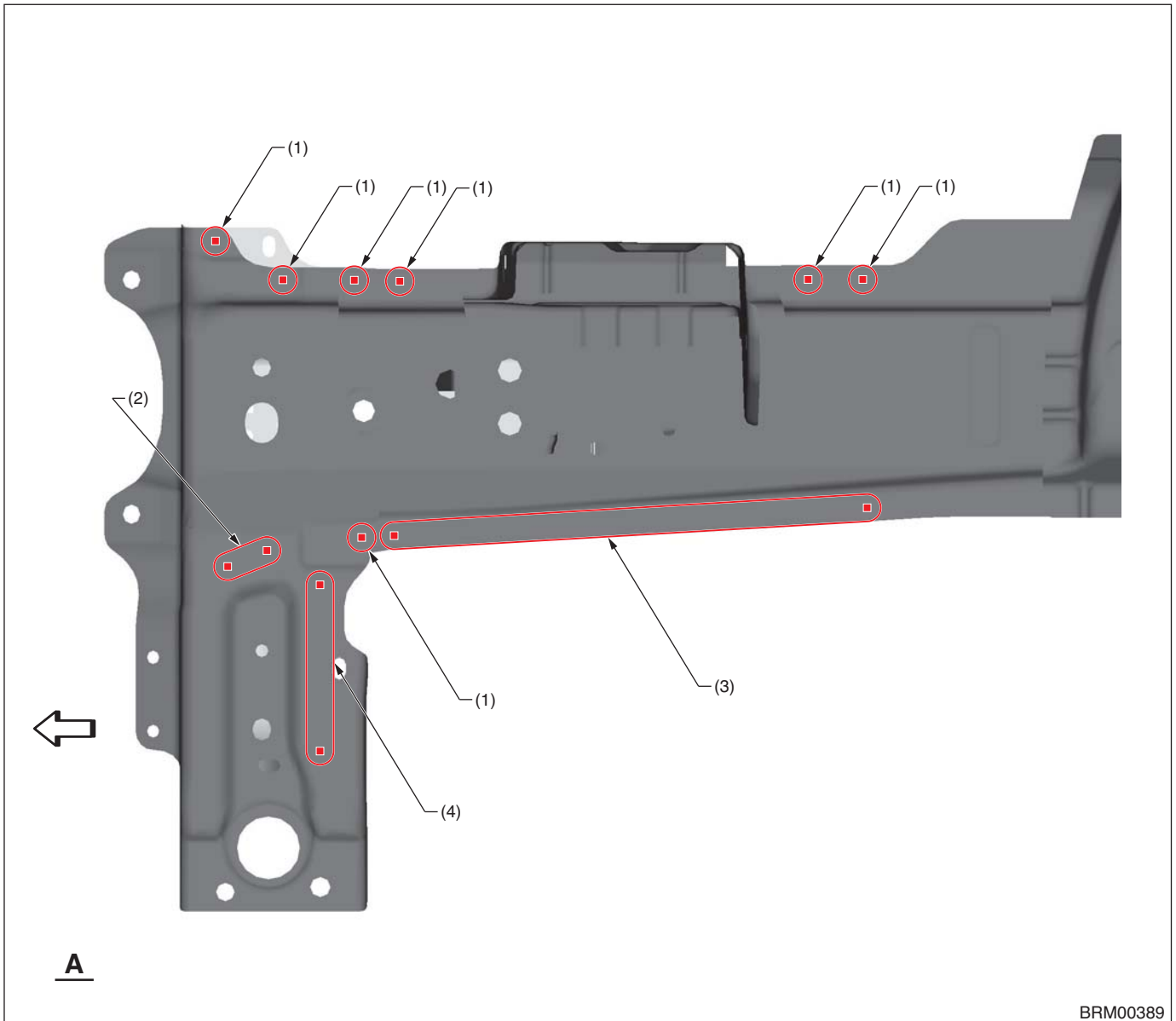
(1) 1 point
(2) 2 points

(3) 7 points

(4) 4 points

Panel Replacement

• Views A (LH) (Hybrid model)



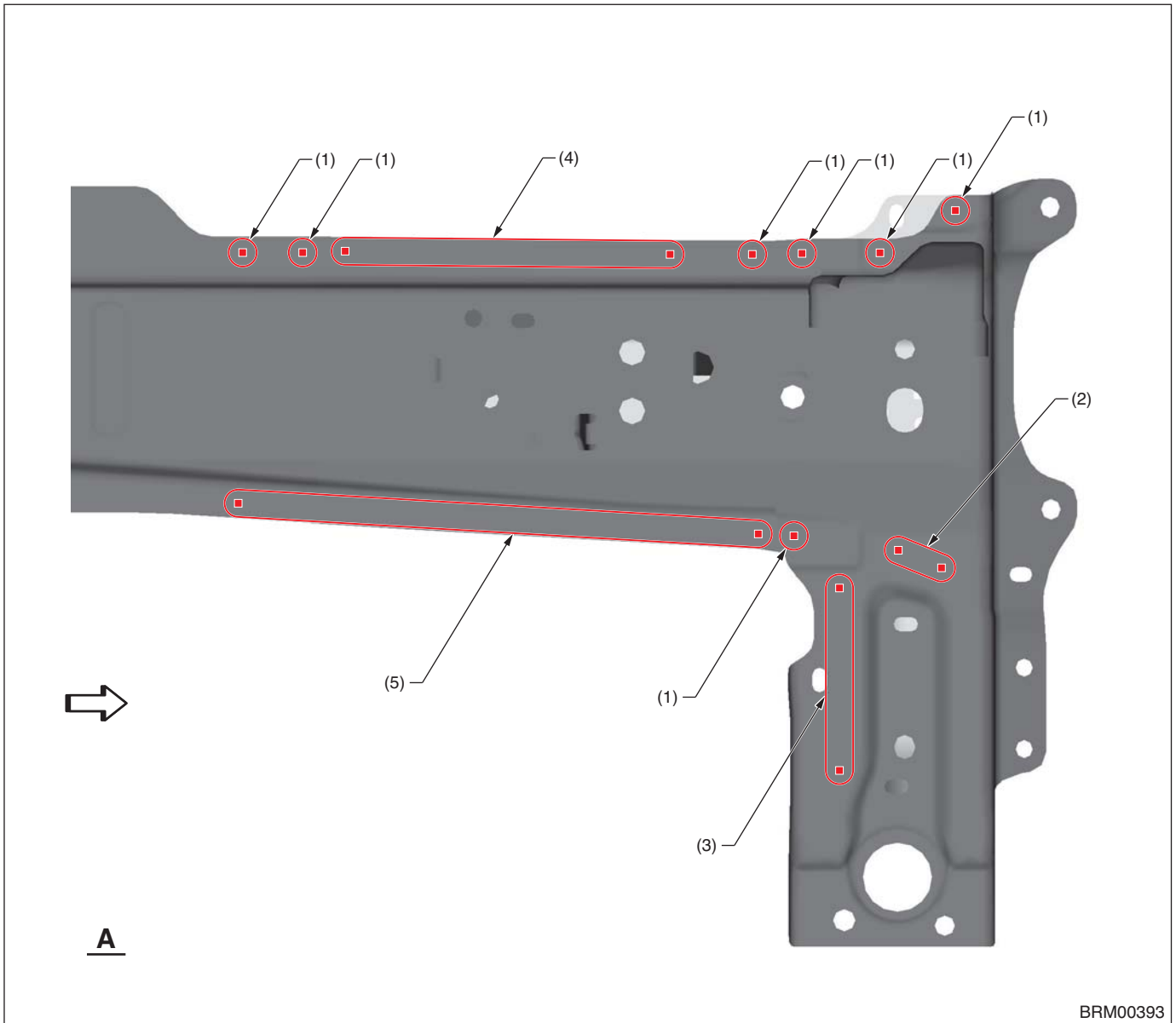
(1) 1 point
(2) 2 points

(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

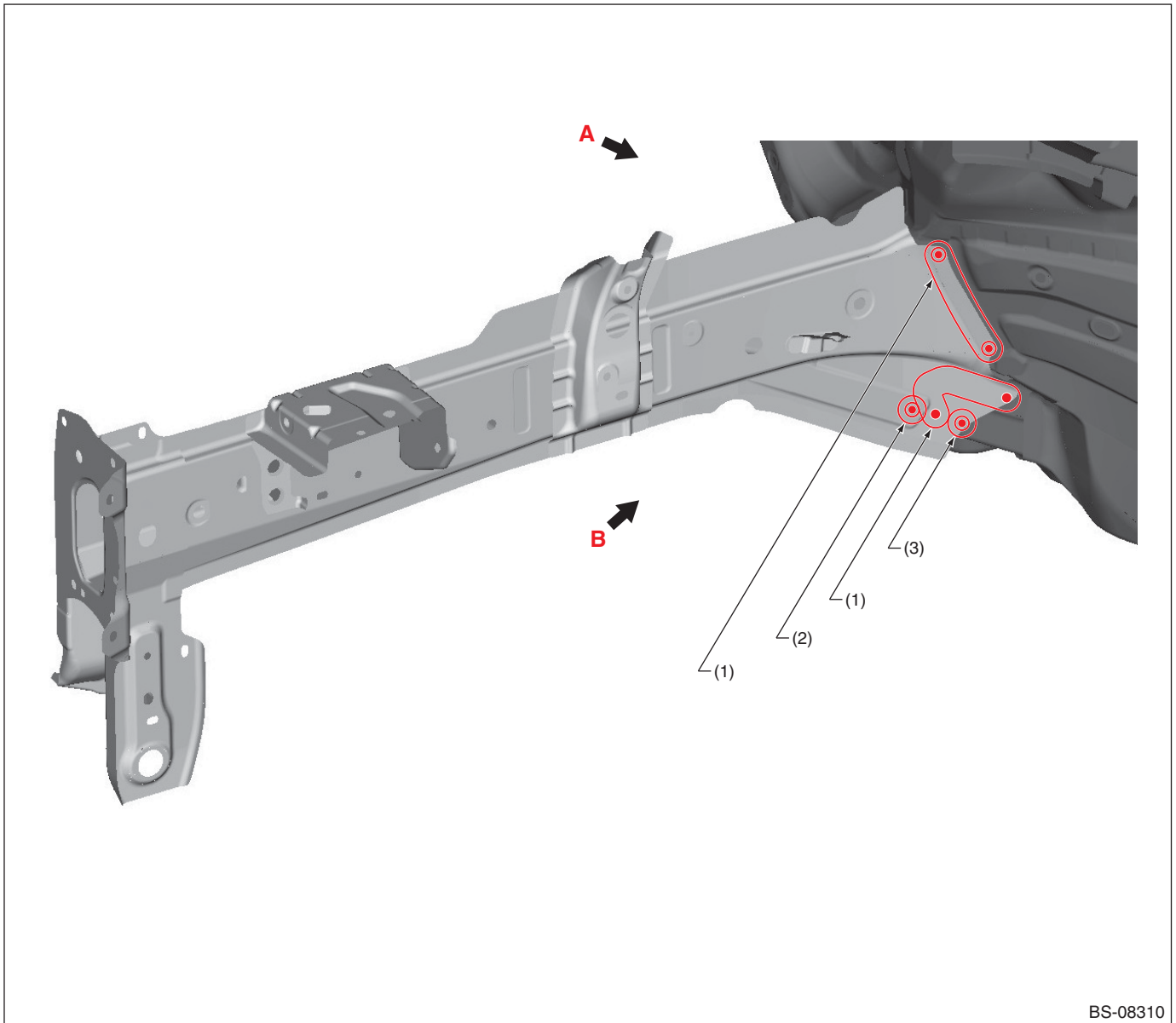
(5) 11 points

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

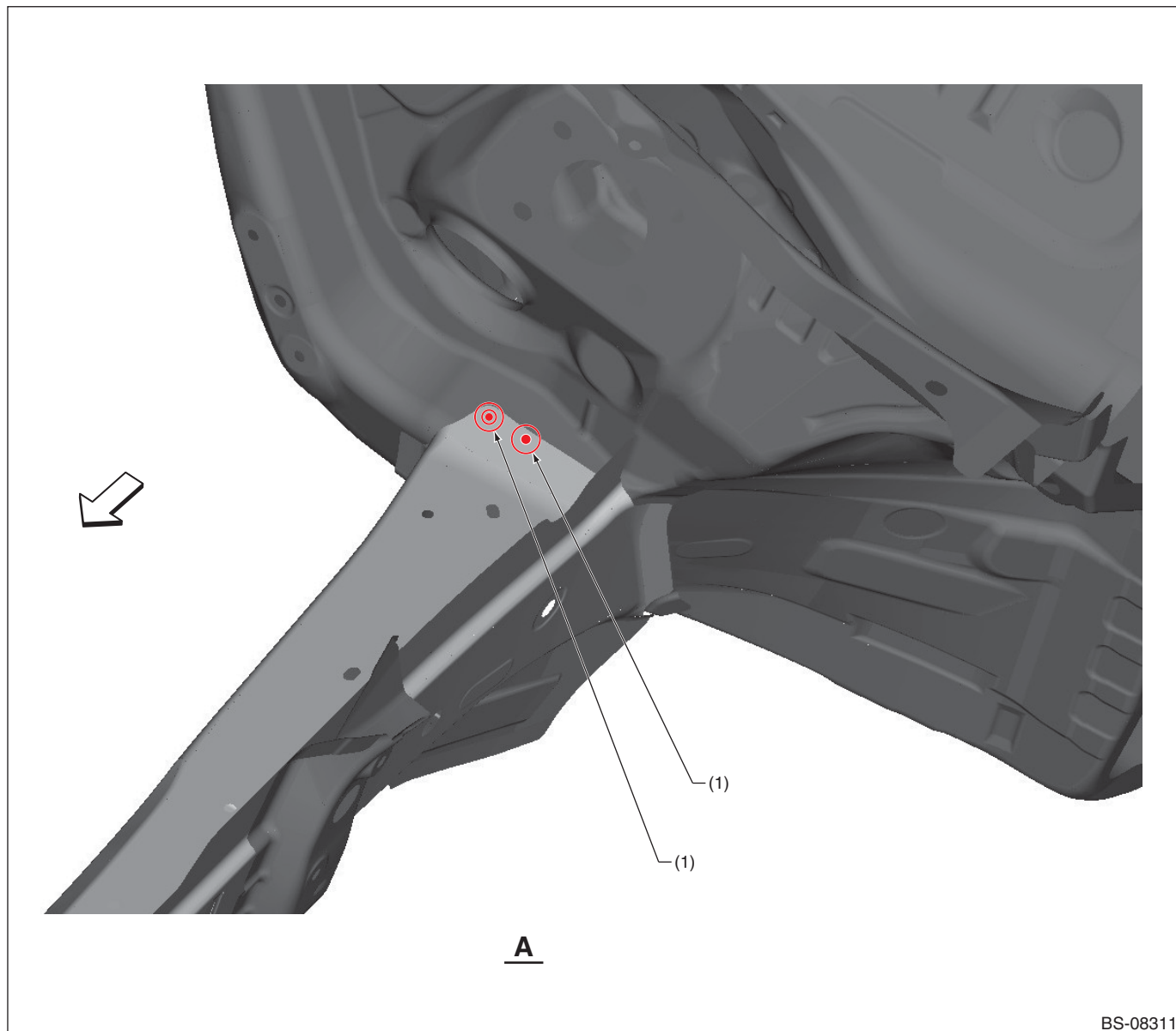
(1) 5 points (outside · 1)

(2) 1 point (outside · 2)

(3) 1 point (outside · 1)

Panel Replacement

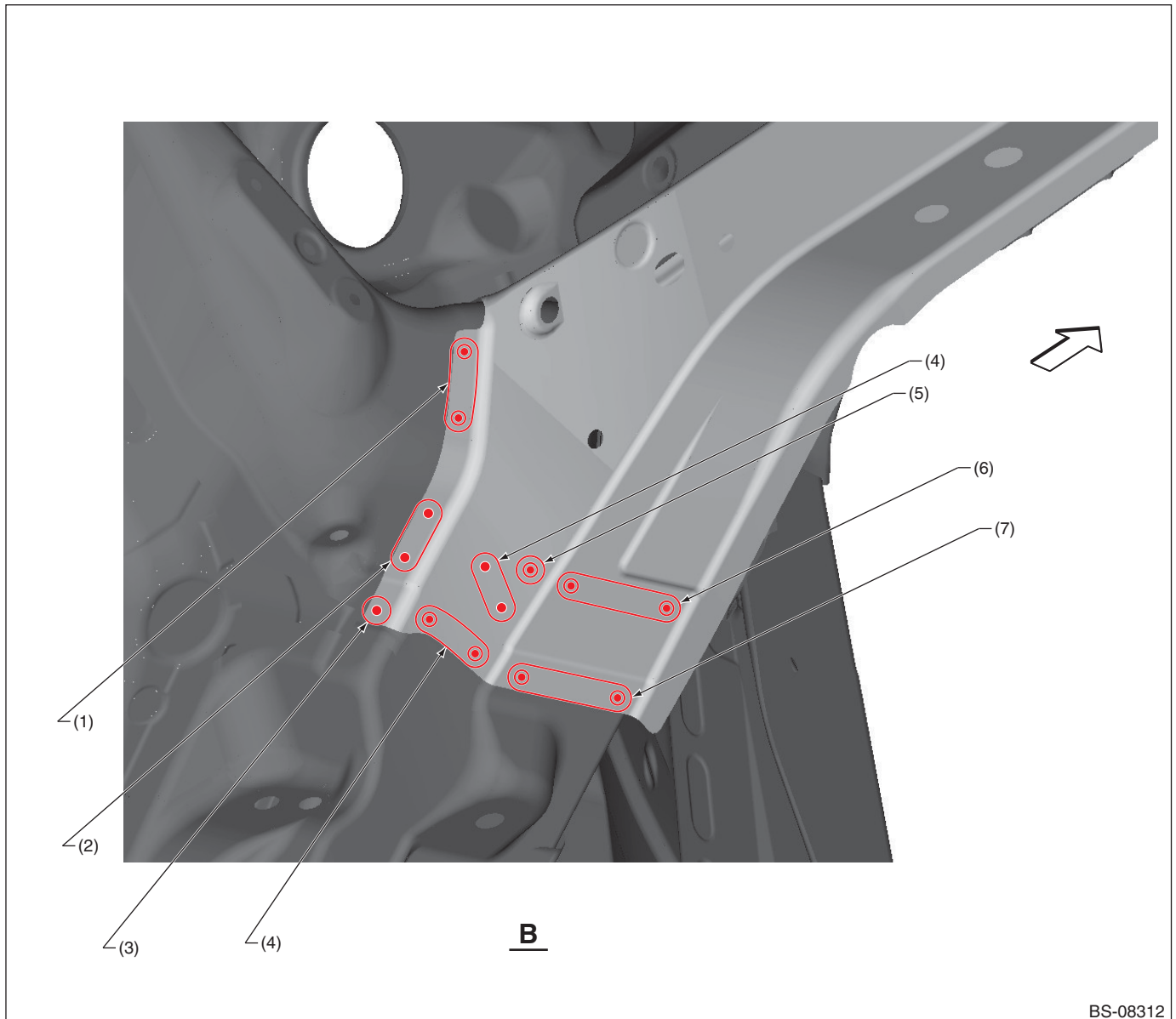
• Views A



(1) 1 point (top · 1)

Panel Replacement

• Views B



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

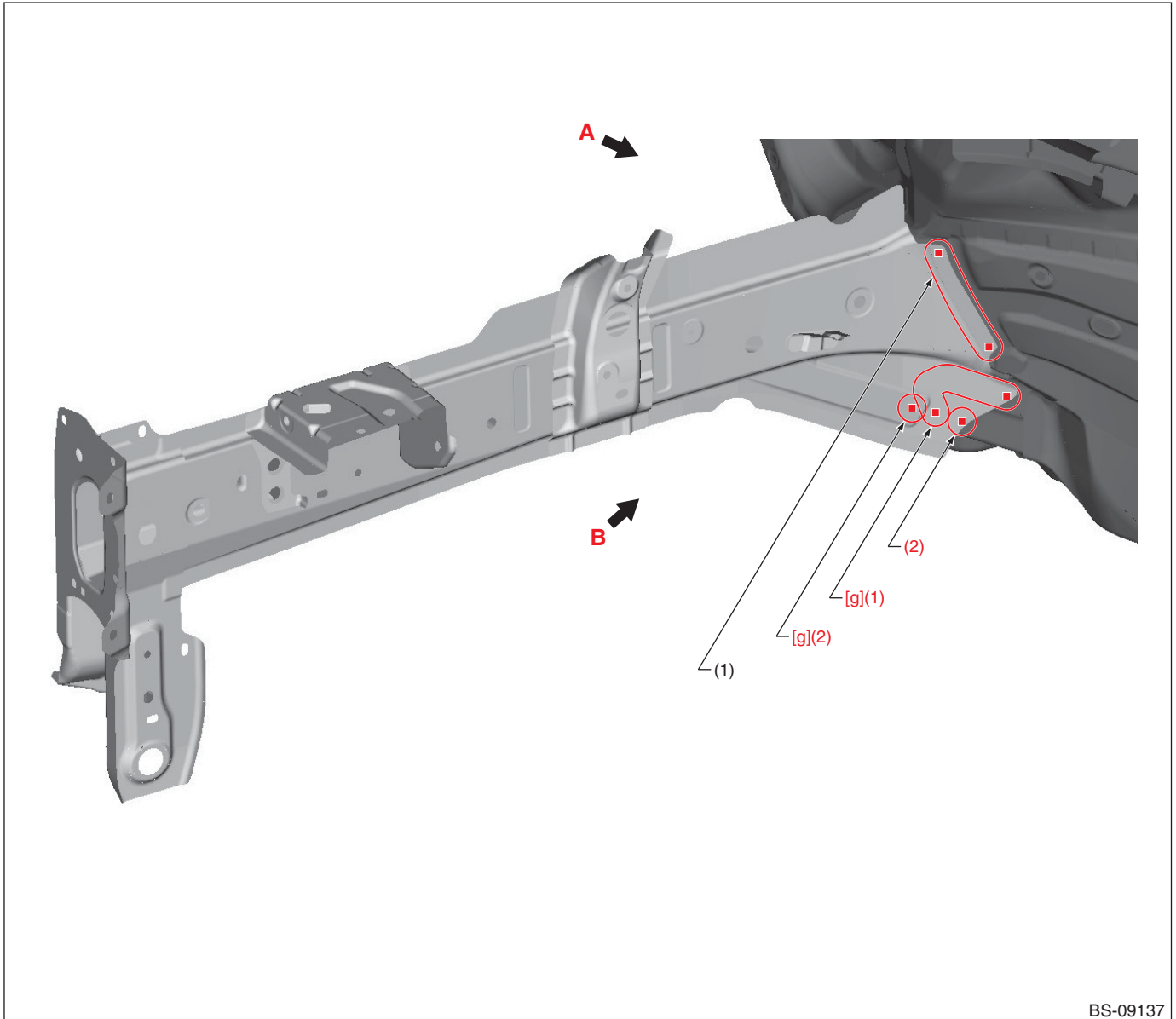
- (4) 2 points (inside · 1)
- (5) 1 point (inside · 2)
- (6) 3 points (bottom · 2)

- (7) 3 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09137

(1) 5 points (service)

(2) 1 point (service)

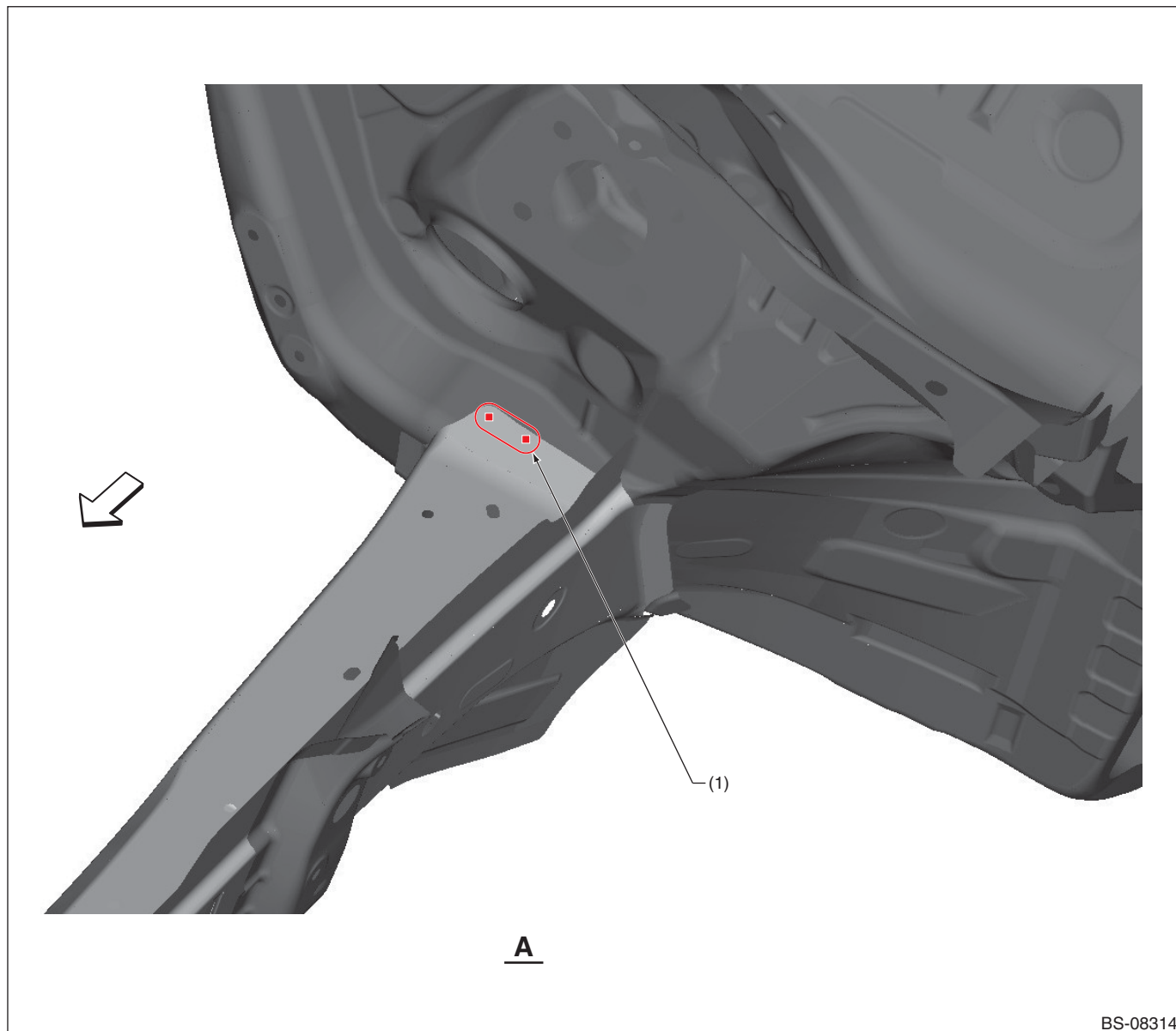
[g] Plug welding

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

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

Panel Replacement

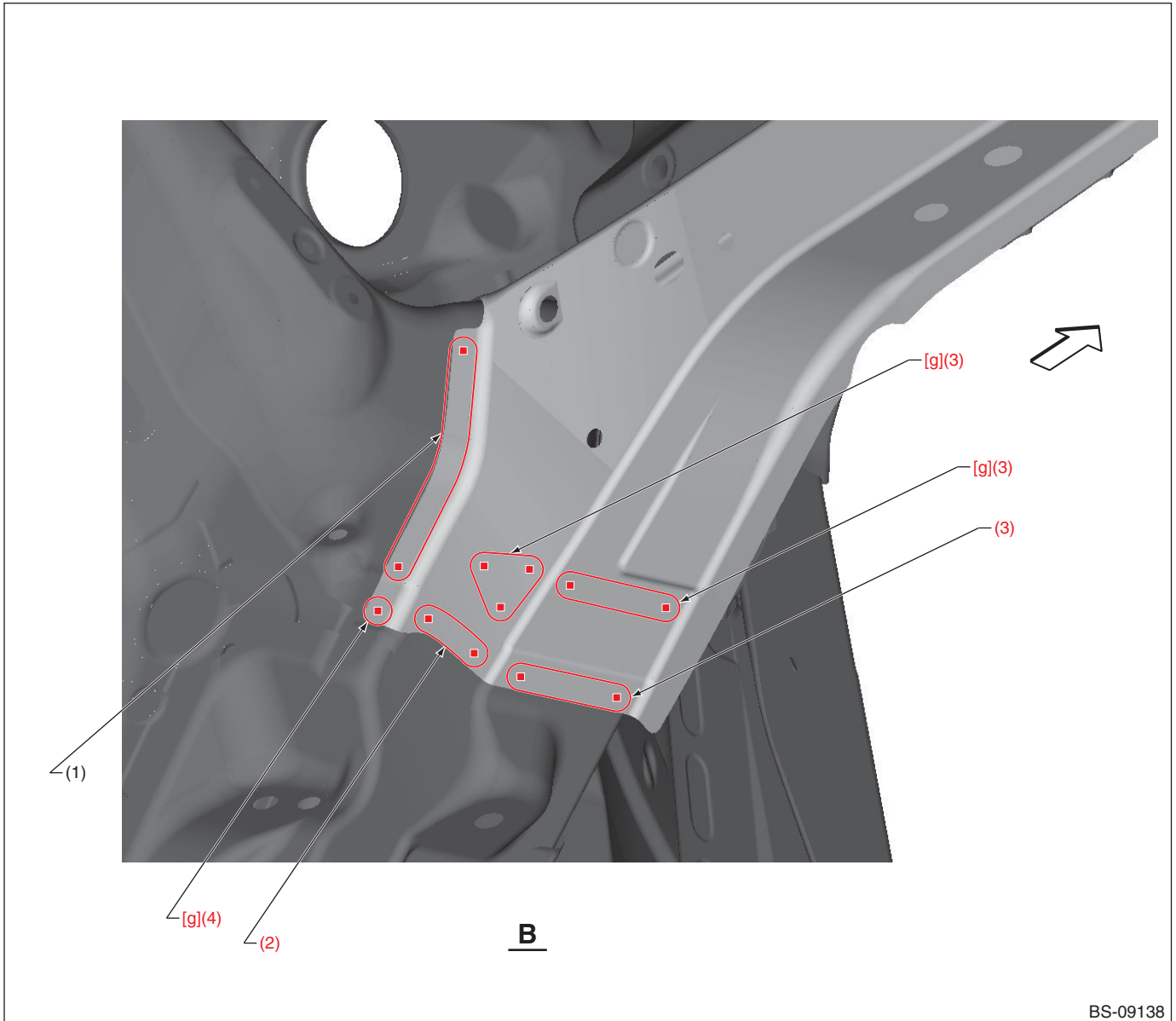
- Views A



(1) 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: CO2

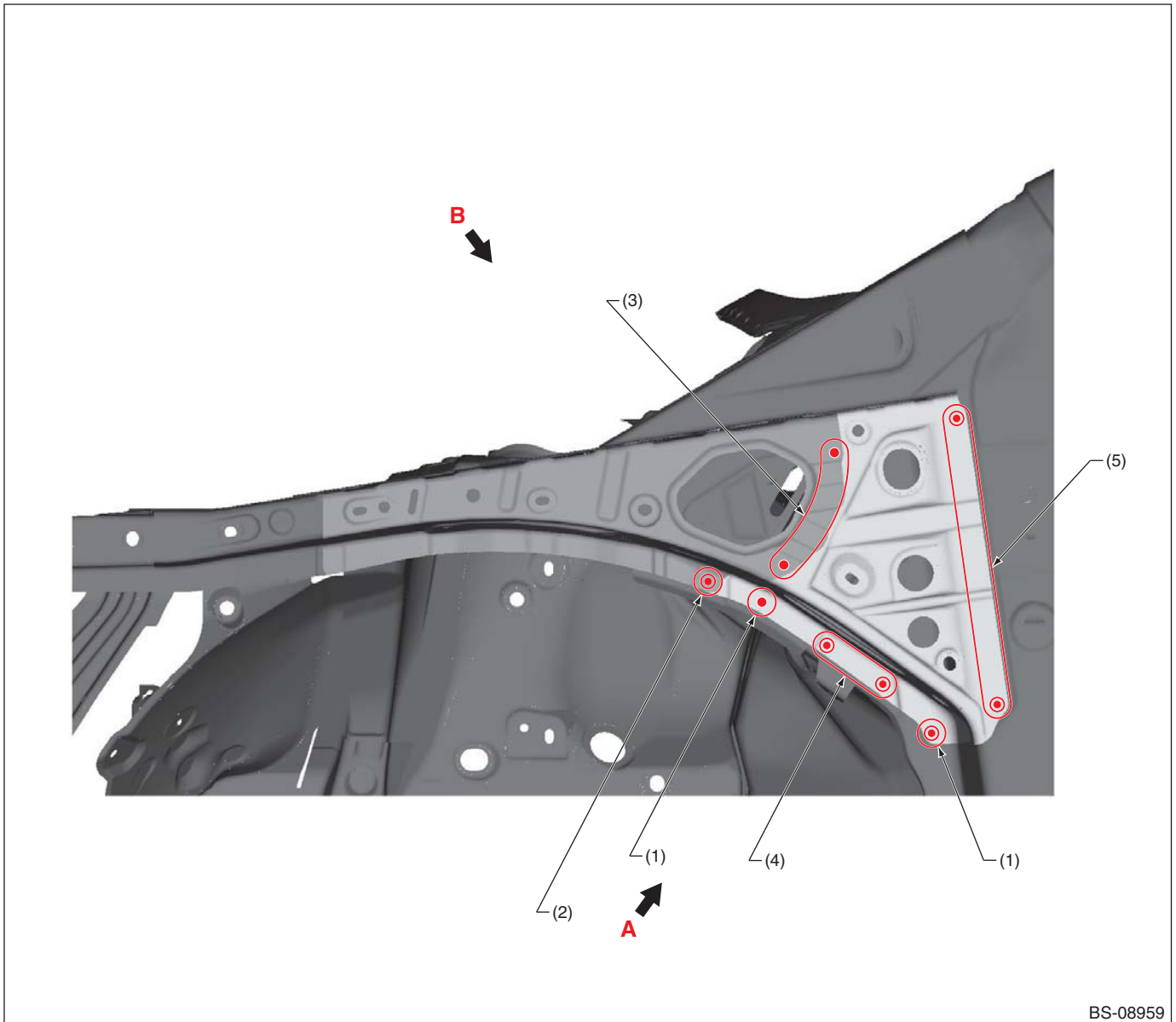
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-12. Front Pillar Outer (partial replacement)

A: REMOVAL

• Overall view1



BS-08959

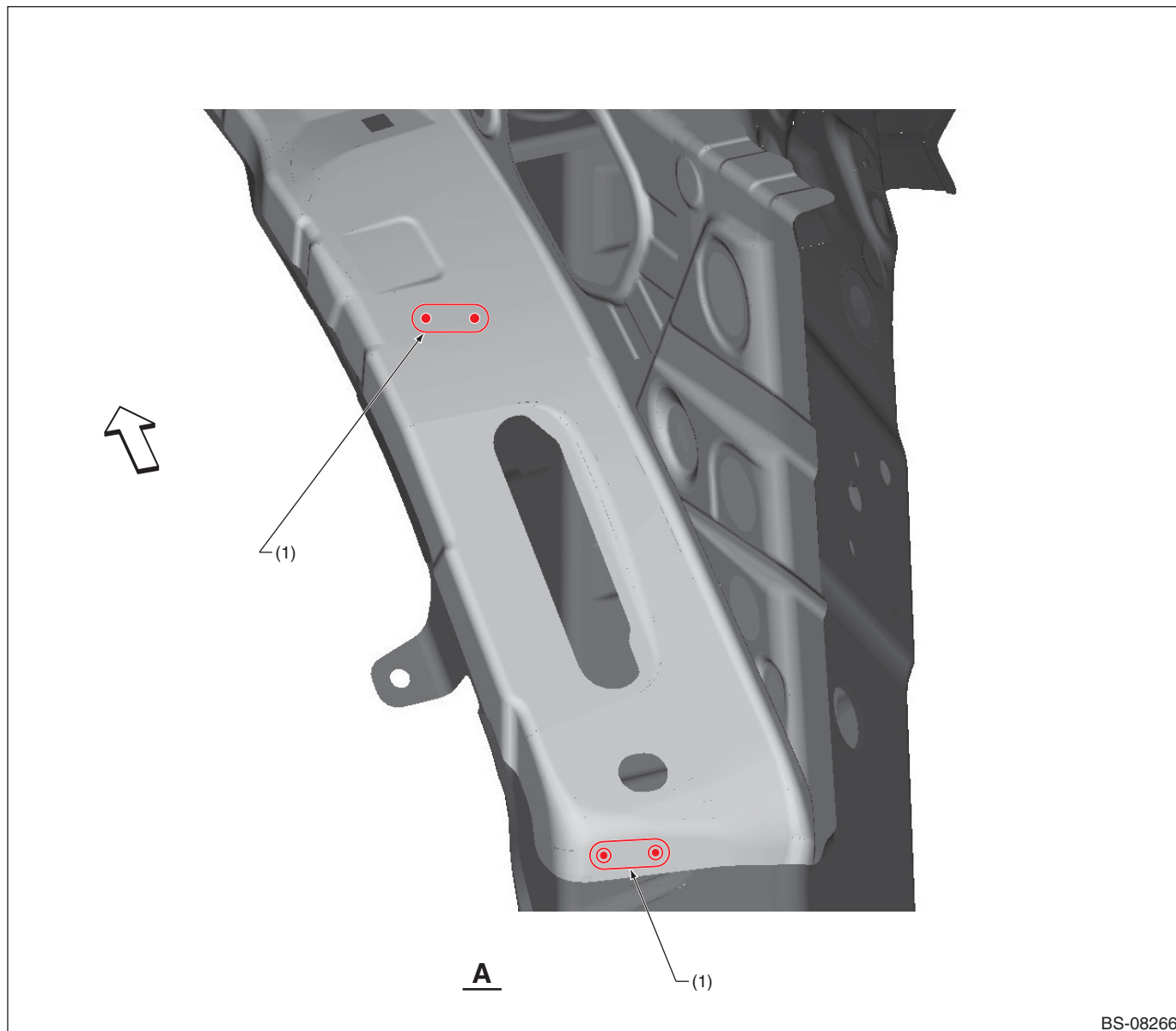
(1) 1 point (outside · 1)
(2) 1 point (outside · 2)

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

(5) 5 points (outside · 1)

Panel Replacement

• Views A

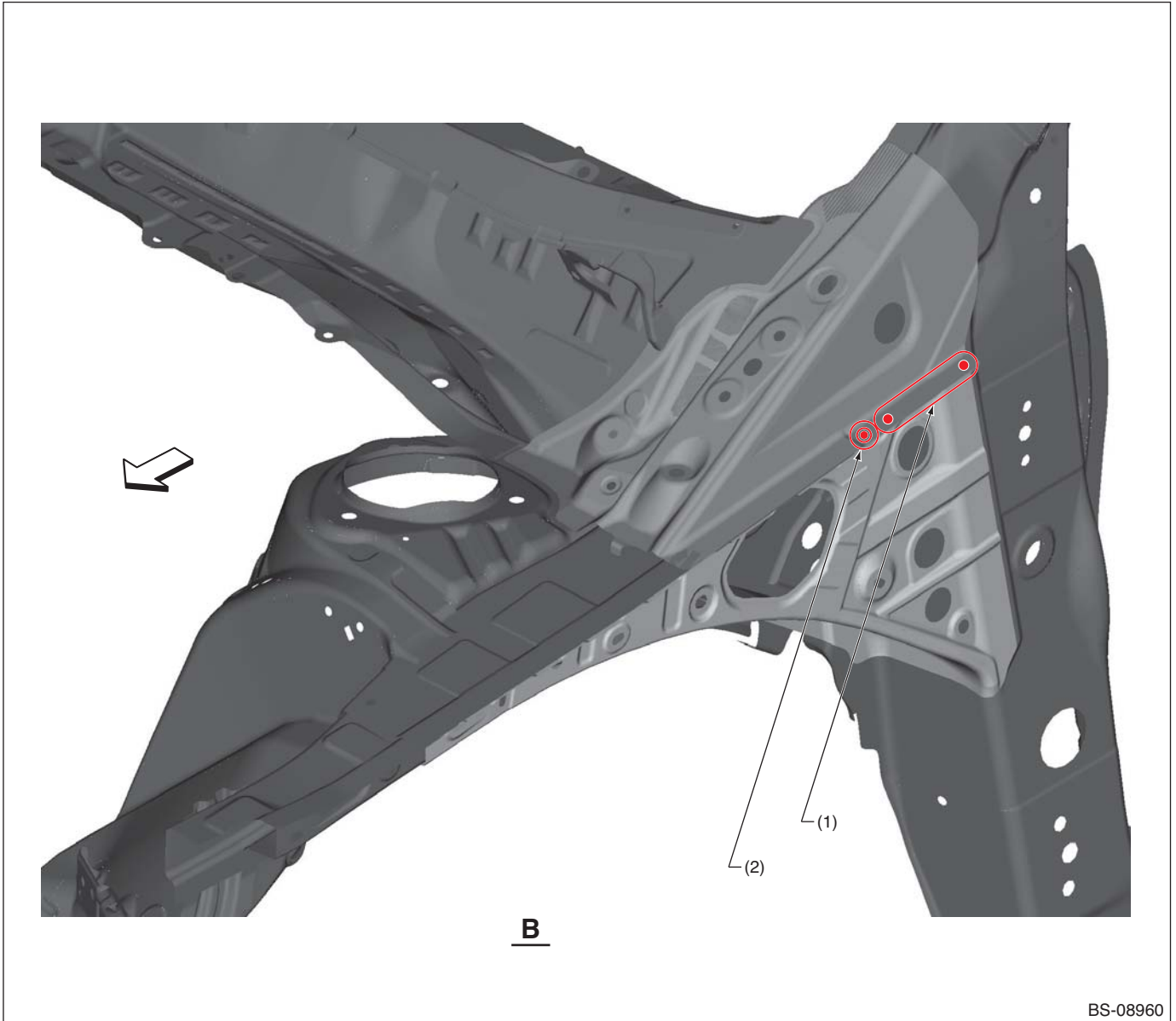


BS-08266

(1) 2 points (outside · 1)

Panel Replacement

• Views B

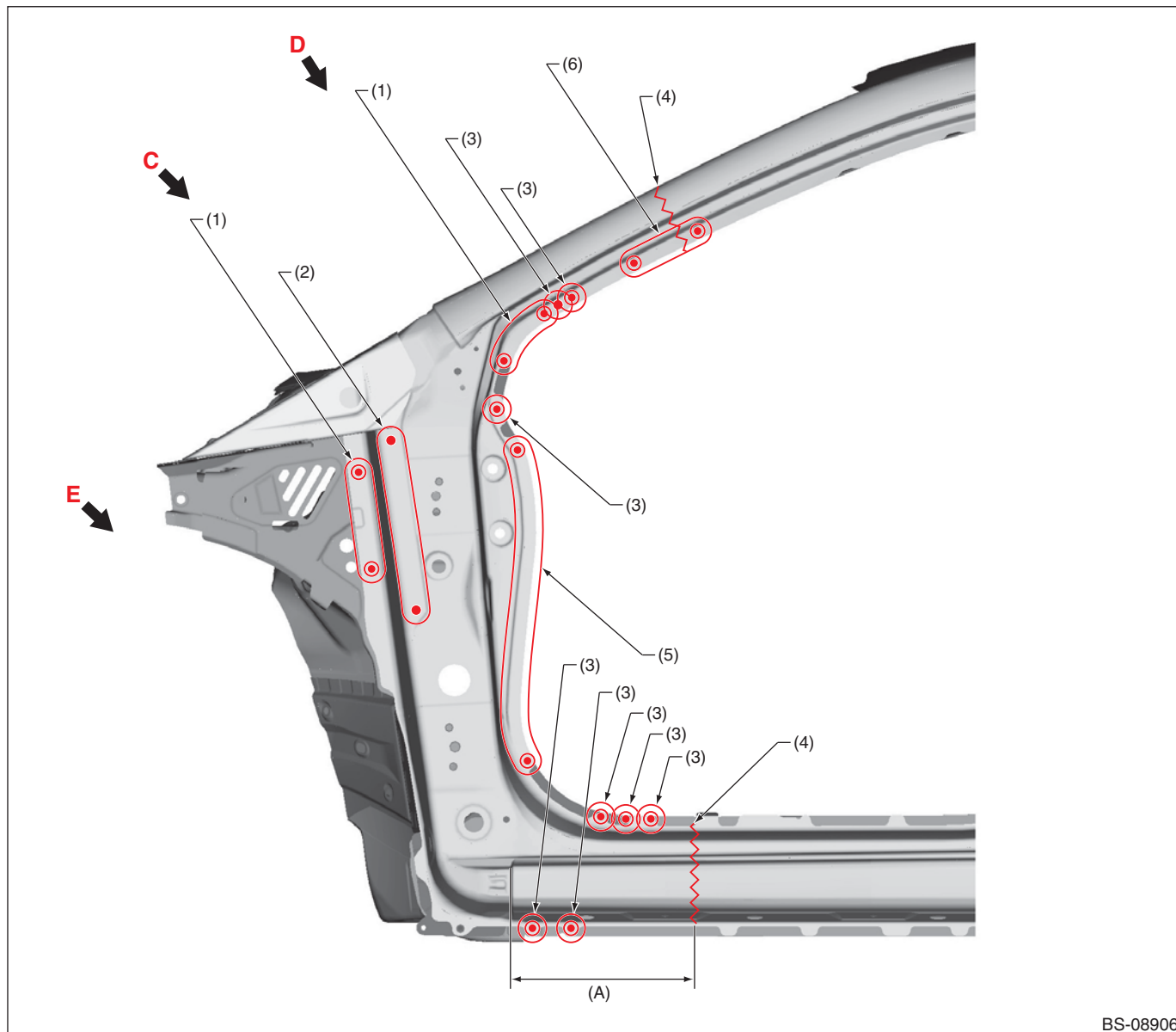


(1) 3 points (top · 1)

(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)

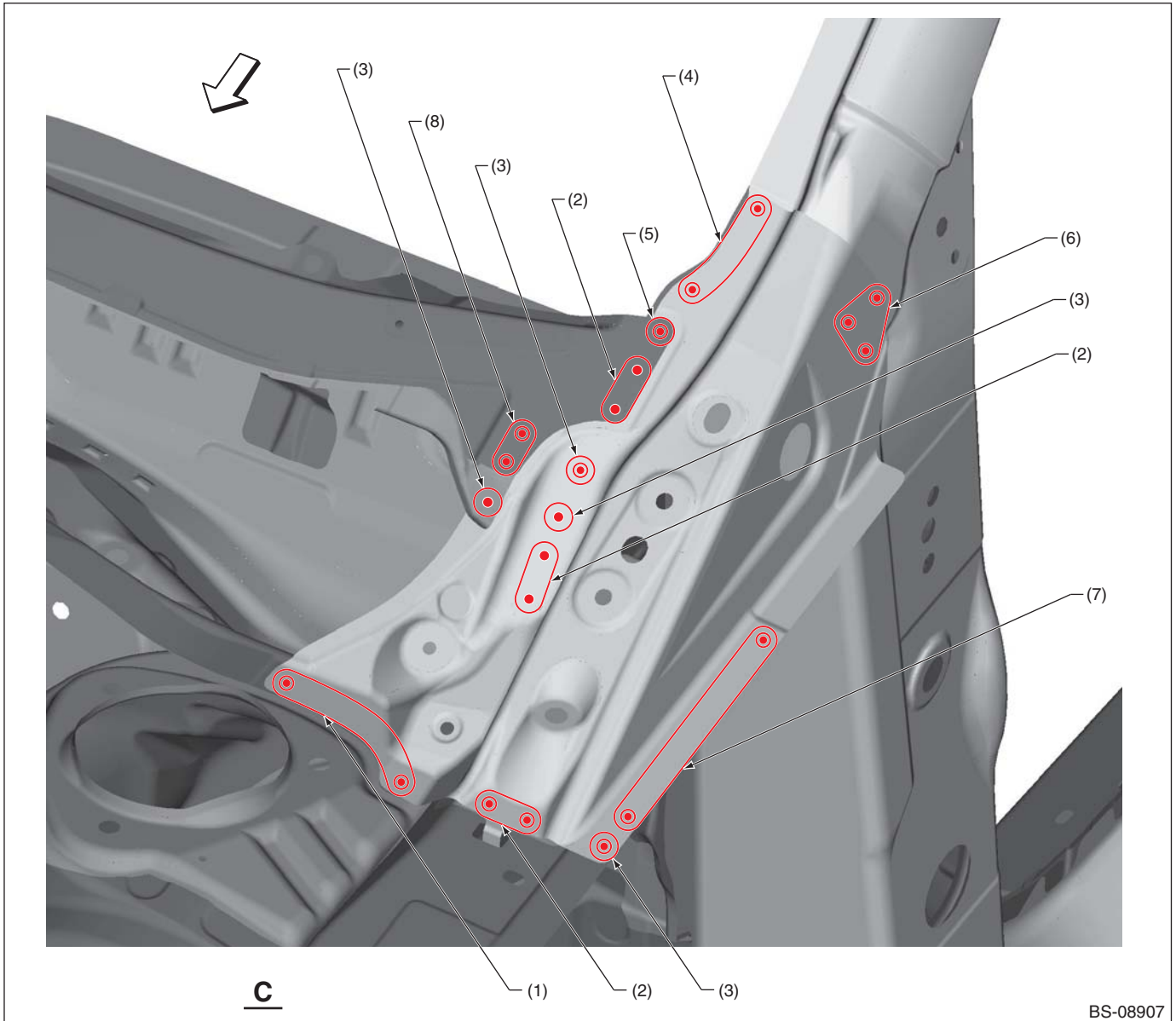
(4) Cut position

(5) 15 points (outside · 1)

(6) 4 points (outside · 1)

Panel Replacement

• Views C



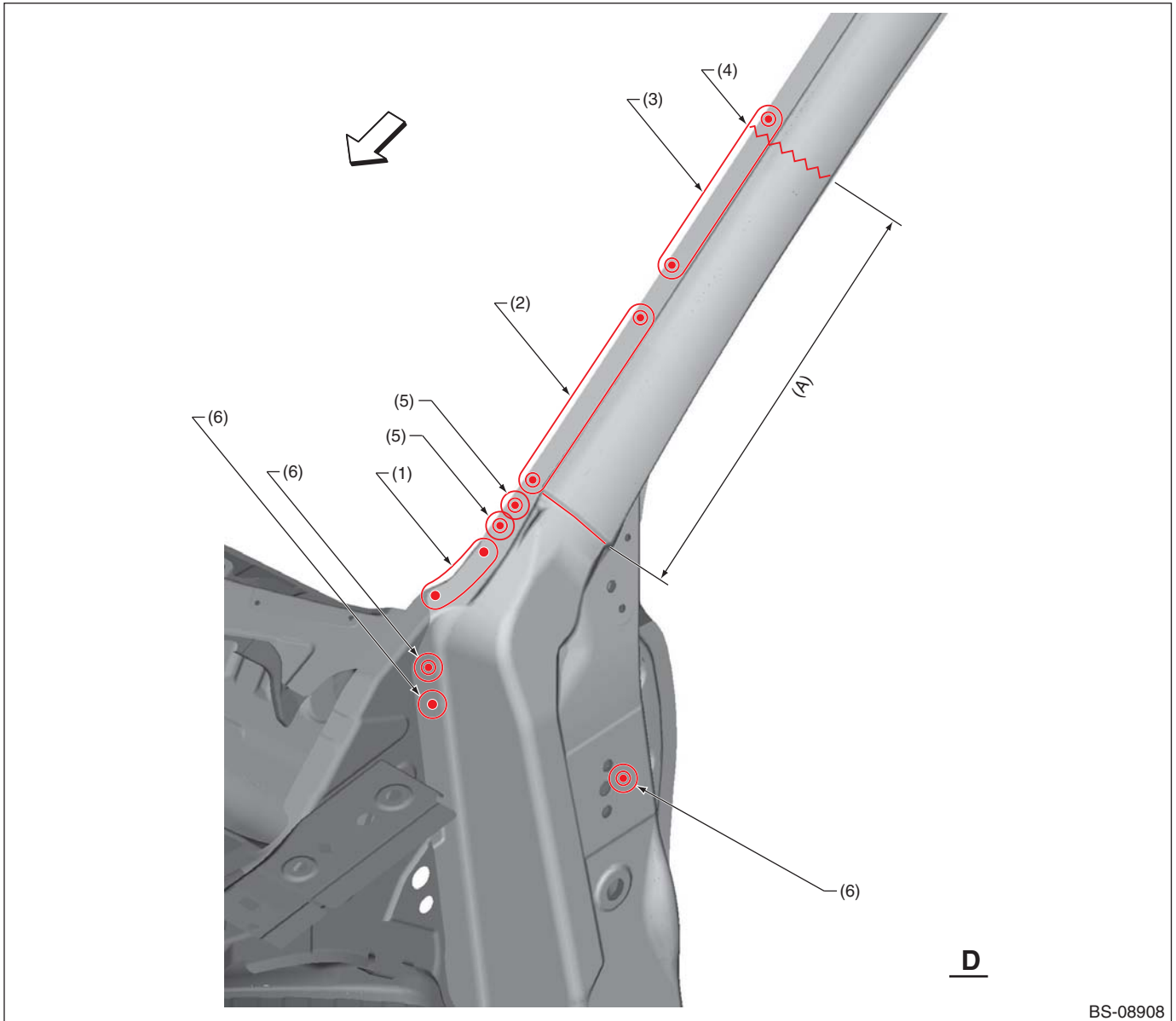
- (1) 4 points (top · 1)
- (2) 2 points (top · 1)
- (3) 1 point (top · 1)

- (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

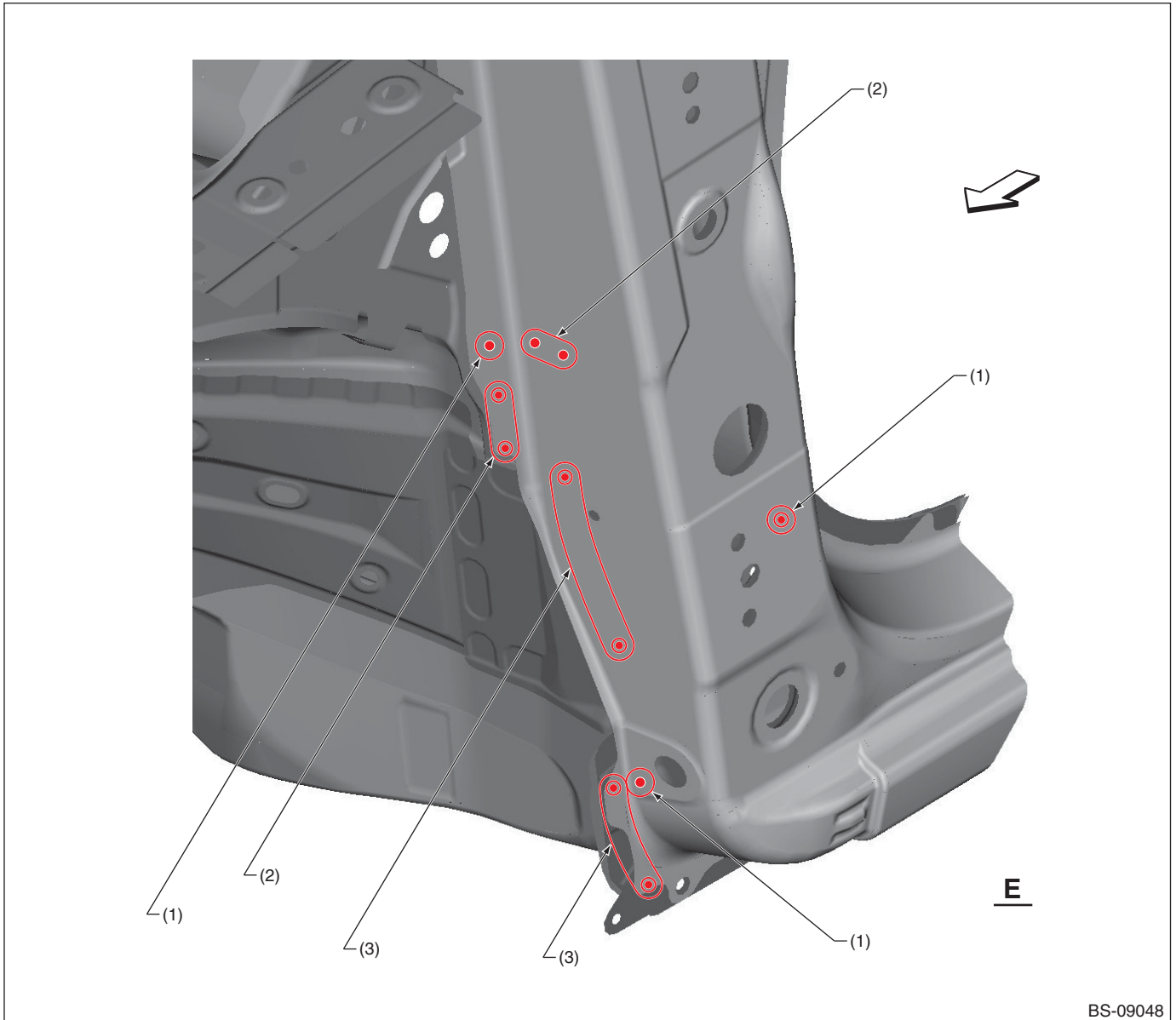
• Views D



BS-08908

Panel Replacement

• Views E



BS-09048

(1) 1 point (outside · 1)

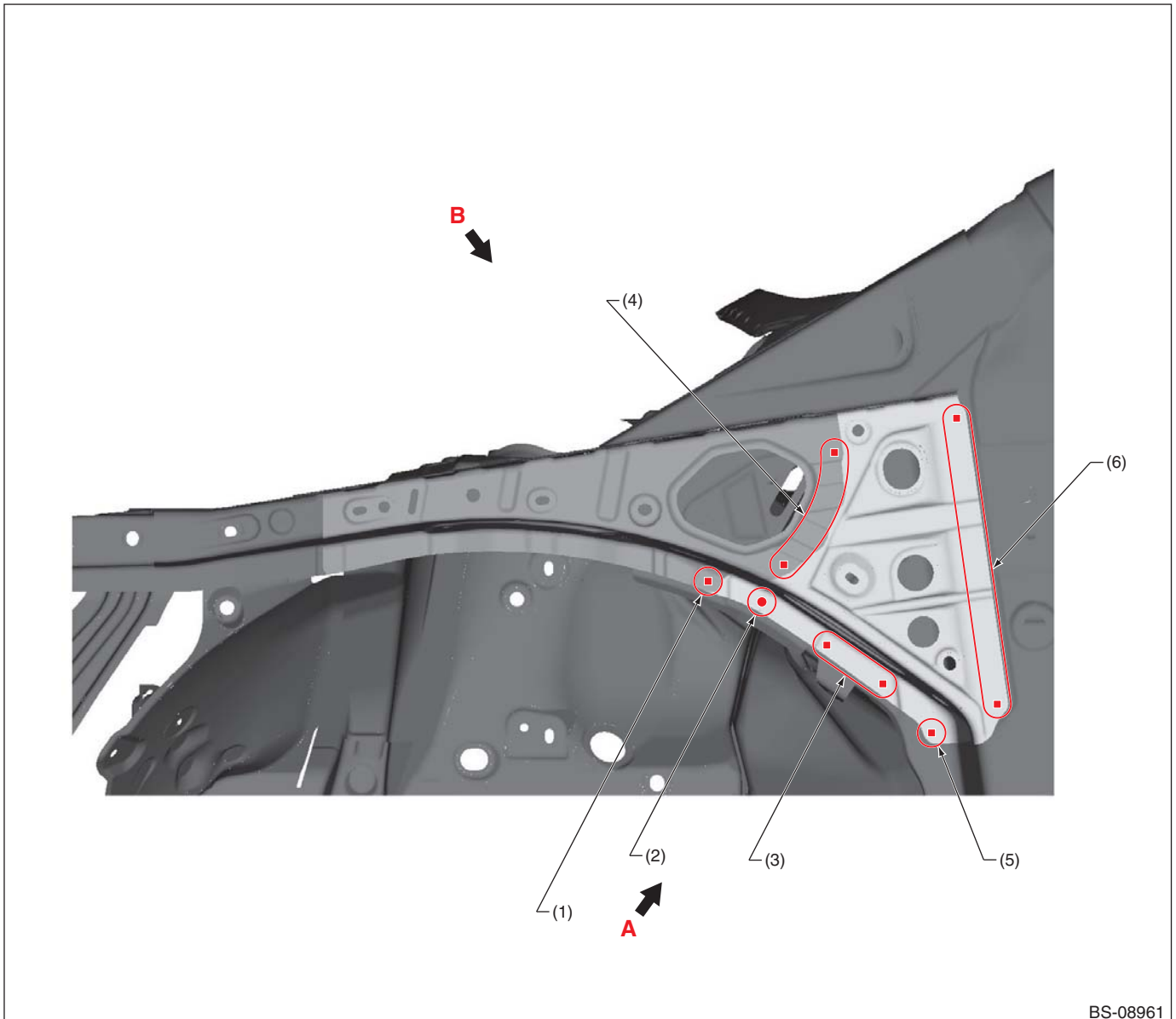
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view1



BS-08961

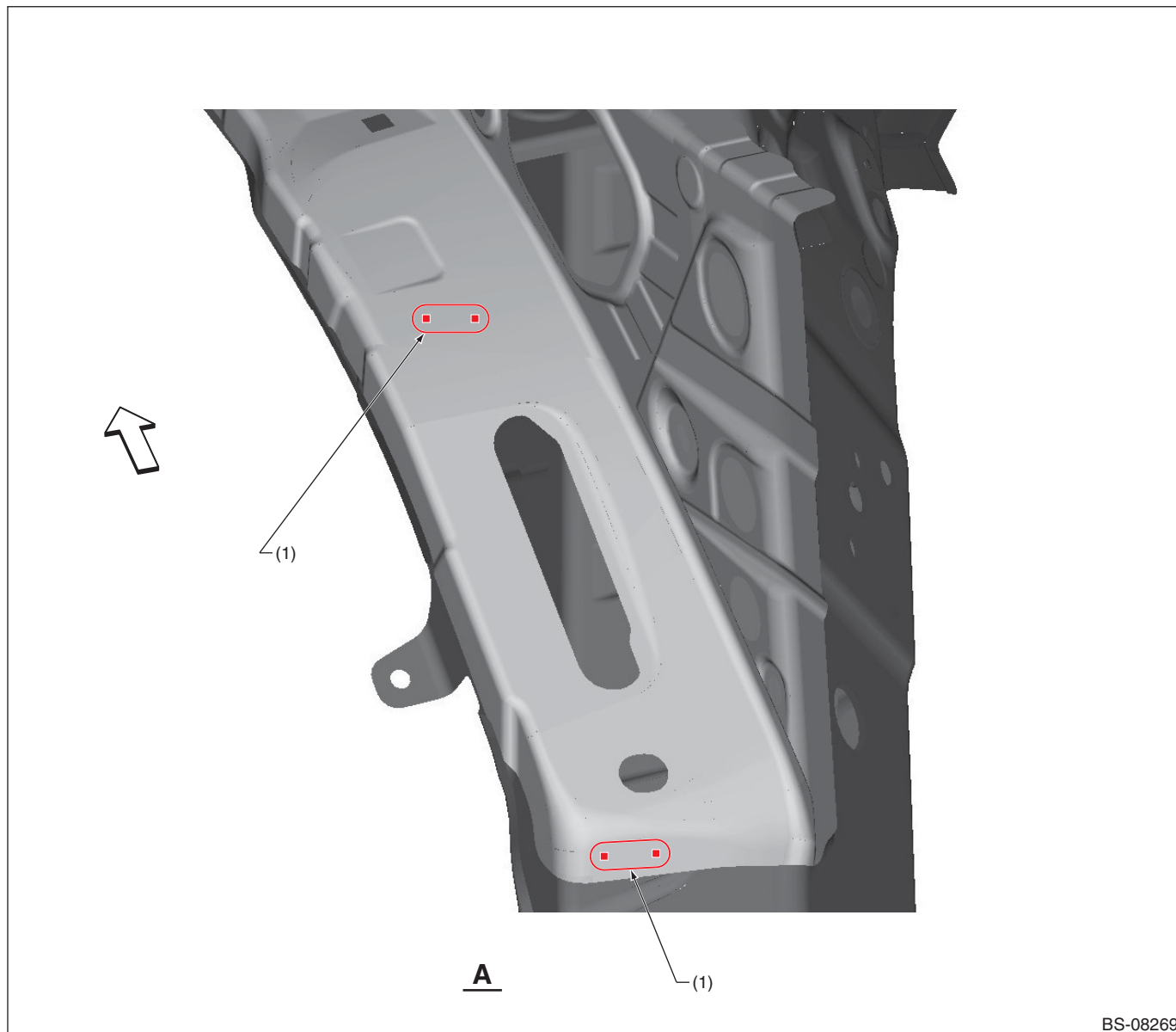
(1) 1 point (service · matching)
(2) 1 point

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

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

Panel Replacement

• Views A

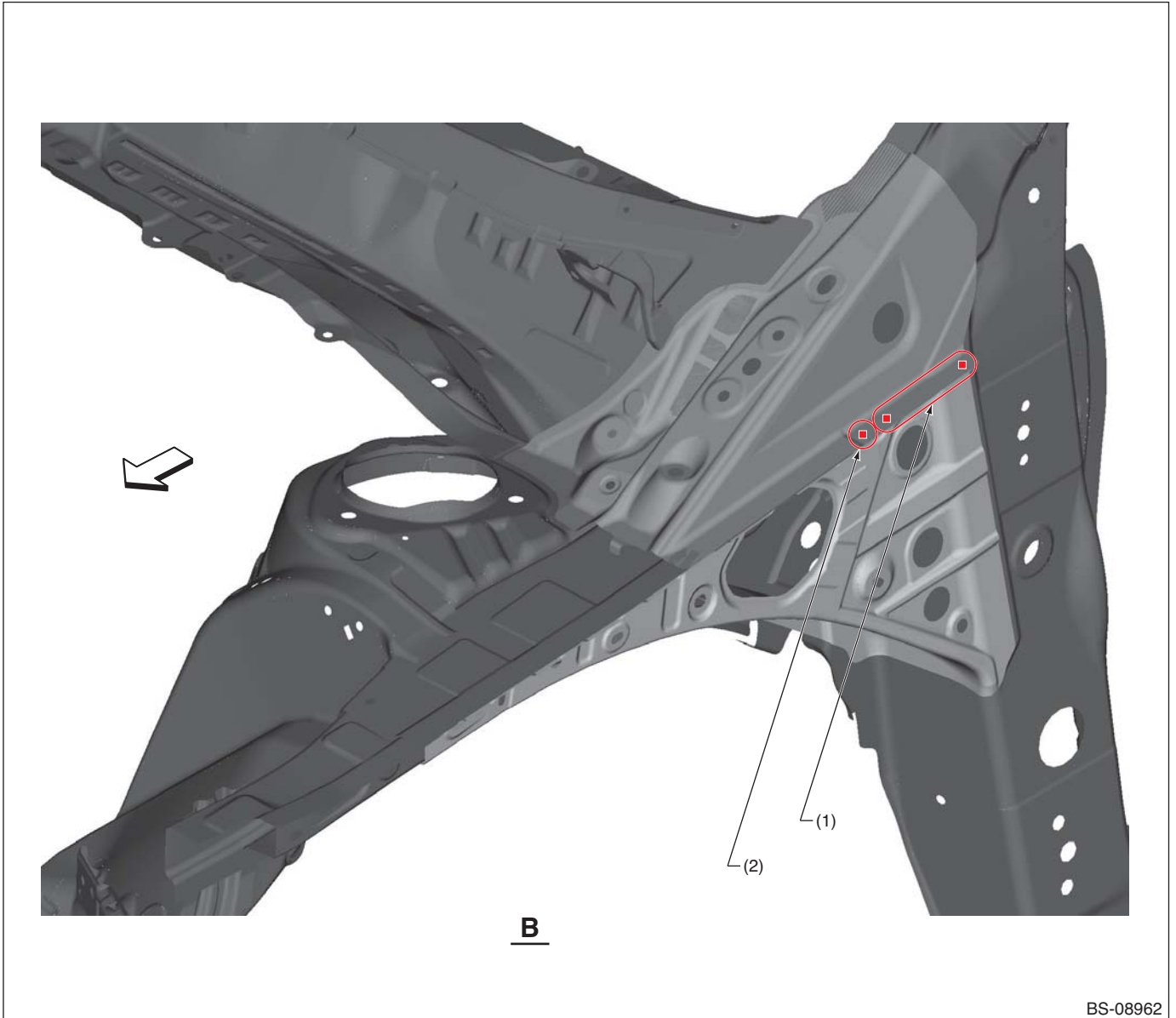


BS-08269

(1) 2 points (service)

Panel Replacement

- Views B

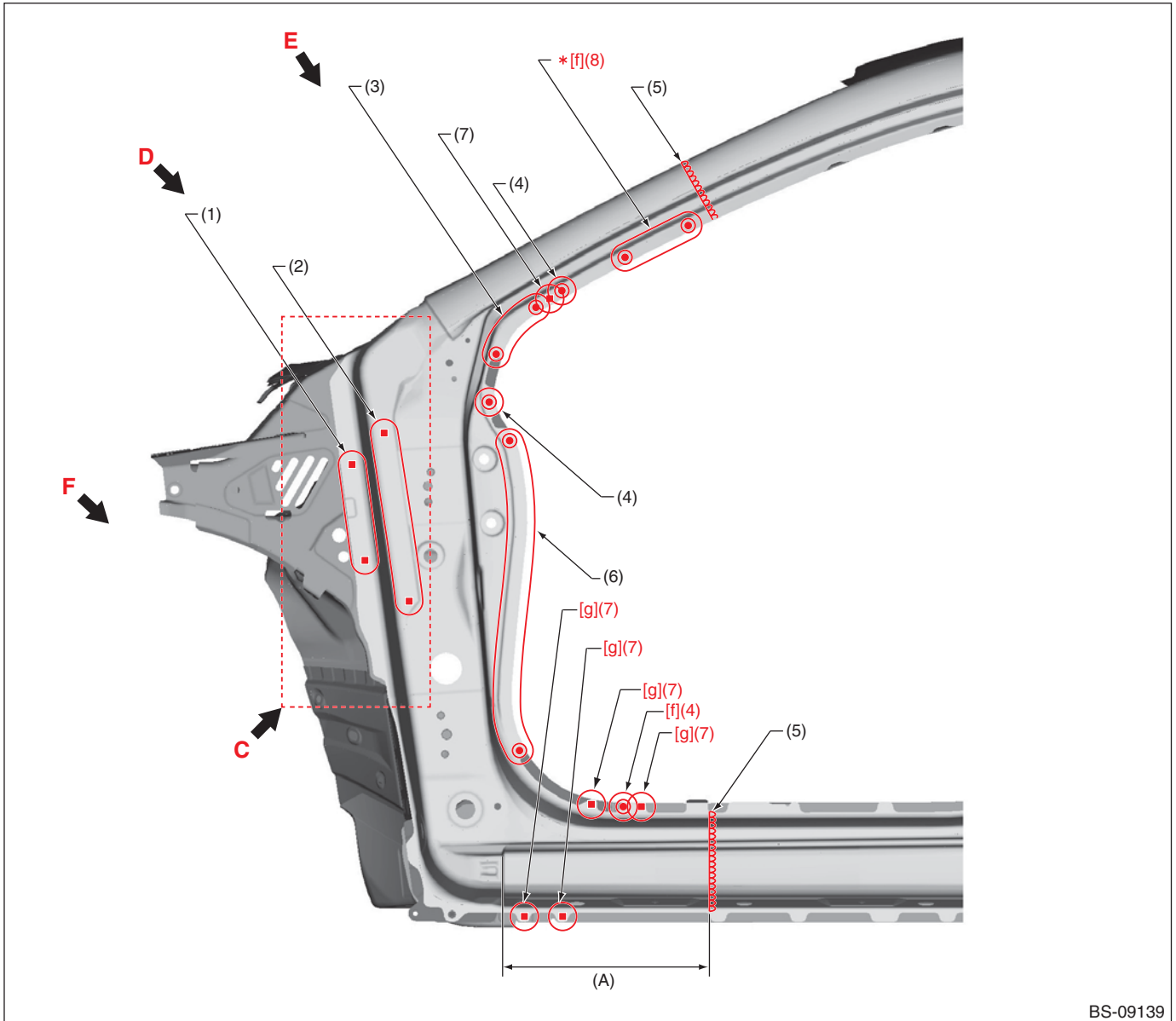


(1) 3 points

(2) 1 point

Panel Replacement

• Overall view2



(A) 290 mm [11.42 in]

(1) 3 points (service)

(2) 5 points (service)

(3) 3 points

(4) 1 point

(5) 1 point (Continuous welding)

(6) 15 points

(7) 1 point (service)

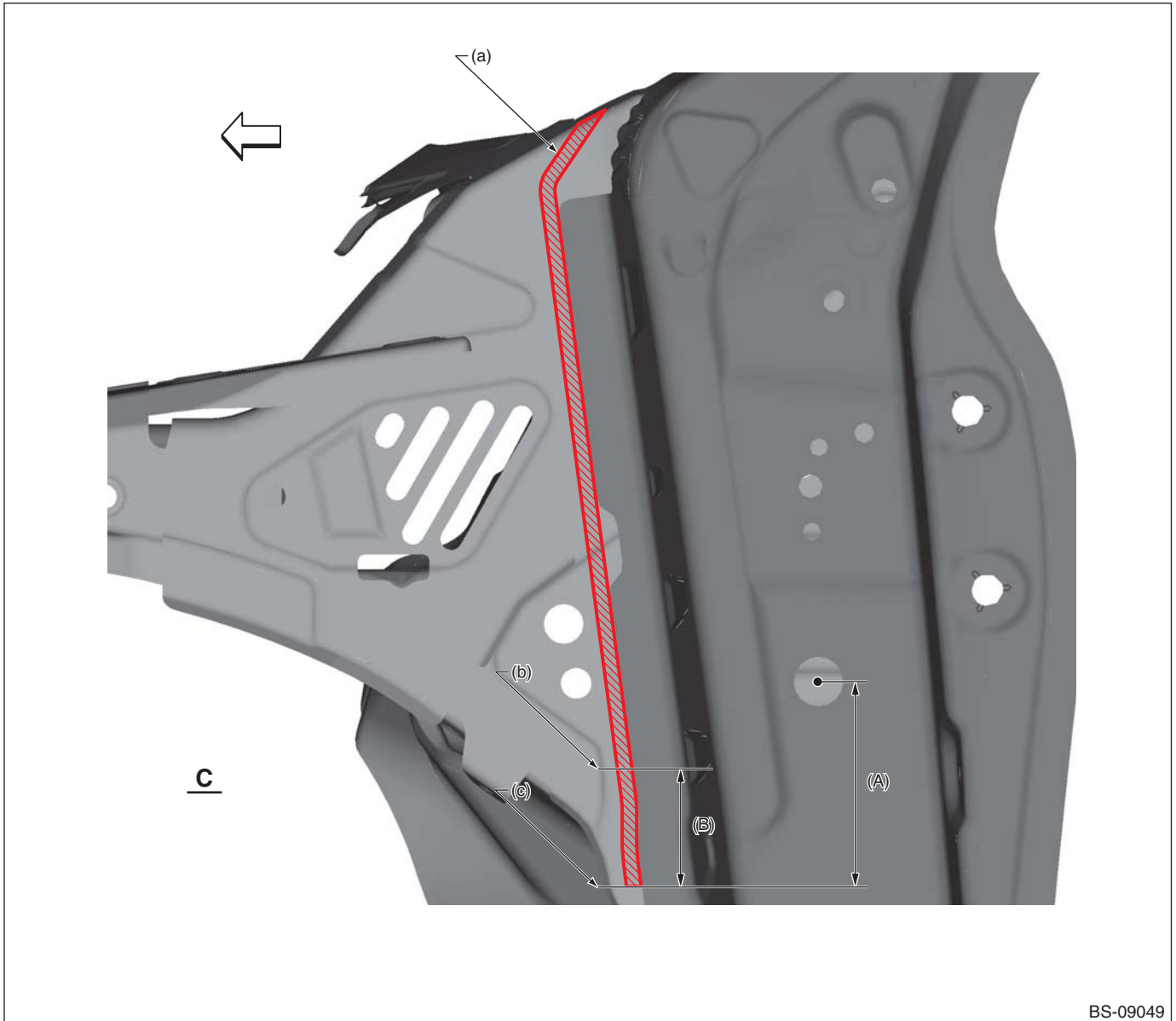
(8) 4 points

* : 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




(A) 104 mm [4.09 in]

(B) 55 mm [2.17 in]

(a) A point

(b) B point

(c) C point

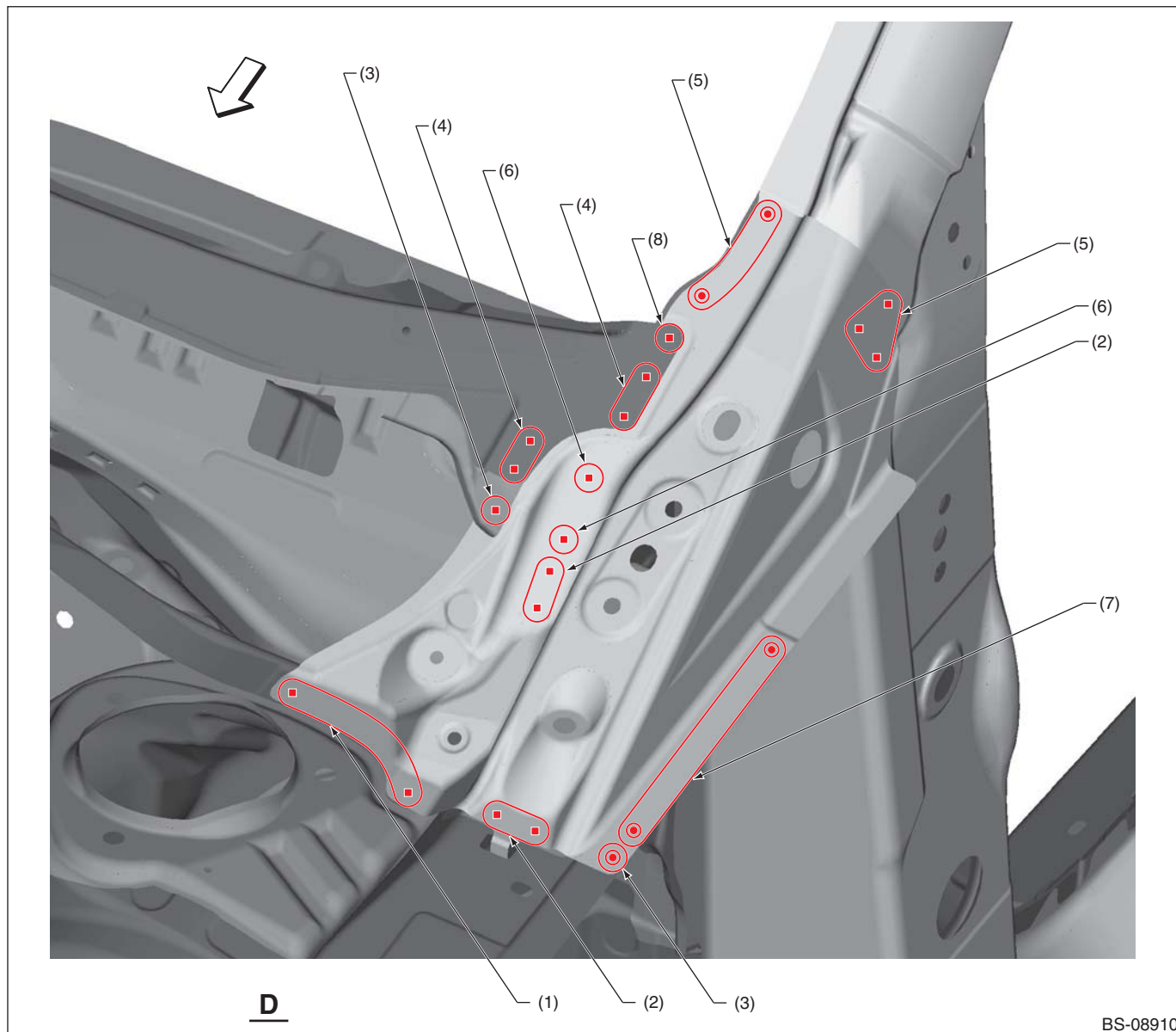
 : Spotting sealer application location (Spotting sealer or sealing [Three Bond 4101 (004403063)])

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



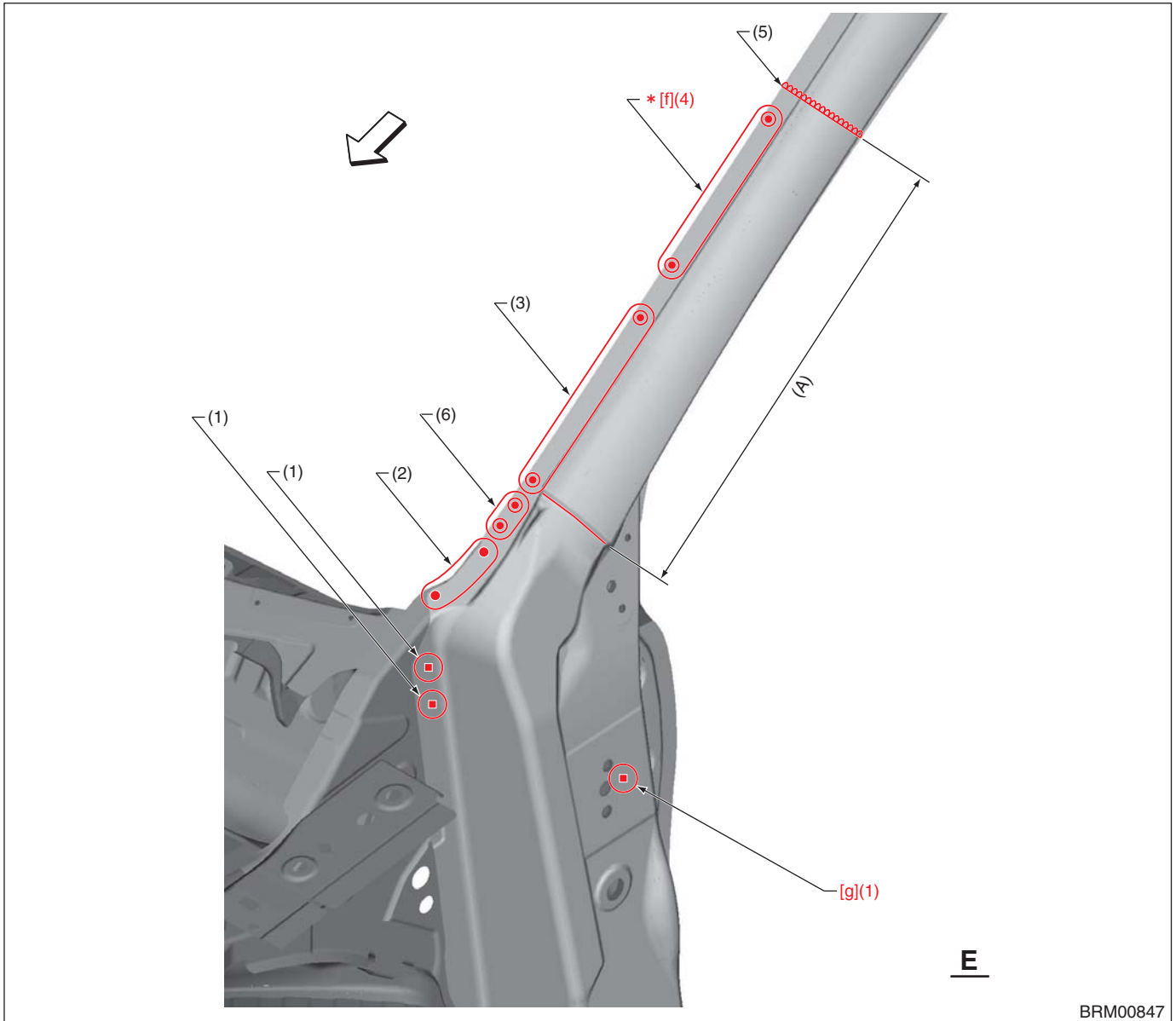
- (1) 4 points (service)
- (2) 2 points (service)
- (3) 1 point

- (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)

(2) 3 points

(3) 5 points

(4) 4 points

(5) 1 point (Continuous welding)

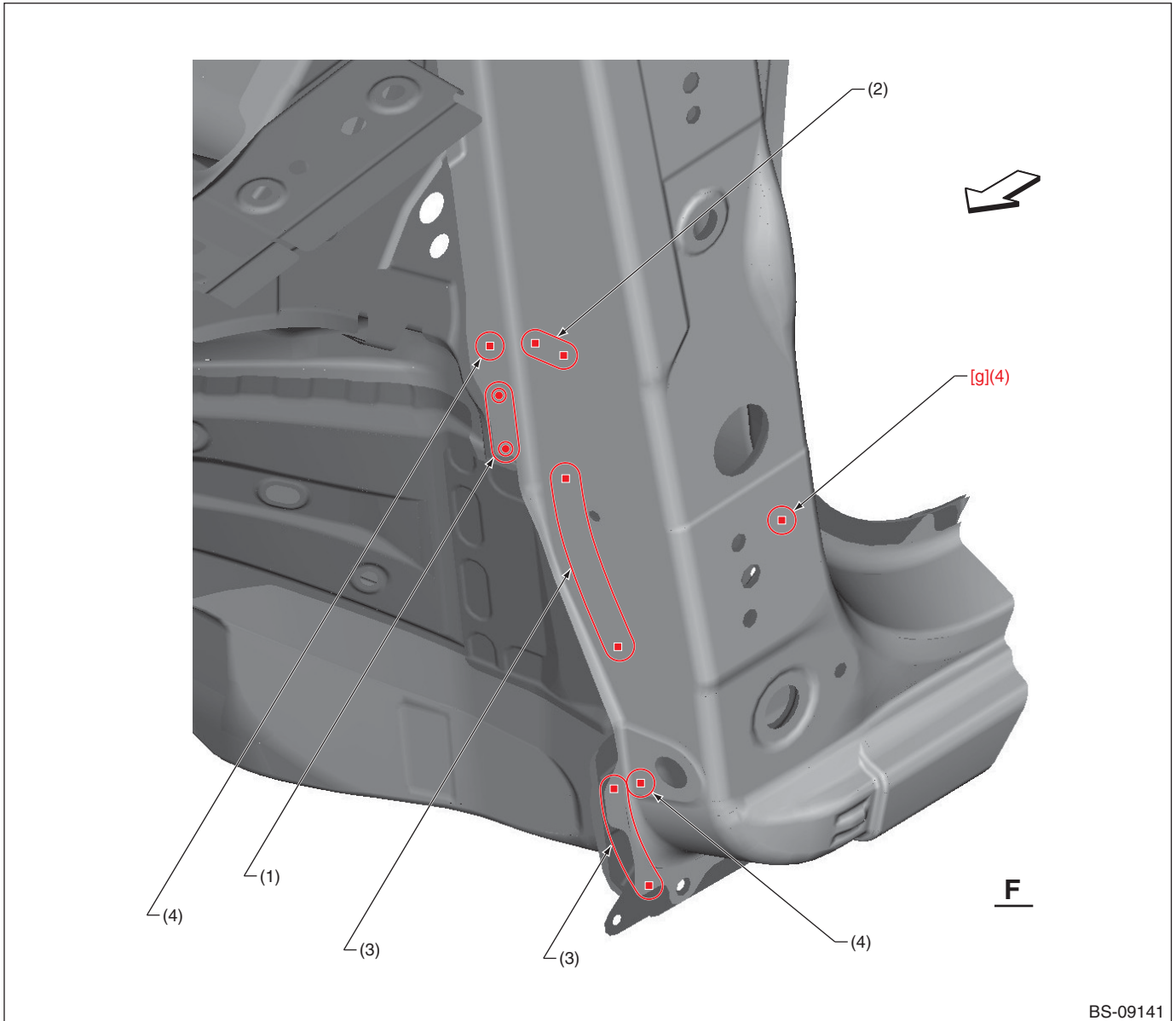
(6) 2 points

* : 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: CO2

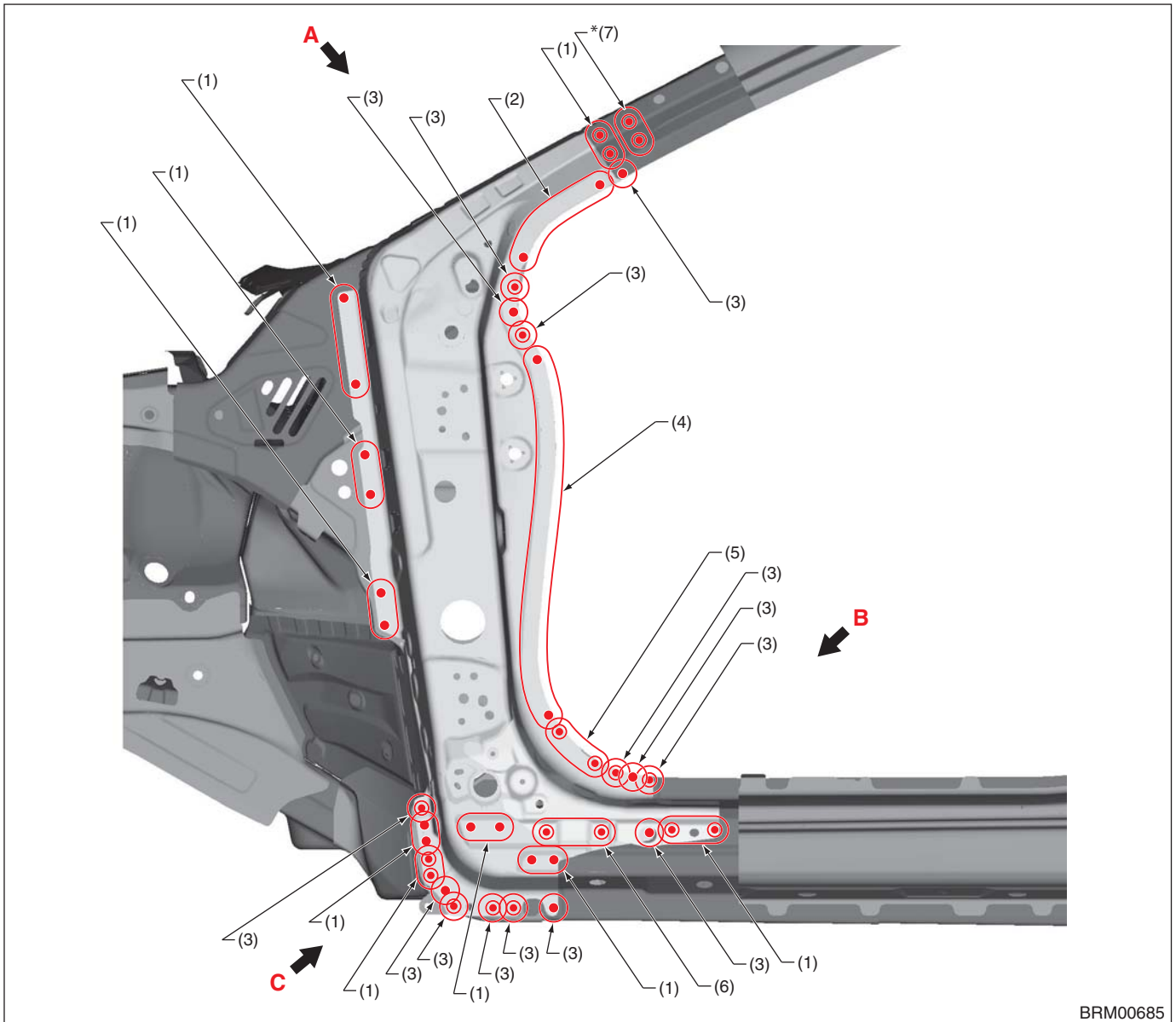
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

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)

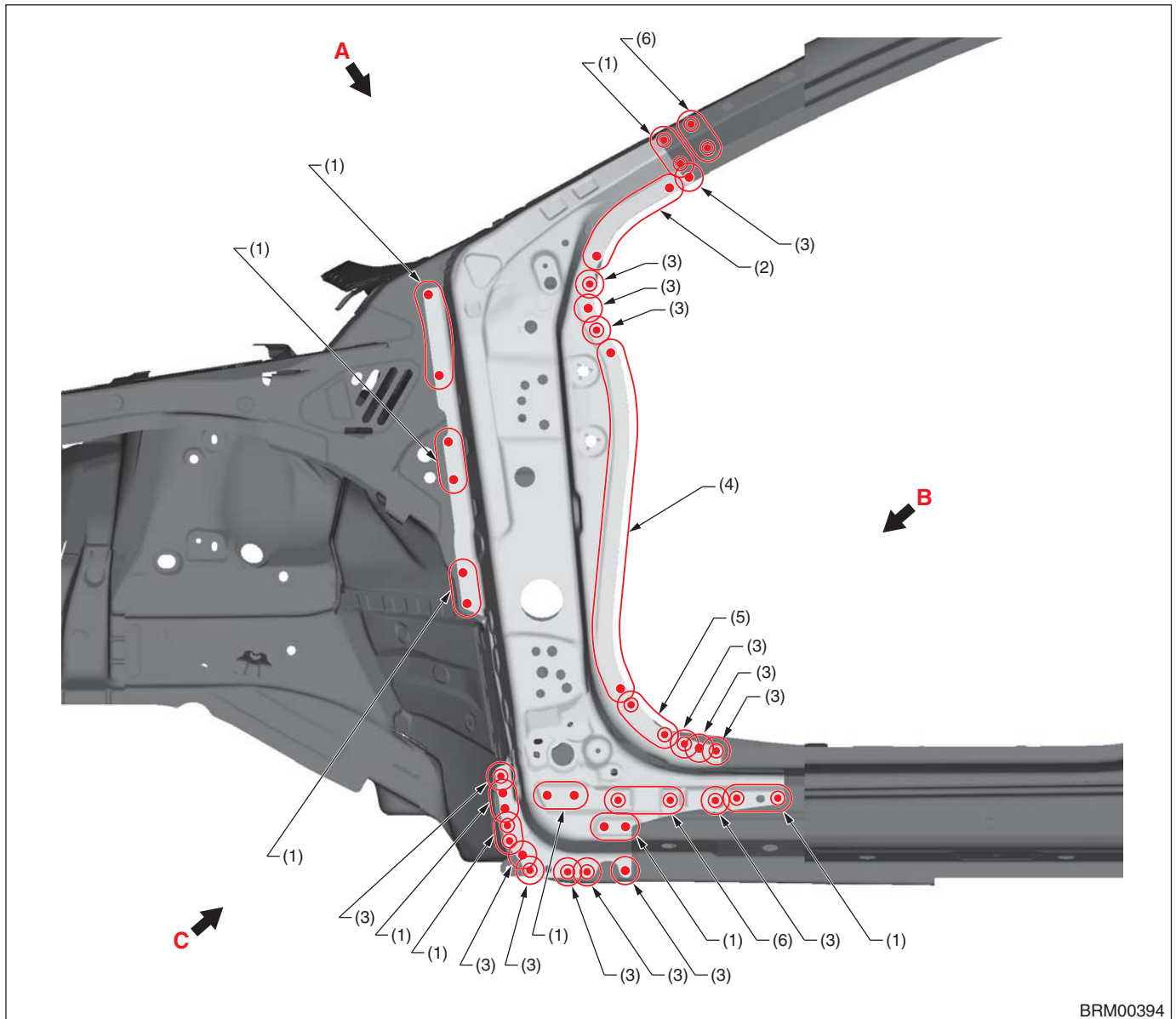
(7) RH: 2 points (outside · 1)

LH: 2 points (outside · 2)

* : RH Two overlapping parts
LH Three overlapping parts

Panel Replacement

• Overall view (Hybrid model)



BRM00394

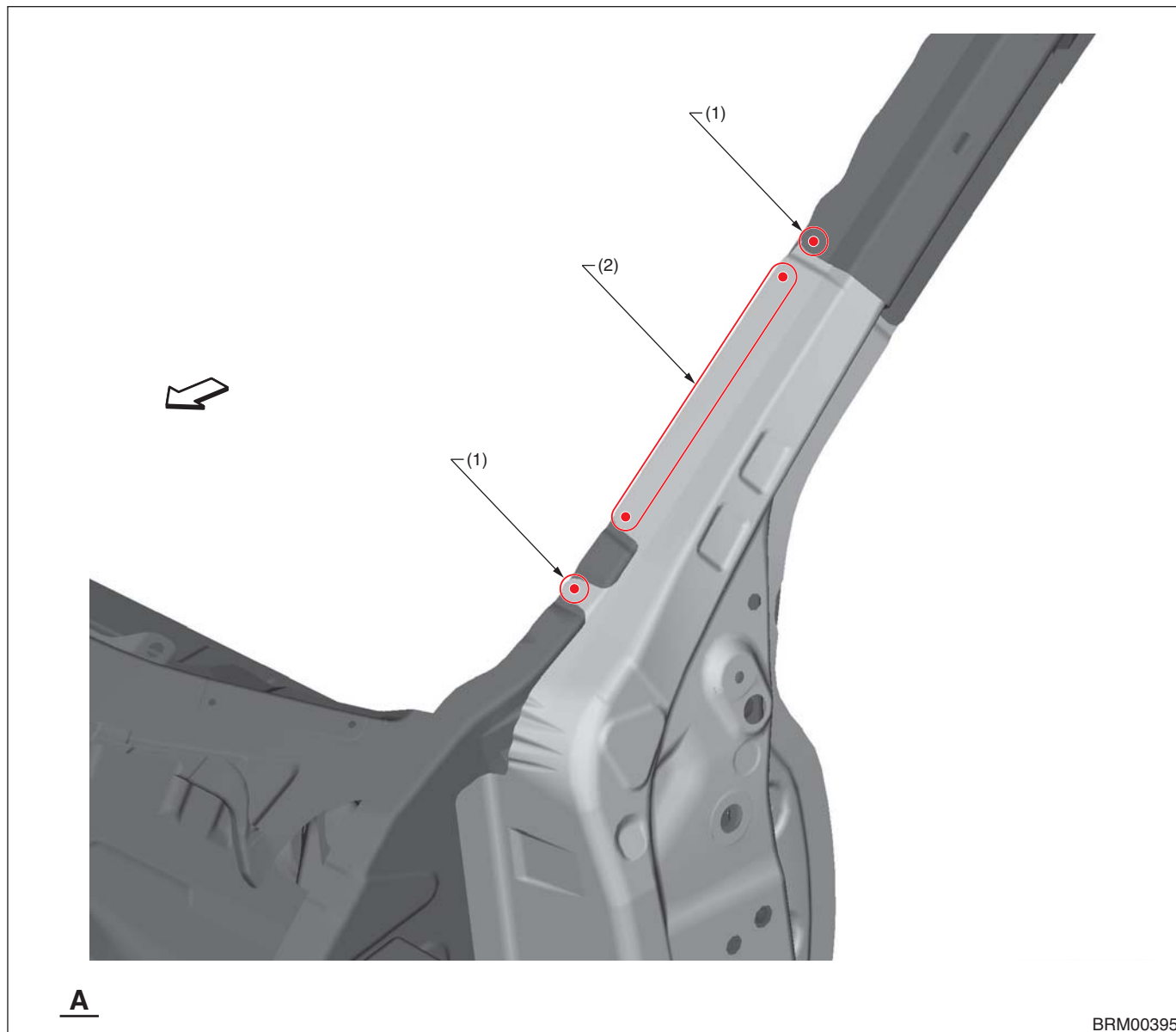
(1) 2 points (outside · 1)
(2) 4 points (outside · 1)

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

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

Panel Replacement

• Views A

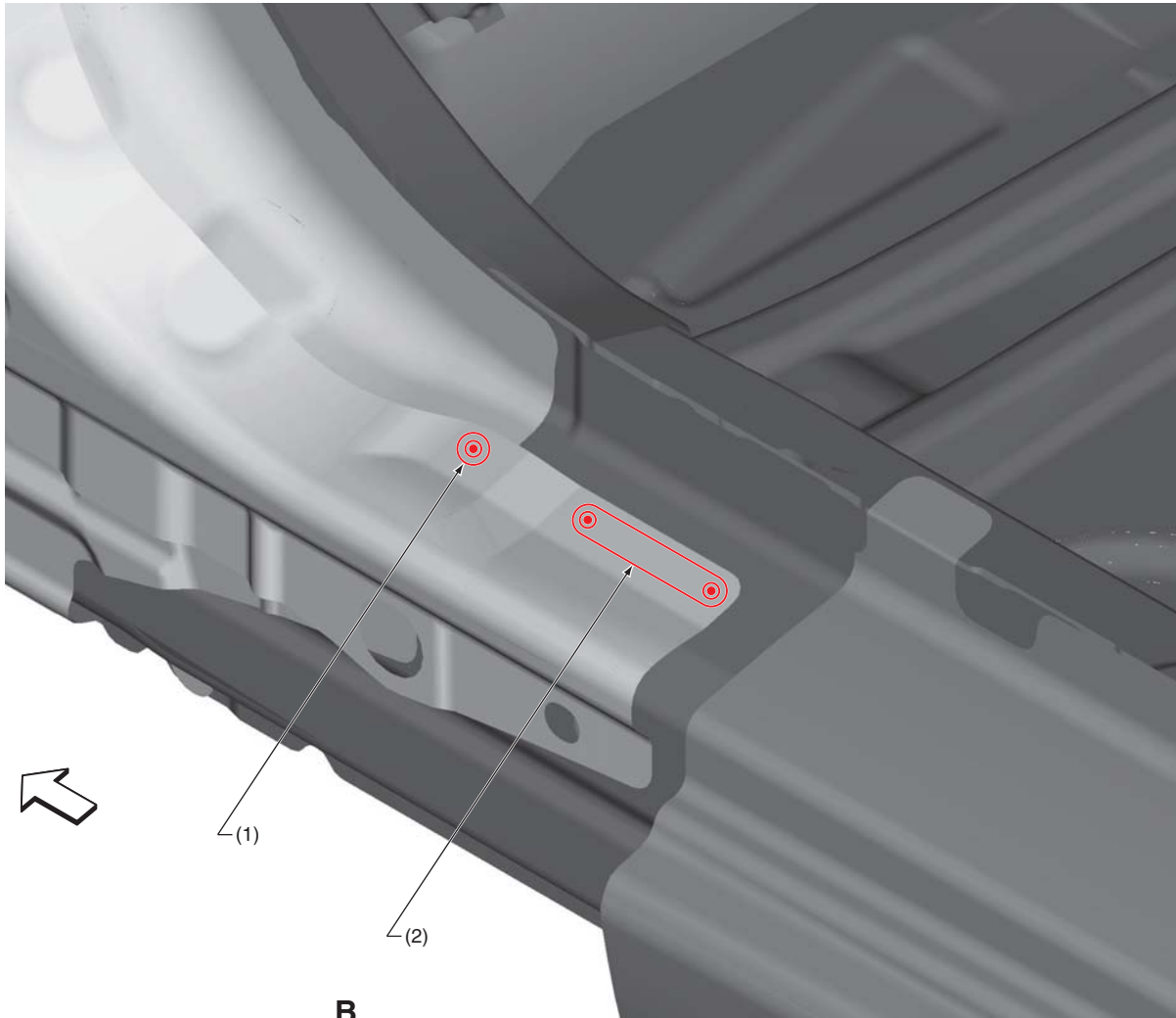


(1) 1 point (outside · 1)

(2) 5 points (top · 1)

Panel Replacement

• Views B



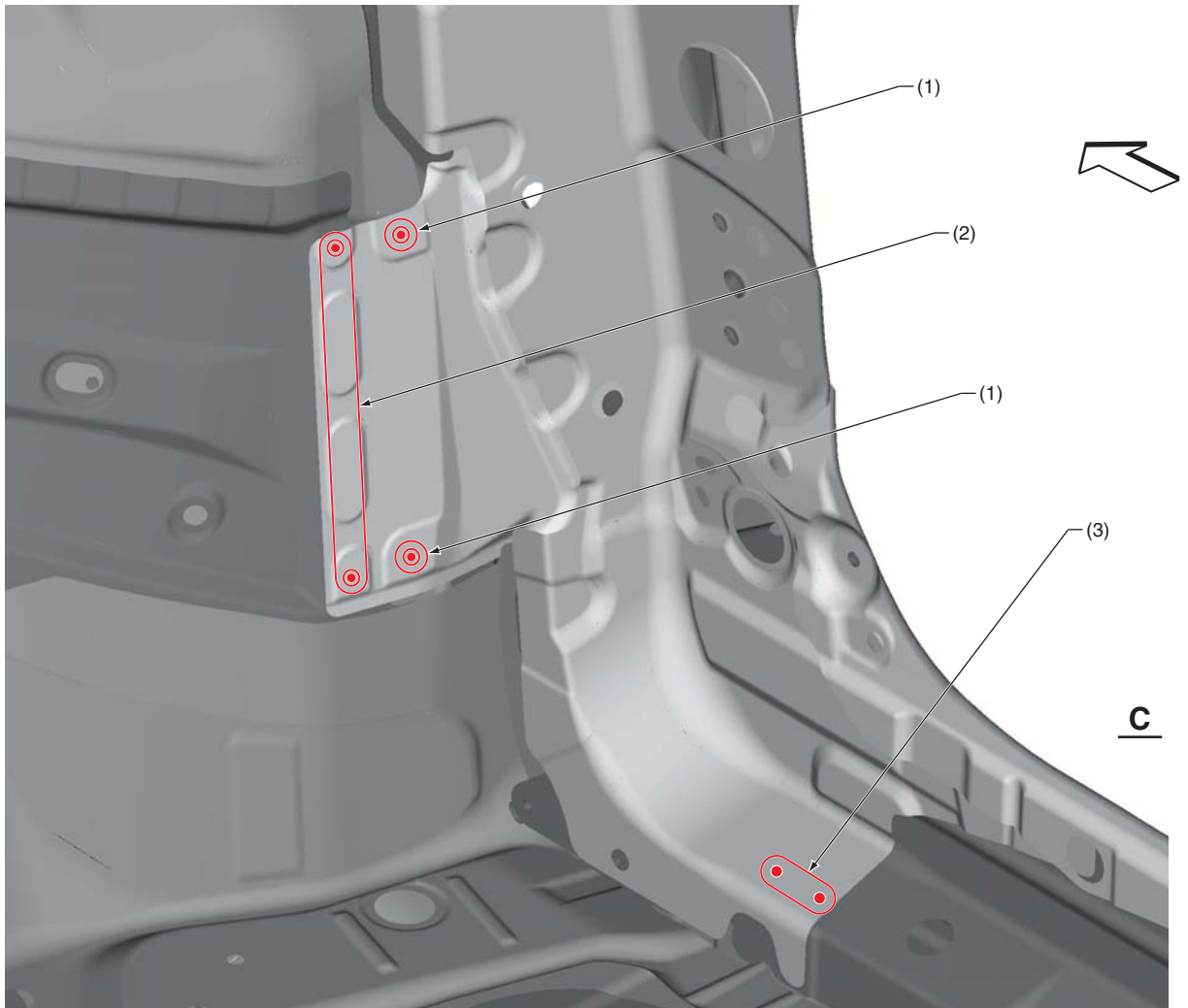
BS-08326

(1) 1 point (top · 2)

(2) 2 points (top · 1)

Panel Replacement

• Views C



BS-08327

(1) 1 point (outside · 1)

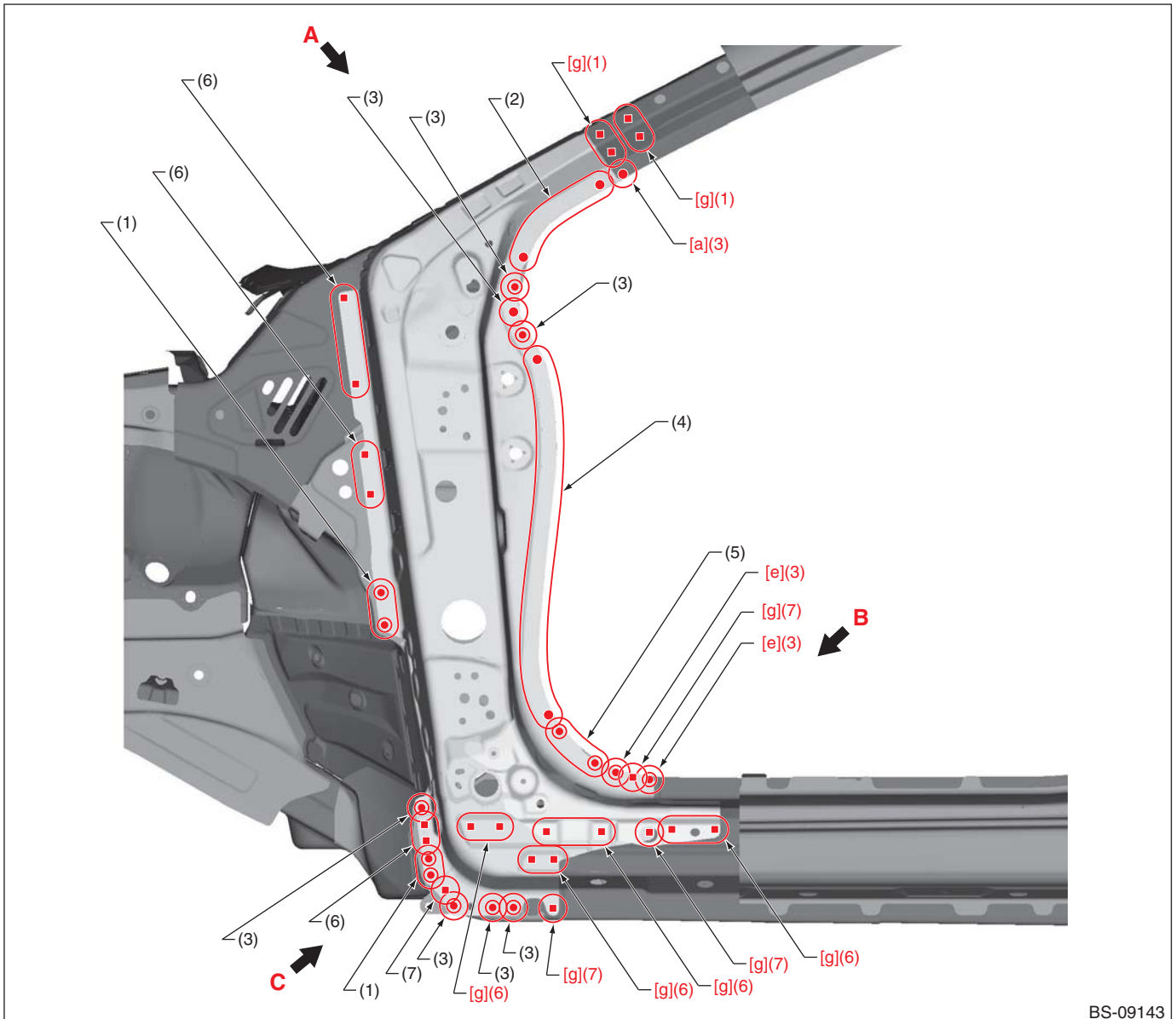
(2) 6 points (outside · 1)

(3) 2 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view

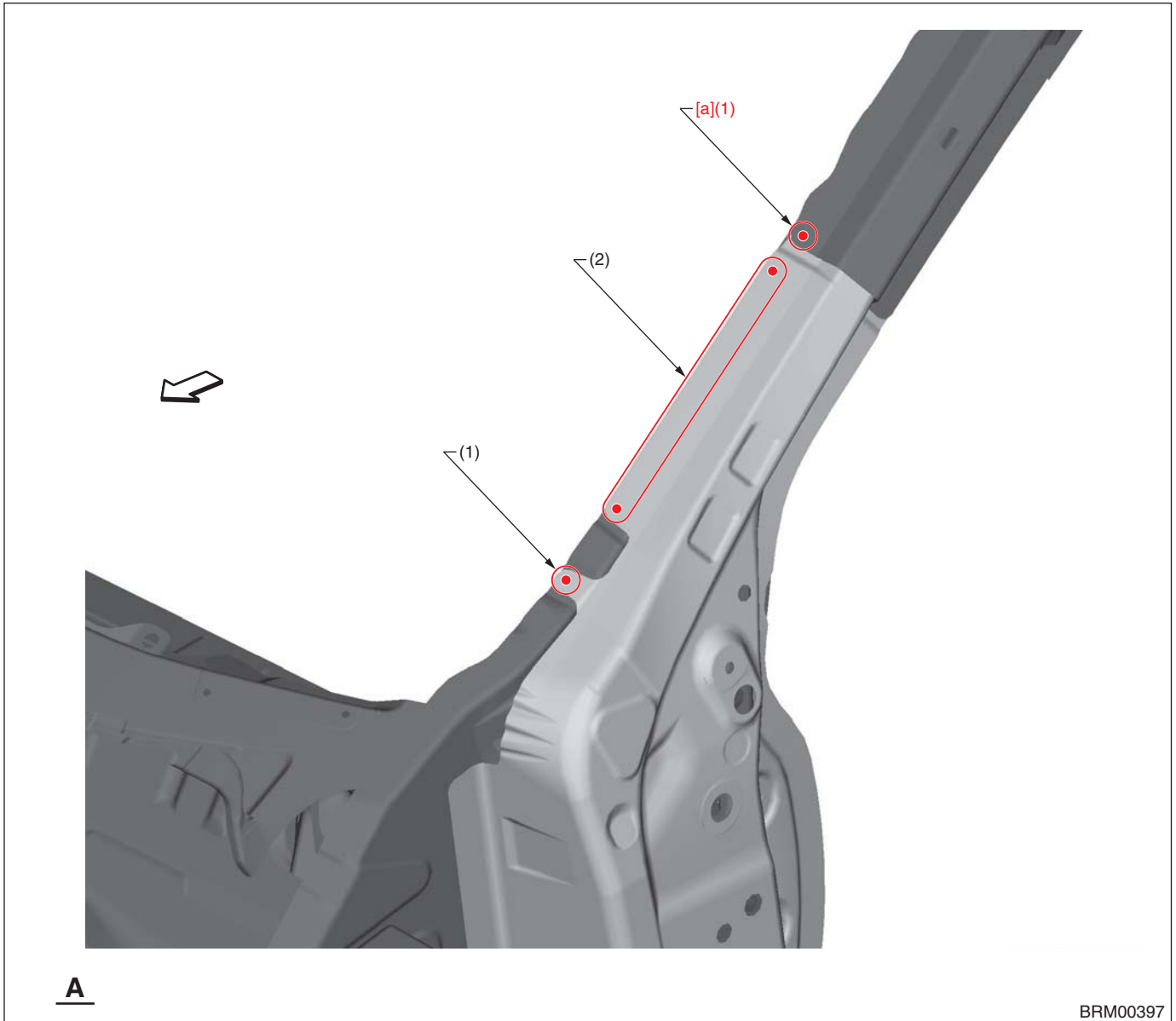


- | | | |
|--------------|------------------------|-----------------------|
| (1) 2 points | (4) 15 points | (7) 1 point (service) |
| (2) 4 points | (5) 3 points | |
| (3) 1 point | (6) 2 points (service) | |

[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
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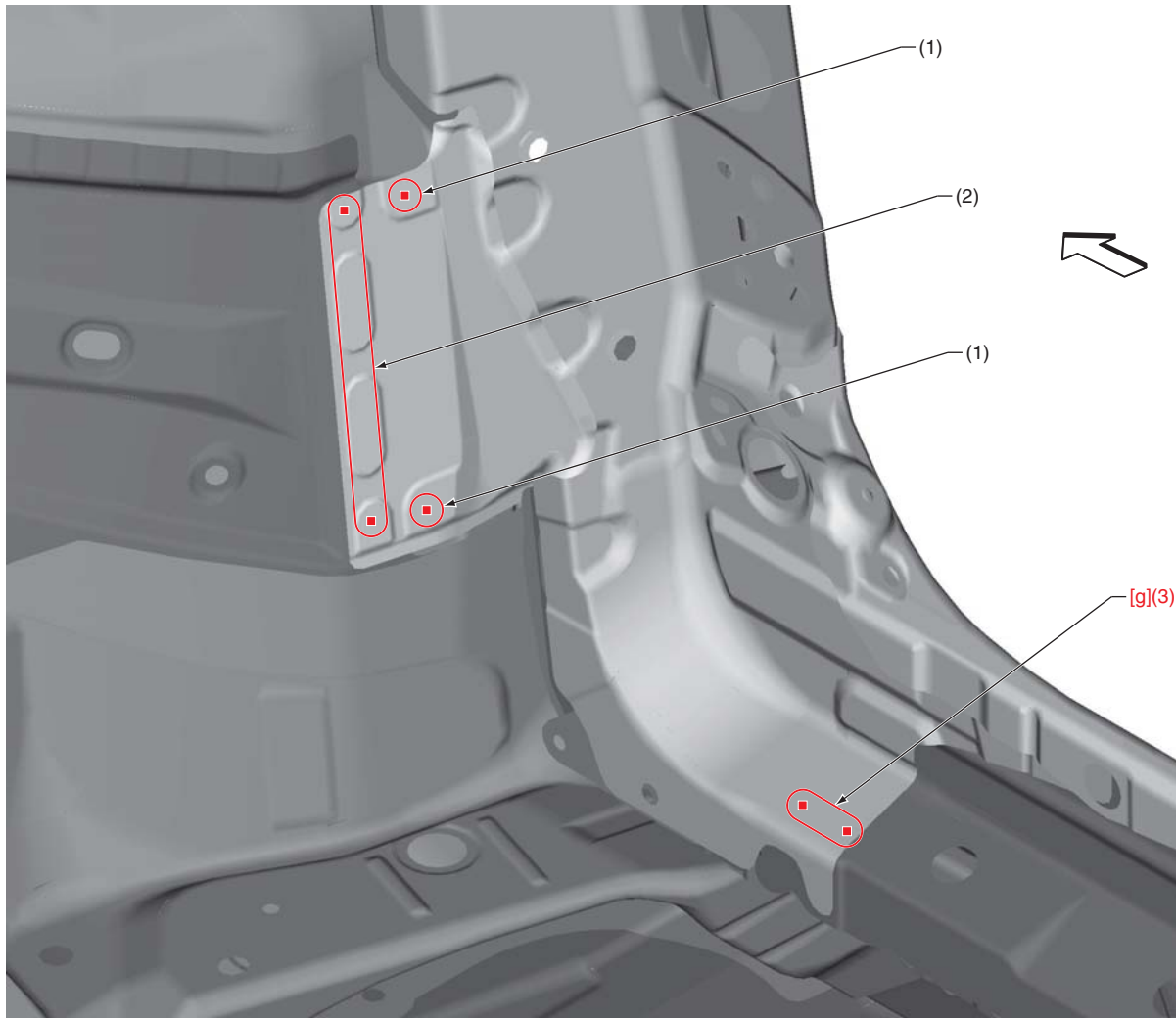
- **Views B**



BS - 191

Panel Replacement

• Views C



BS-08736

(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: CO2

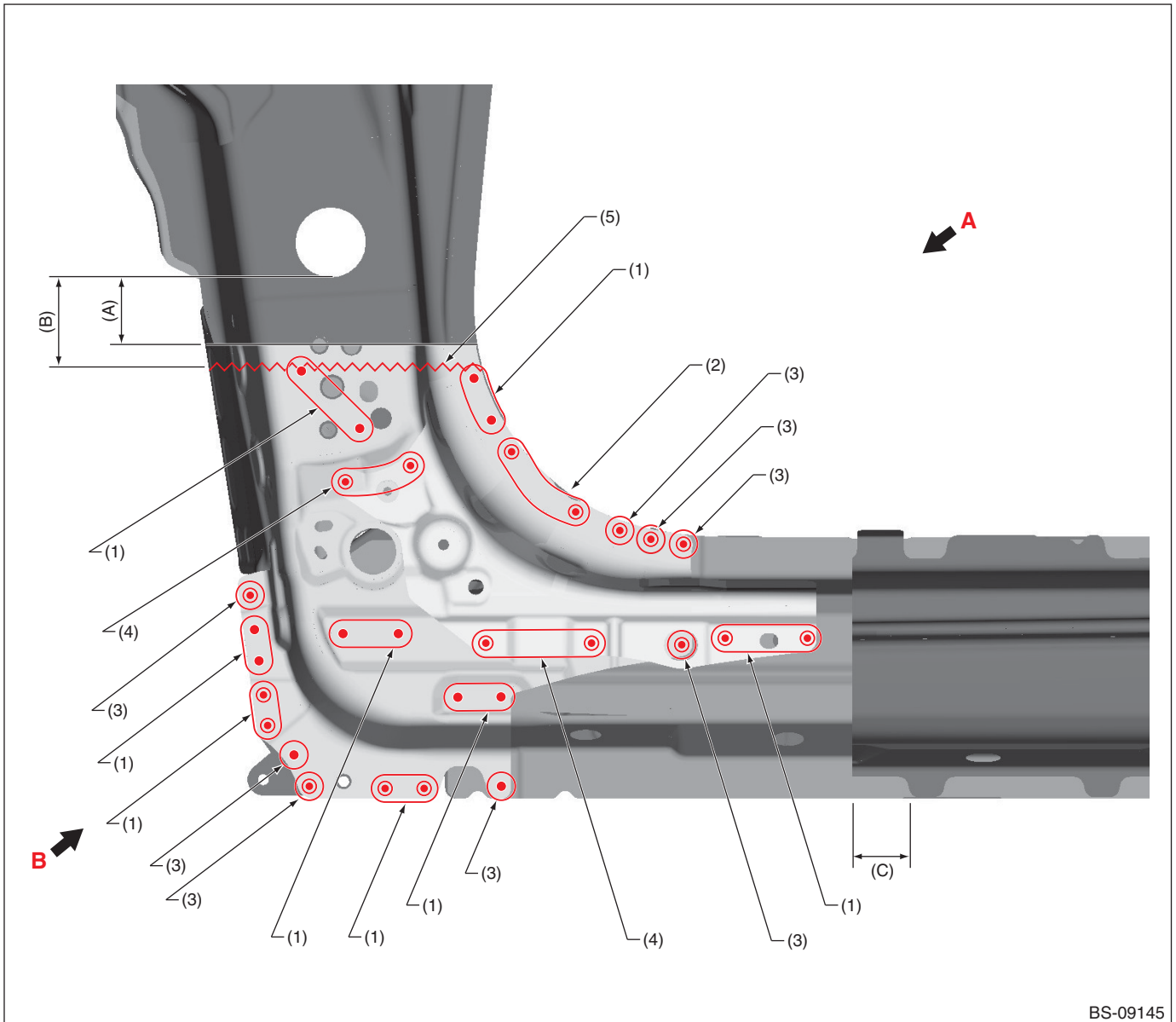
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-14. Front Pillar Reinforcement (partial replacement)

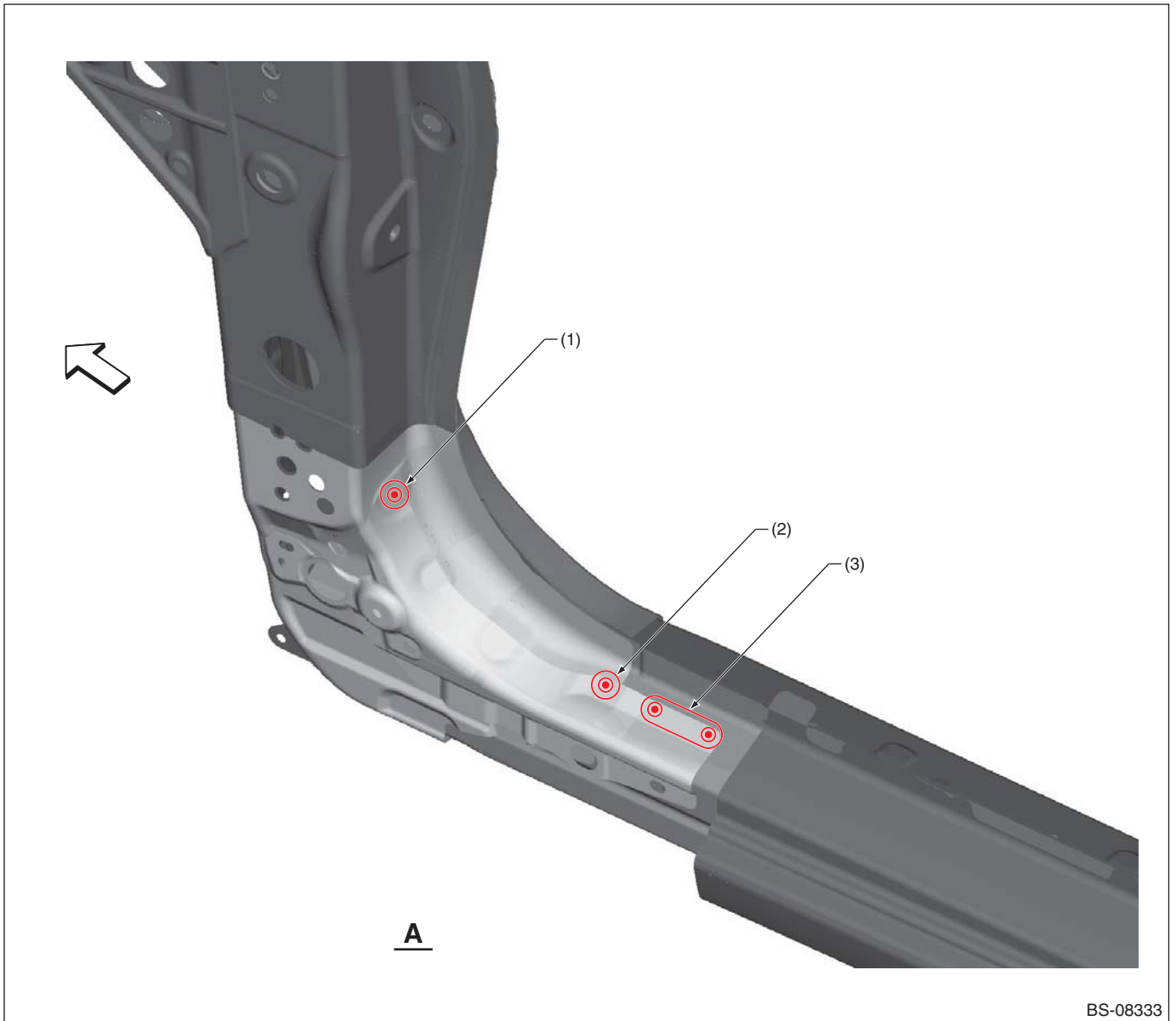
A: REMOVAL

• Overall view



Panel Replacement

• Views A



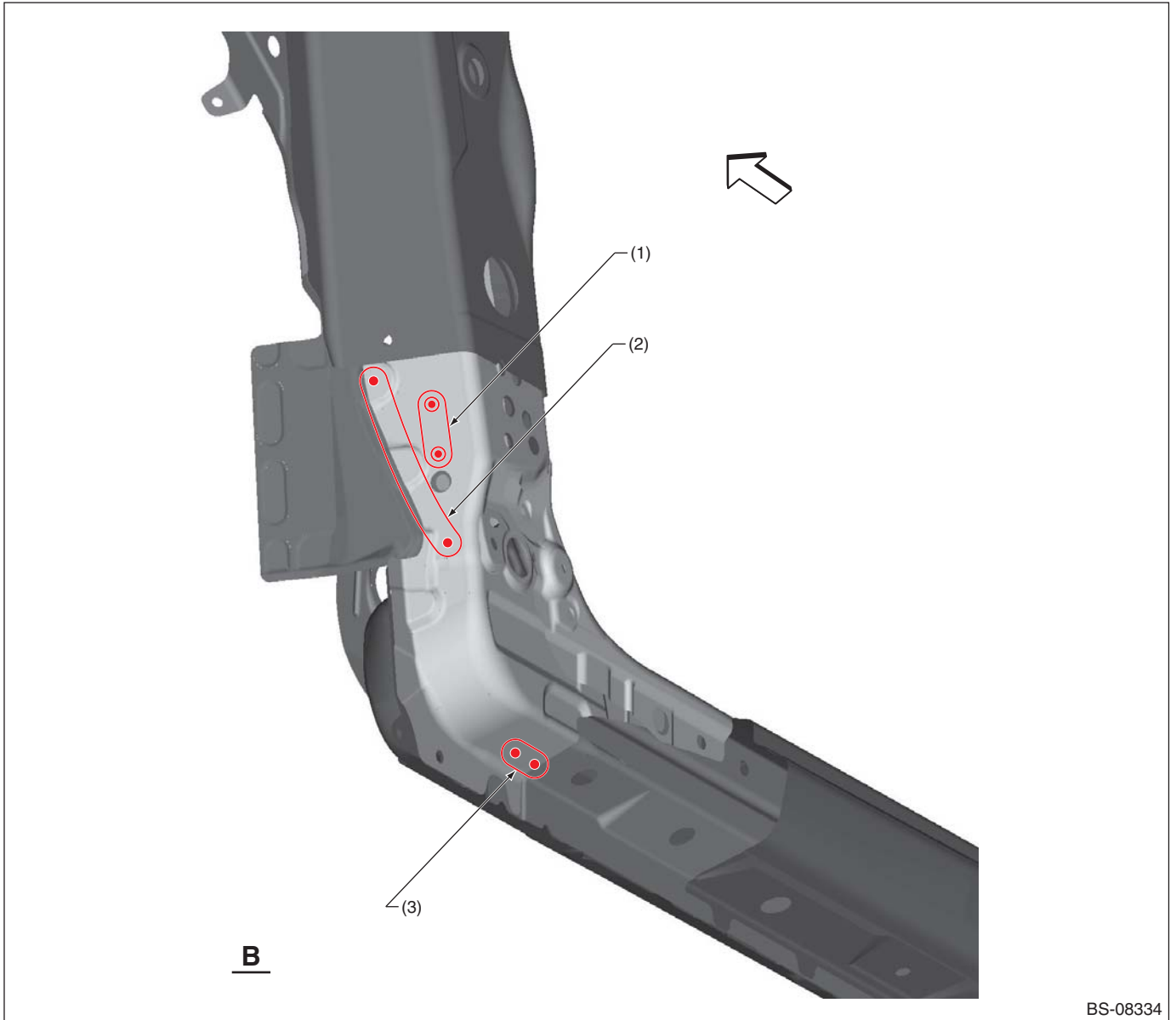
(1) 1 point (outside · 2)

(2) 1 point (top · 2)

(3) 2 points (top · 1)

Panel Replacement

• Views B



(1) 2 points (outside · 1)

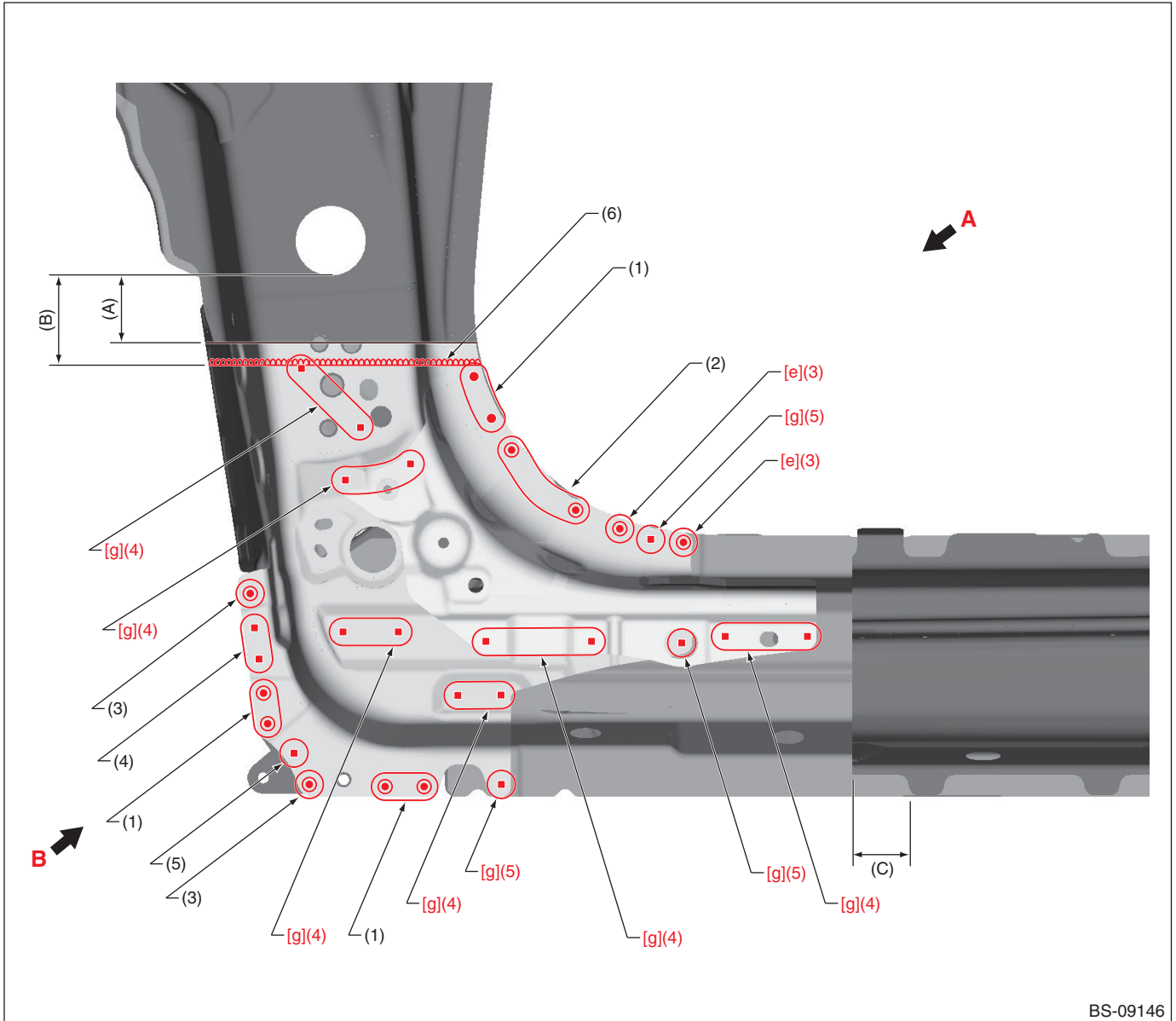
(2) 3 points (outside · 1)

(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

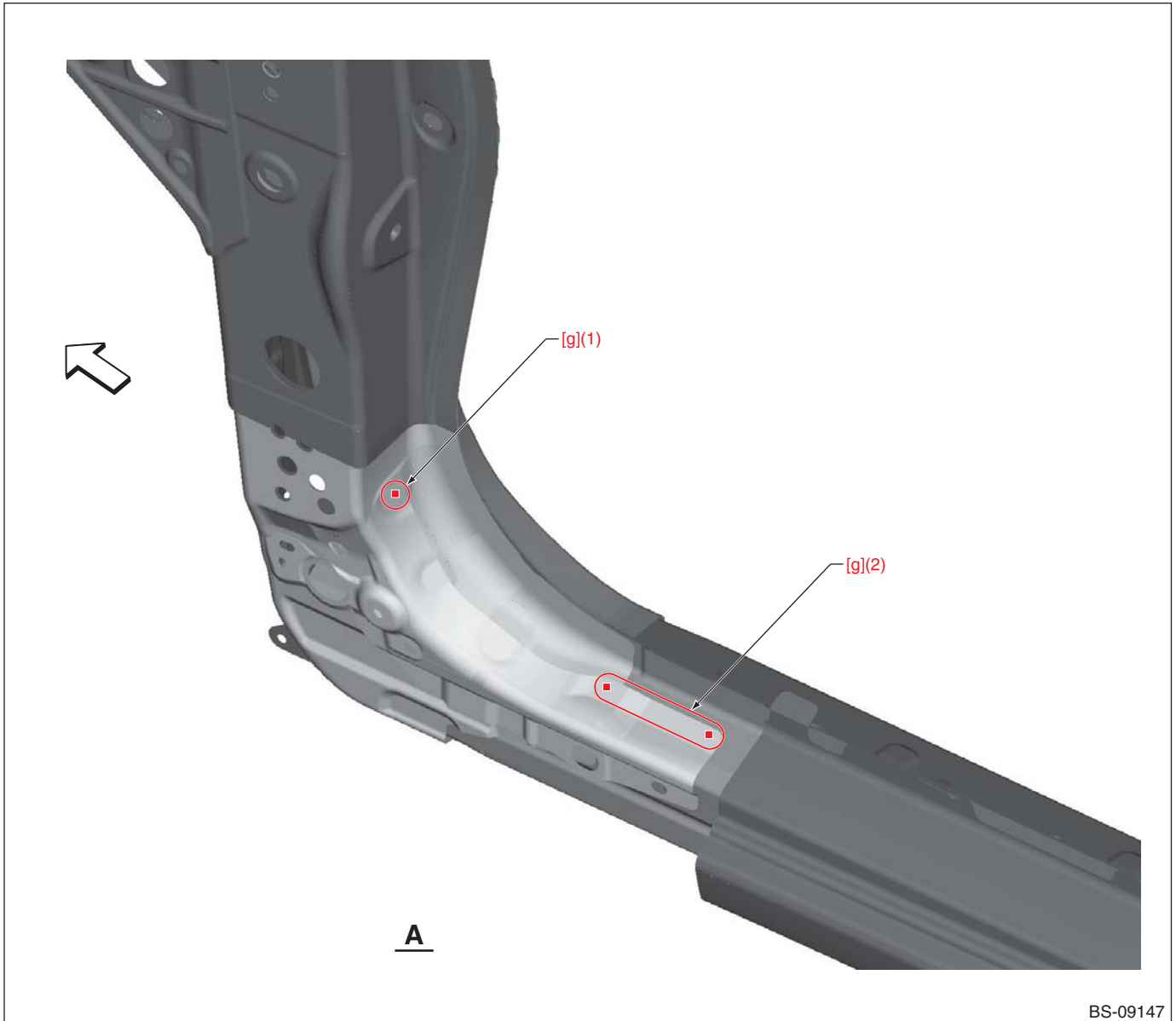
(4) 2 points (service)

(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



BS-09147

(1) 1 point (service)

(2) 3 points (service)

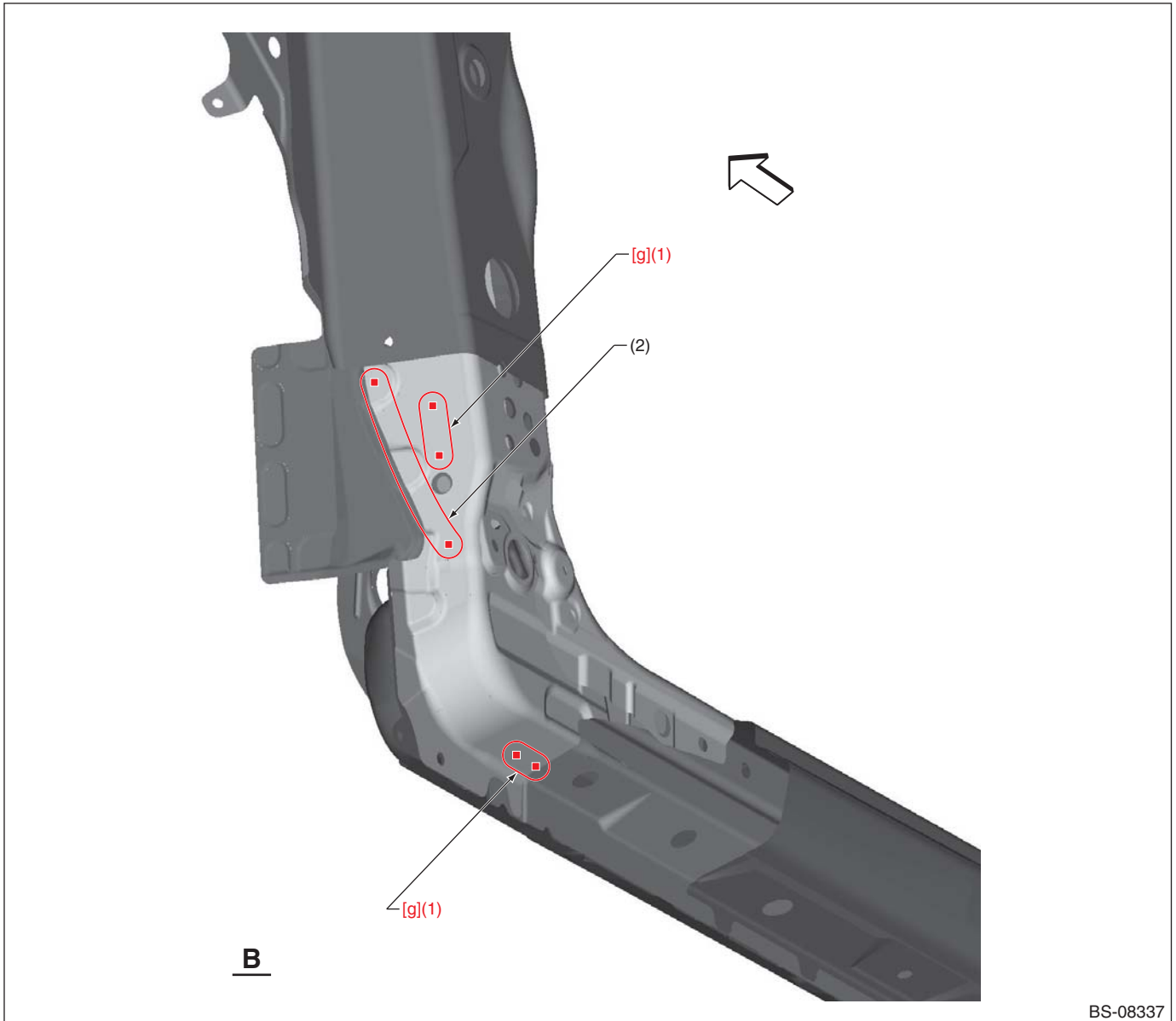
[g] Plug welding

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

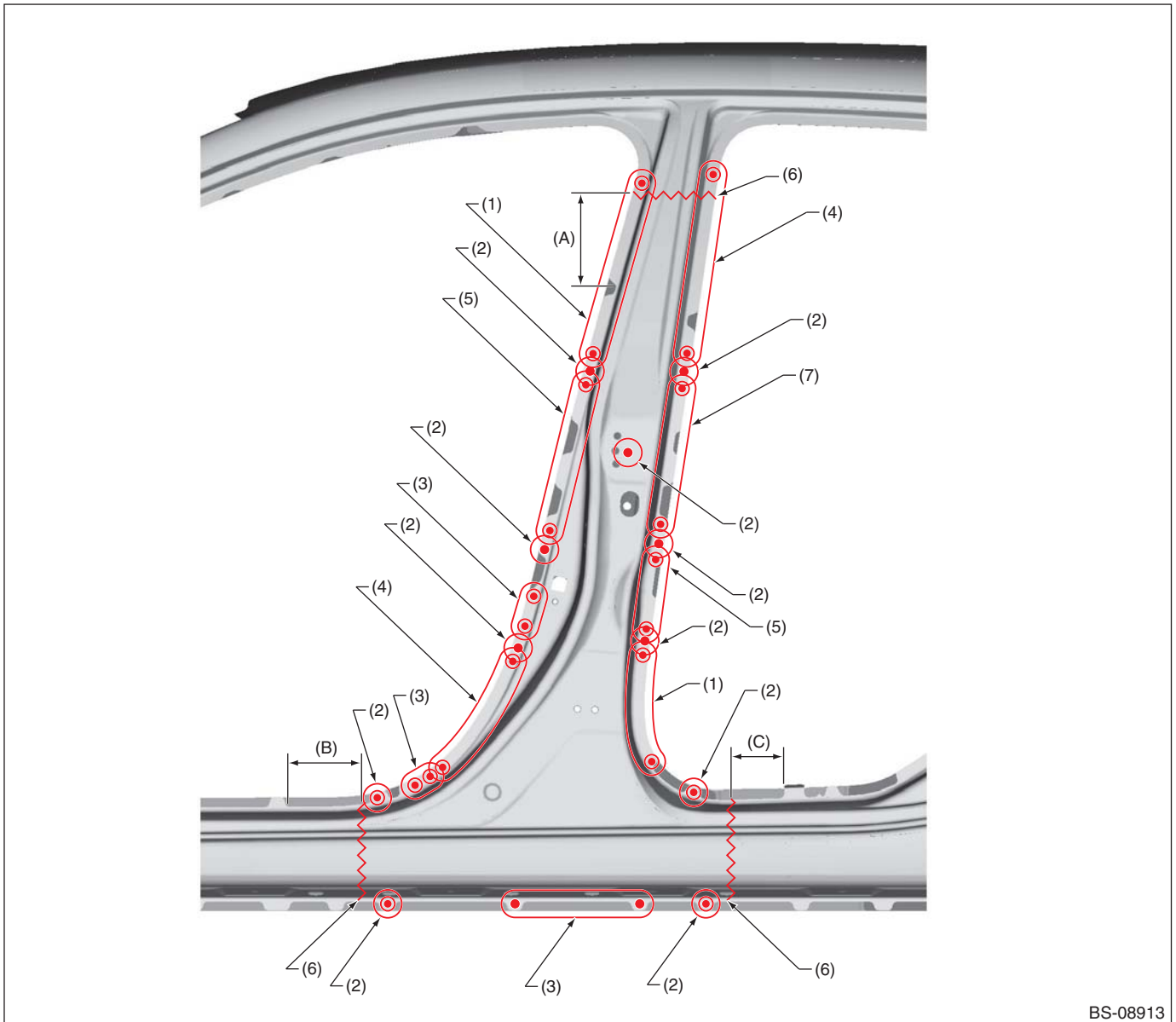
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

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

A: REMOVAL

- Overall view (Gasoline model)



BS-08913

(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)

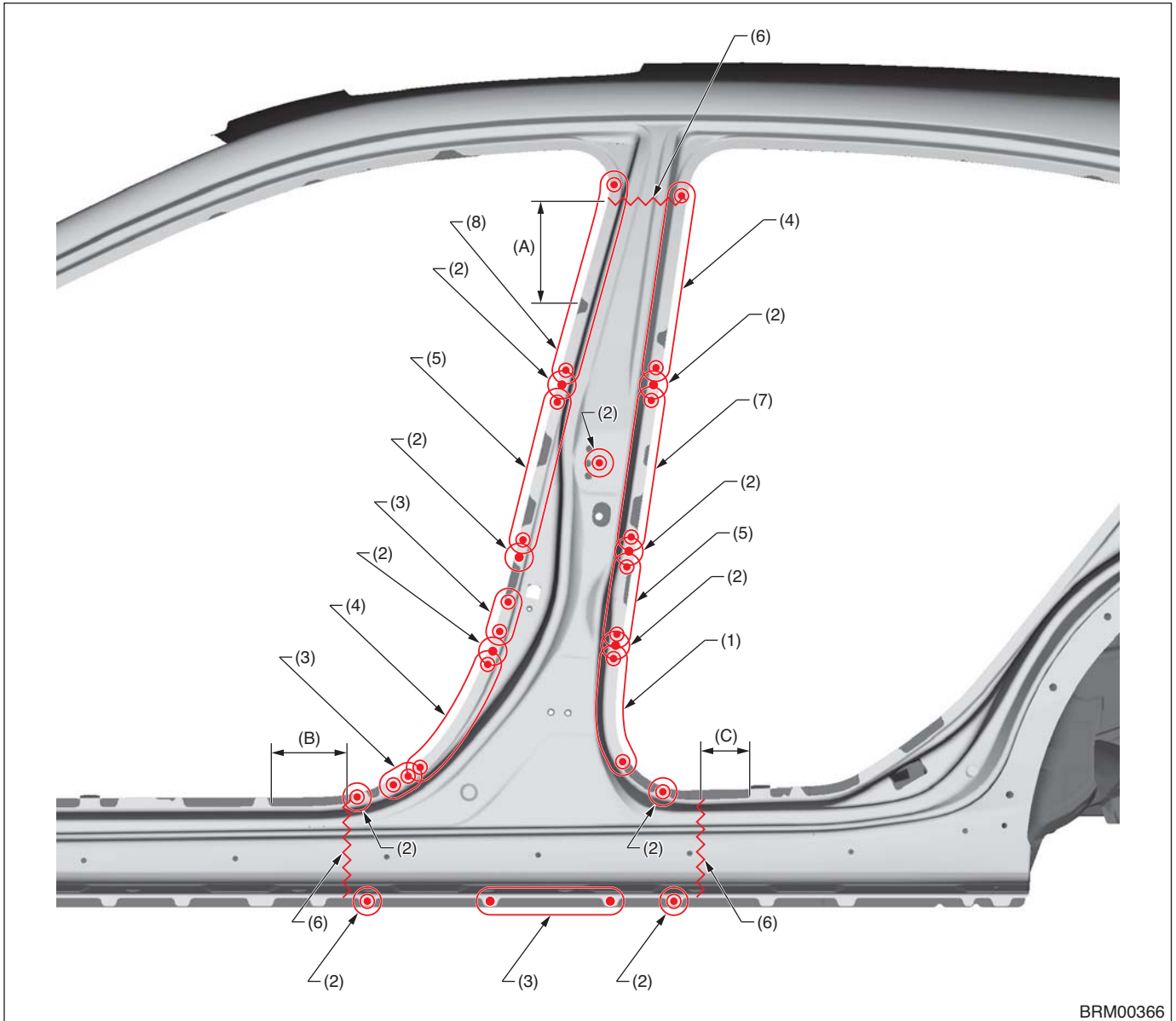
(5) 3 points (outside · 1)

(3) 2 points (outside · 1)

(6) Cut position

Panel Replacement

• Overall view (Hybrid model)



BRM00366

(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)

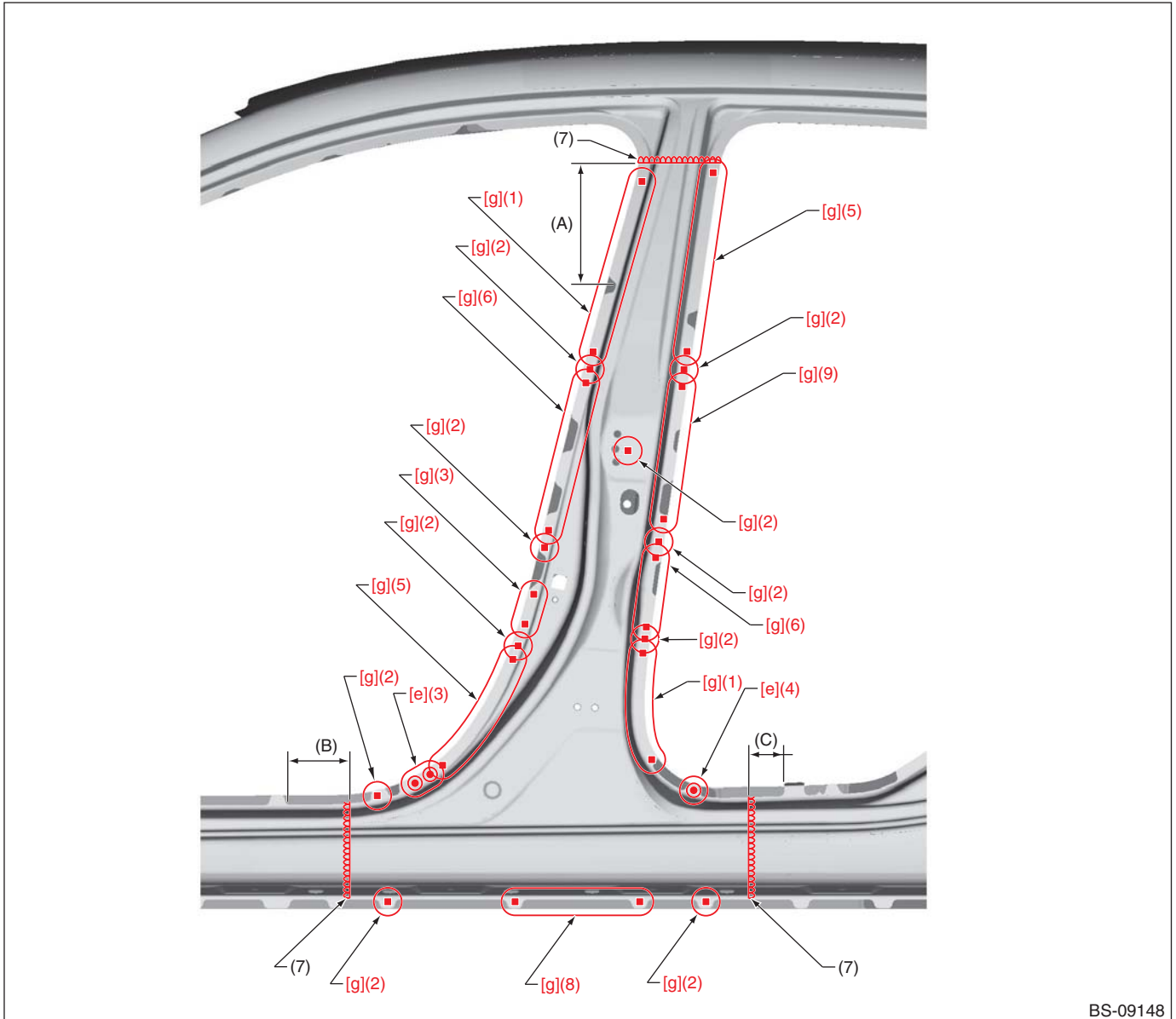
(3) 2 points (outside · 1)

(6) Cut position

Panel Replacement

B: INSTALLATION

• Overall view (Gasoline model)



(A) 200 mm [7.87 in]

(B) 90 mm [3.54 in]

(C) 50 mm [1.97 in]

- (1) 8 points
- (2) 1 point (service)
- (3) 2 points

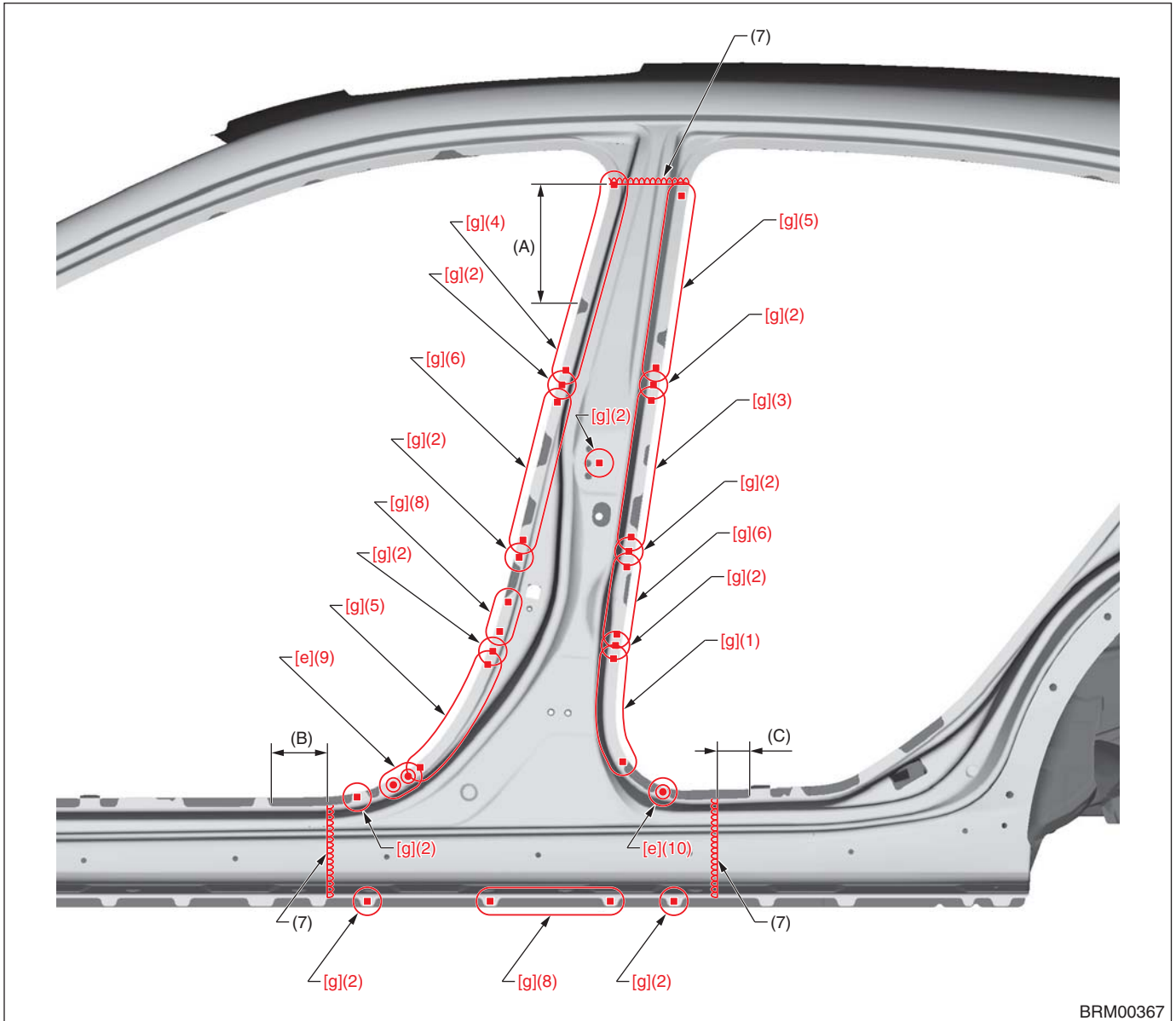
- (4) 1 point
- (5) 7 points
- (6) 3 points

- (7) 1 point (Continuous welding)
- (8) 2 points (service)
- (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)



BRM00367

(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)

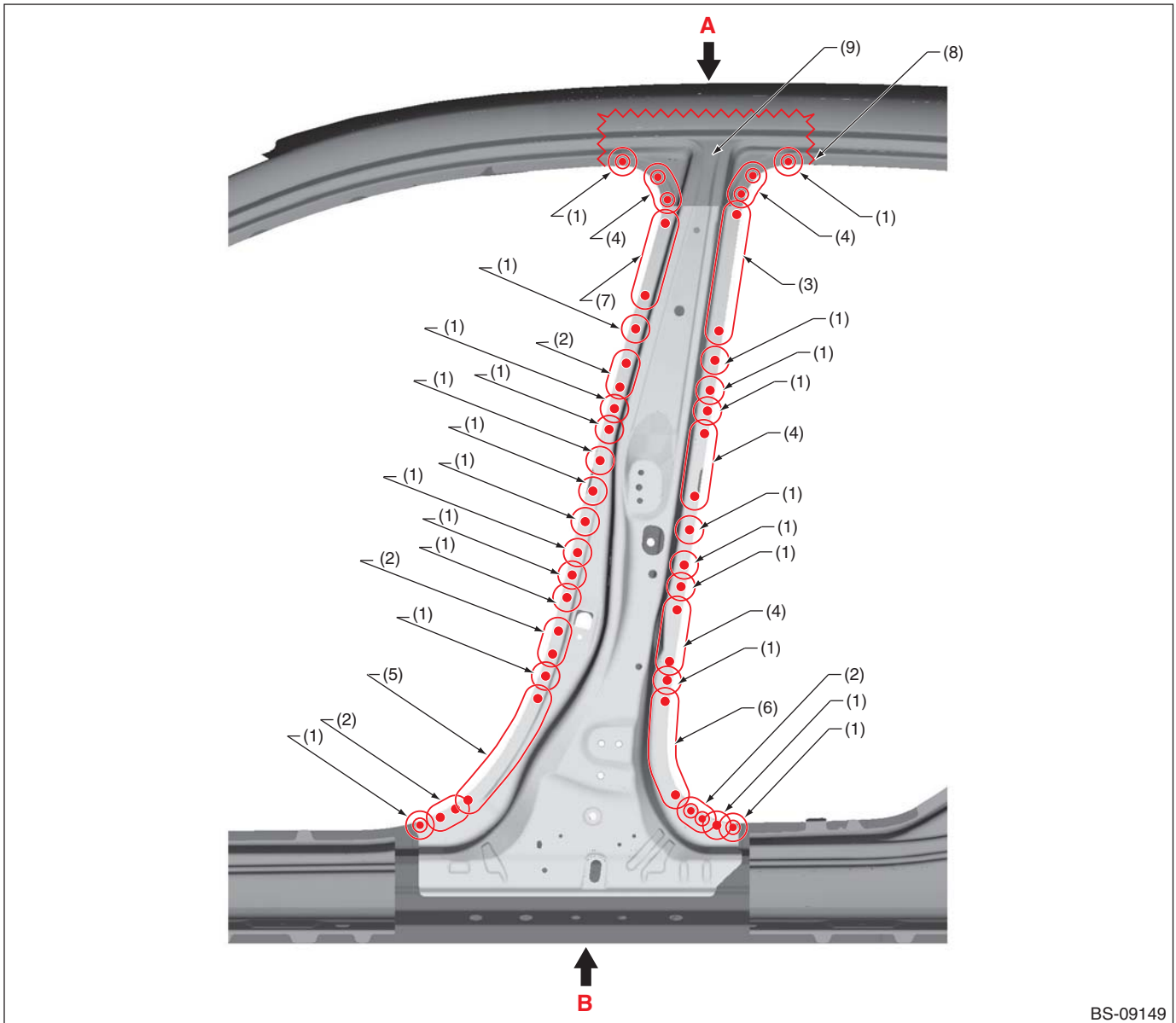
[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

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

A: REMOVAL

- Overall view (Gasoline model)



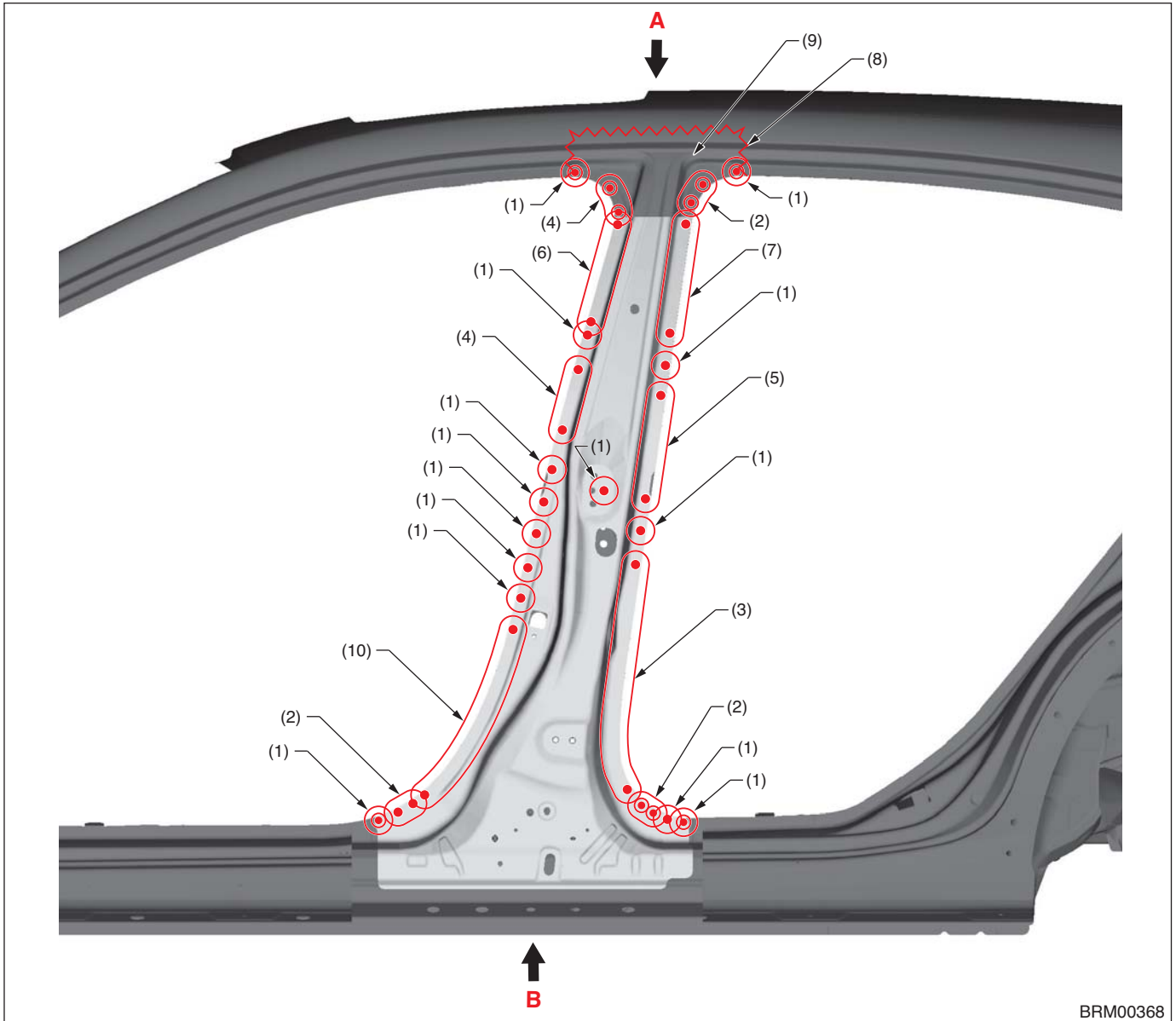
BS-09149

- | | | |
|----------------------------|----------------------------|----------------------------------|
| (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)



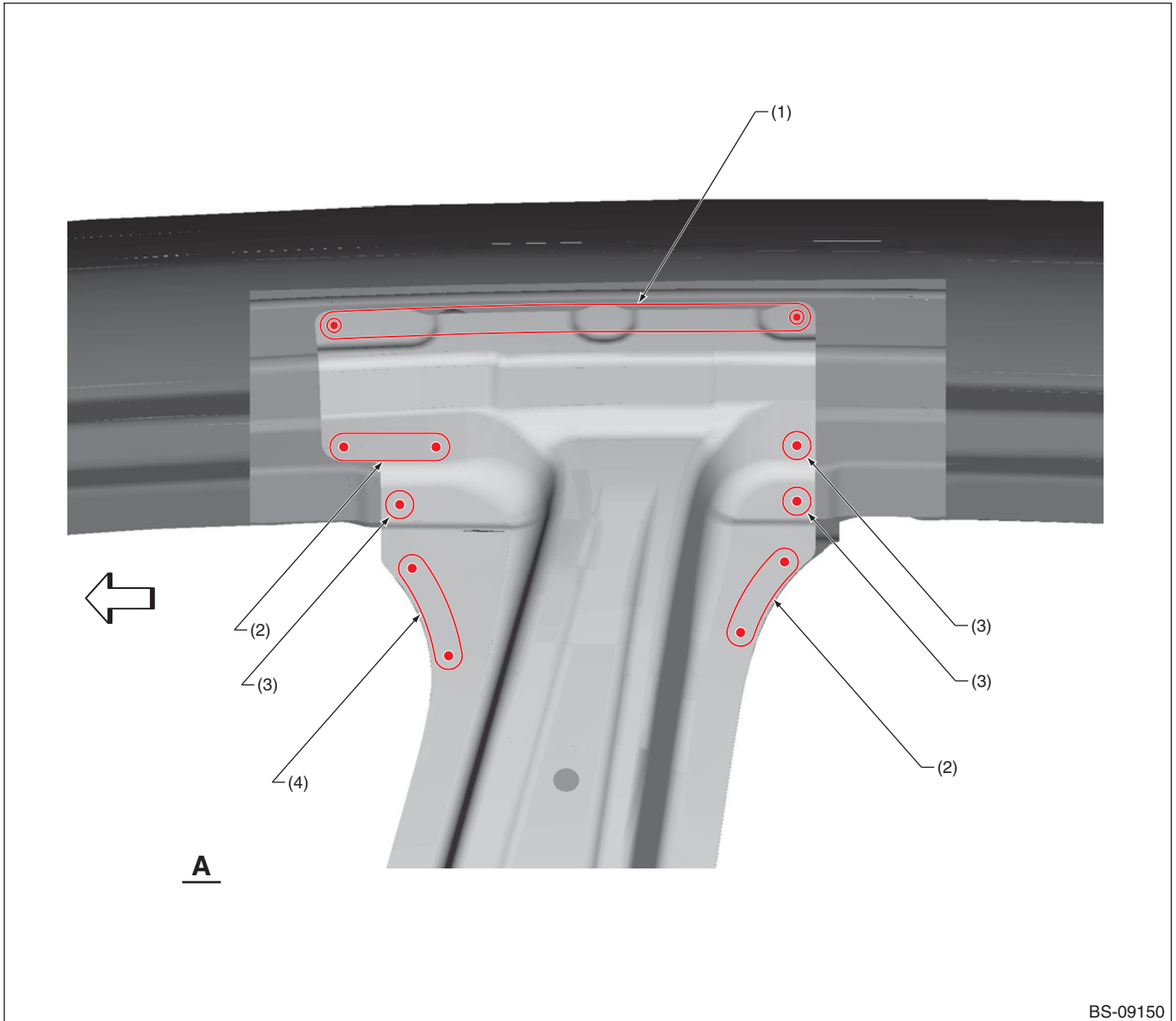
BRM00368

- | | | |
|-----------------------------|----------------------------|----------------------------------|
| (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



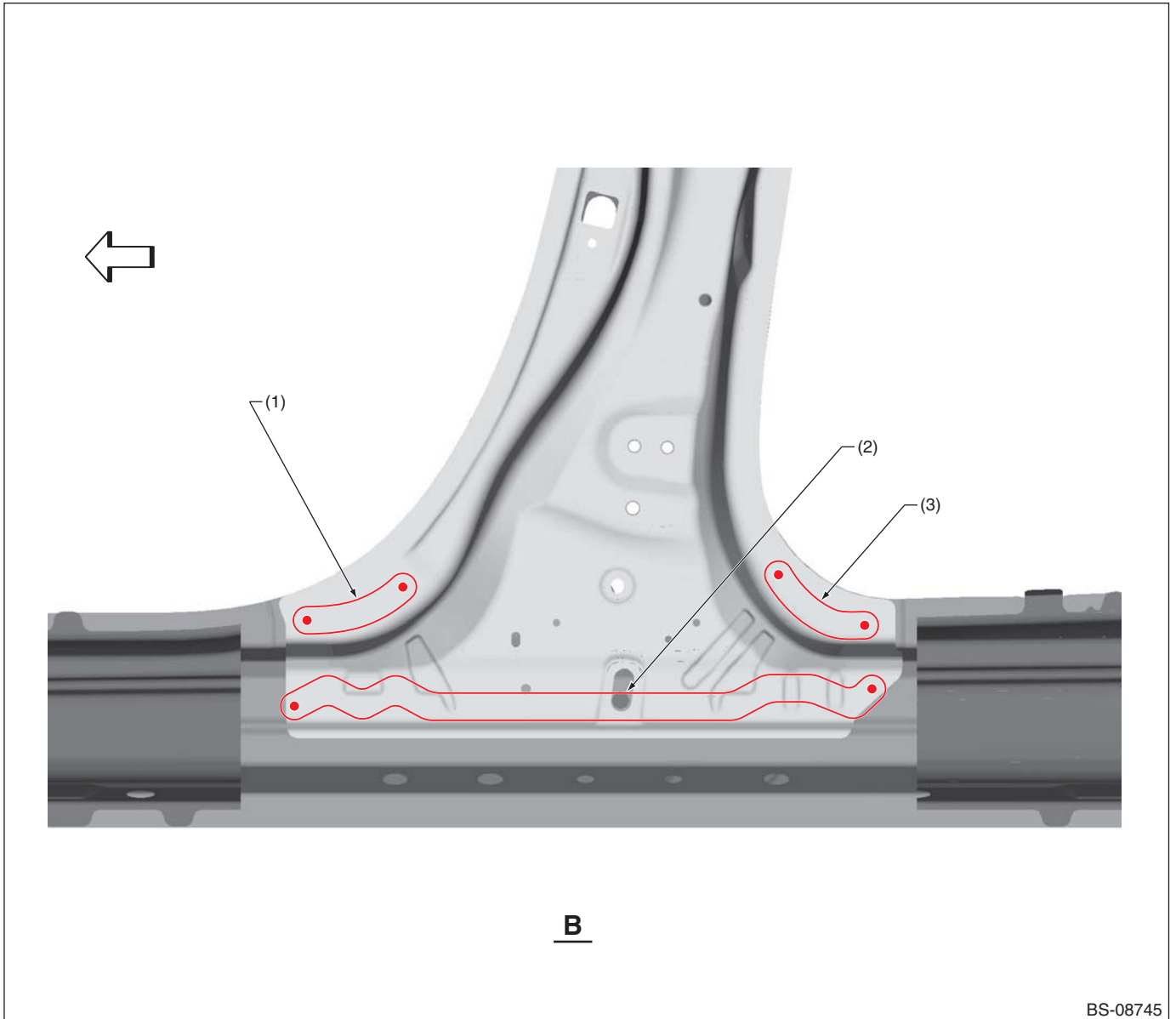
(1) 4 points (outside · 1)
(2) 2 points (outside · 1)

(3) 1 point (outside · 1)

(4) 3 points (outside · 1)

Panel Replacement

• Views B (Gasoline model)



BS-08745

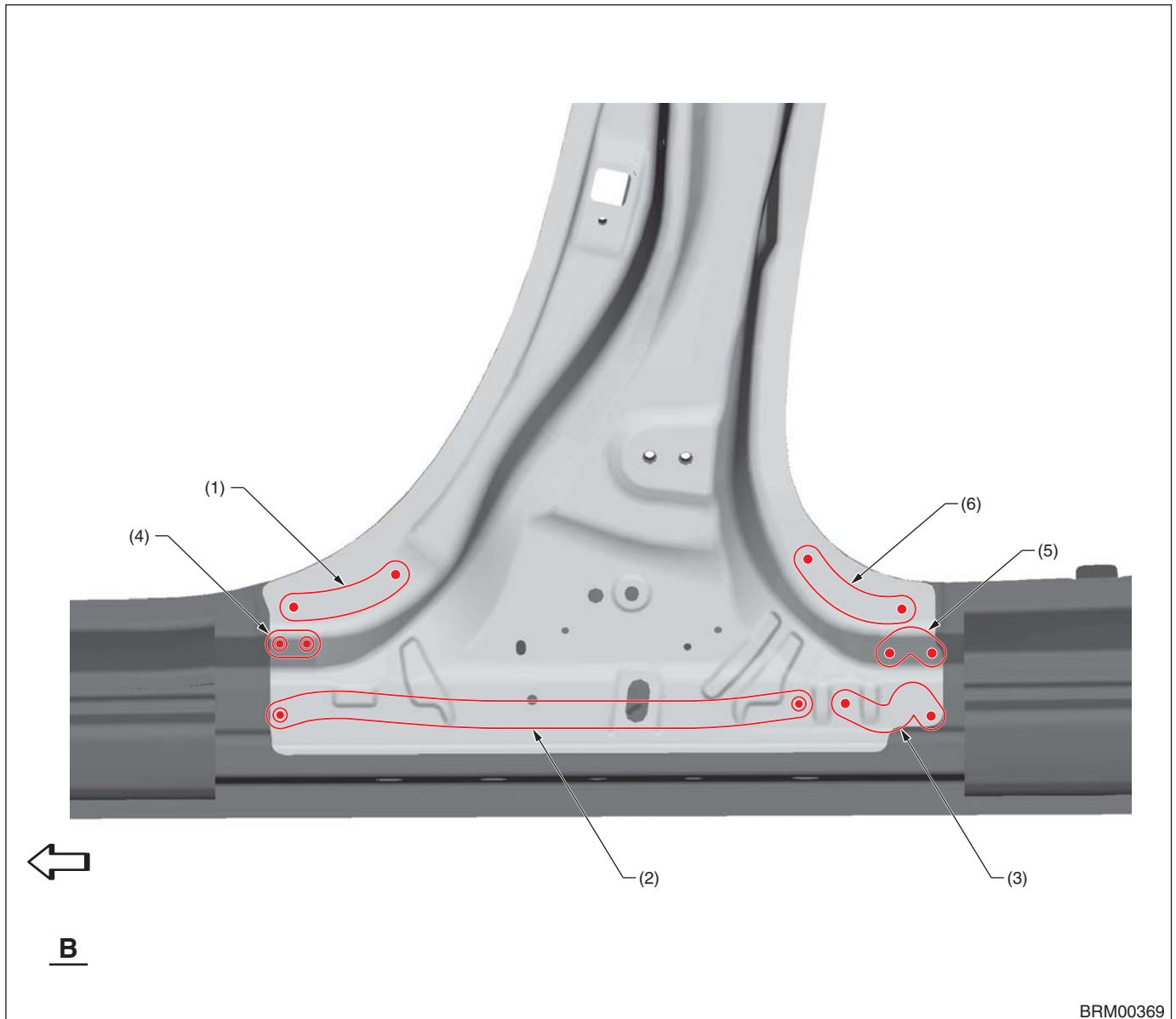
(1) 5 points (outside · 1)

(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)

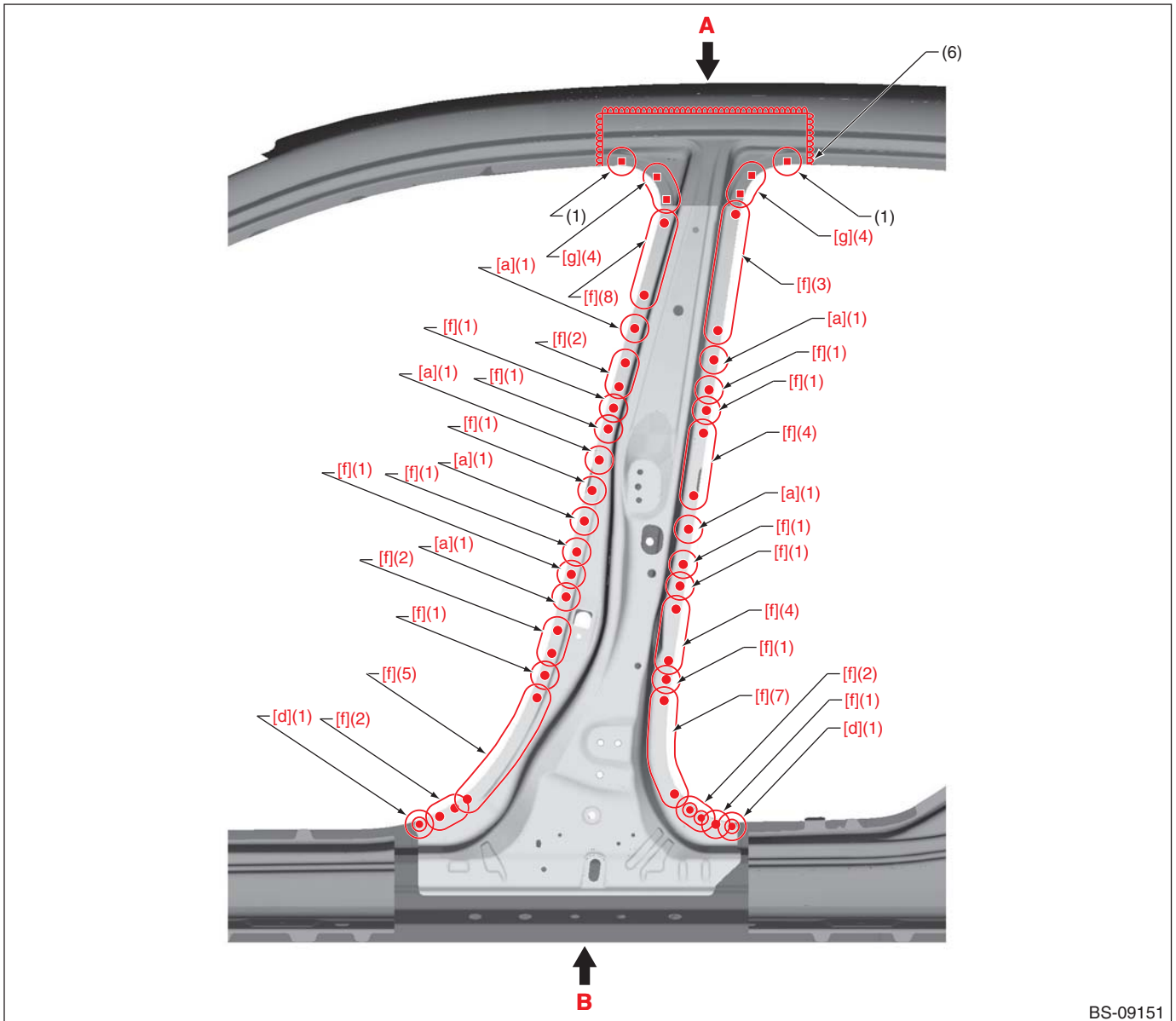
(3) 4 points (outside · 1)
(4) 2 points (top · 1)

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

Panel Replacement

B: INSTALLATION

• Overall view (Gasoline model)



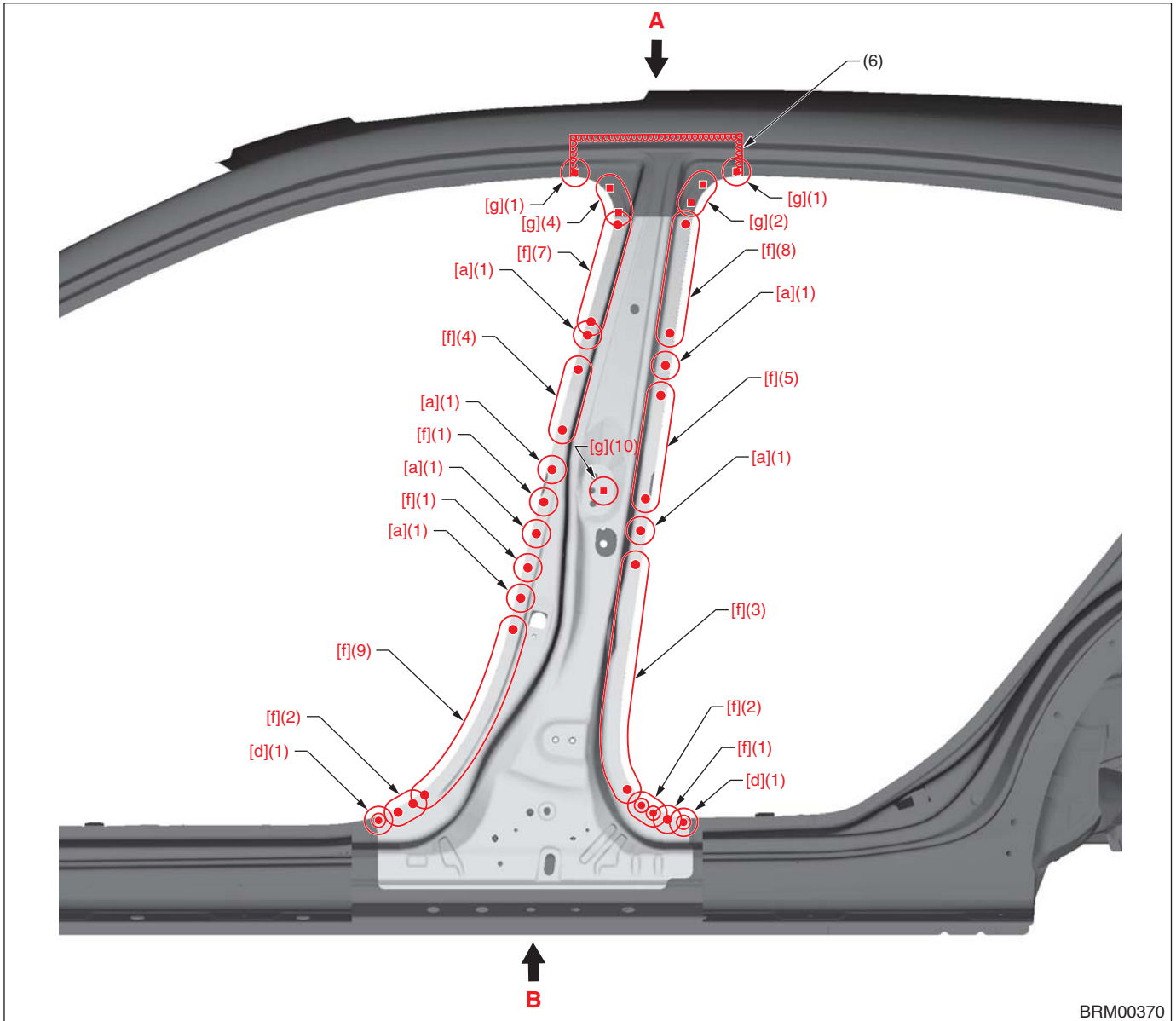
BS-09151

- | | | |
|--------------|----------------------------------|--------------|
| (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)

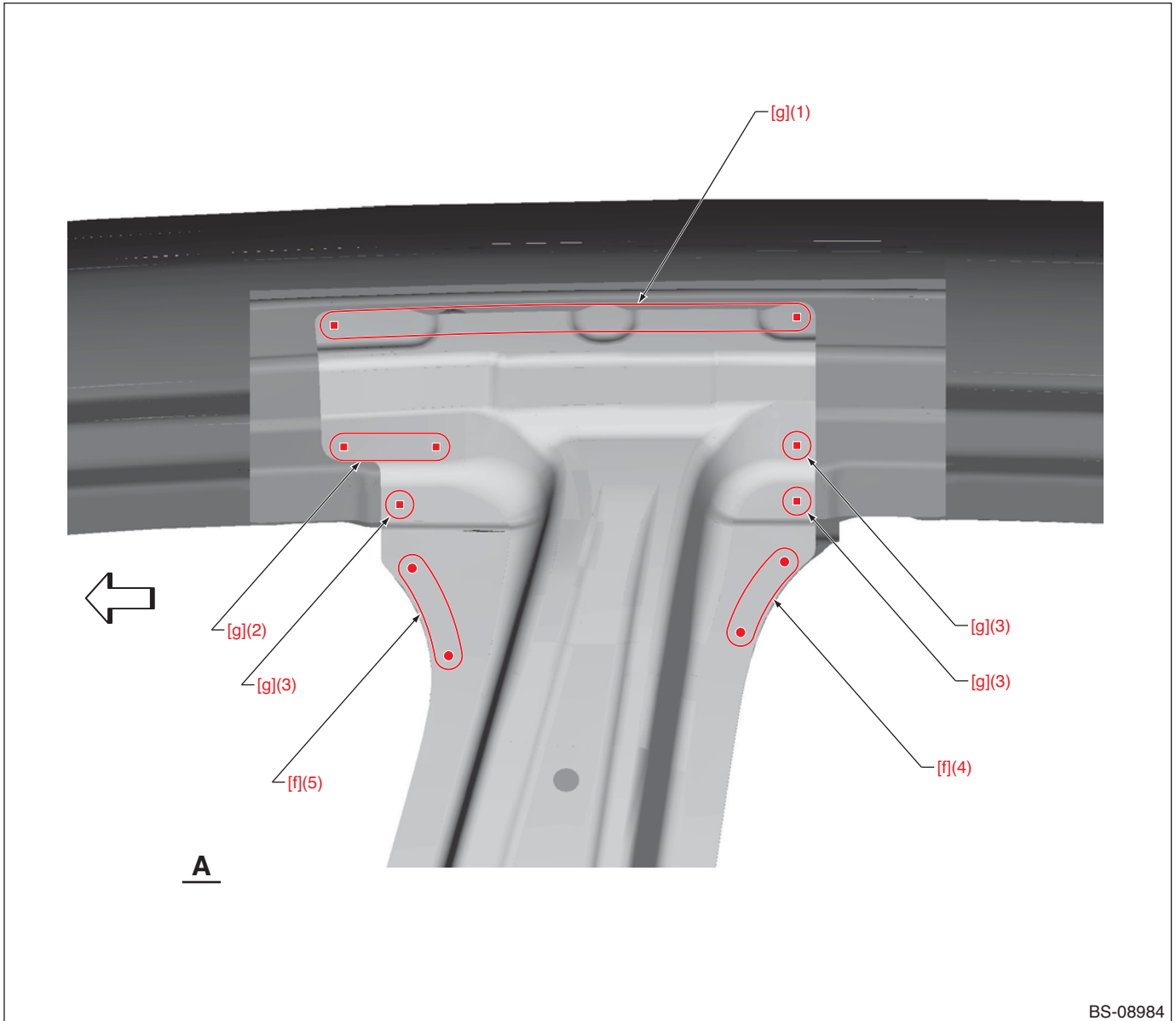


- | | | |
|---------------|----------------------------------|------------------------|
| (1) 1 point | (5) 4 points | (9) 9 points |
| (2) 2 points | (6) 1 point (Continuous welding) | (10) 1 point (service) |
| (3) 12 points | (7) 8 points | |
| (4) 3 points | (8) 6 points | |

[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)

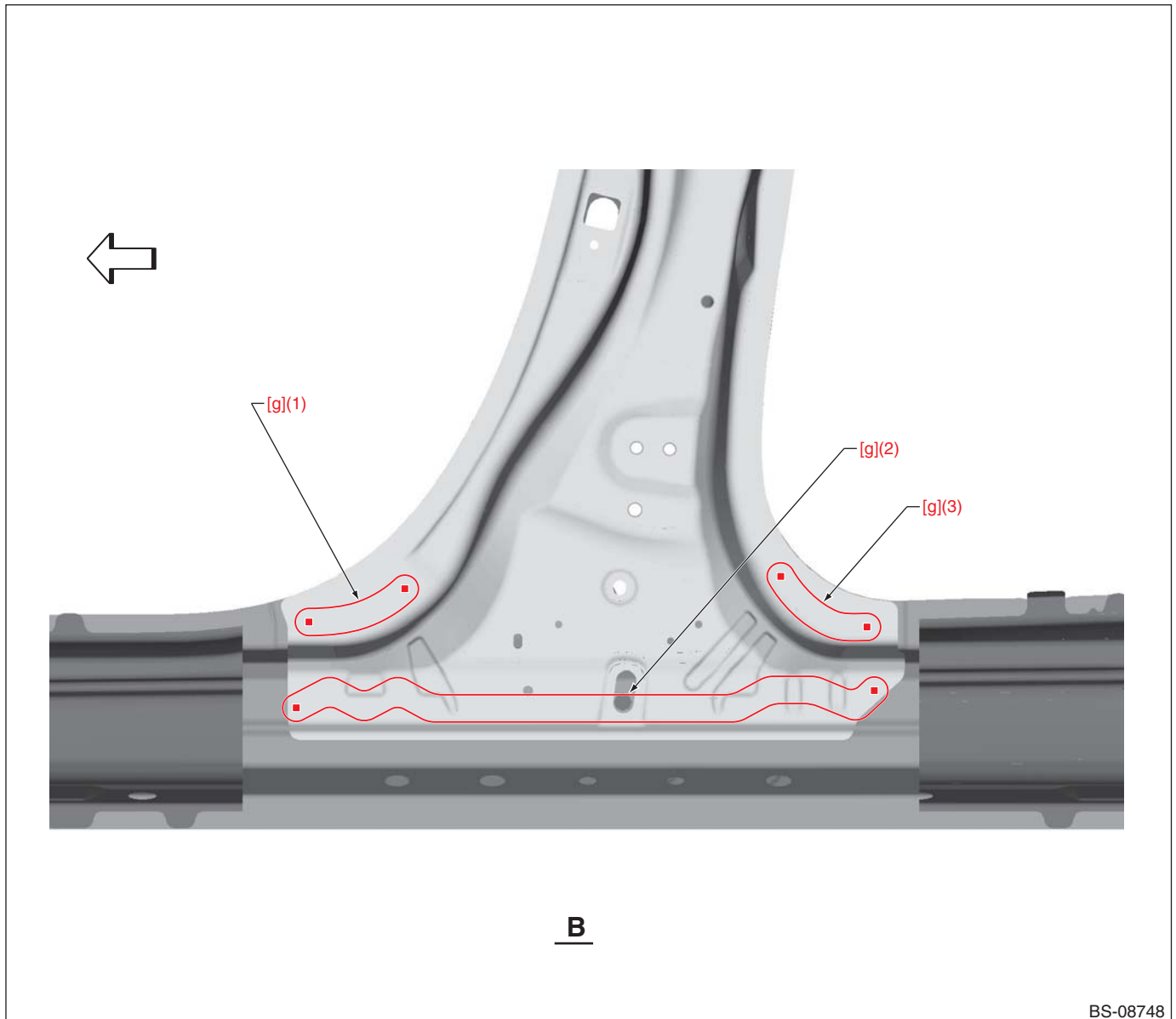
(3) 1 point (service)
(4) 2 points

(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)

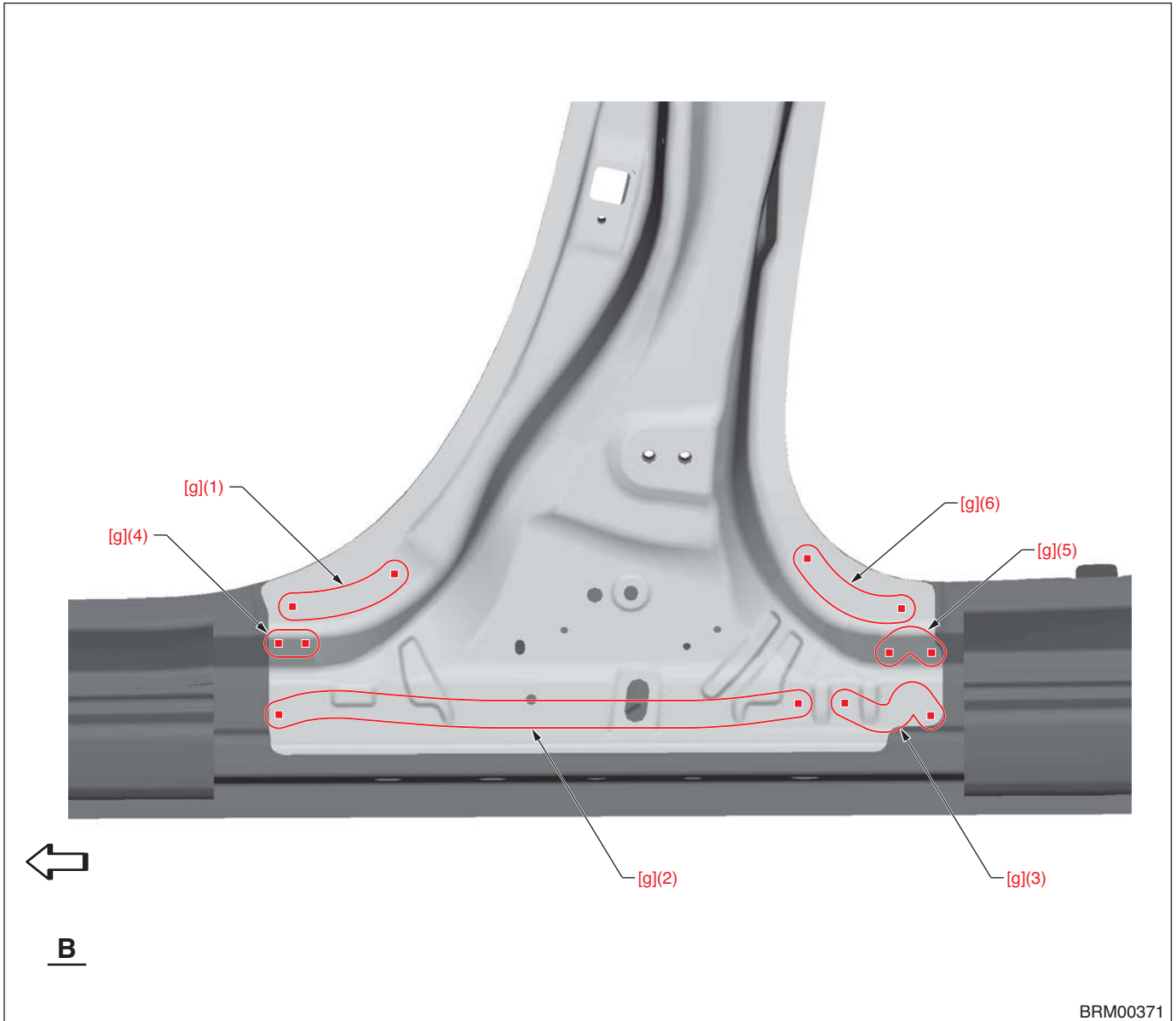
[g] Plug welding

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

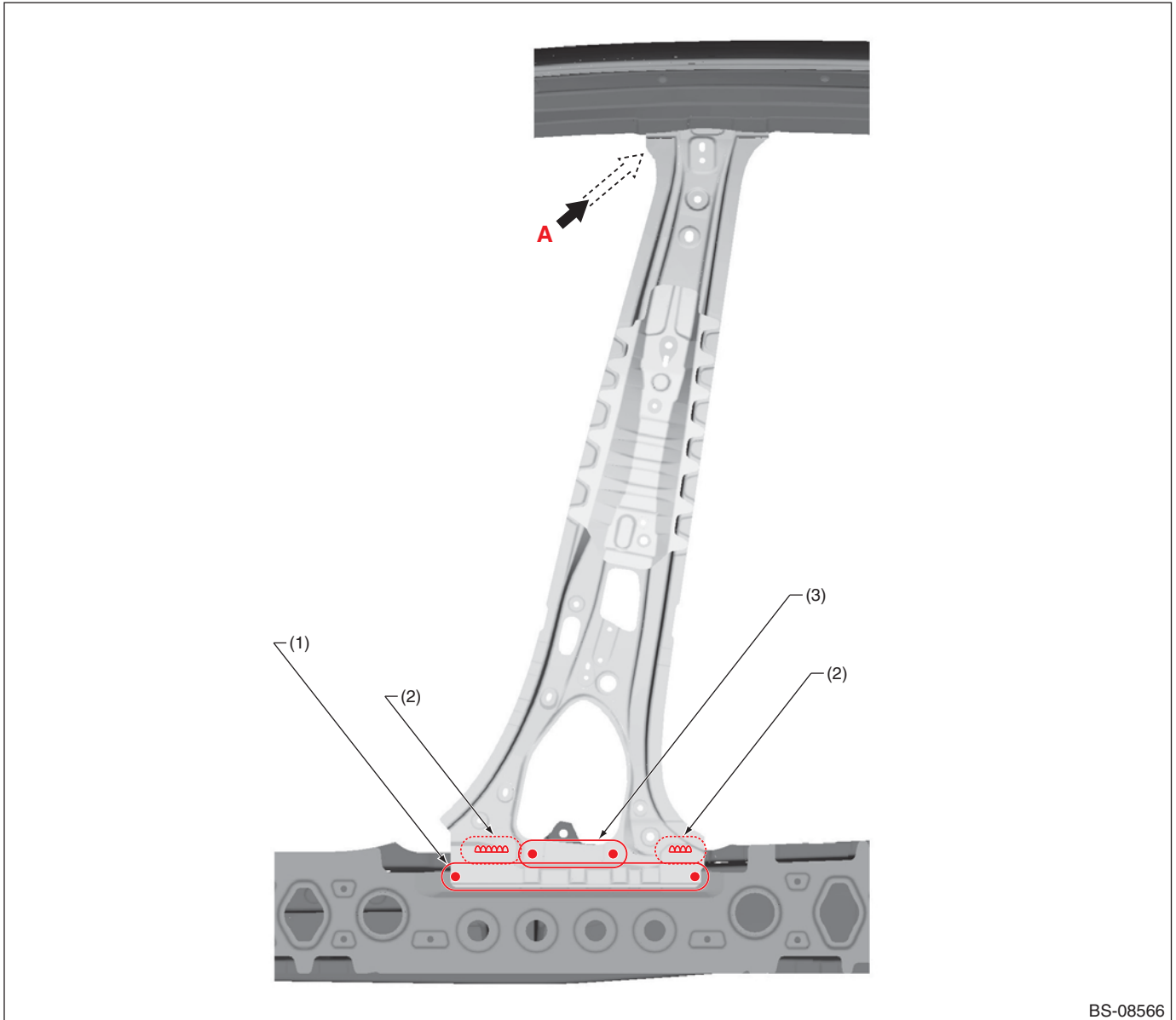
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-17. Center Pillar Inner (total replacement)

A: REMOVAL

• Overall view



BS-08566

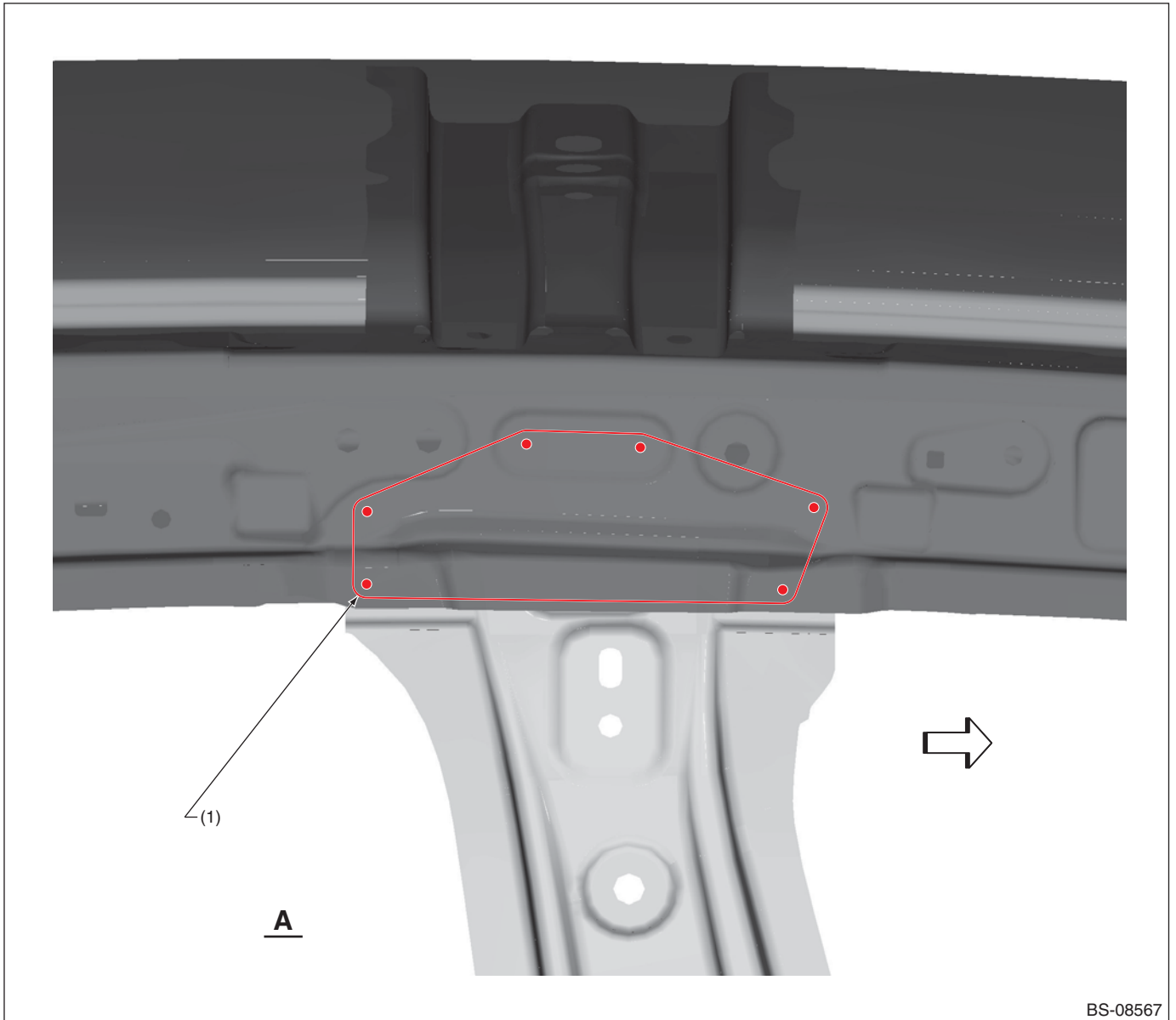
(1) 9 points (outside · 1)

(2) 1 point (inside · 1 belt sander)

(3) 2 points (outside · 1)

Panel Replacement

• Views A

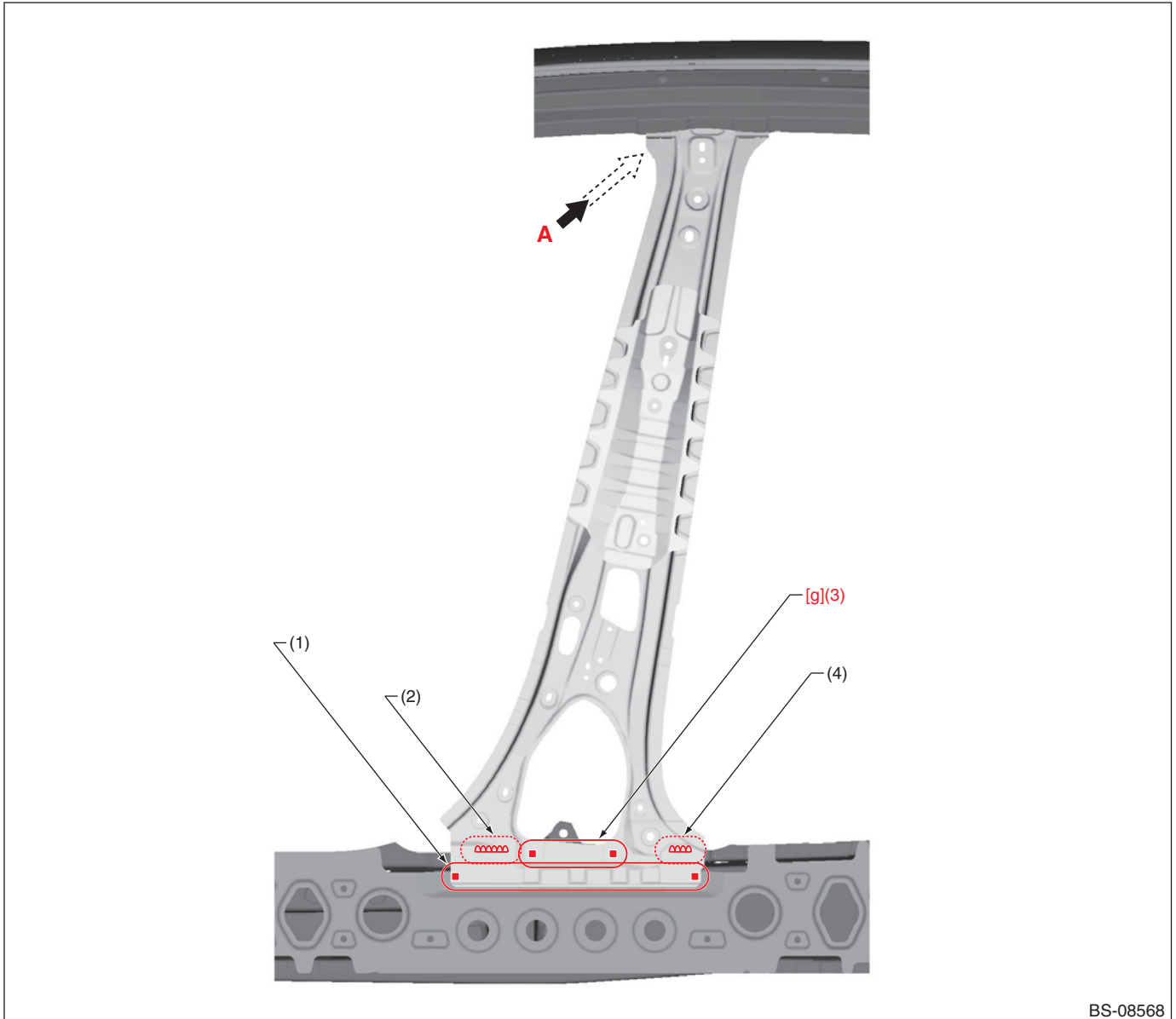


(1) 7 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(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])

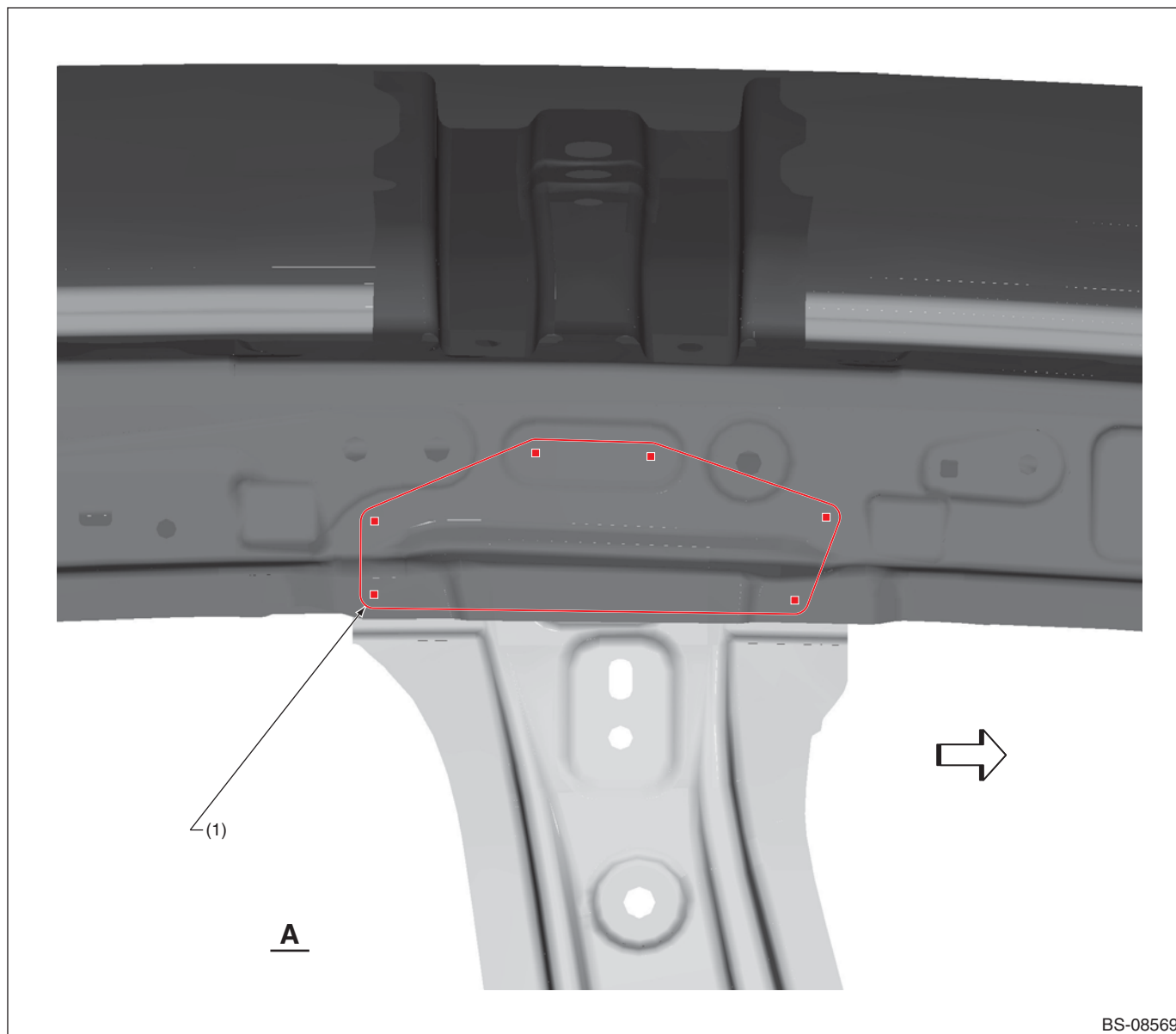
[g] Plug welding

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

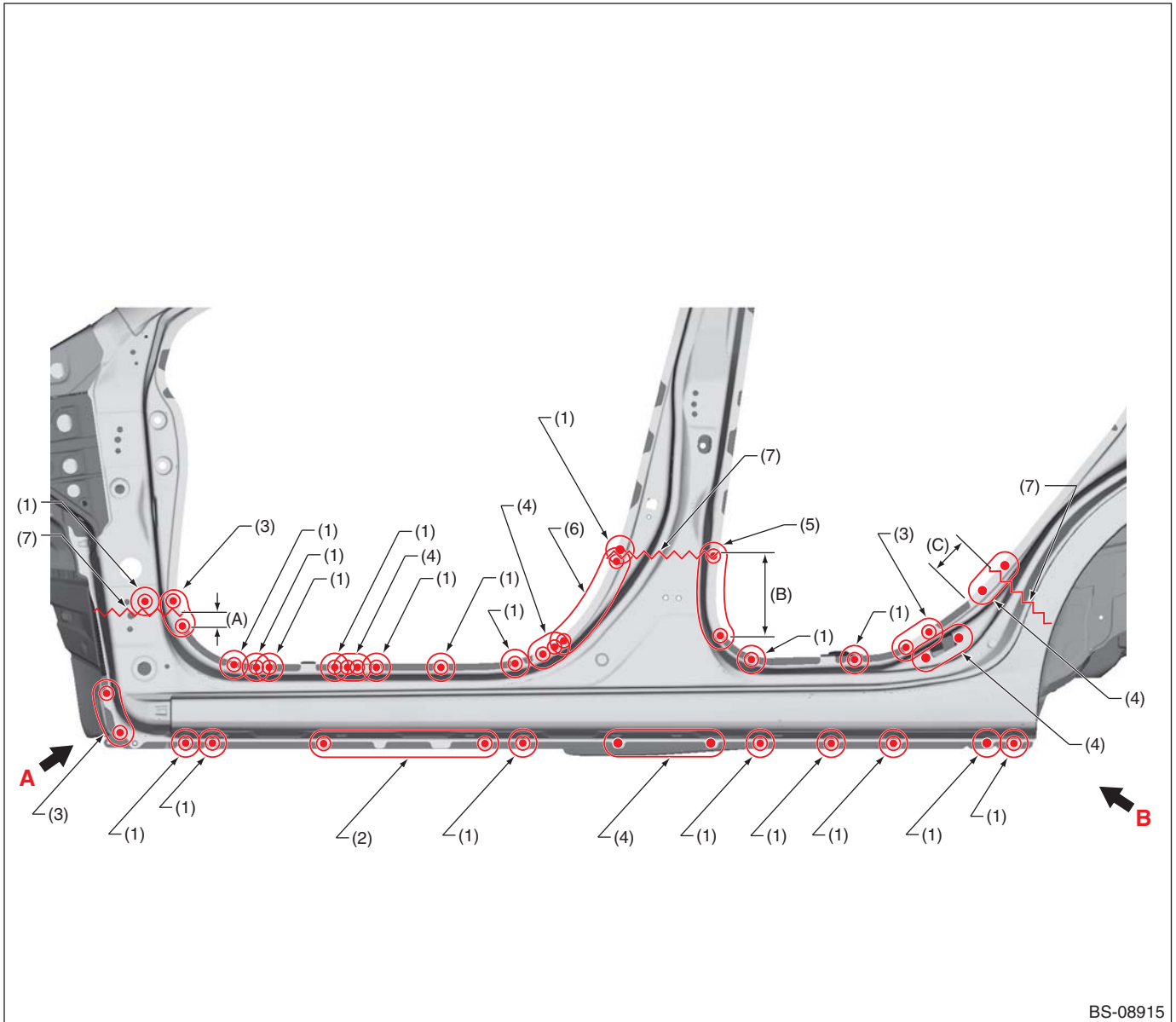


(1) 7 points

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)

(4) 2 points (outside · 1)

(7) Cut position

(2) 4 points (outside · 1)

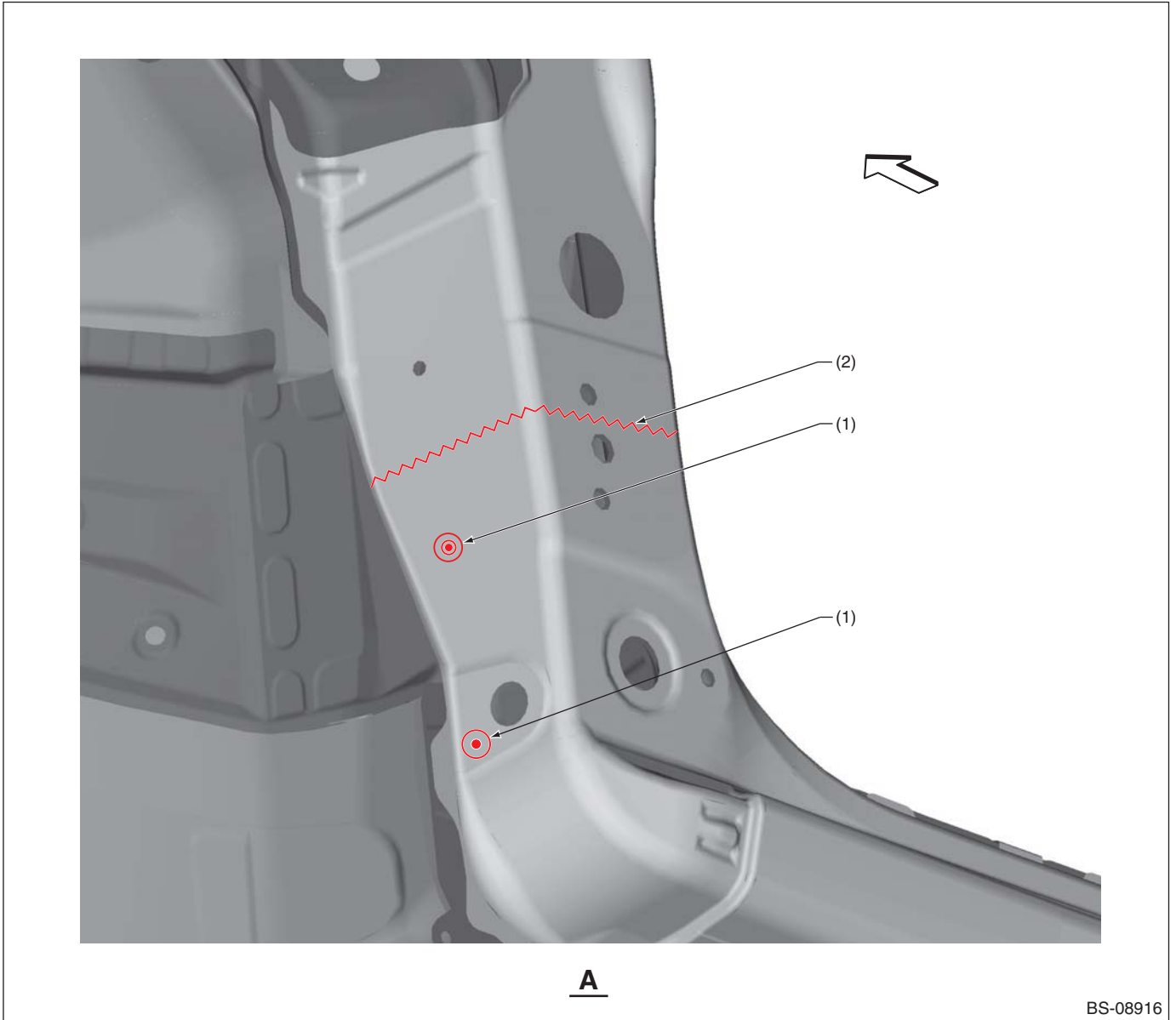
(5) 8 points (outside · 1)

(3) 3 points (outside · 1)

(6) 7 points (outside · 1)

Panel Replacement

• Views A

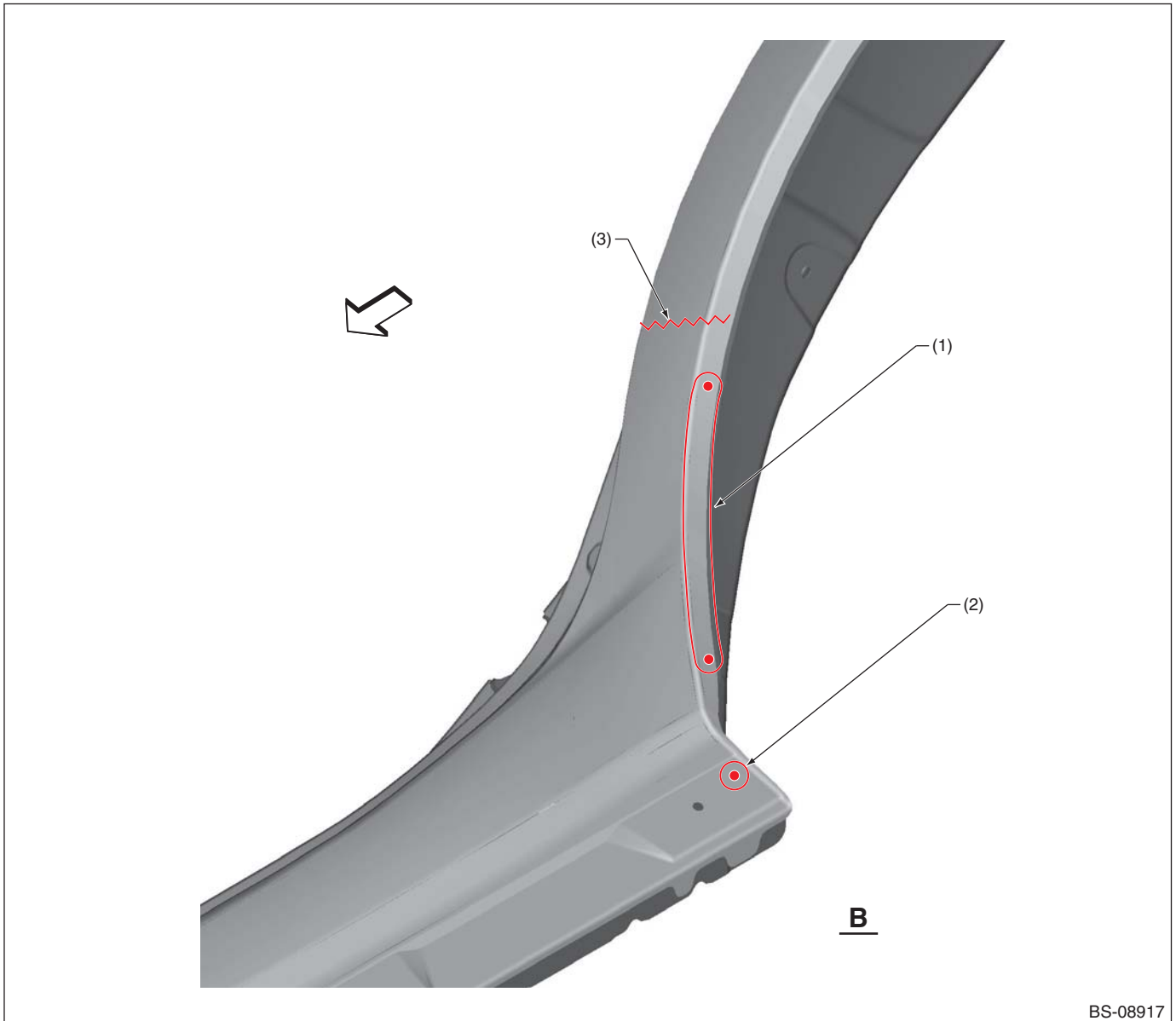


(1) 1 point (outside · 1)

(2) Cut position

Panel Replacement

- Views B (5D/4D model)



BS-08917

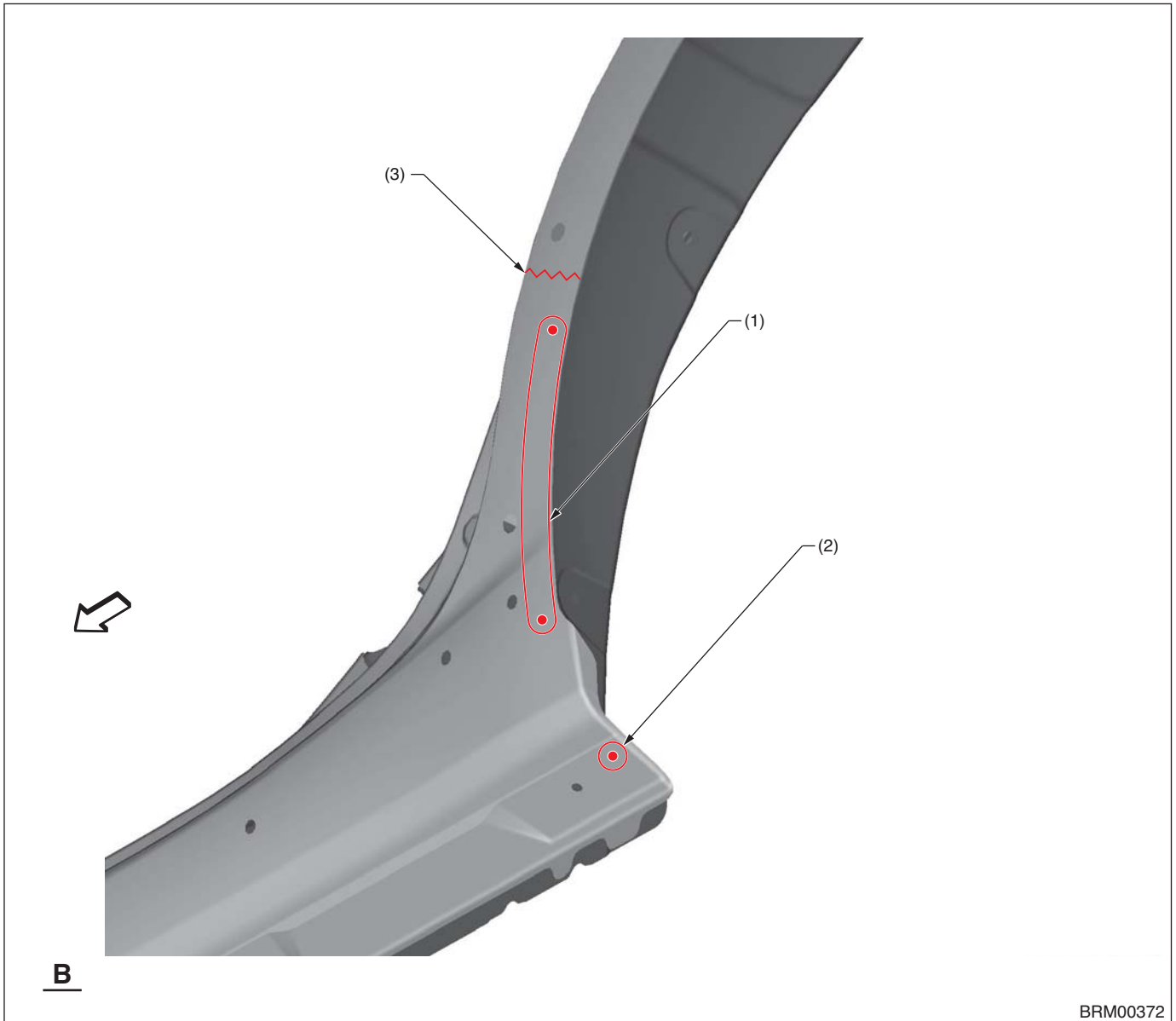
(1) 3 points (outside · 1)

(2) 1 point (bottom · 1)

(3) Cut position

Panel Replacement

- Views B (XV / Hybrid model)



(1) 3 points (outside · 1)

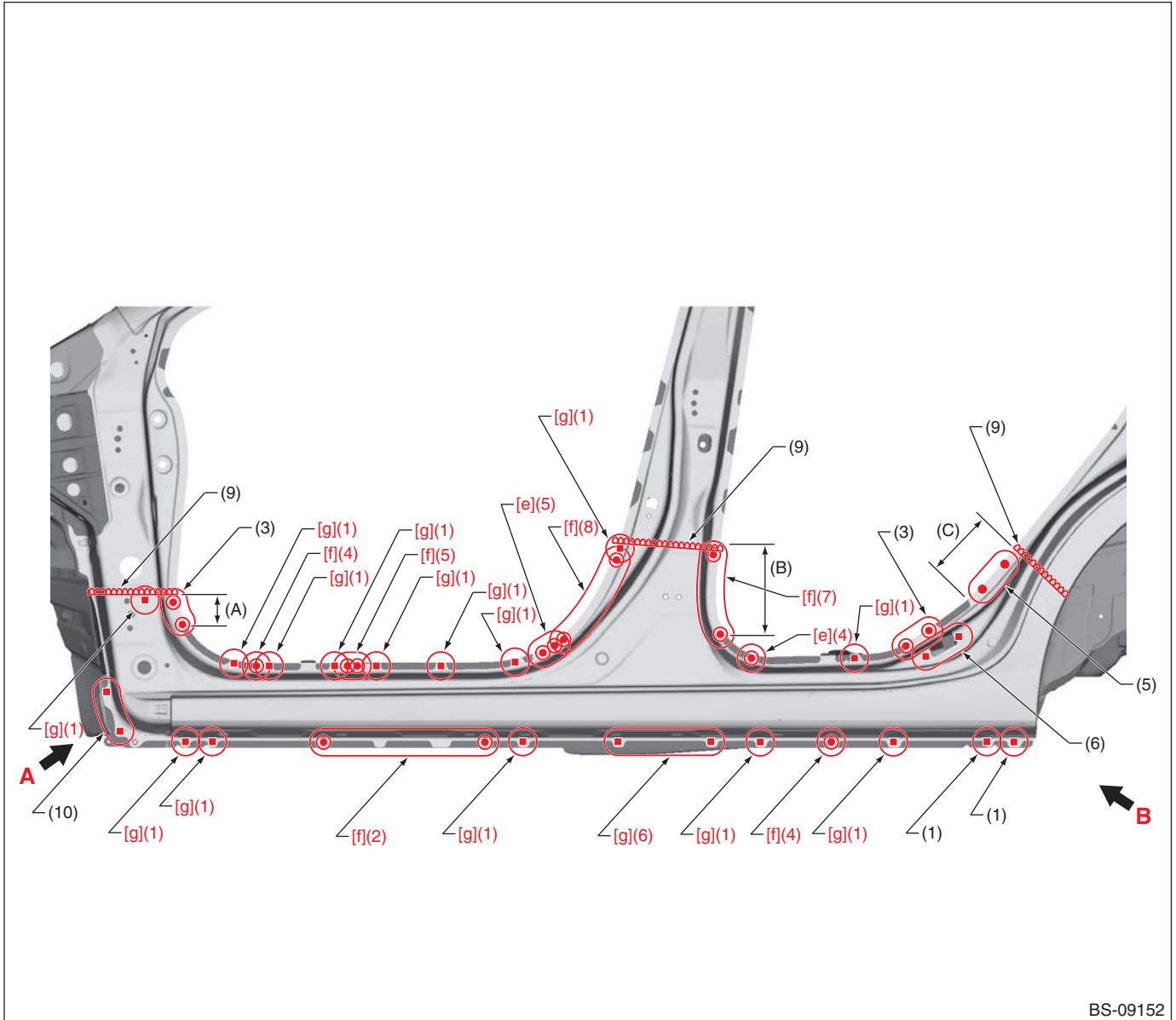
(2) 1 point (bottom · 1)

(3) Cut position

Panel Replacement

B: INSTALLATION

- **Overall view**

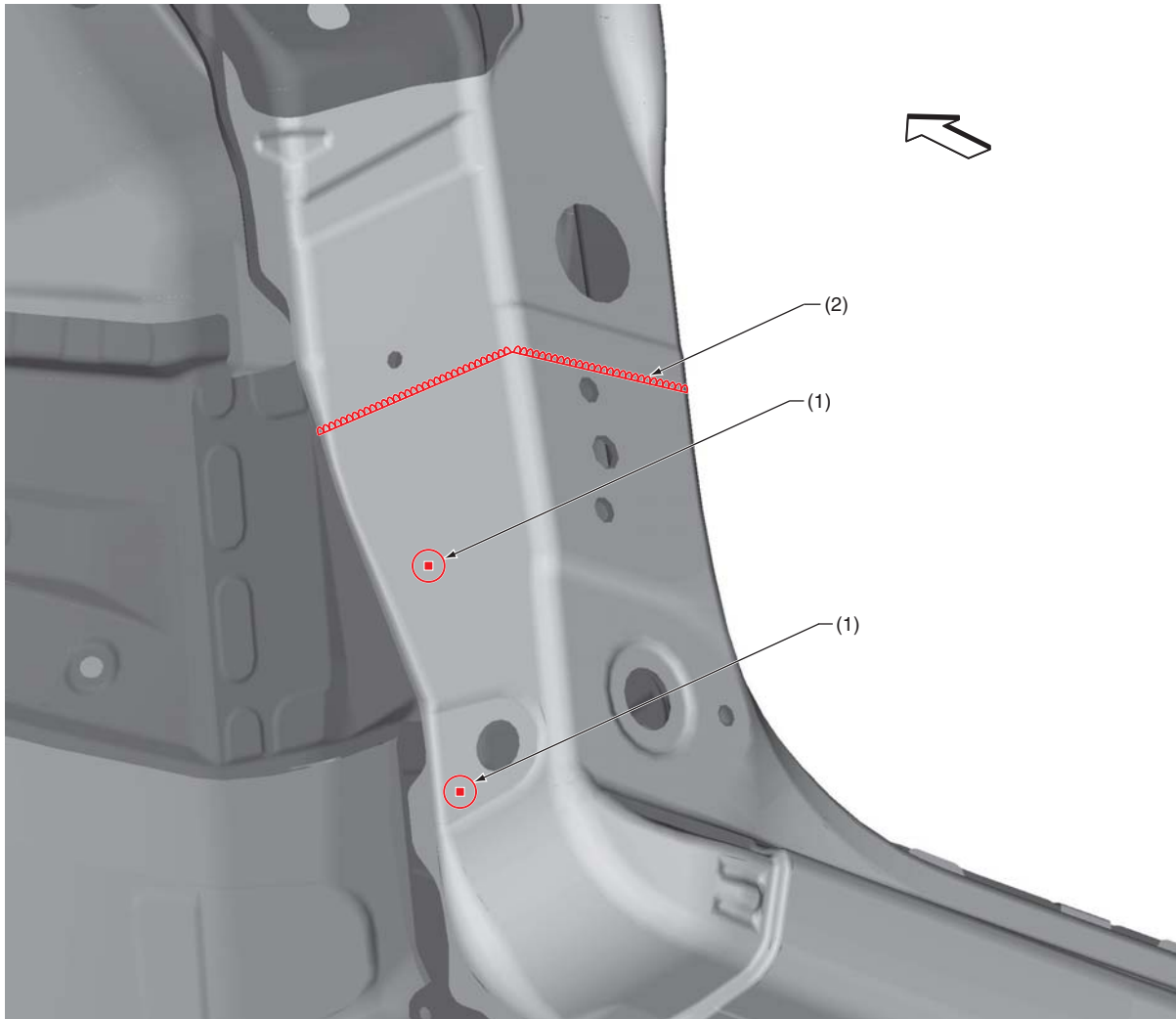


- | | | | | | |
|-----|-------------------|-----|--------------------|------|------------------------------|
| (A) | 70 mm [2.76 in] | (B) | 170 mm [6.69 in] | (C) | 120 mm [4.72 in] |
| (1) | 1 point (service) | (5) | 2 points | (9) | 1 point (Continuous welding) |
| (2) | 4 points | (6) | 2 points (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



A

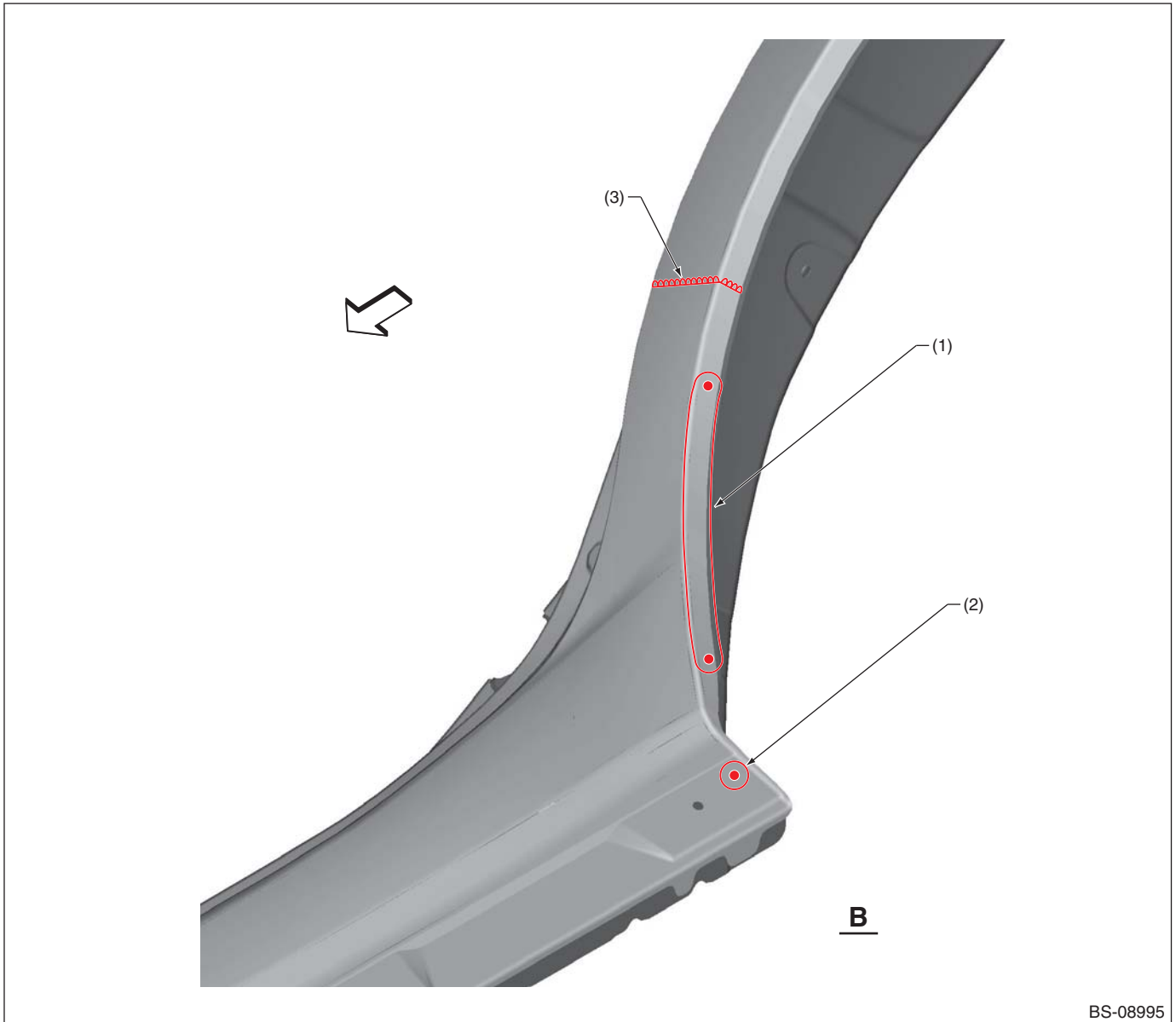
BS-08919

(1) 1 point (service)

(2) 1 point (Continuous welding)

Panel Replacement

- Views B (5D/4D model)



BS-08995

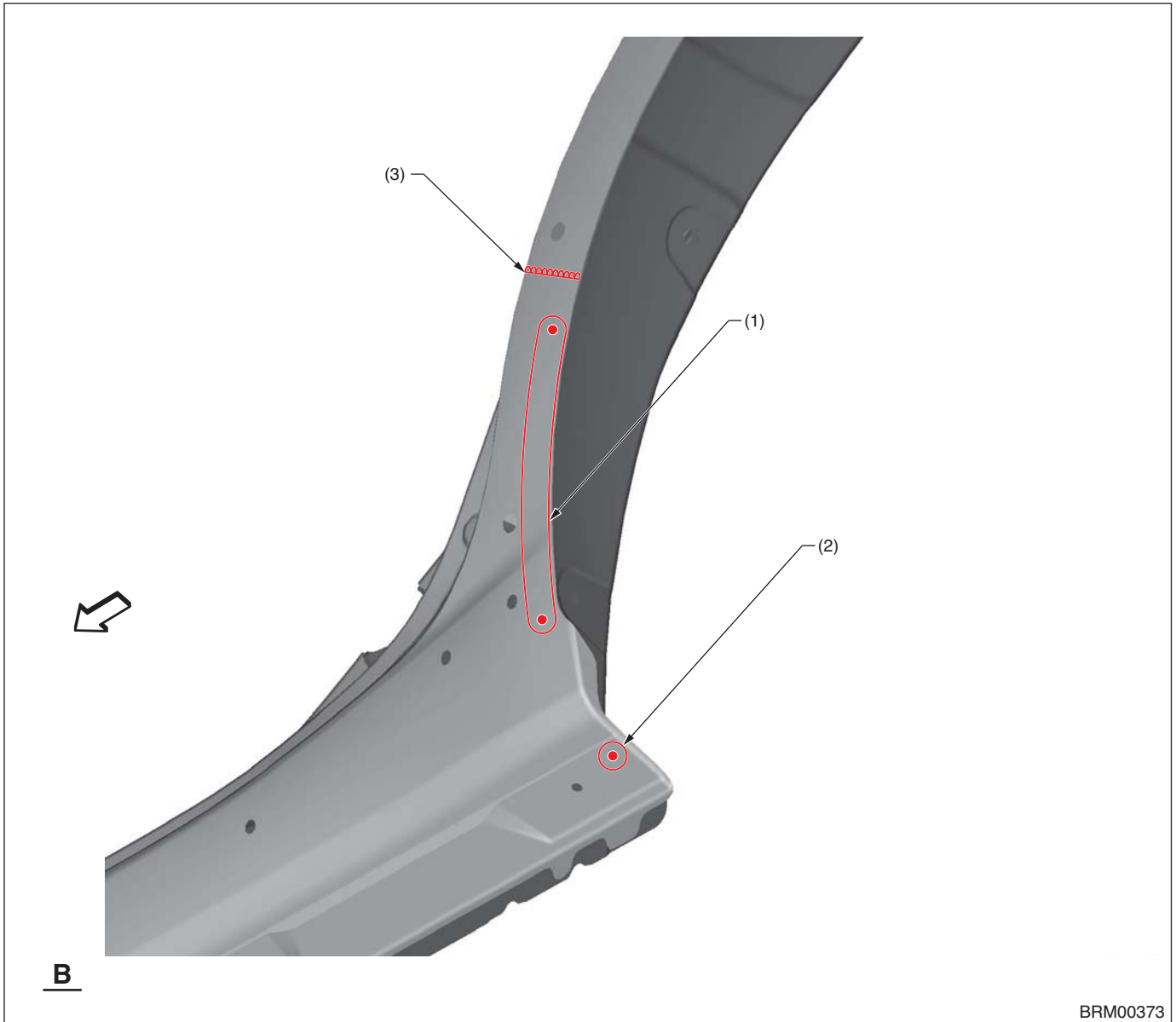
(1) 3 points

(2) 1 point

(3) 1 point (Continuous welding)

Panel Replacement

- Views B (XV / Hybrid model)



(1) 3 points

(2) 1 point

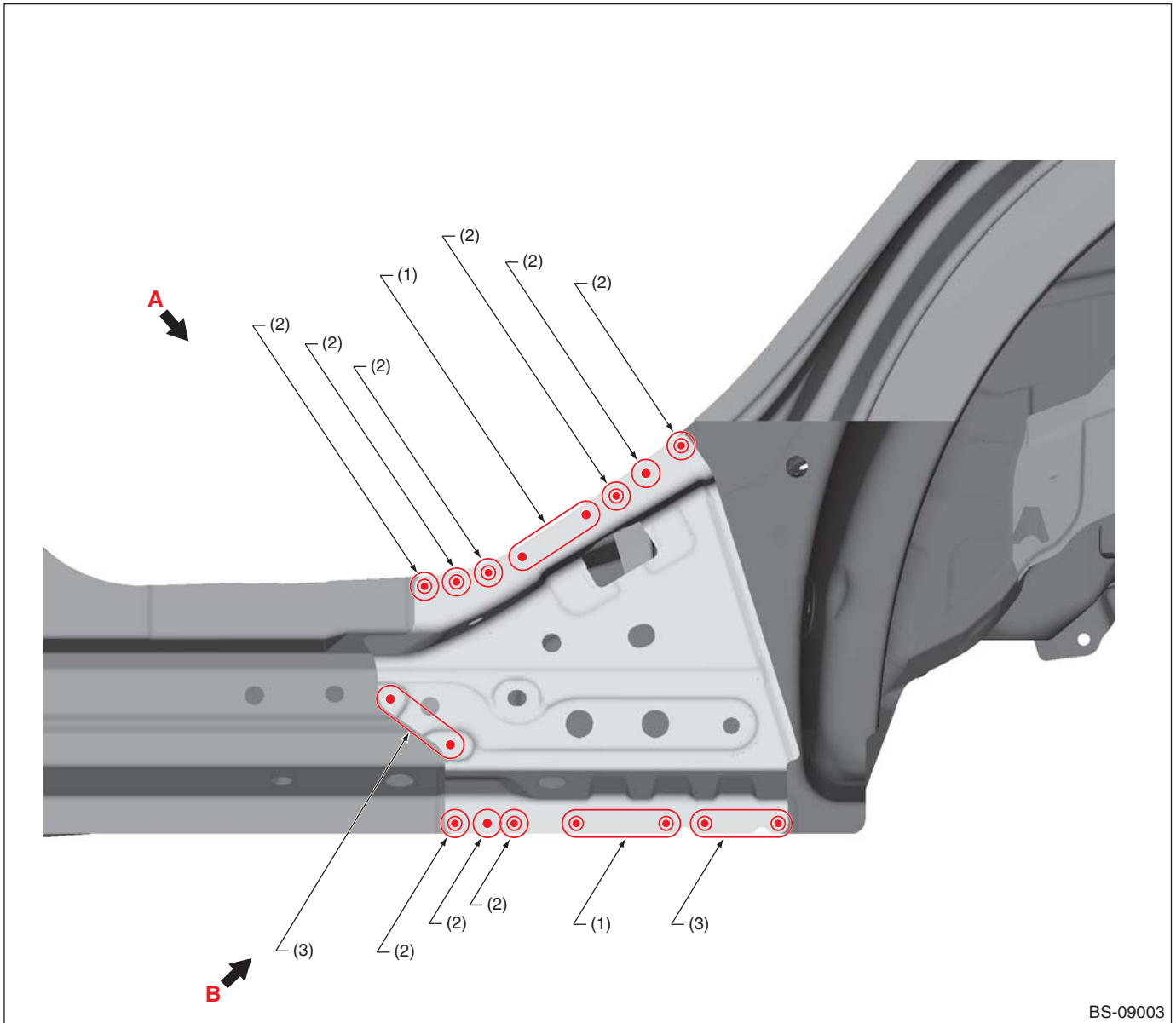
(3) 1 point (Continuous welding)

Panel Replacement

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

A: REMOVAL

• Overall view



BS-09003

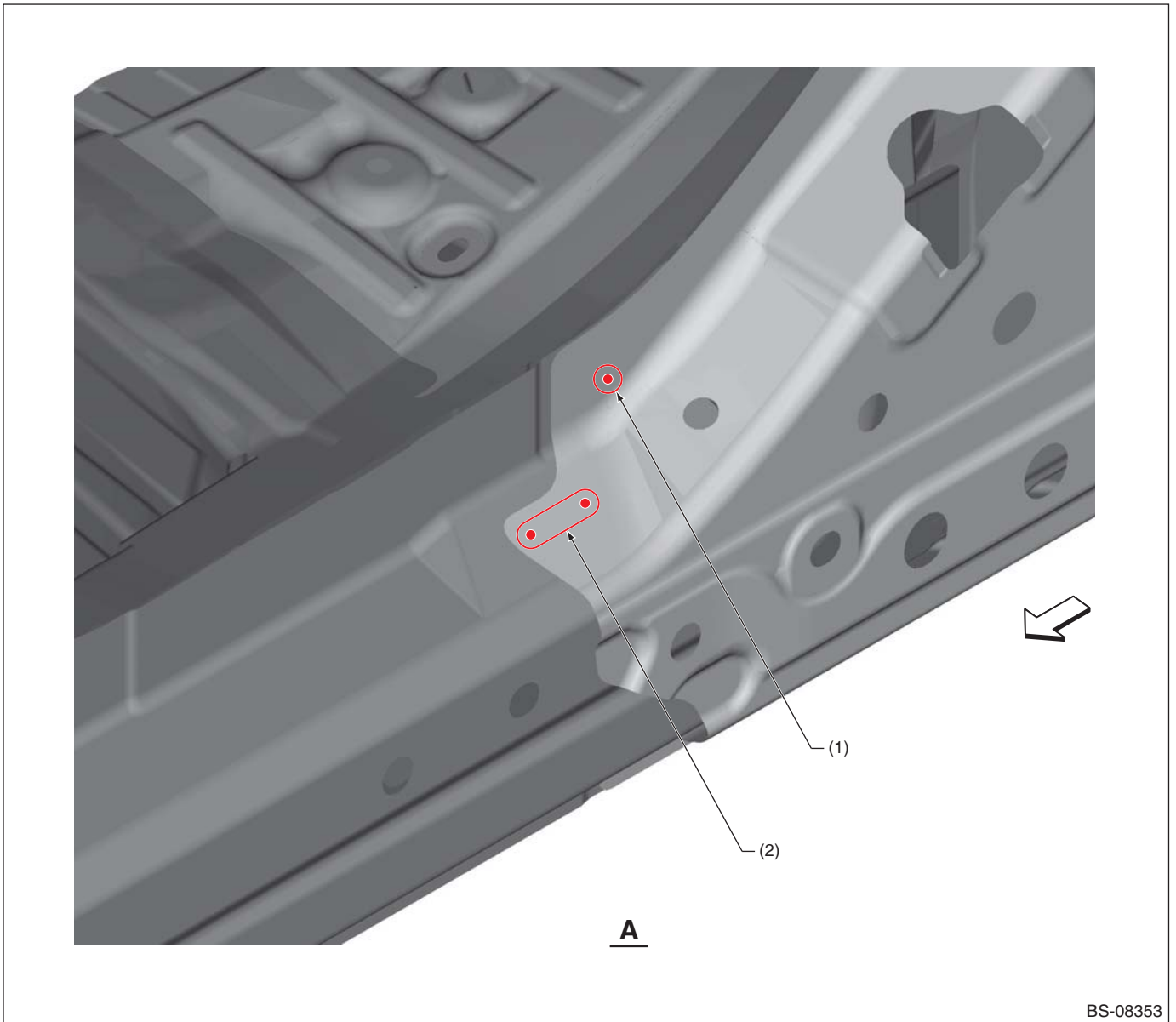
(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

(3) 2 points (outside · 1)

Panel Replacement

• Views A

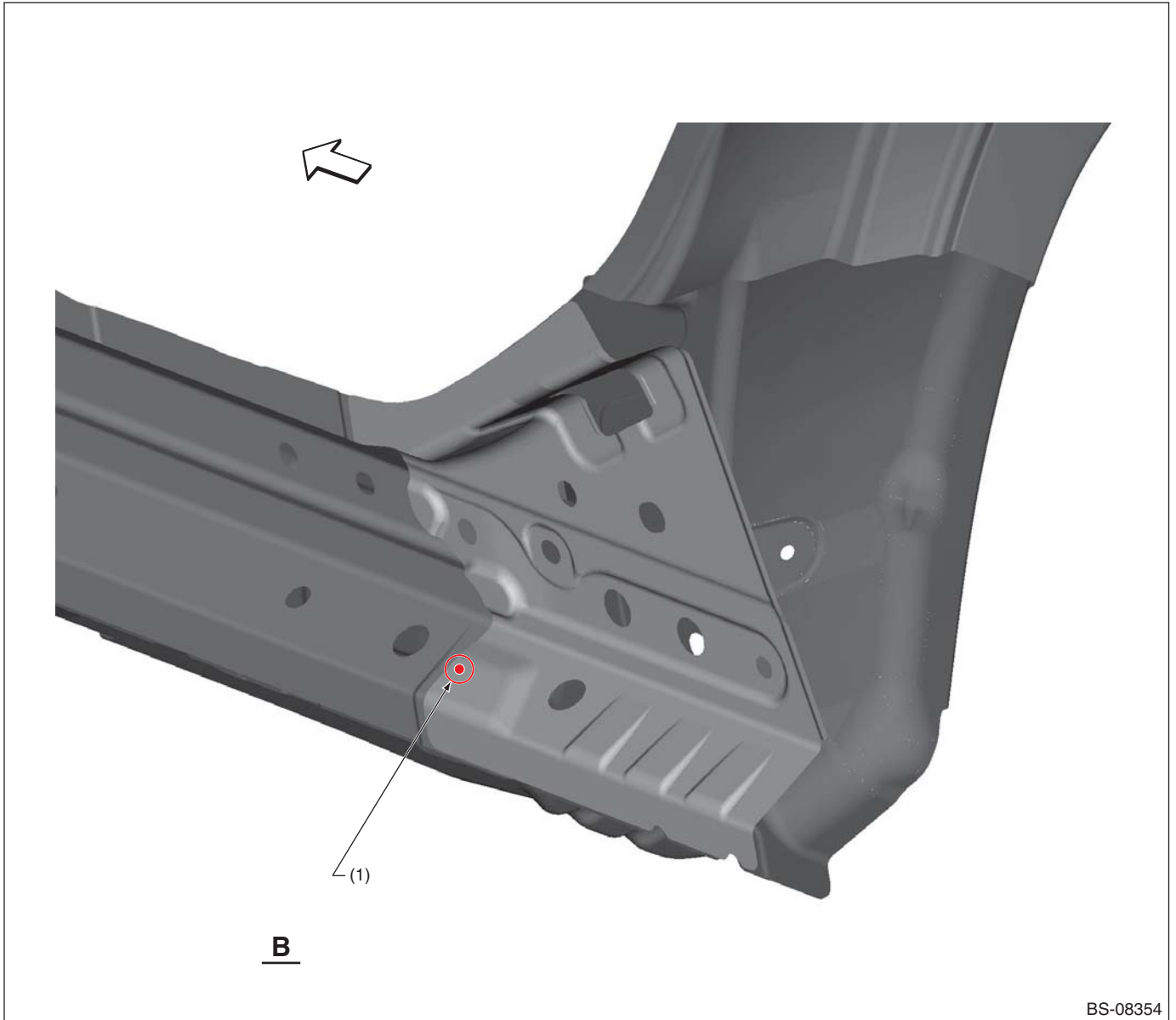


(1) 1 point (outside · 1)

(2) 2 points (top · 1)

Panel Replacement

- Views B

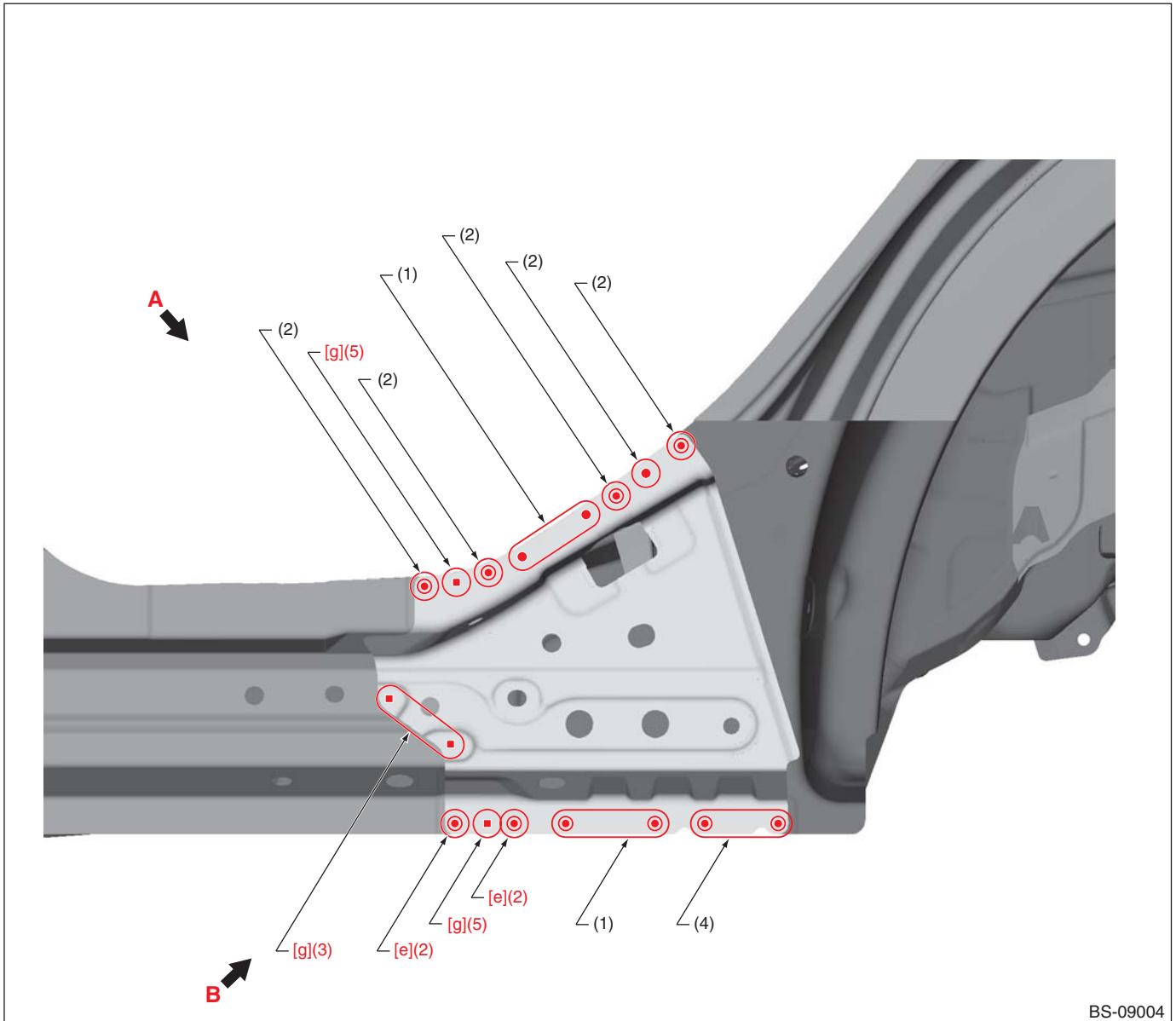


(1) 1 point (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 3 points
(2) 1 point

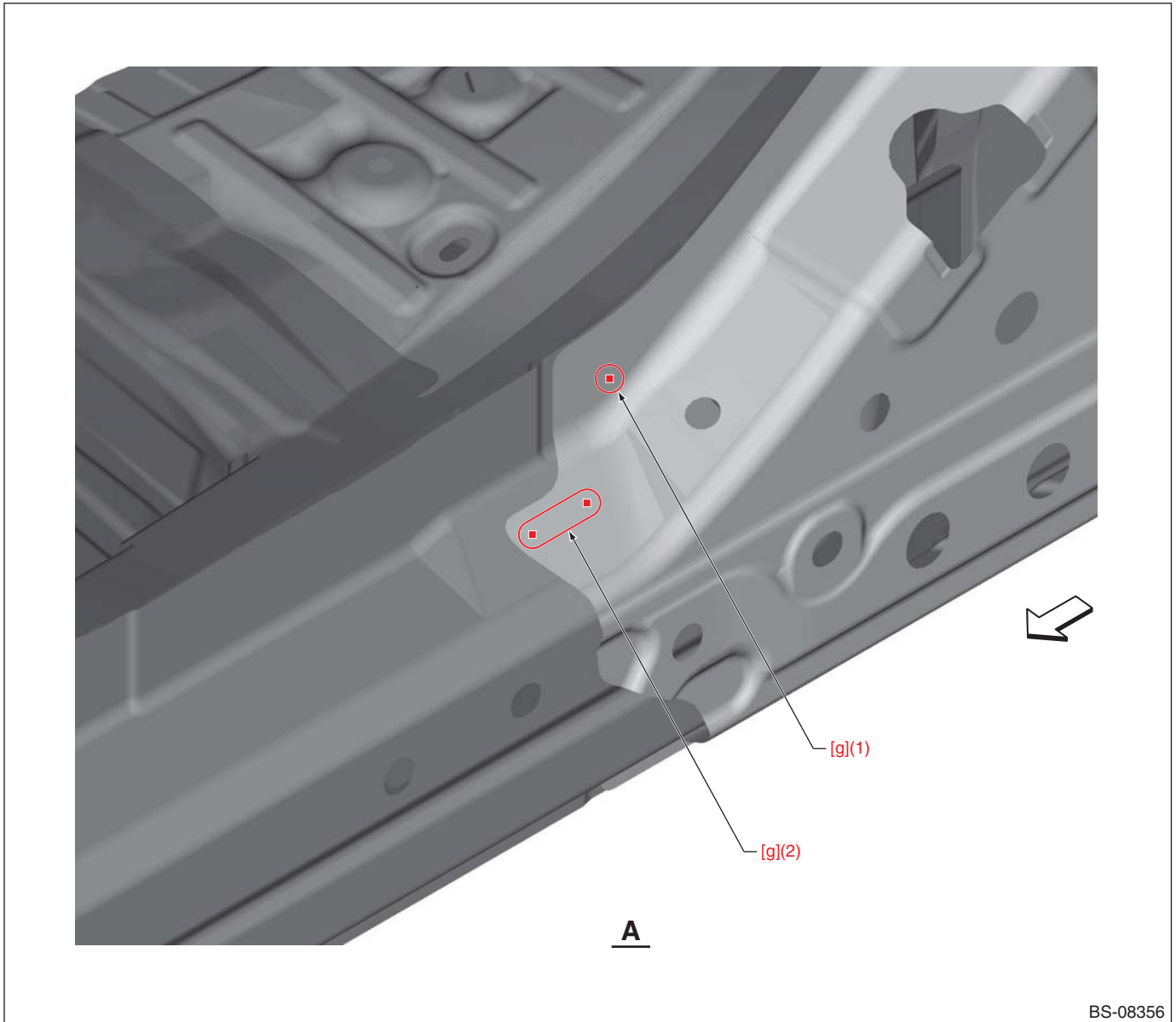
(3) 2 points (service)
(4) 2 points

(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)

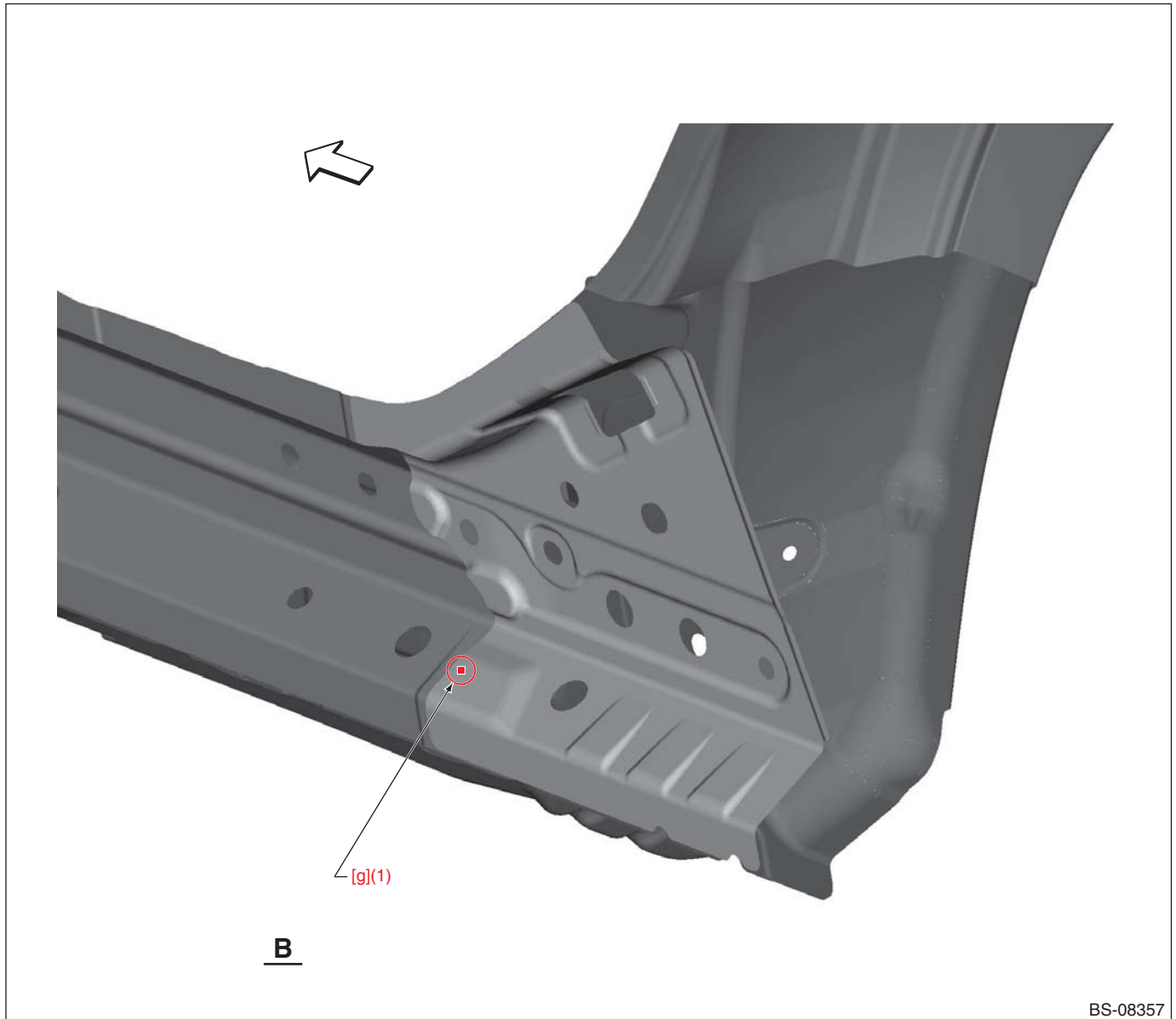
[g] Plug welding

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

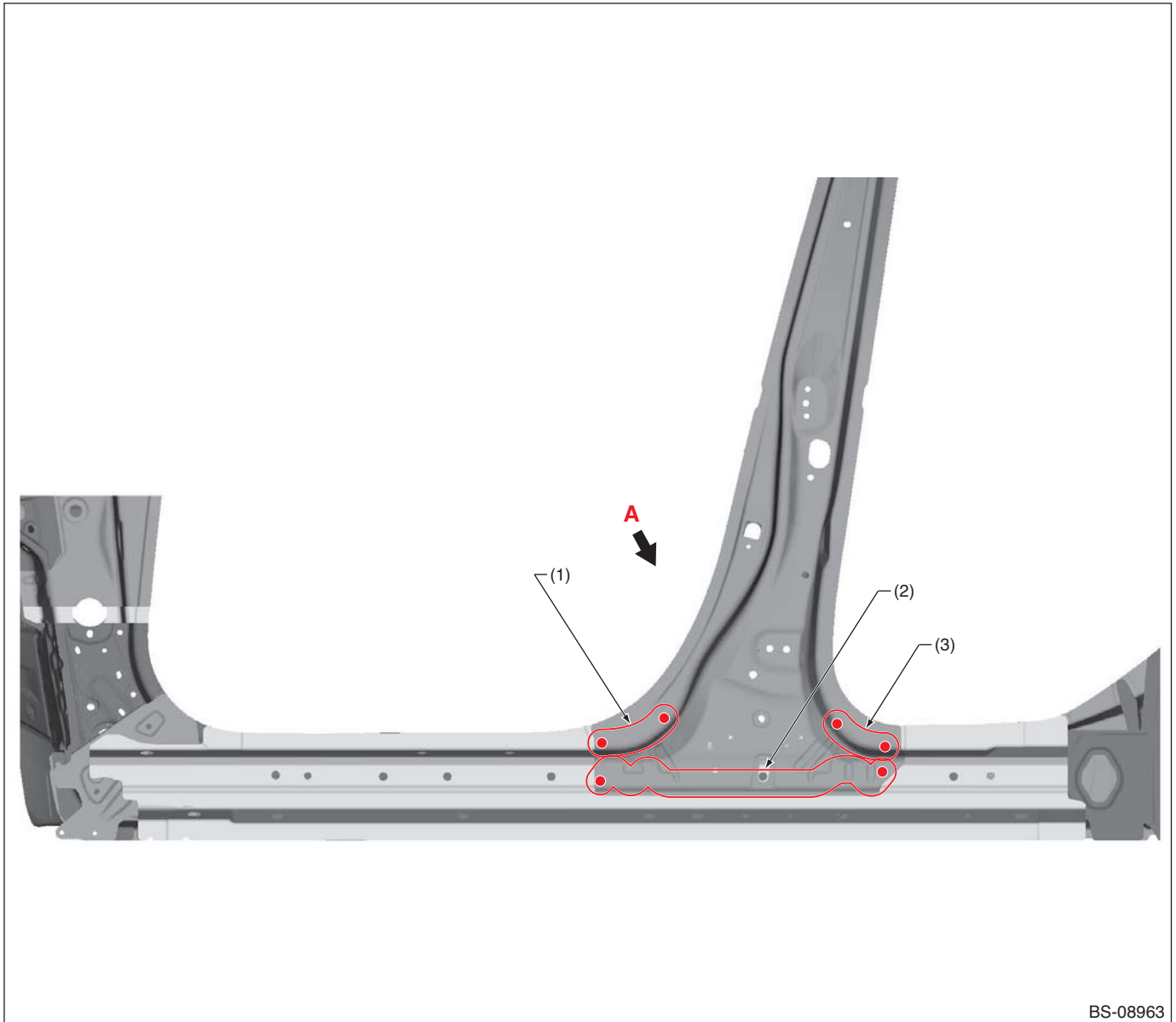
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

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

A: REMOVAL

- Overall view1 (Gasoline model)



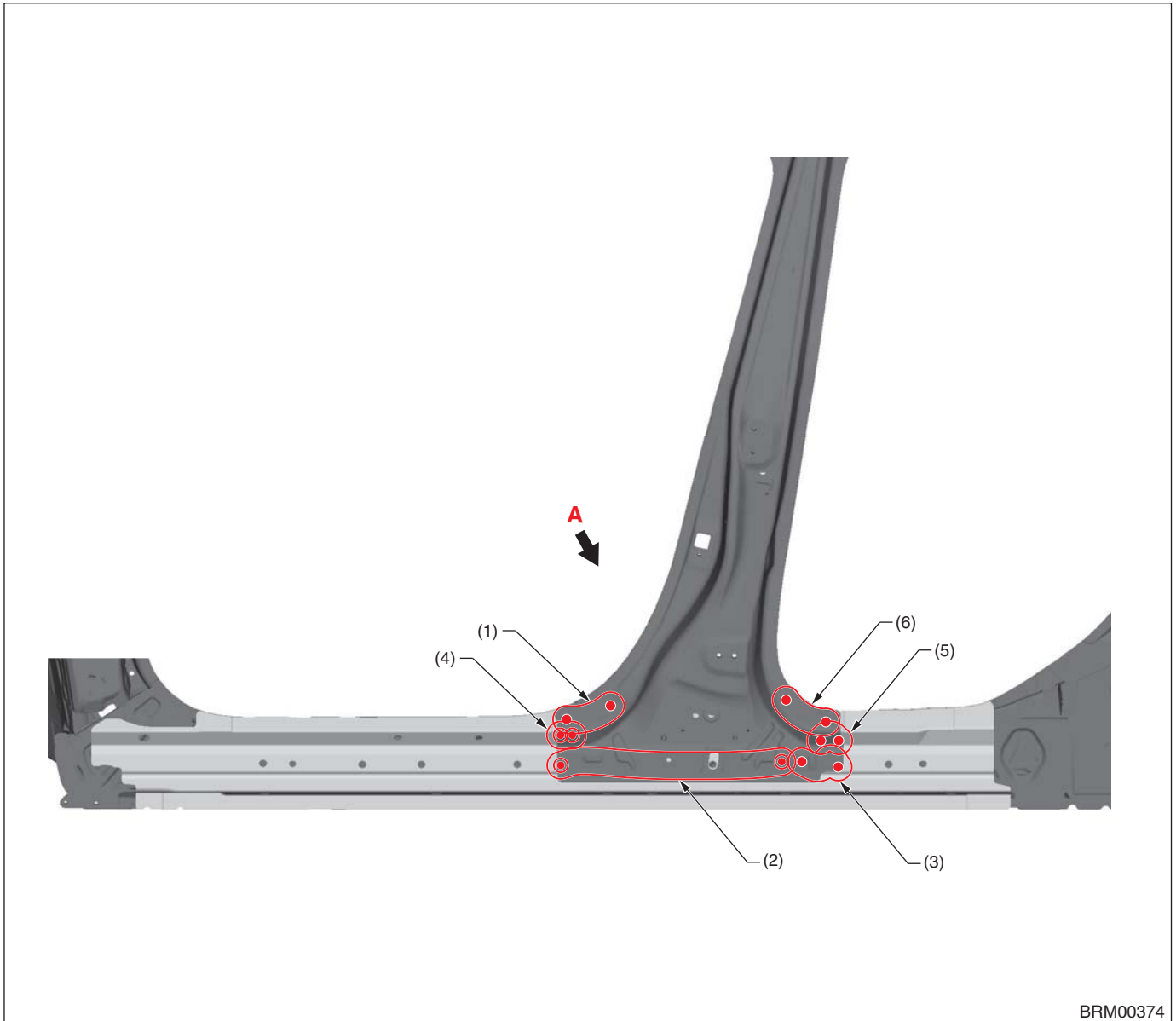
(1) 5 points (outside · 1)

(2) 16 points (outside · 1)

(3) 4 points (outside · 1)

Panel Replacement

- Overall view1 (Hybrid model)



BRM00374

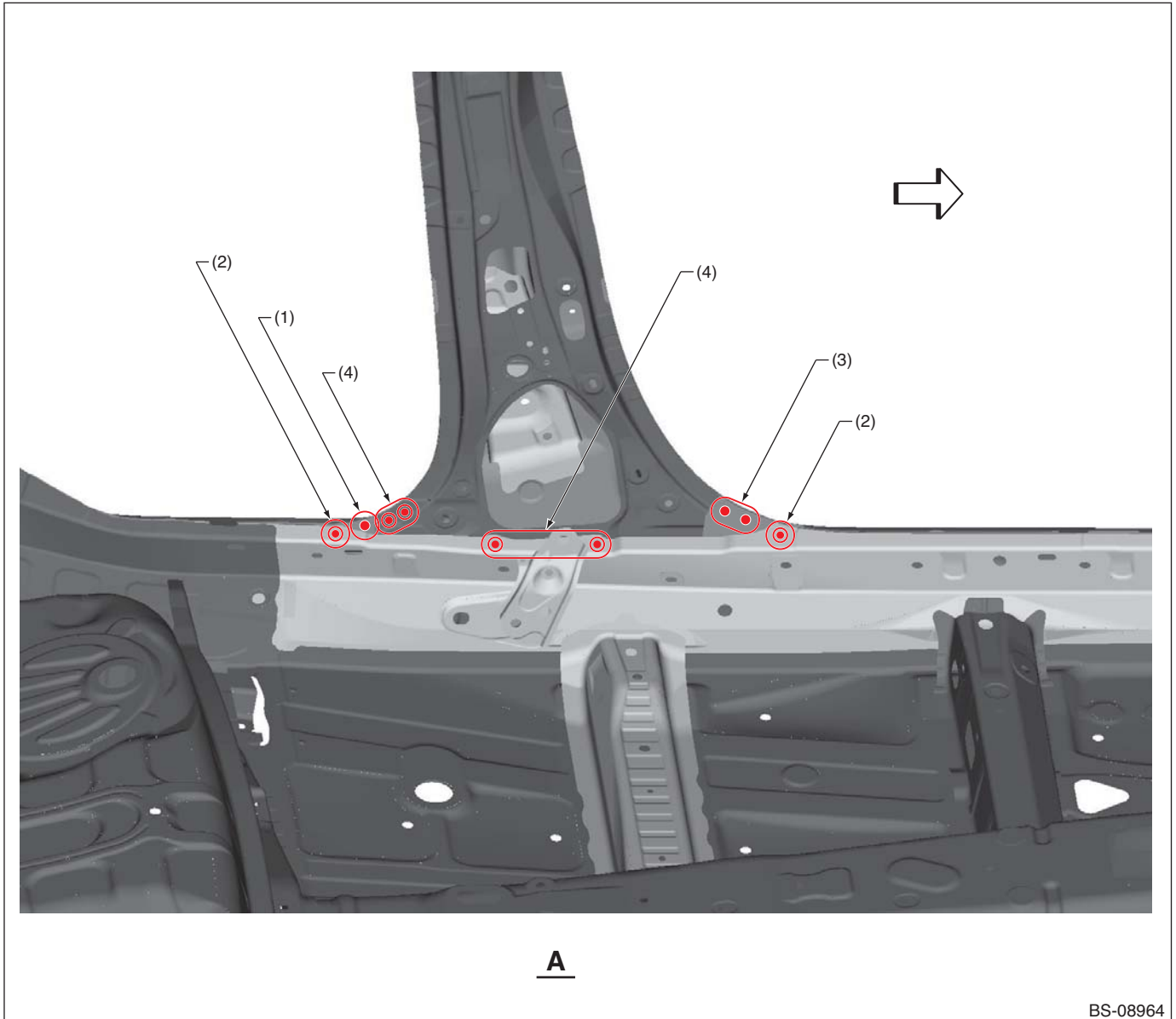
(1) 5 points (outside · 1)
(2) 10 points (outside · 1)

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

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

Panel Replacement

• Views A



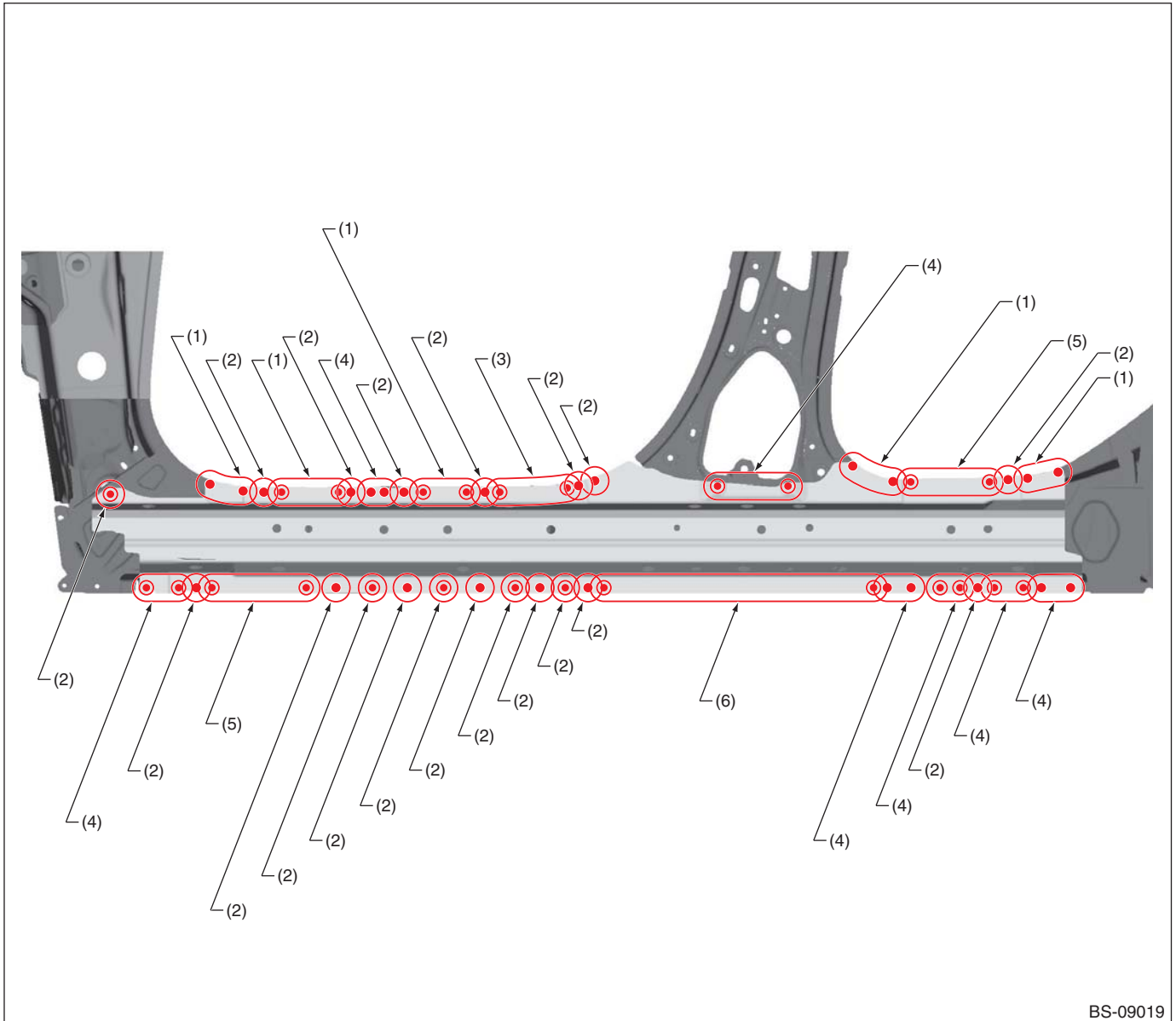
BS-08964

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

(3) 2 points (inside · 1)

(4) 2 points (inside · 2)

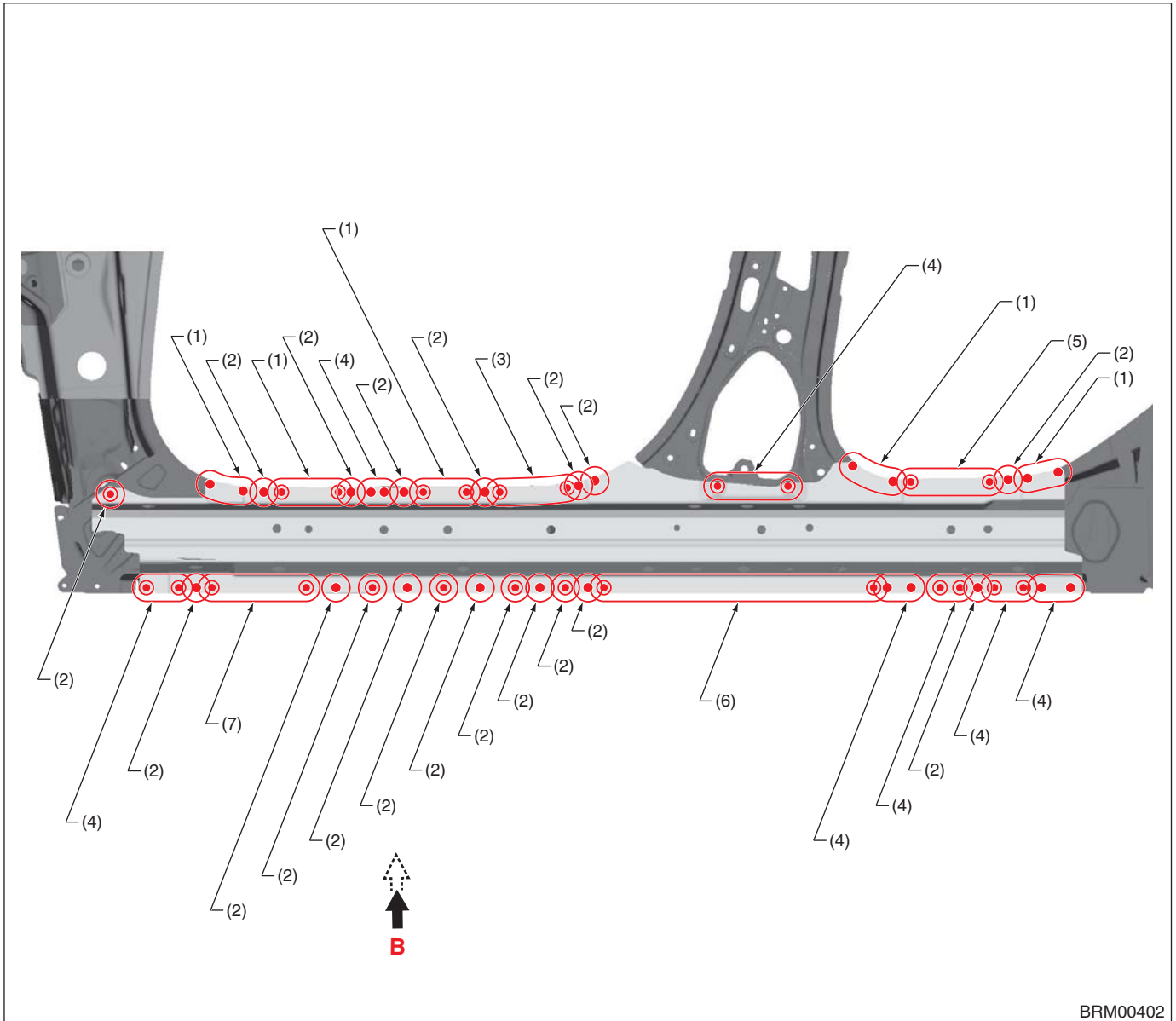
- **Overall view2 (Gasoline model)**



- (1) 3 points (outside · 1) (3) 7 points (outside · 1) (5) 5 points (outside · 1)
- (2) 1 point (outside · 1) (4) 2 points (outside · 1) (6) 11 points (outside · 1)

Panel Replacement

• Overall view2 (Hybrid model)

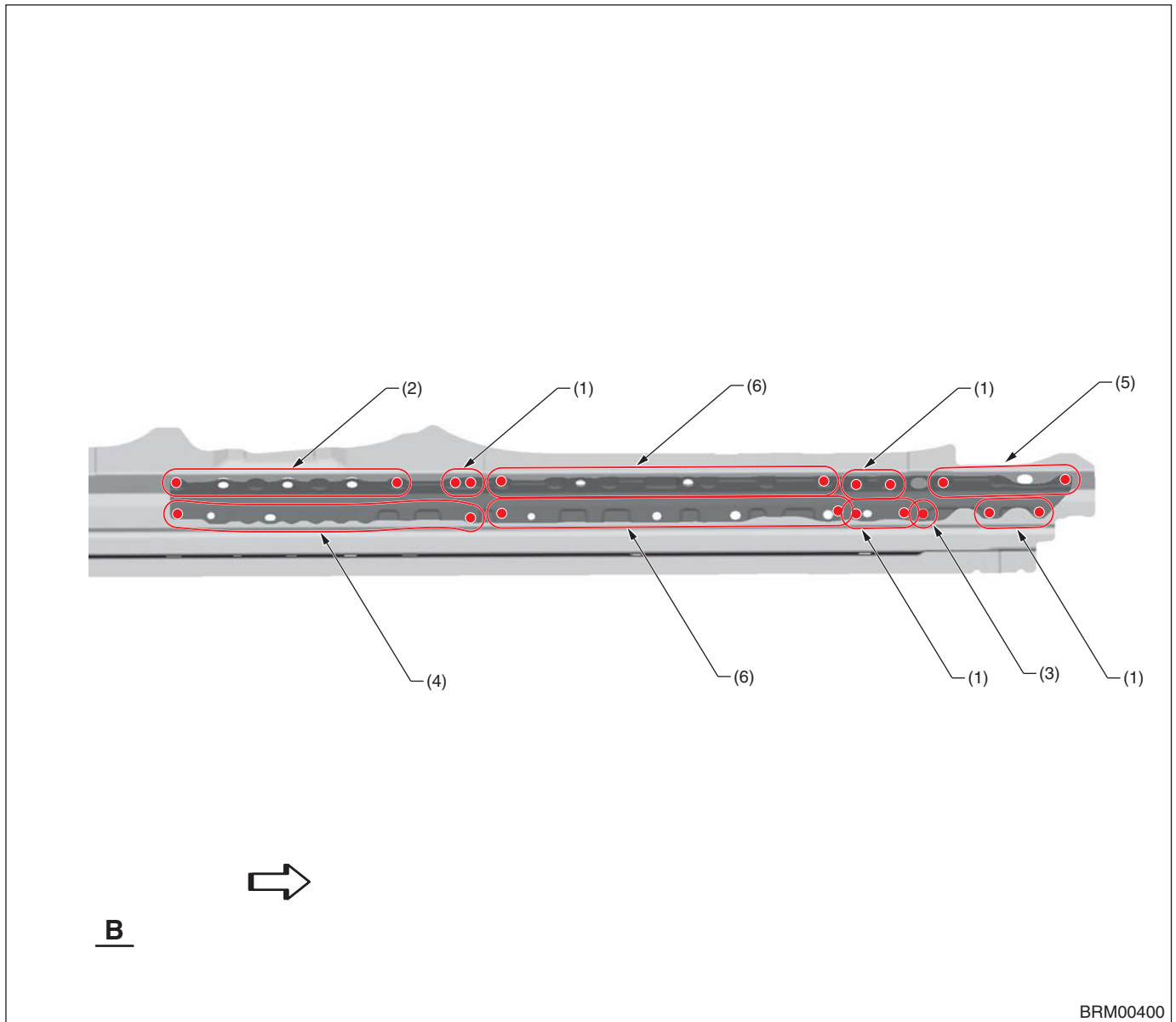


BRM00402

- | | | |
|----------------------------|-----------------------------|----------------------------|
| (1) 3 points (outside · 1) | (4) 2 points (outside · 1) | (7) 6 points (outside · 1) |
| (2) 1 point (outside · 1) | (5) 5 points (outside · 1) | |
| (3) 7 points (outside · 1) | (6) 11 points (outside · 1) | |

Panel Replacement

• Views B (Hybrid model)



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

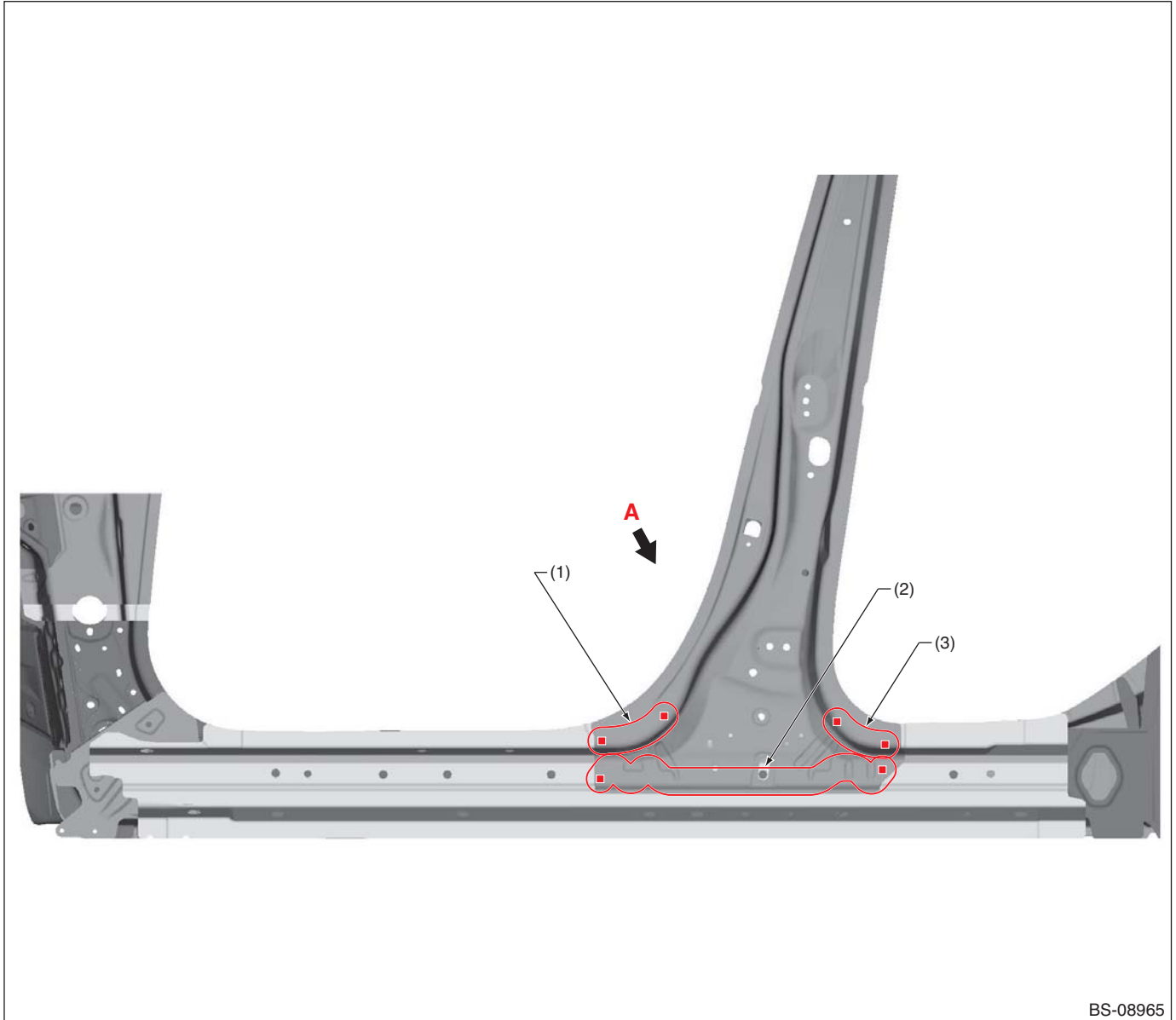
(3) 1 point (inside · 1)
(4) 10 points (inside · 1)

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

Panel Replacement

B: INSTALLATION

• Overall view1 (Gasoline model)



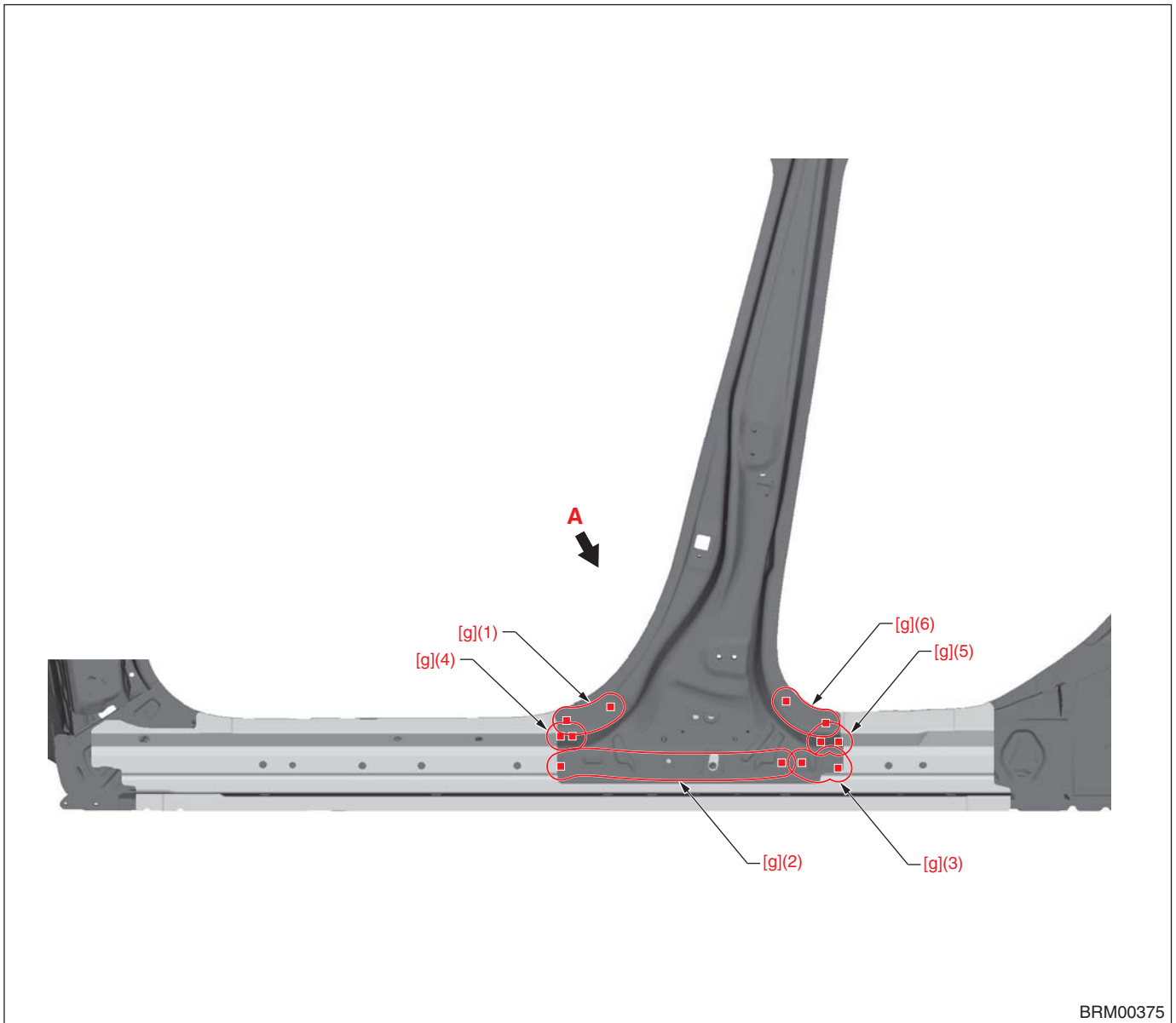
(1) 5 points

(2) 16 points

(3) 4 points

Panel Replacement

- Overall view1 (Hybrid model)



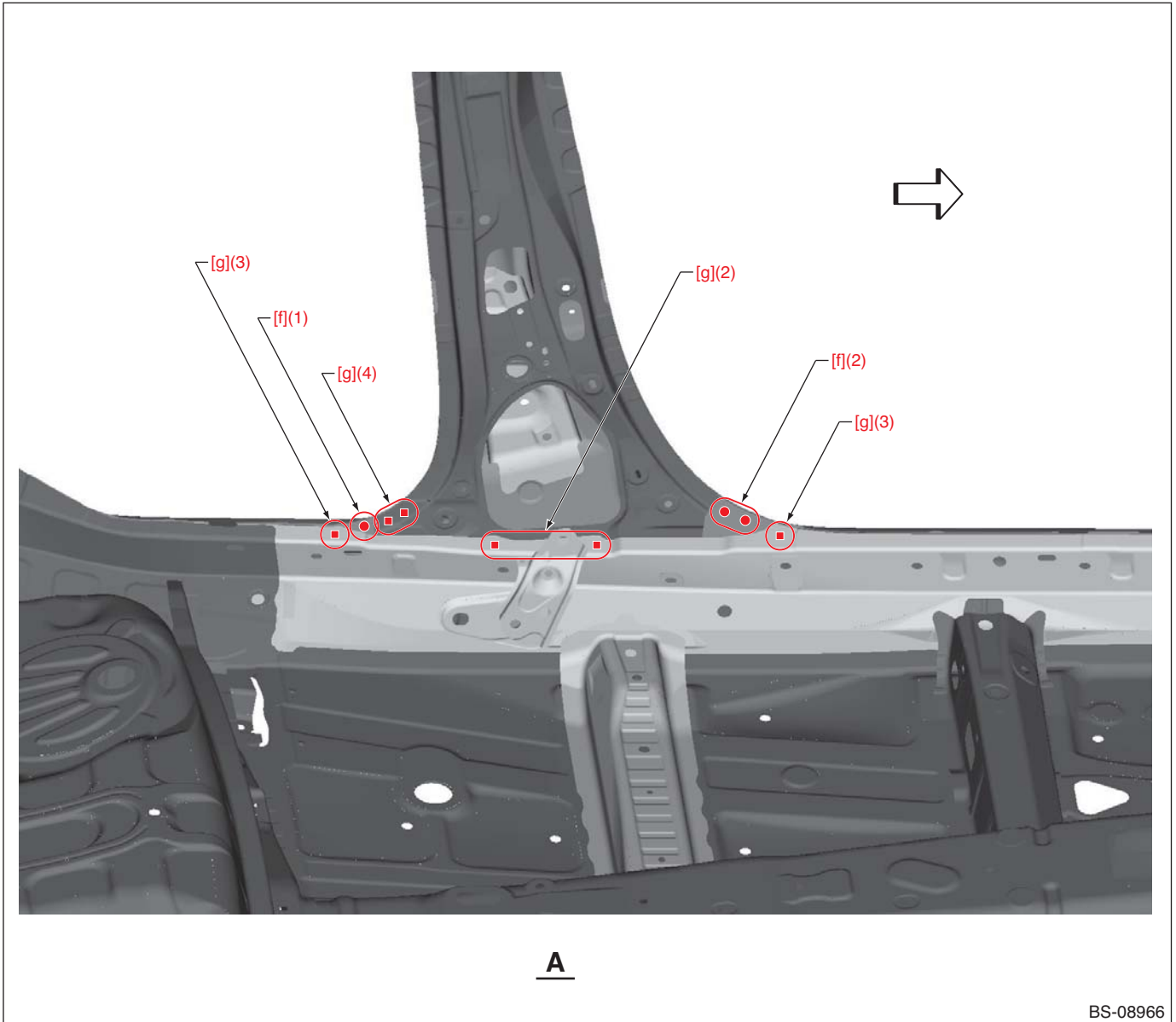
(1) 5 points
(2) 10 points

(3) 4 points
(4) 2 points

(5) 3 points
(6) 6 points

Panel Replacement

• Views A



(1) 1 point
(2) 2 points

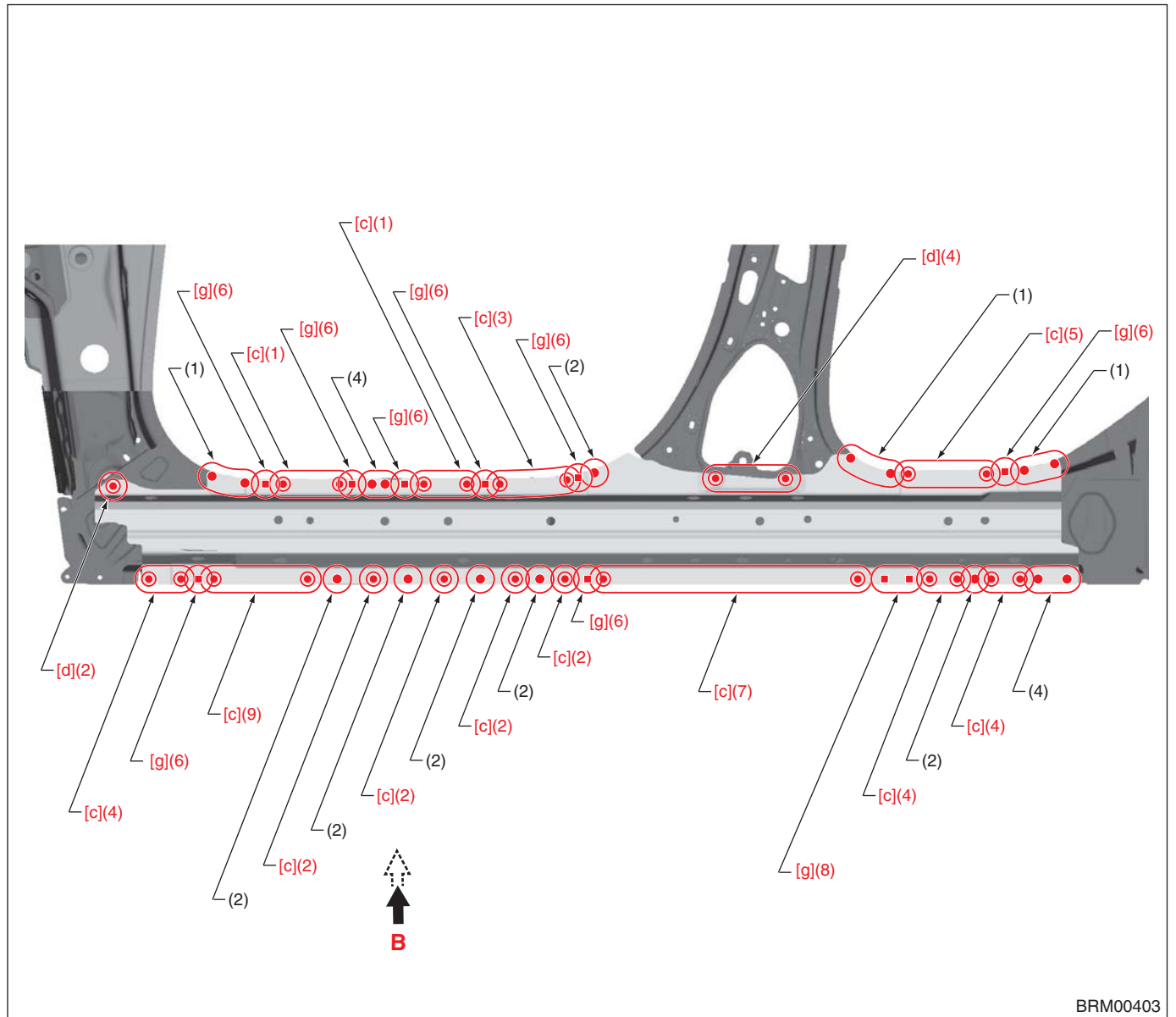
(3) 1 point (service · matching)

(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 %)

BS-09020

- | | |
|------------------|---|
| [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 %) |

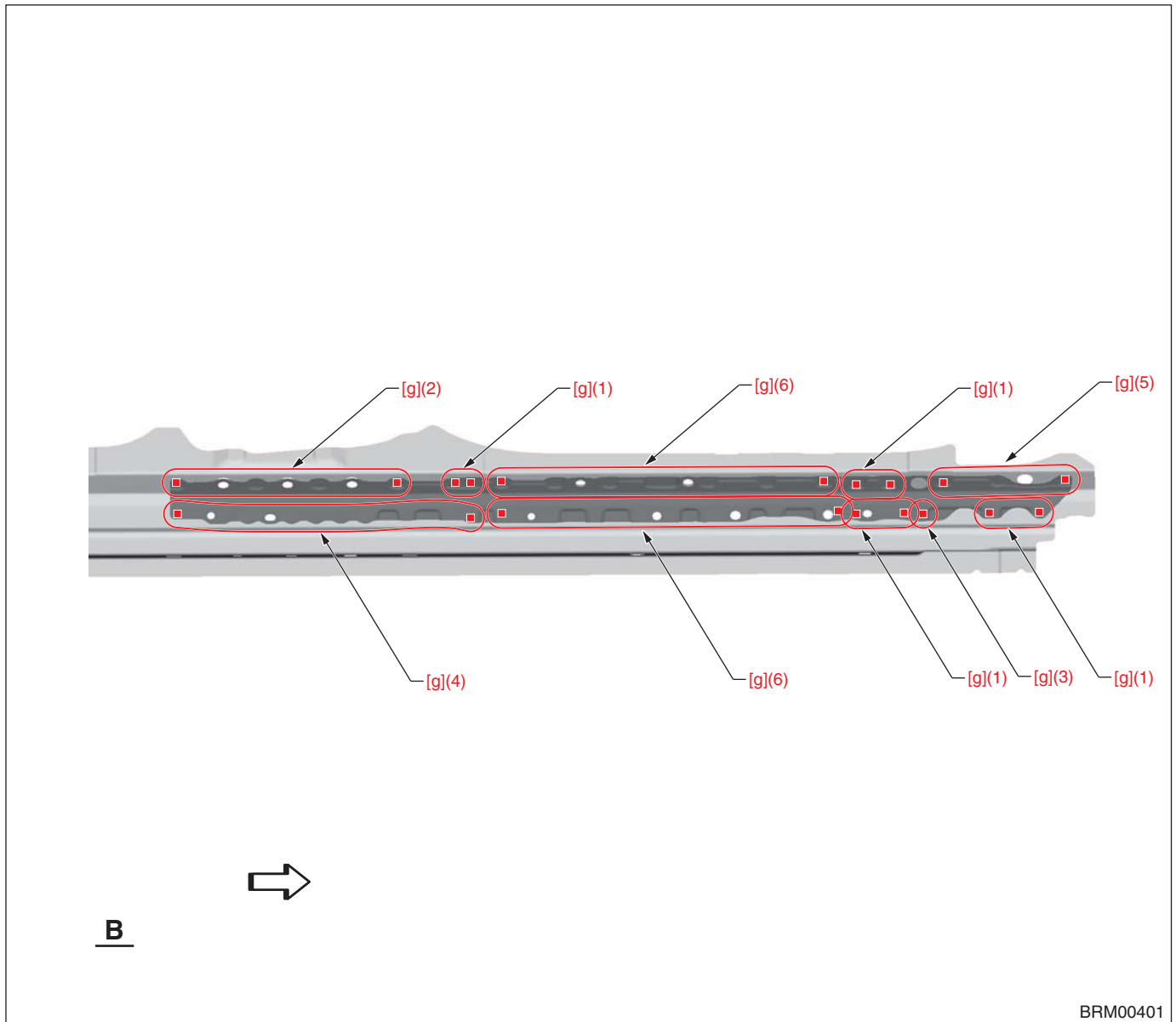


- | | | |
|--------------|-----------------------|------------------------|
| (1) 3 points | (4) 2 points | (7) 11 points |
| (2) 1 point | (5) 5 points | (8) 2 points (service) |
| (3) 7 points | (6) 1 point (service) | (9) 6 points |

[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

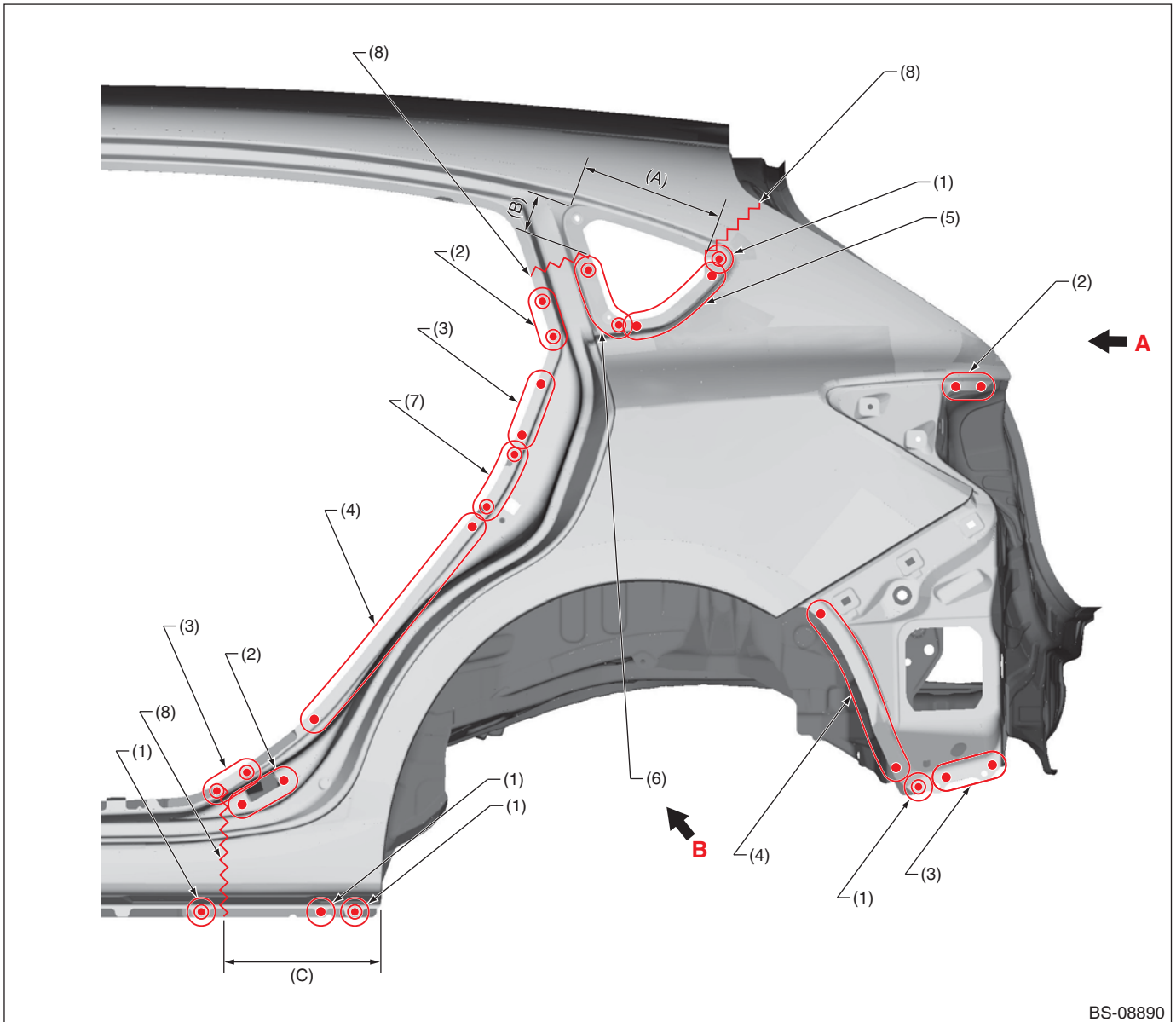
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

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)

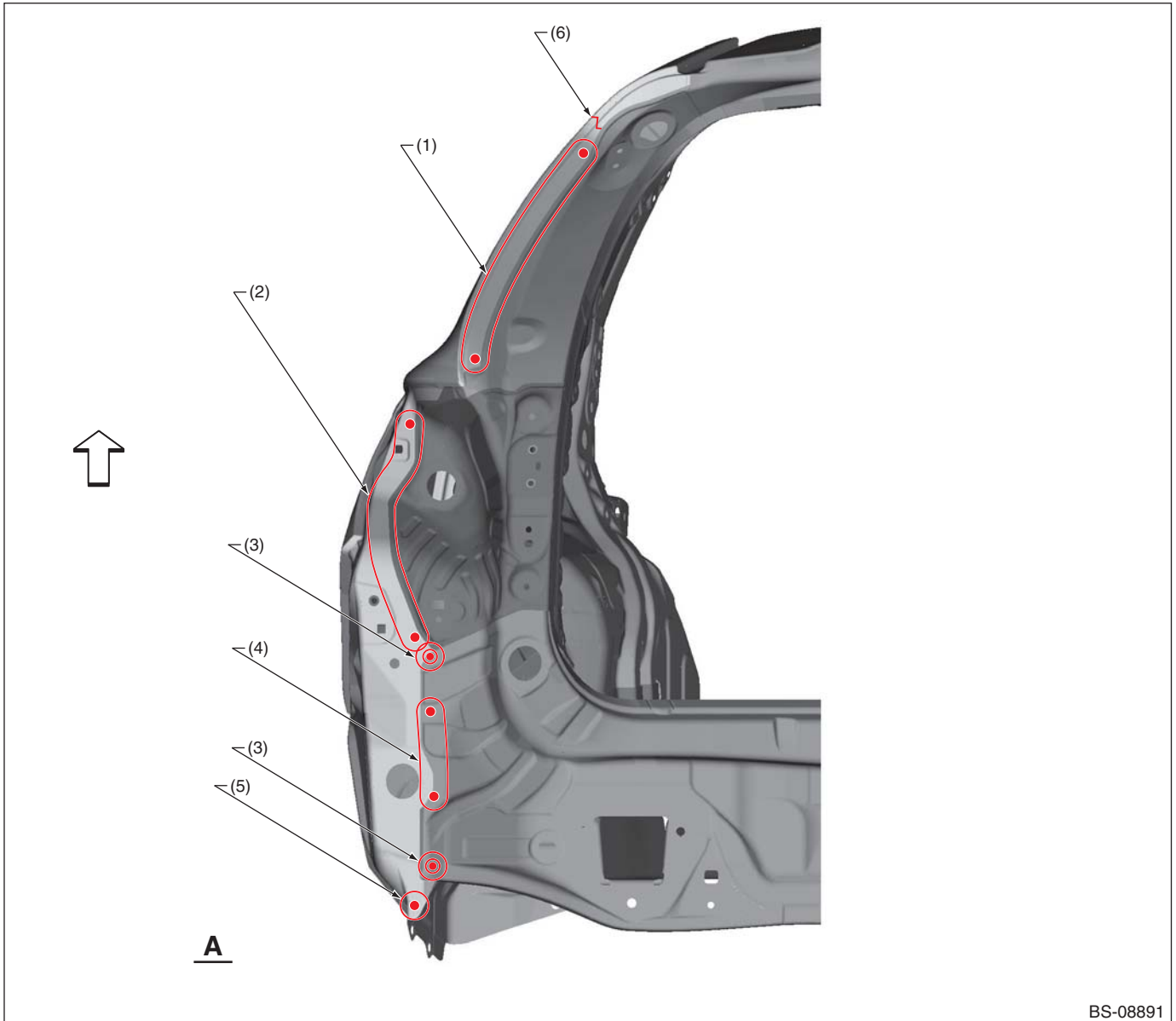
(6) 4 points (outside · 1)

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



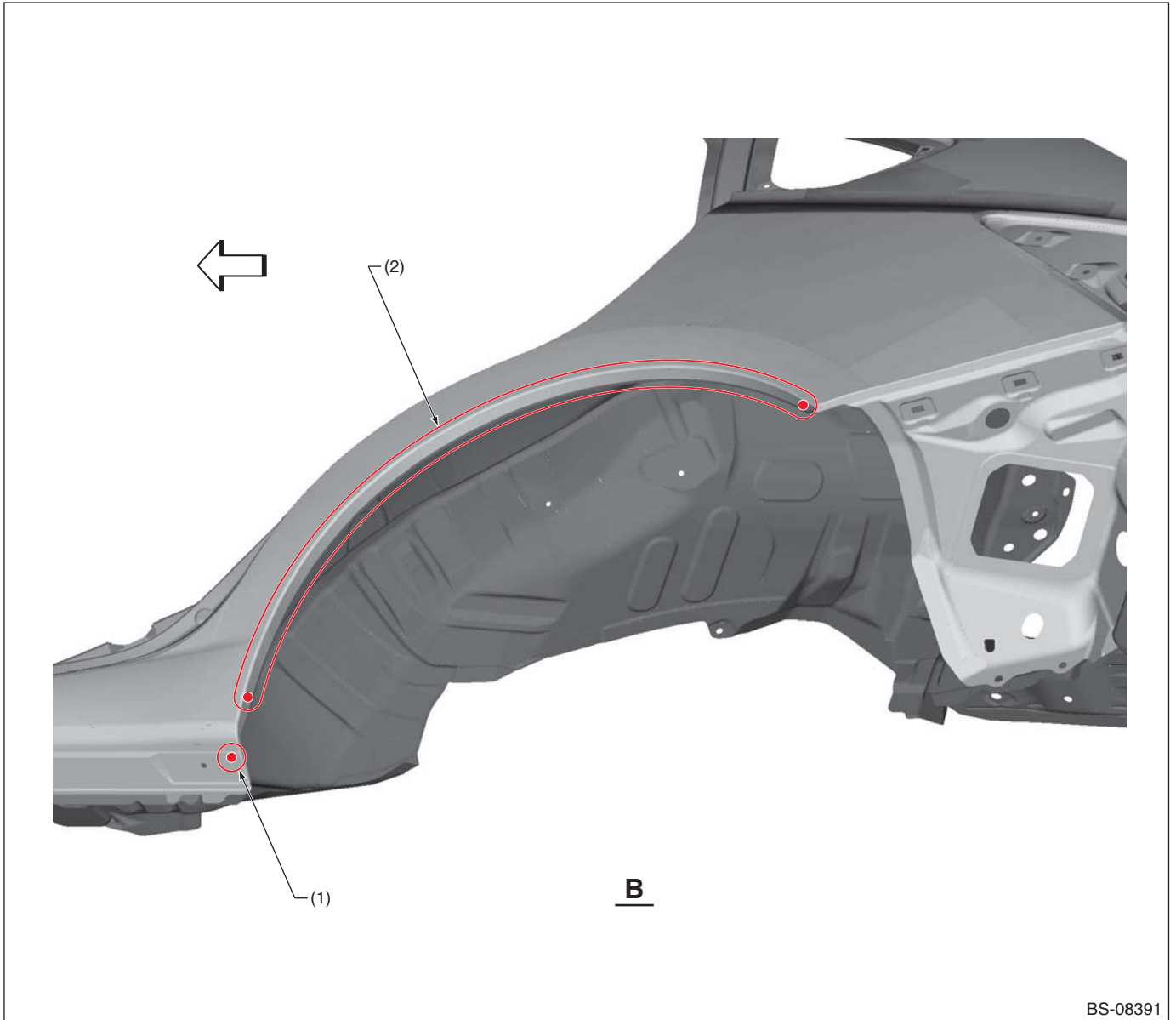
(1) 8 points (outside · 1)
(2) 6 points (outside · 1)

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

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

Panel Replacement

- Views B (Gasoline model)

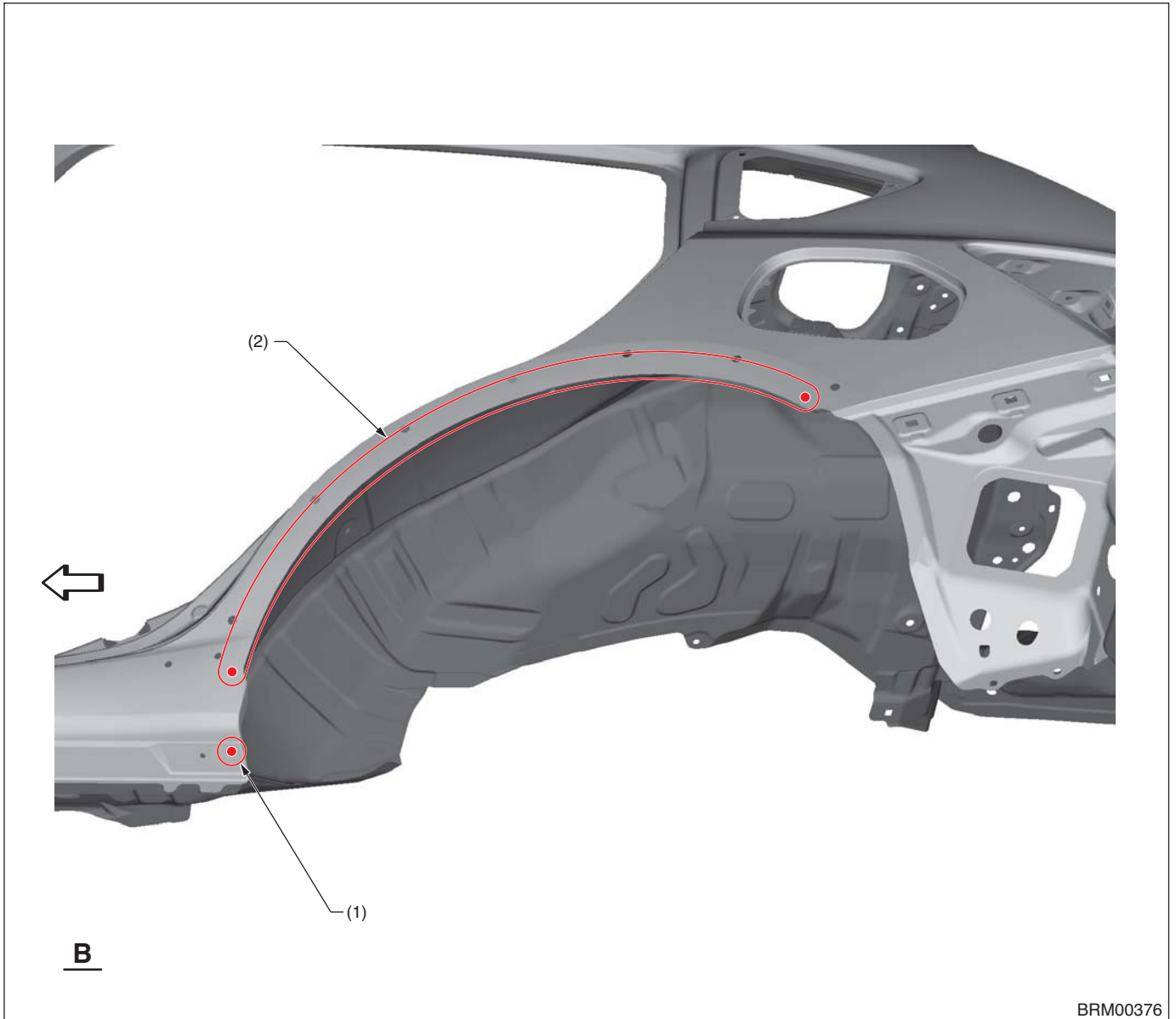


(1) 1 point (bottom · 1)

(2) 14 points (bottom · 1)

Panel Replacement

- Views B (XV / Hybrid model)



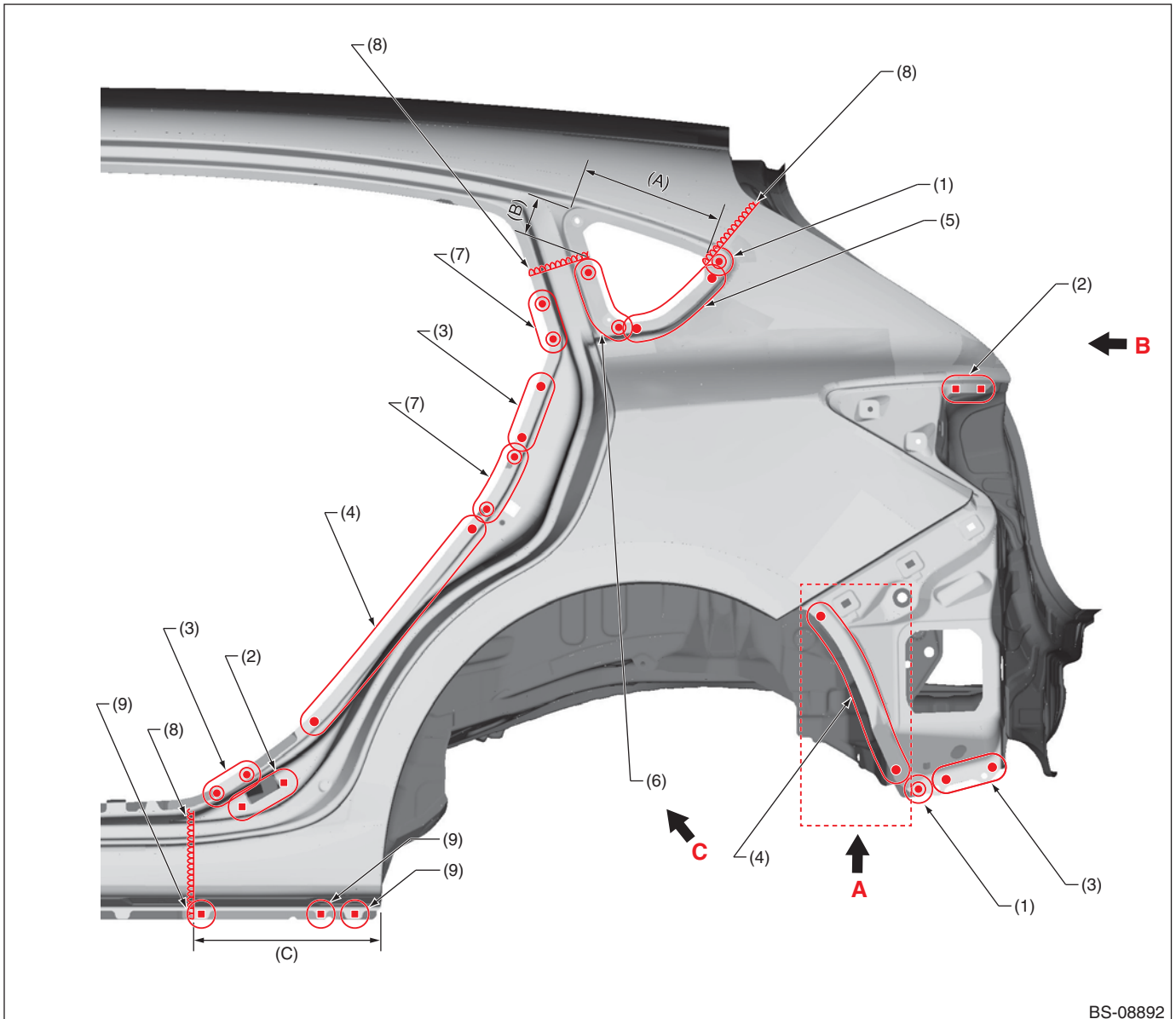
(1) 1 point (bottom · 1)

(2) 12 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-08892

(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

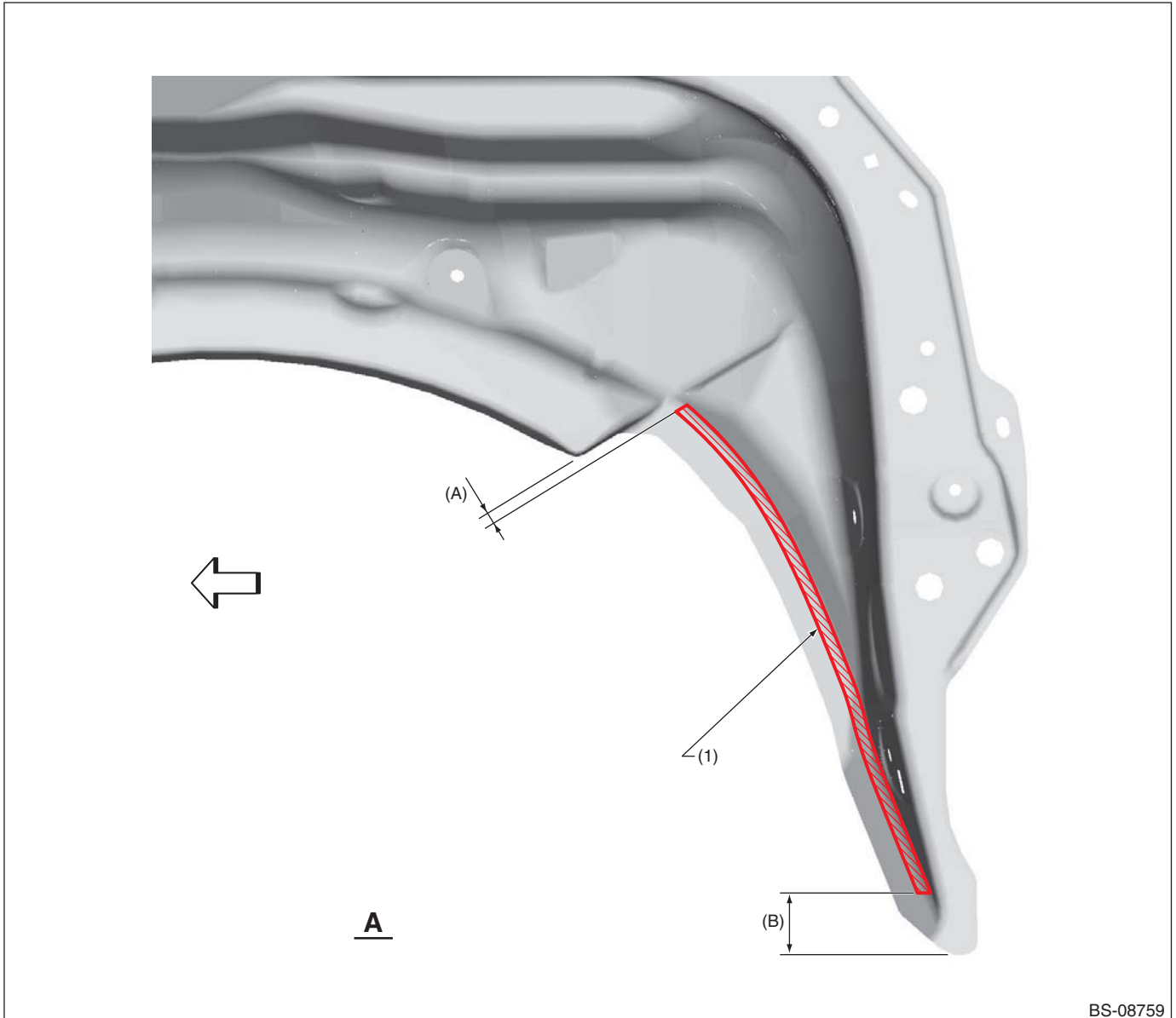
(9) 1 point (service)

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




BS-08759

(A) 5 mm [0.02 in]

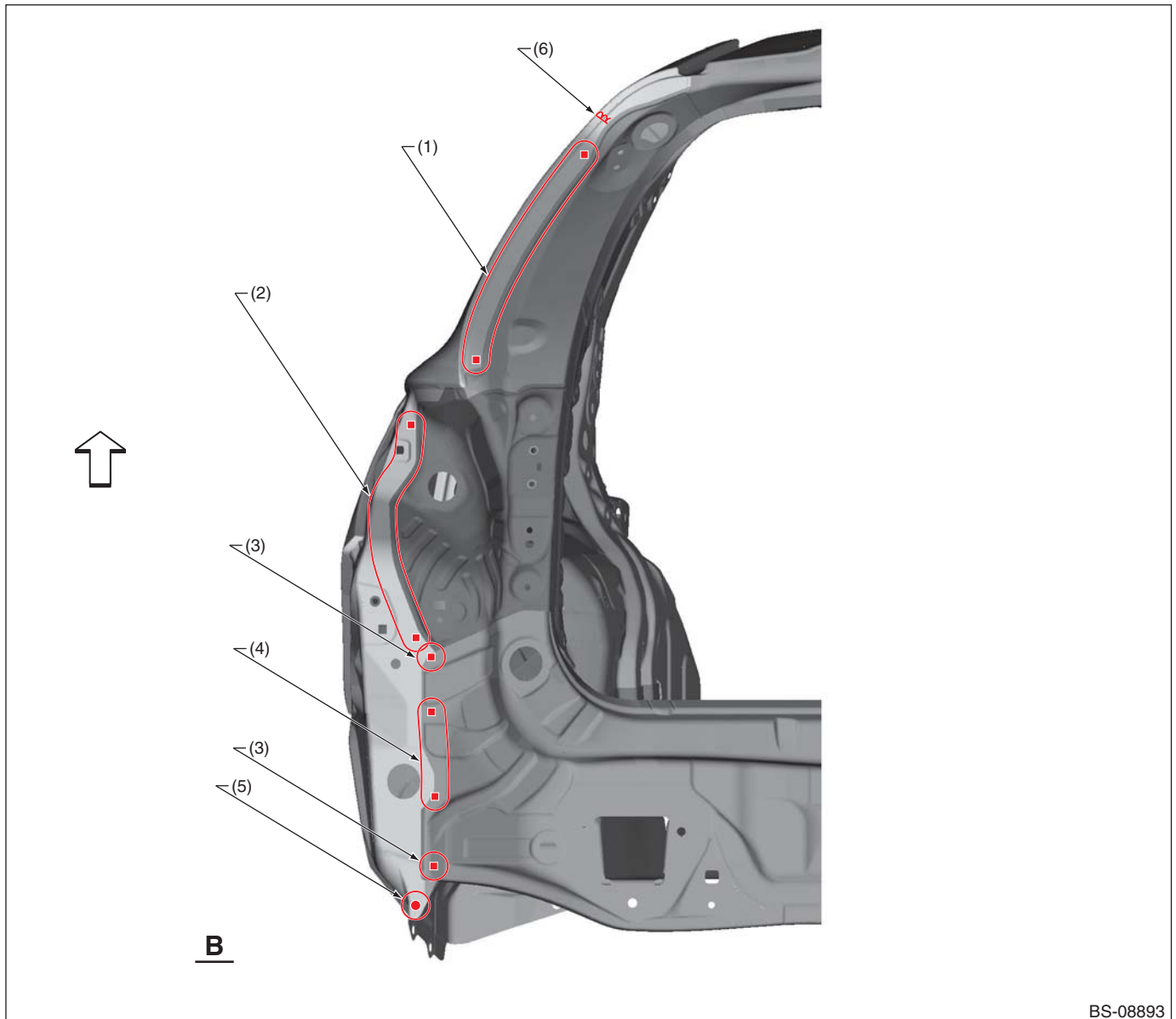
(B) 34 mm [1.34 in]

(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



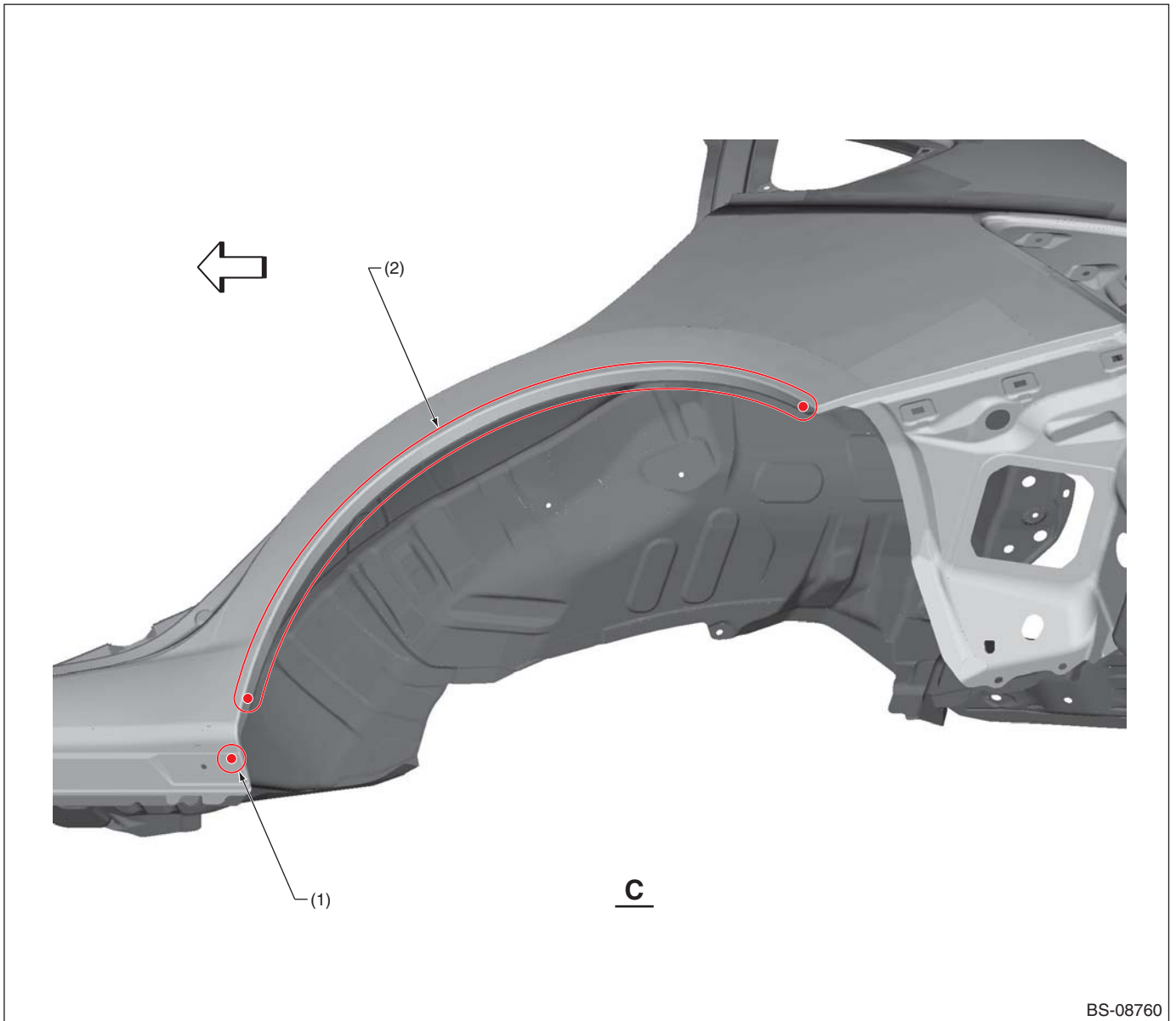
(1) 8 points (service)
(2) 6 points (service)

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

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

Panel Replacement

- Views C (Gasoline model)

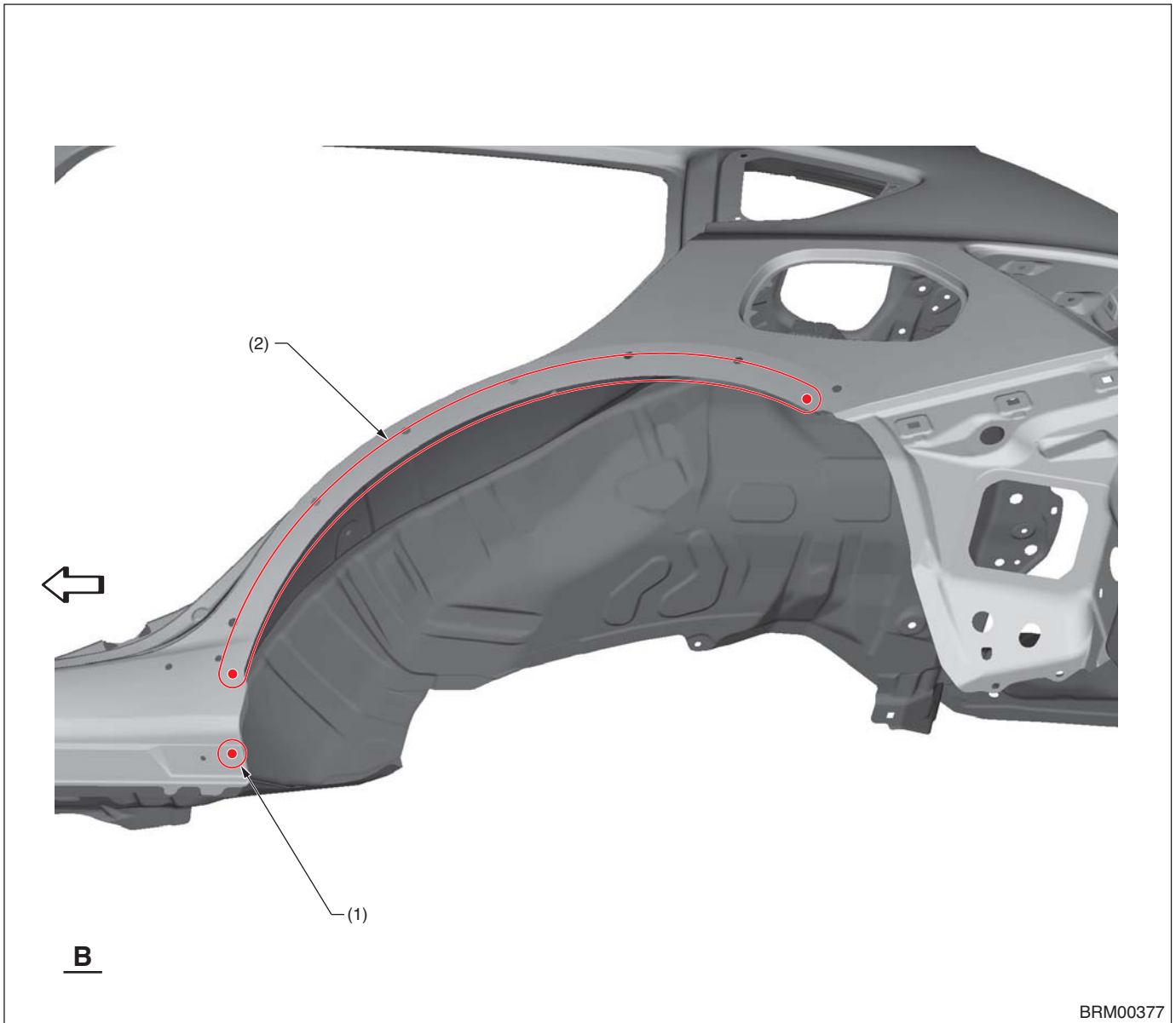


(1) 1 point

(2) 14 points

Panel Replacement

- Views C (XV / Hybrid model)



(1) 1 point

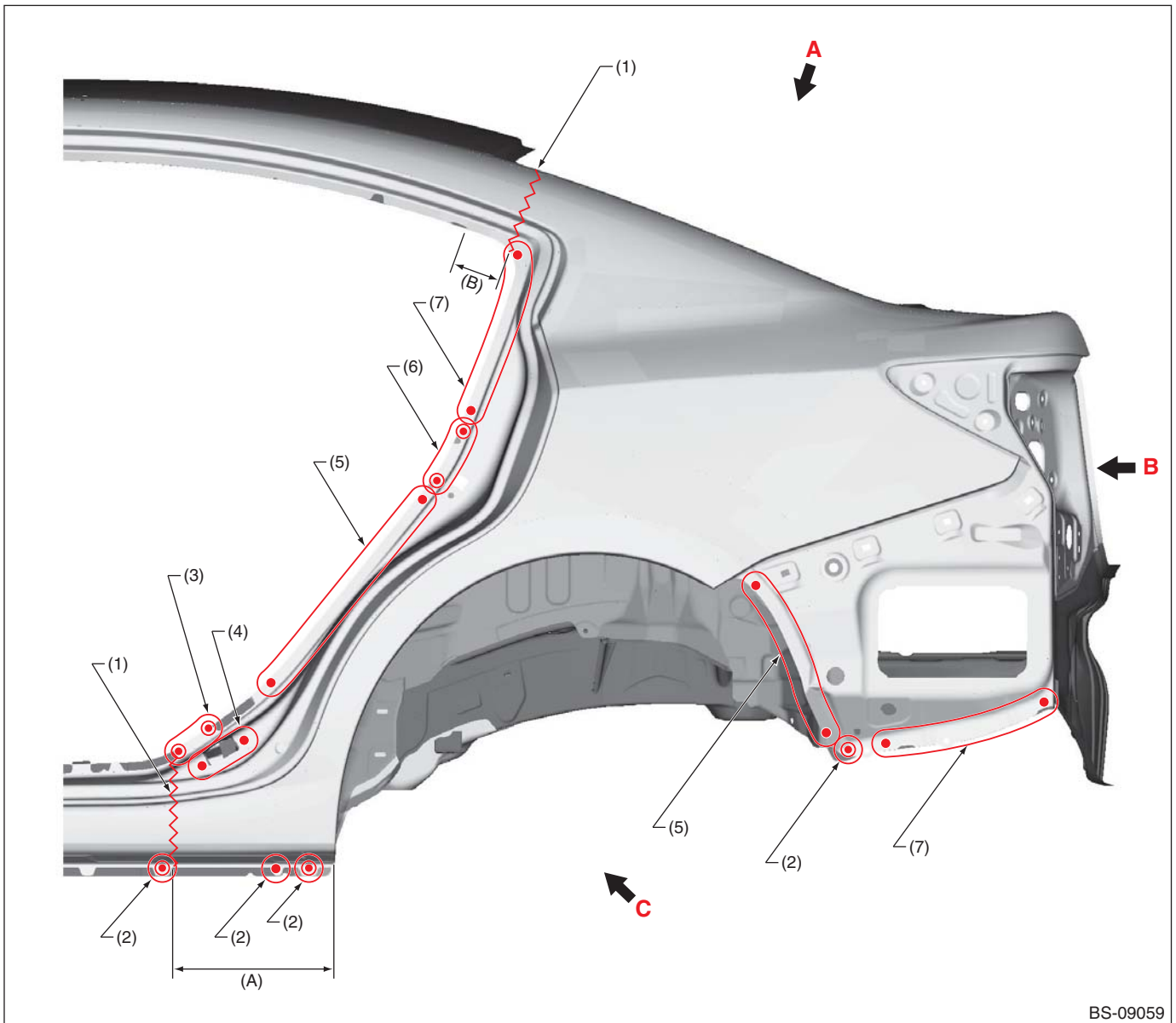
(2) 12 points

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)

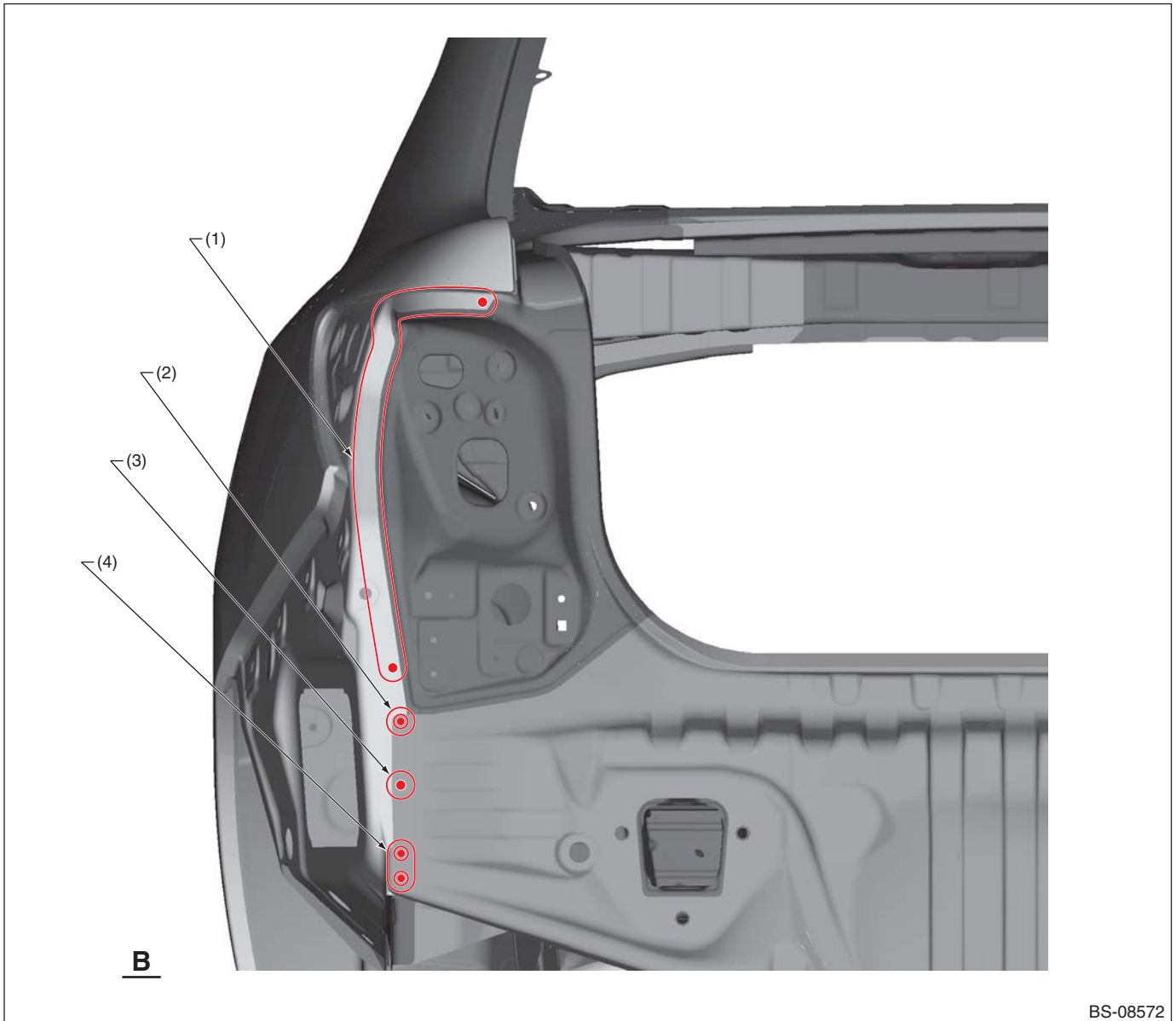
(2) 1 point (outside · 1)

(3) 8 points (outside · 1)

(4) Cut position

Panel Replacement

• Views B



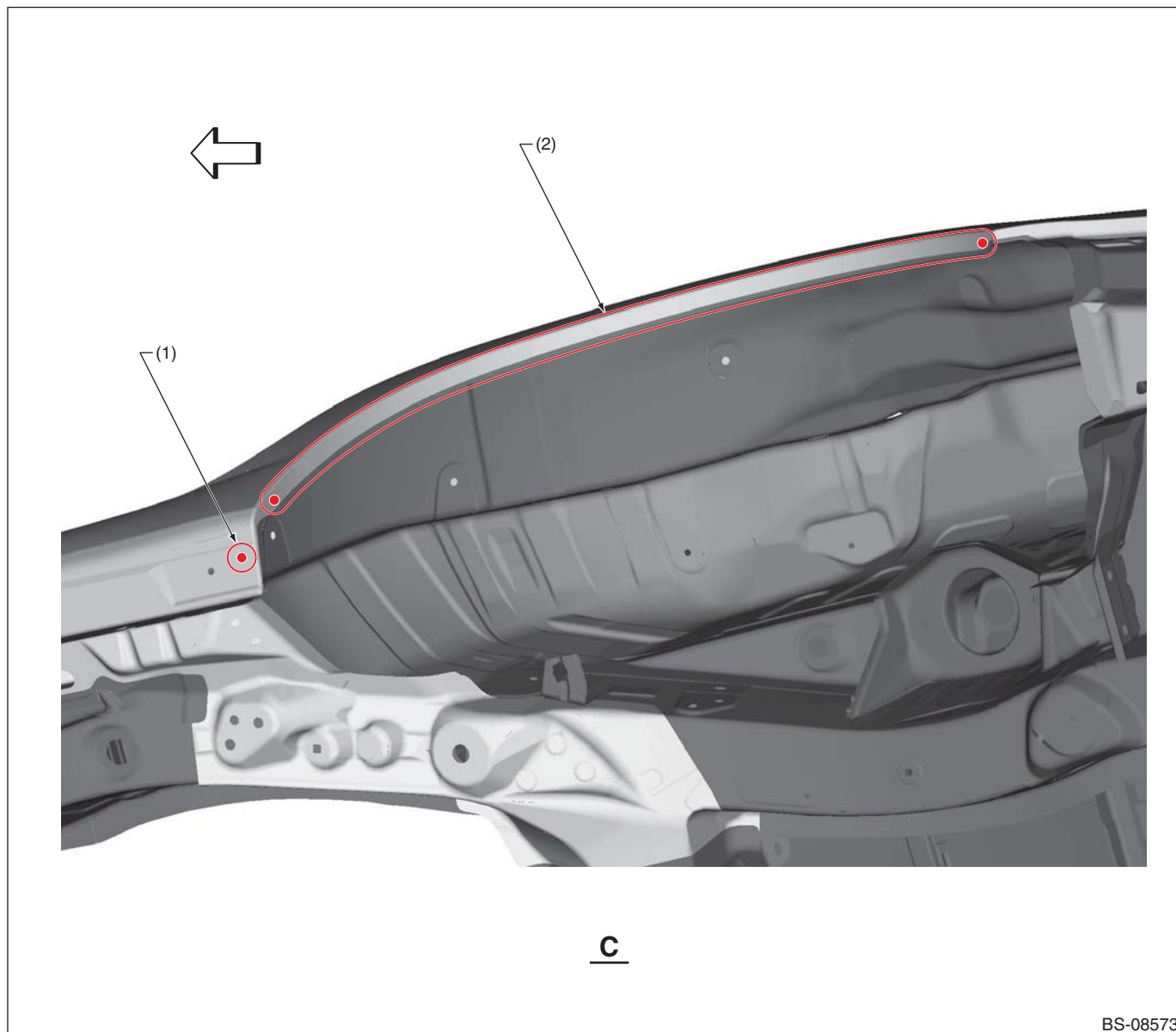
(1) 11 points (outside · 1)
(2) 1 point (outside · 2)

(3) 1 point (outside · 1)

(4) 2 points (outside · 2)

Panel Replacement

• Views C



BS-08573

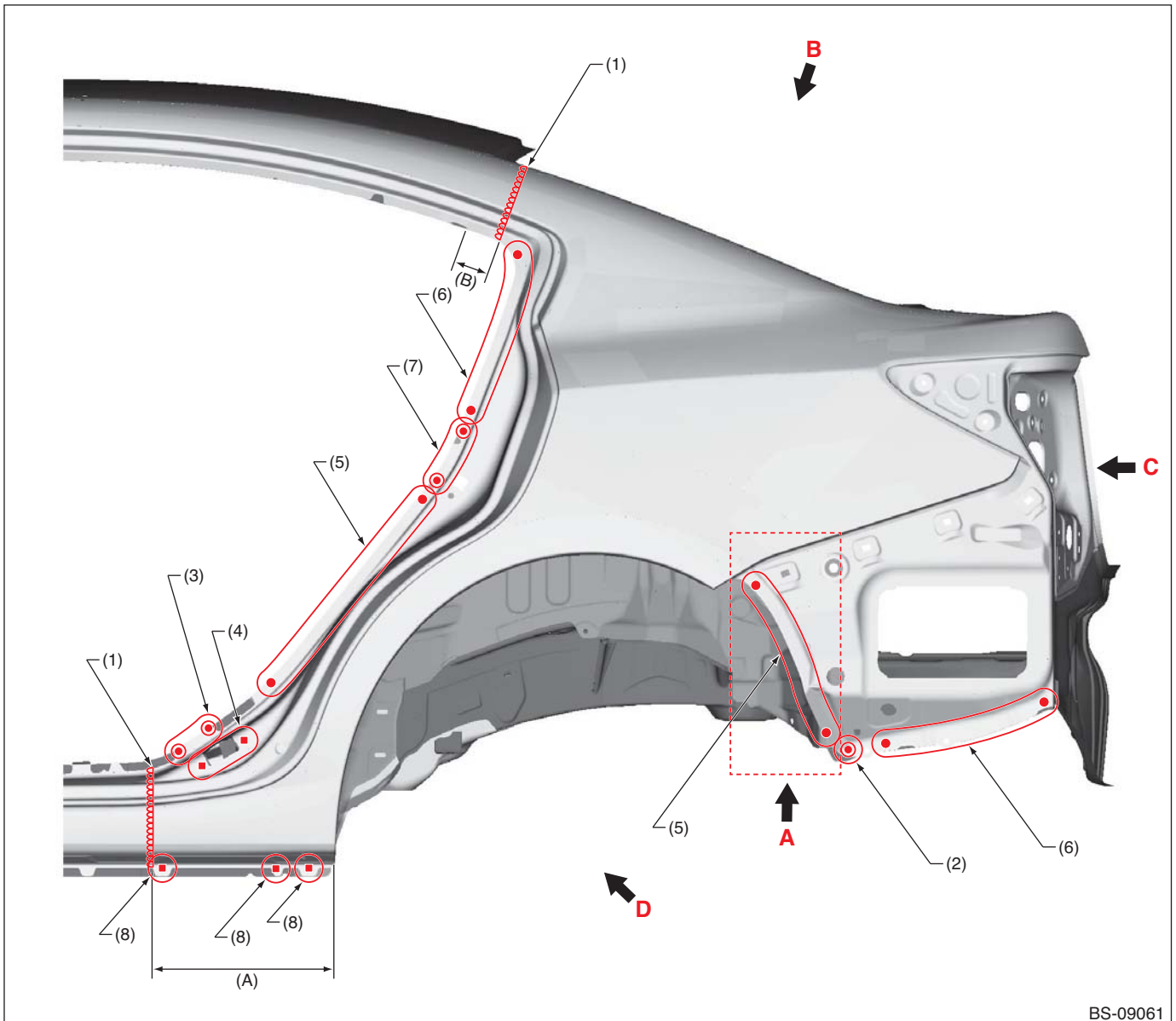
(1) 1 point (bottom · 1)

(2) 14 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(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

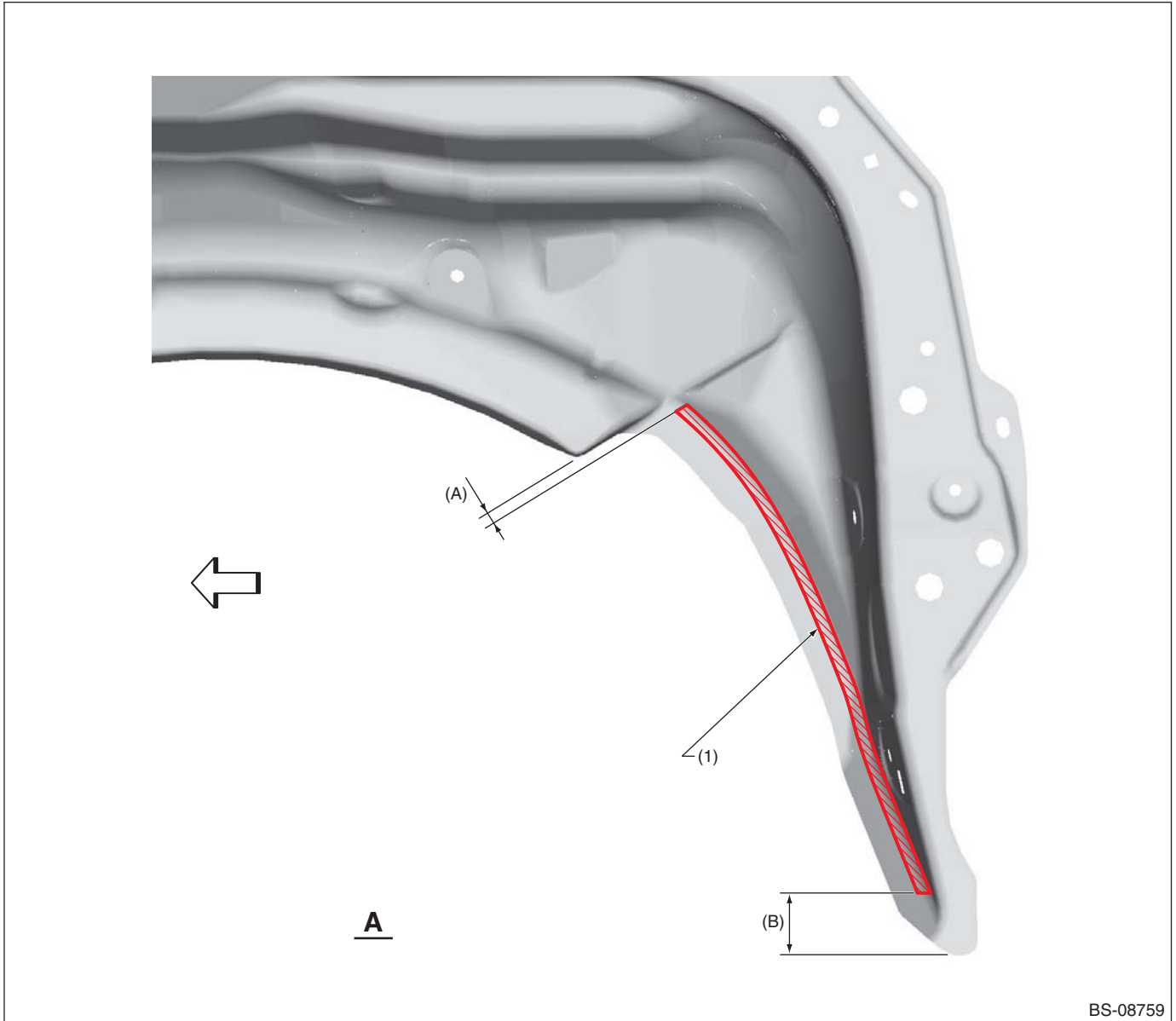
(8) 1 point (service)

(3) 3 points

(6) 6 points

Panel Replacement

• Views A




BS-08759

(A) 5 mm [0.02 in]

(B) 34 mm [1.34 in]

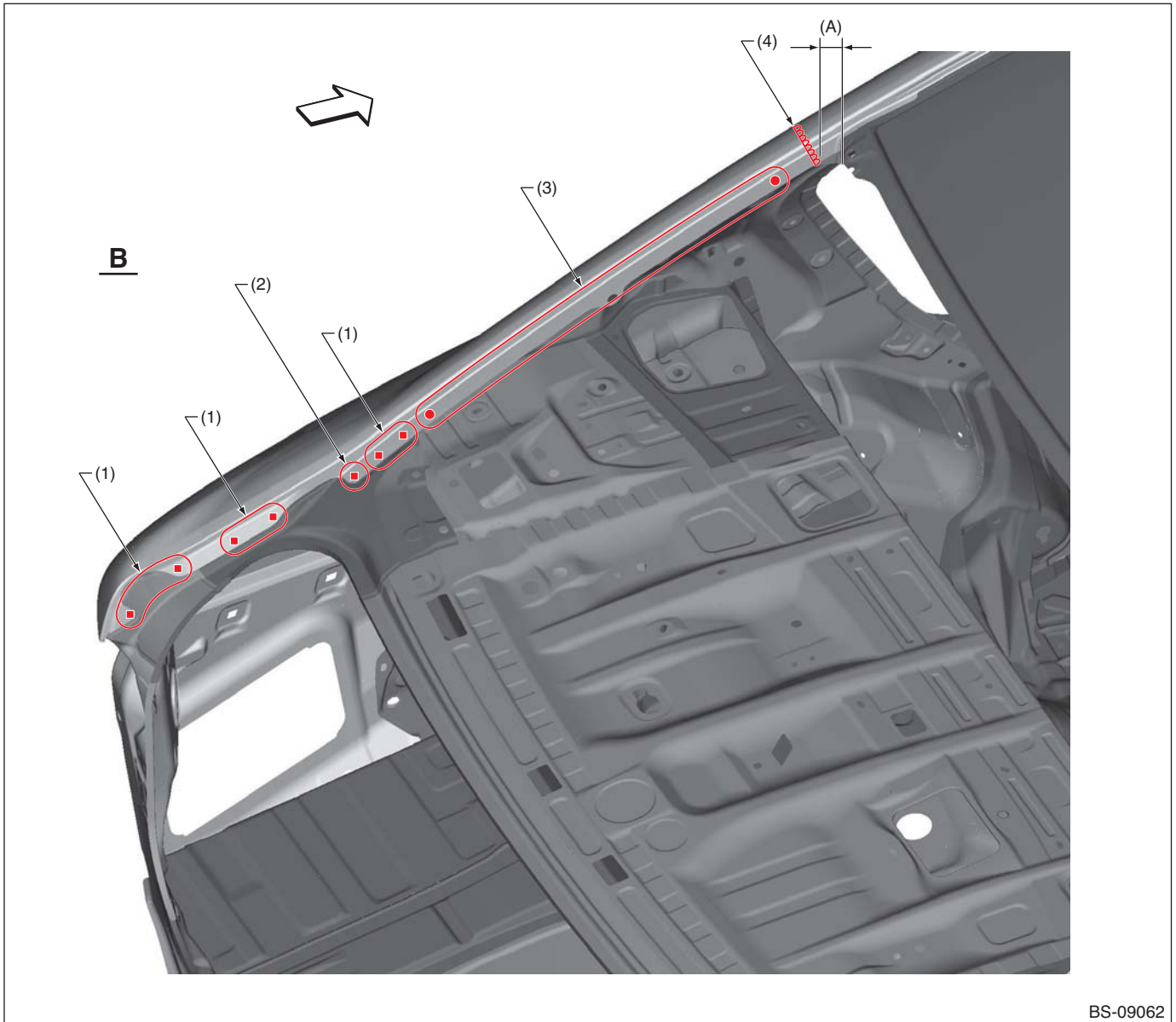
(1) Spotting sealer

 : 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



(A) 25 mm [0.98 in]

(1) 2 points (service)

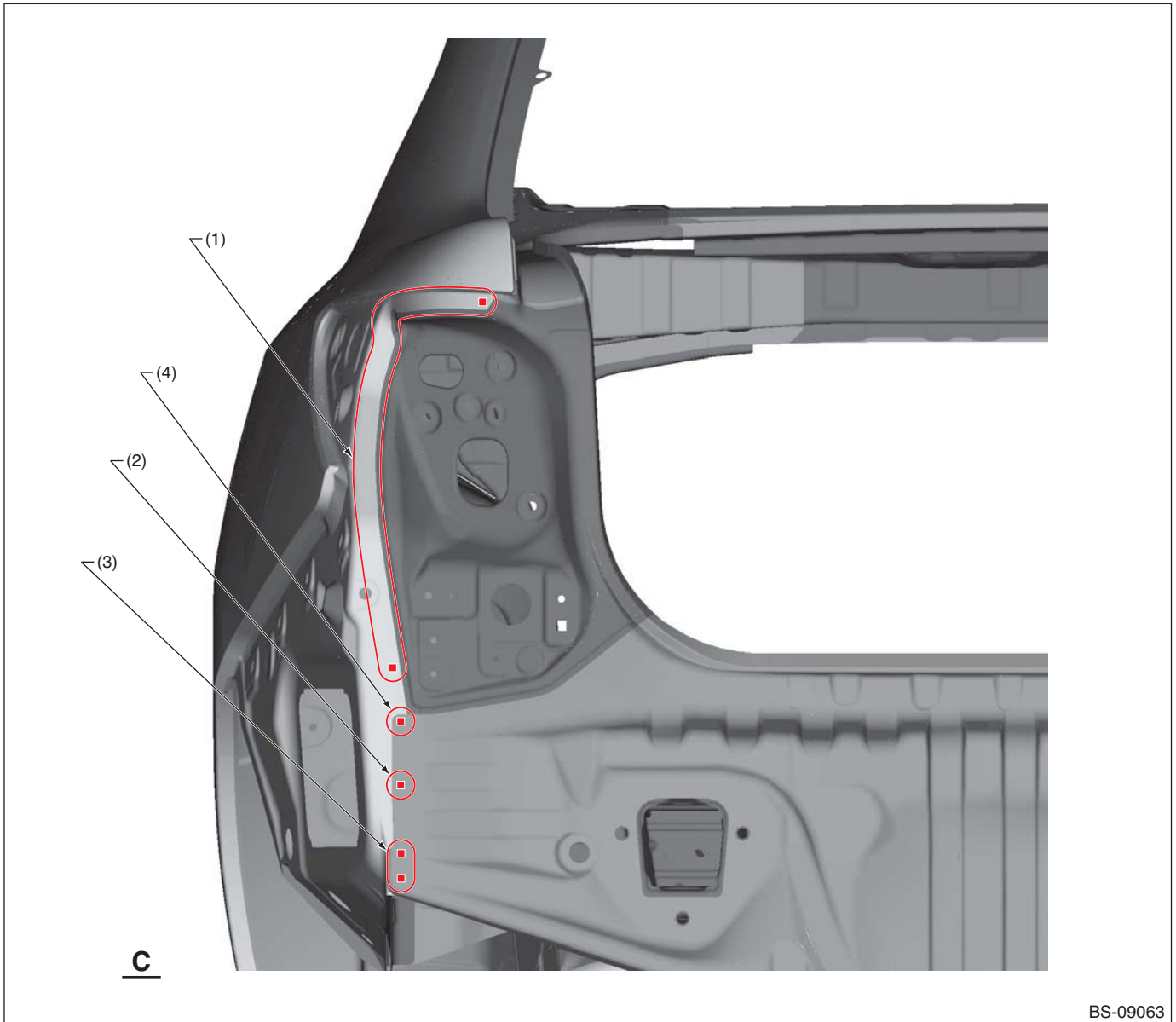
(2) 1 point (service)

(3) 8 points

(4) 1 point (Continuous welding)

Panel Replacement

• Views C



(1) 11 points (service)

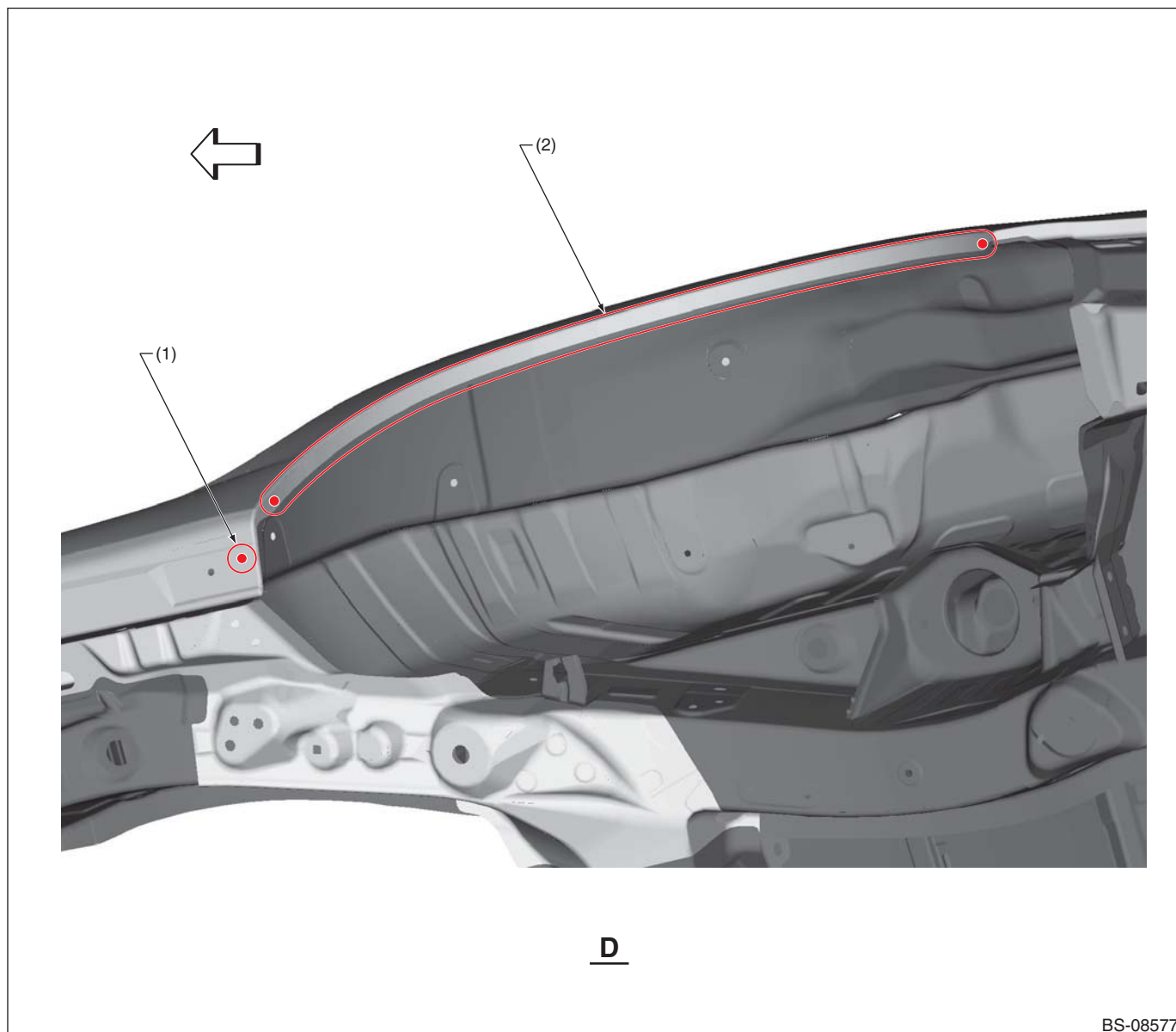
(2) 1 point

(3) 2 points (service · matching)

(4) 1 point (service · matching)

Panel Replacement

• Views D



(1) 1 point

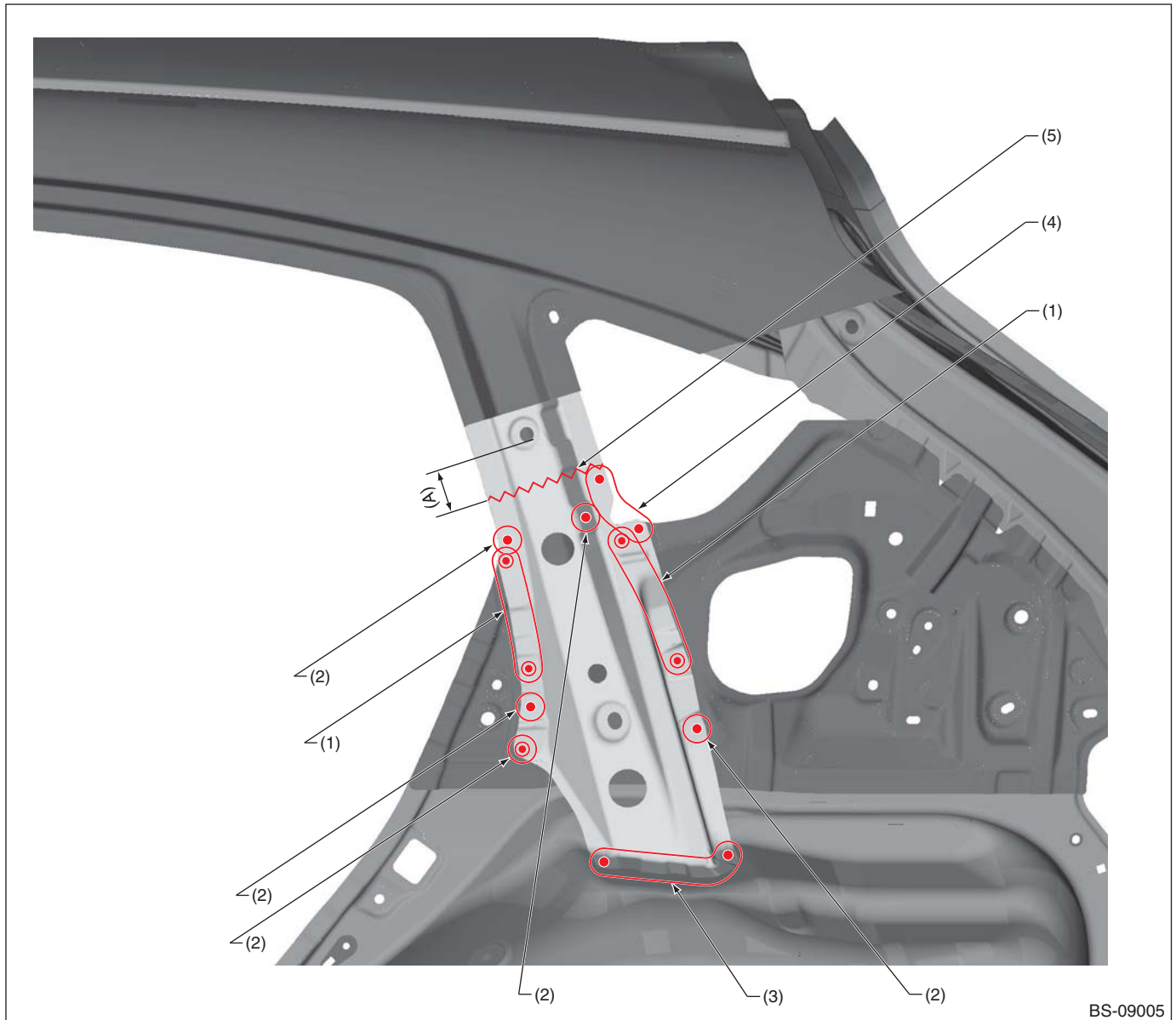
(2) 14 points

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)

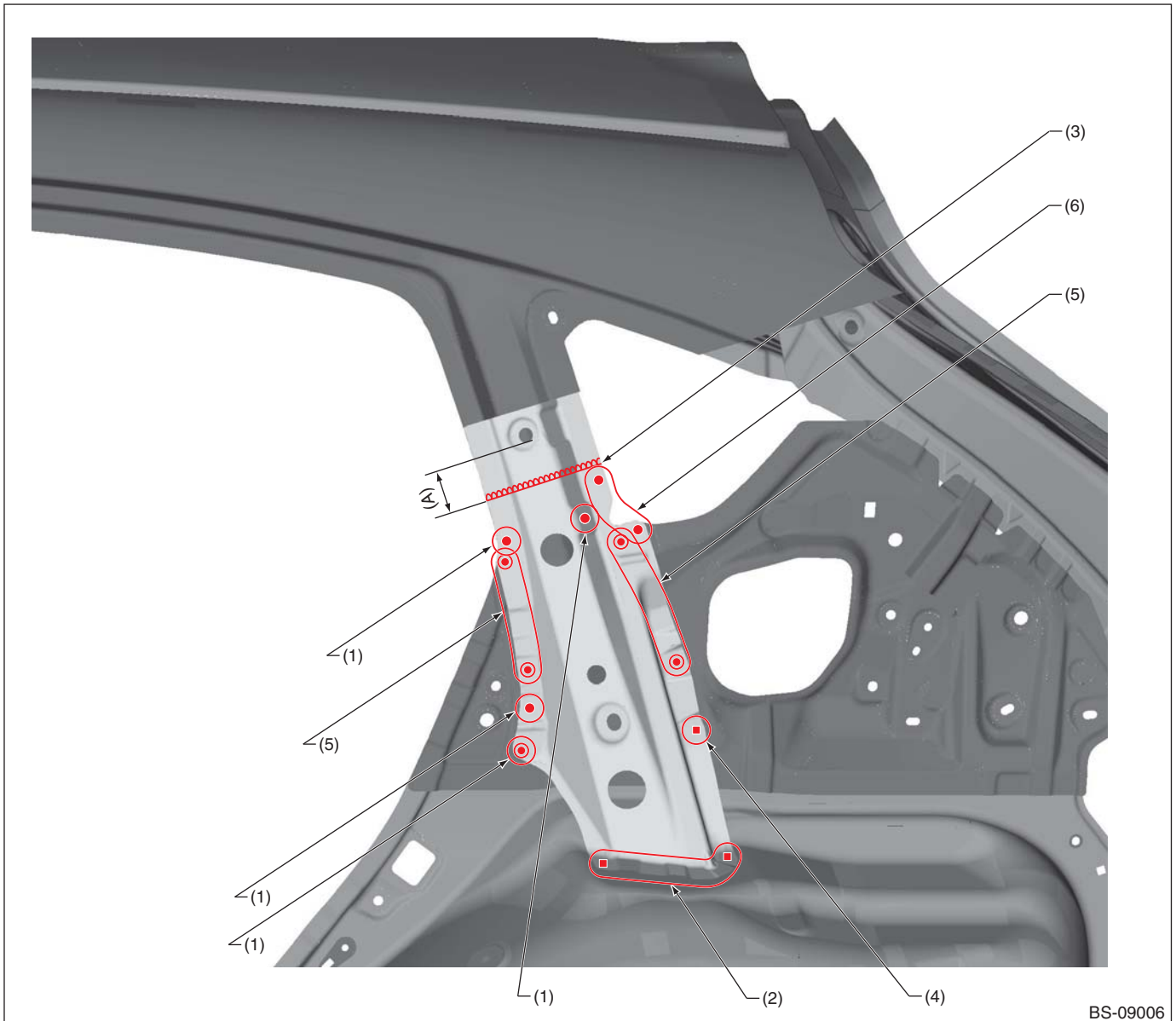
(4) 2 points (outside · 1)

(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

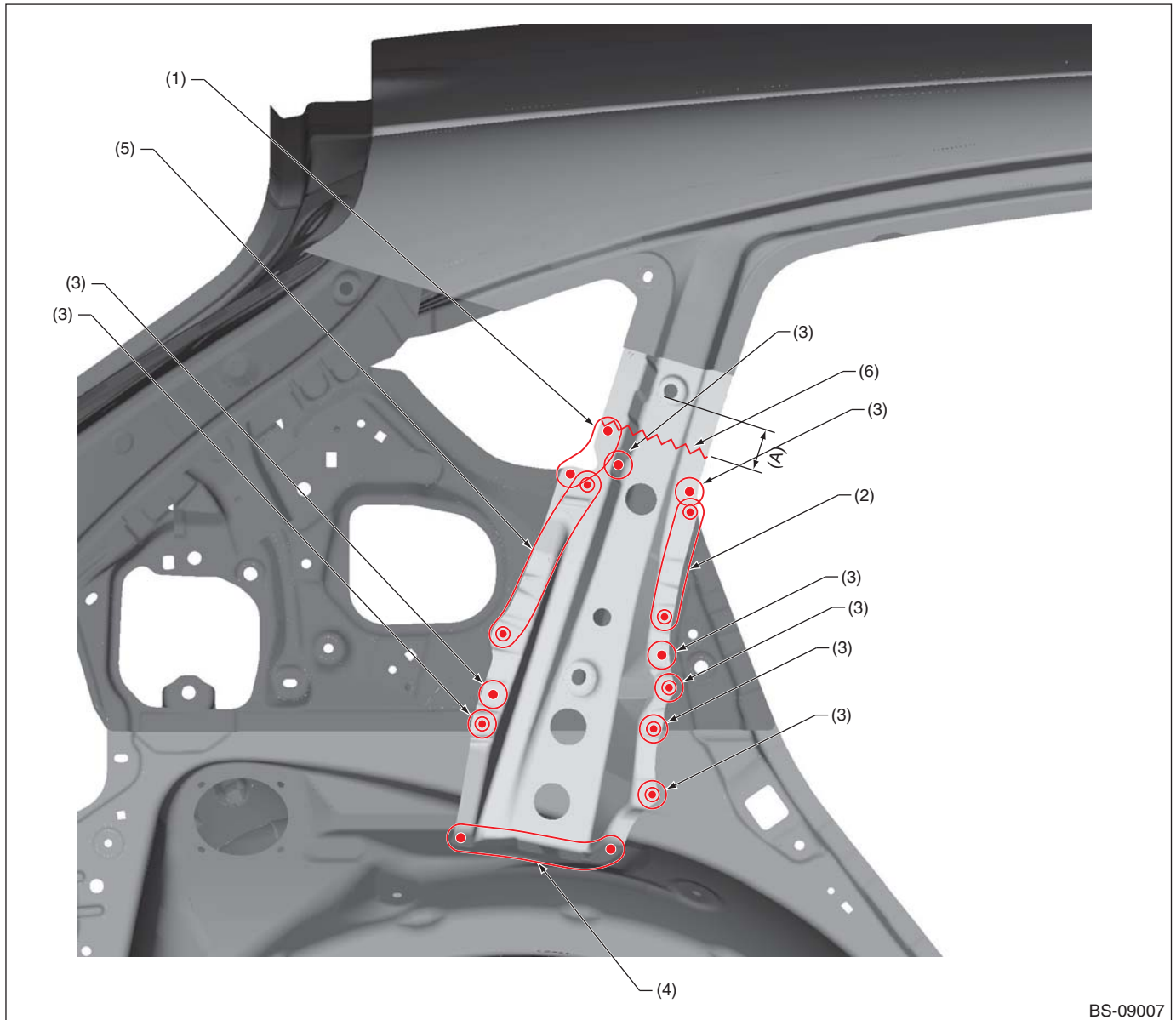
(6) 2 points

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)

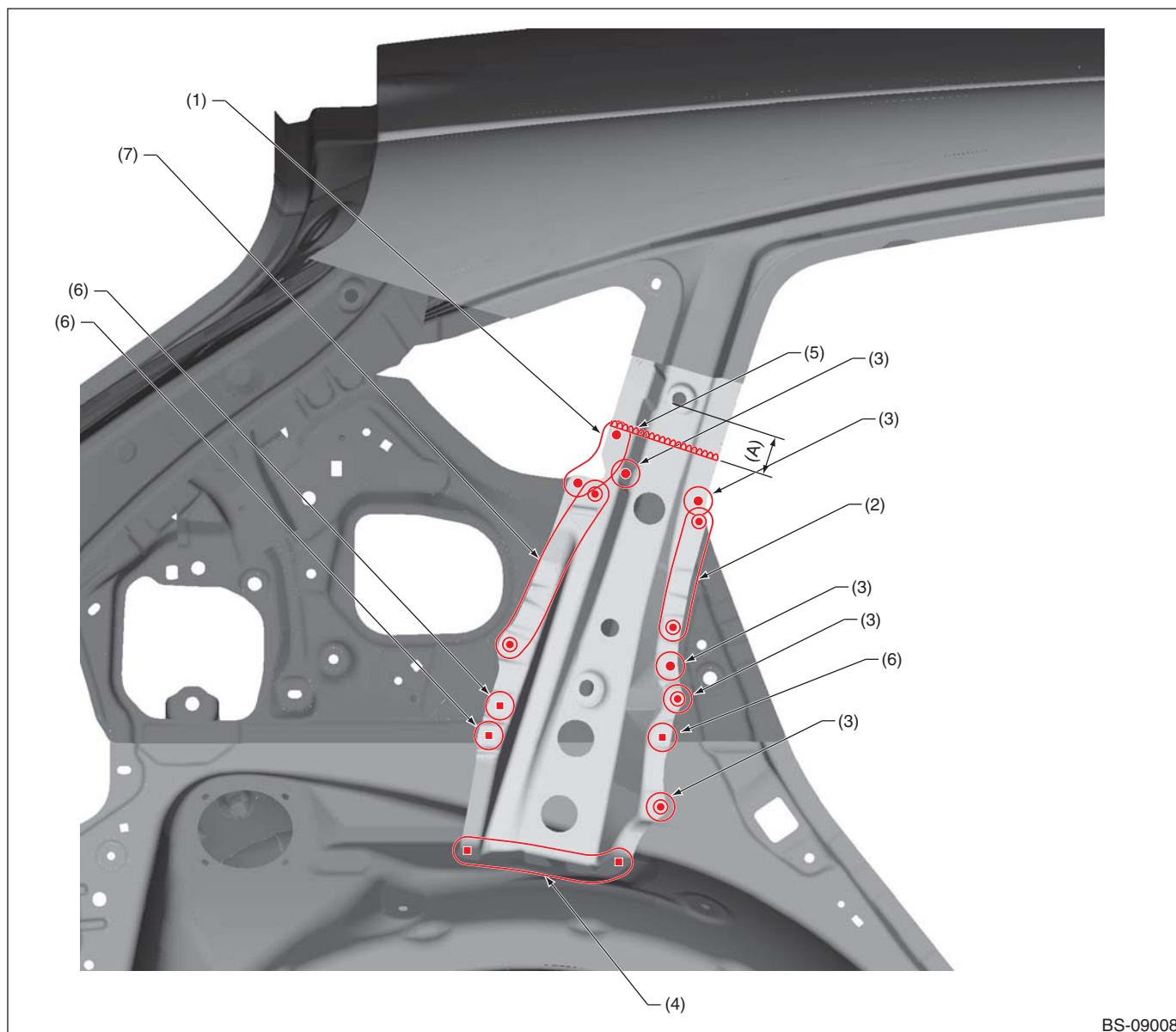
(5) 4 points (outside · 1)

(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)

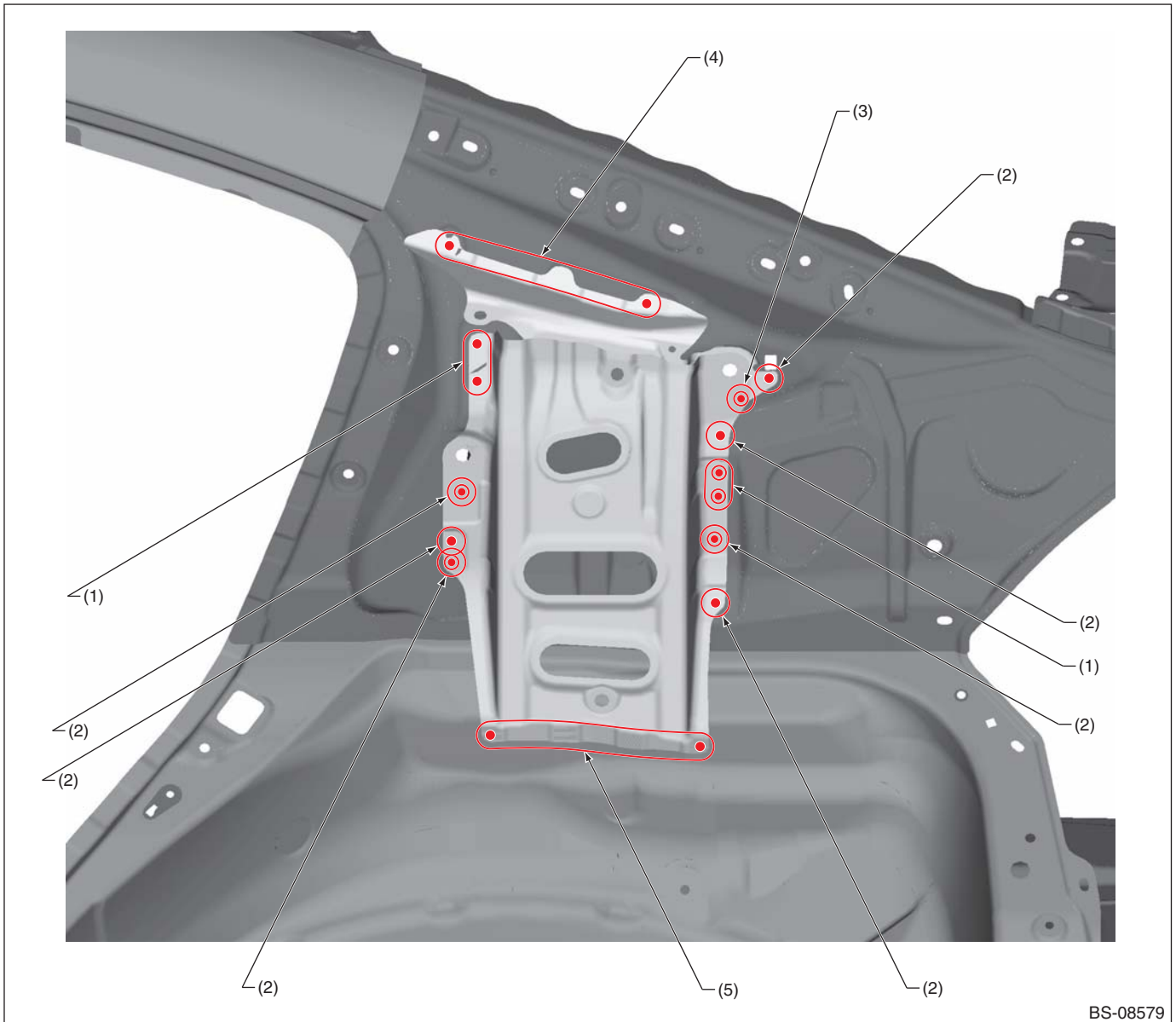
(7) 4 points

Panel Replacement

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

A: REMOVAL

• Overall view



(1) 2 points (outside · 1)

(2) 1 point (outside · 1)

(3) 1 point (outside · 2)

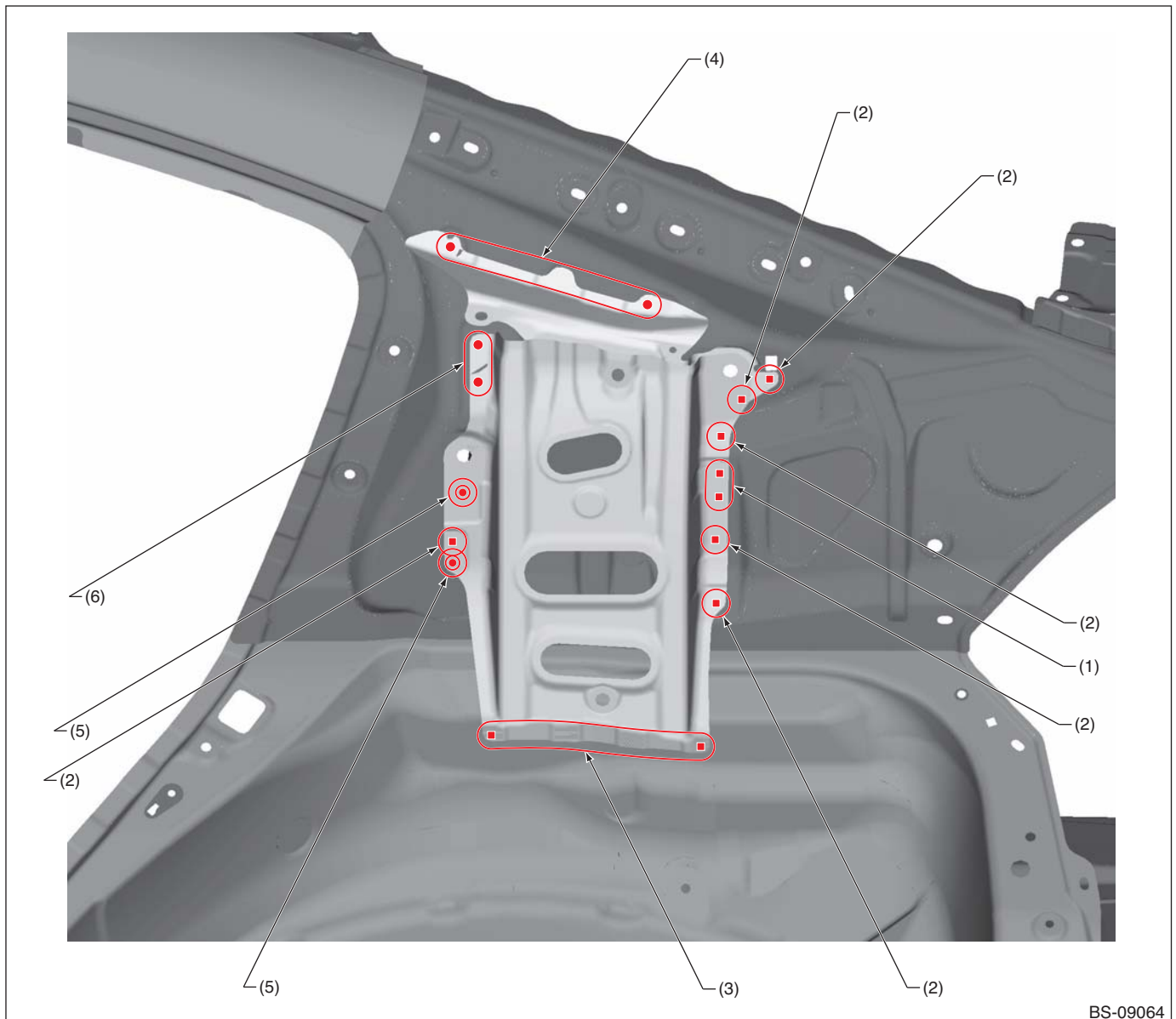
(4) 3 points (outside · 1)

(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

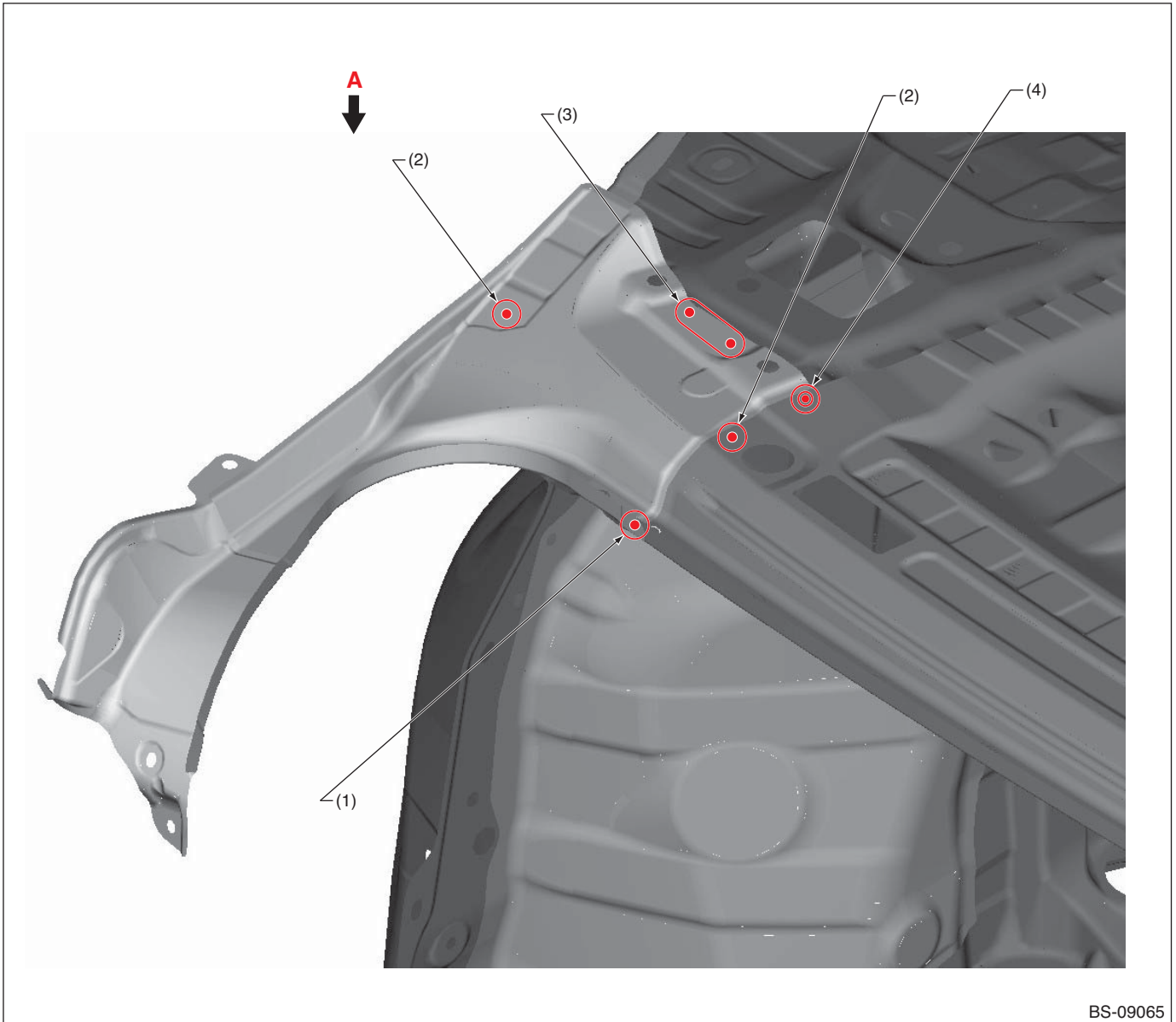
(5) 1 point
(6) 2 points

Panel Replacement

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

A: REMOVAL

• Overall view



(1) 1 point (outside · 1)

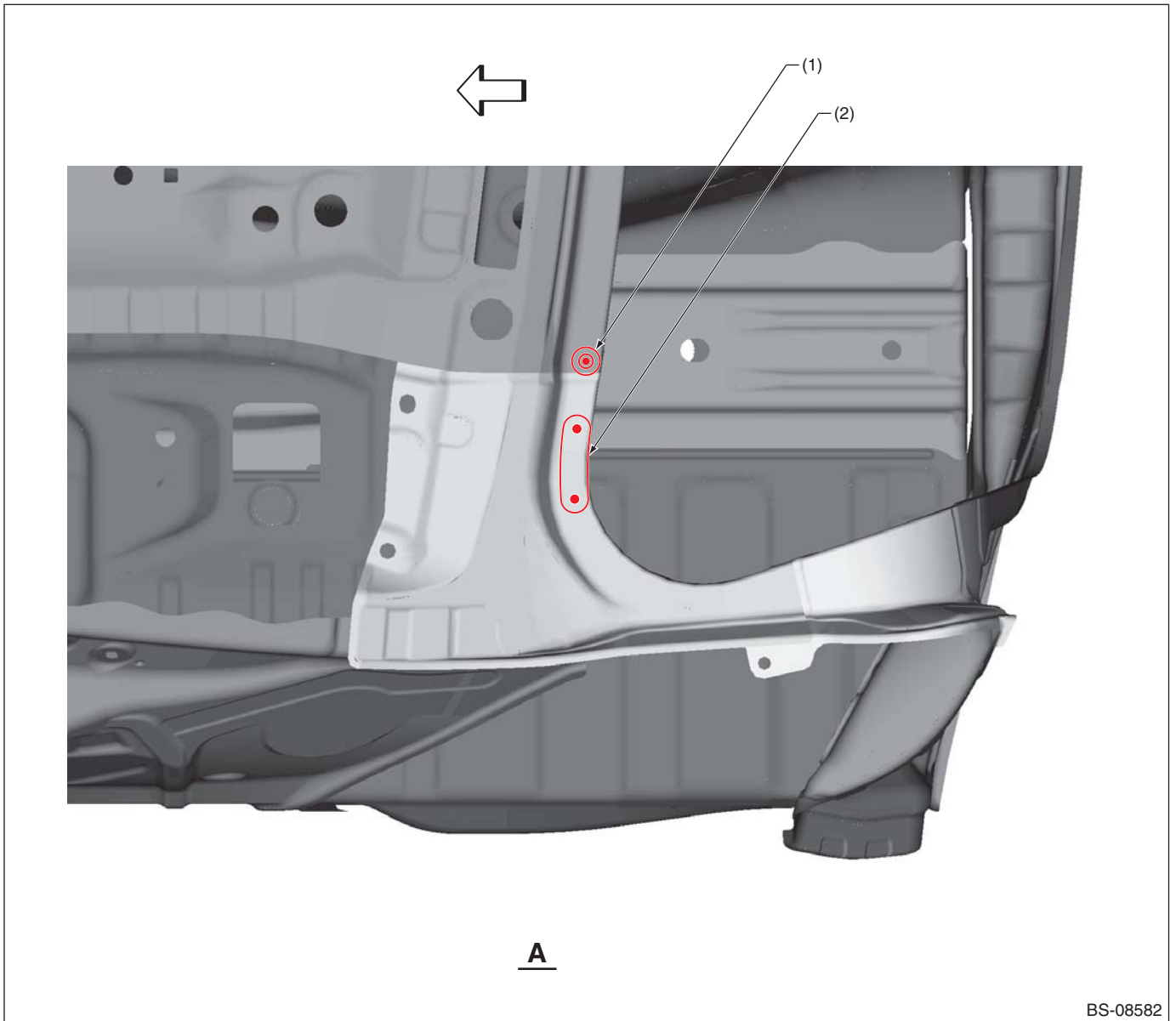
(2) 1 point (top · 1)

(3) 2 points (top · 1)

(4) 1 point (top · 2)

Panel Replacement

• Views A



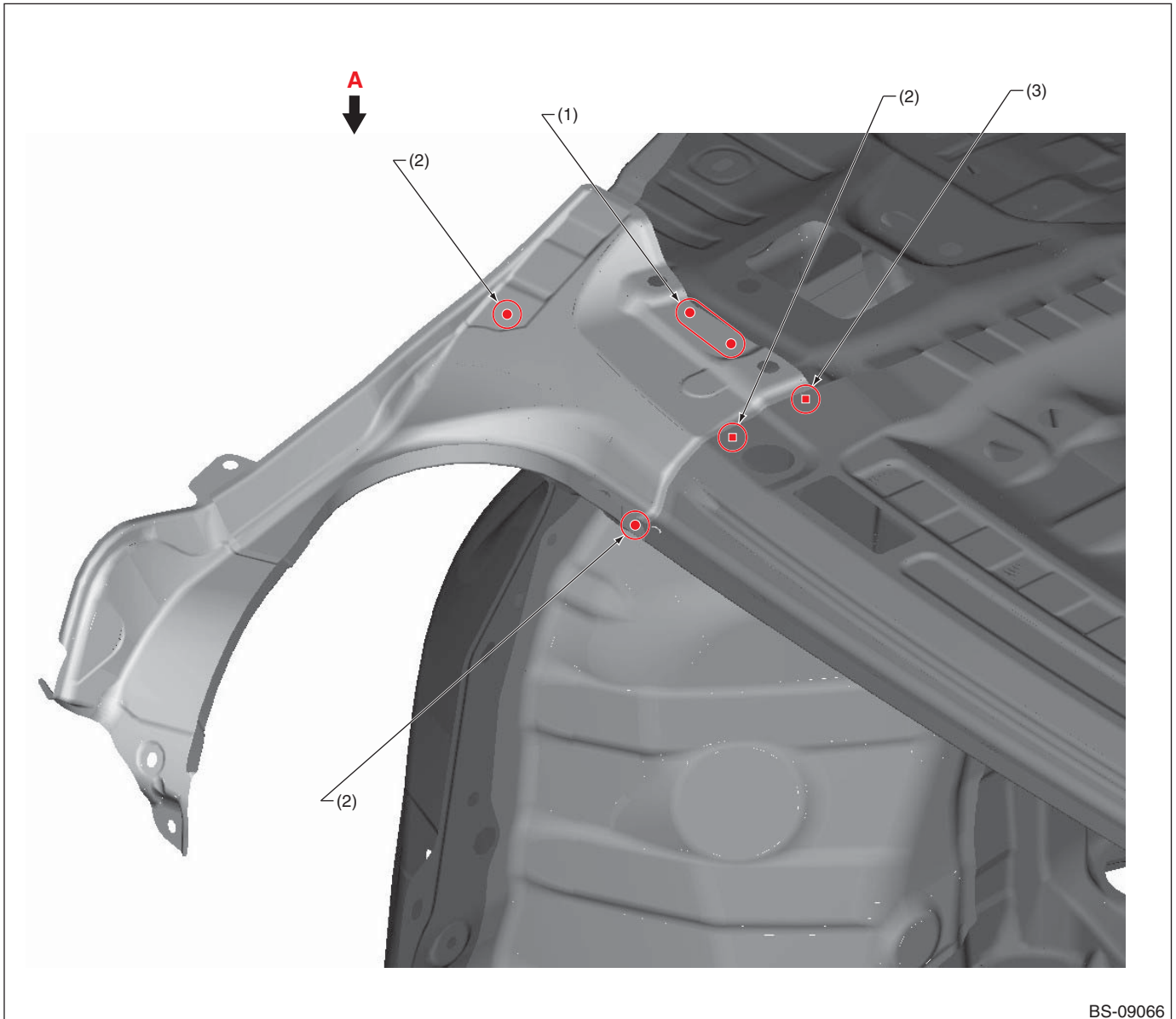
(1) 1 point (top · 2)

(2) 2 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



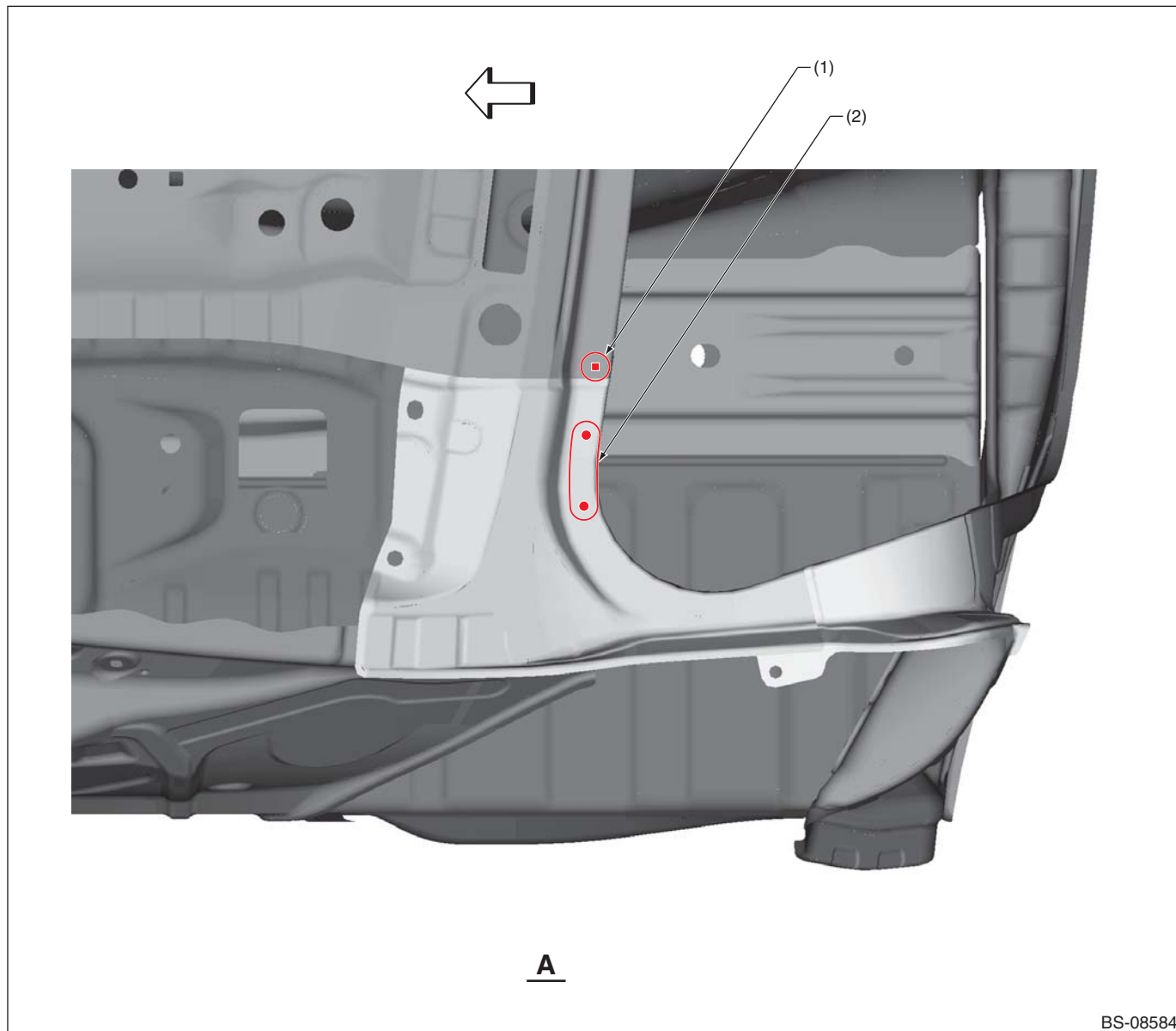
(1) 2 points

(2) 1 point

(3) 1 point (service · matching)

Panel Replacement

• Views A



BS-08584

(1) 1 point (service · matching)

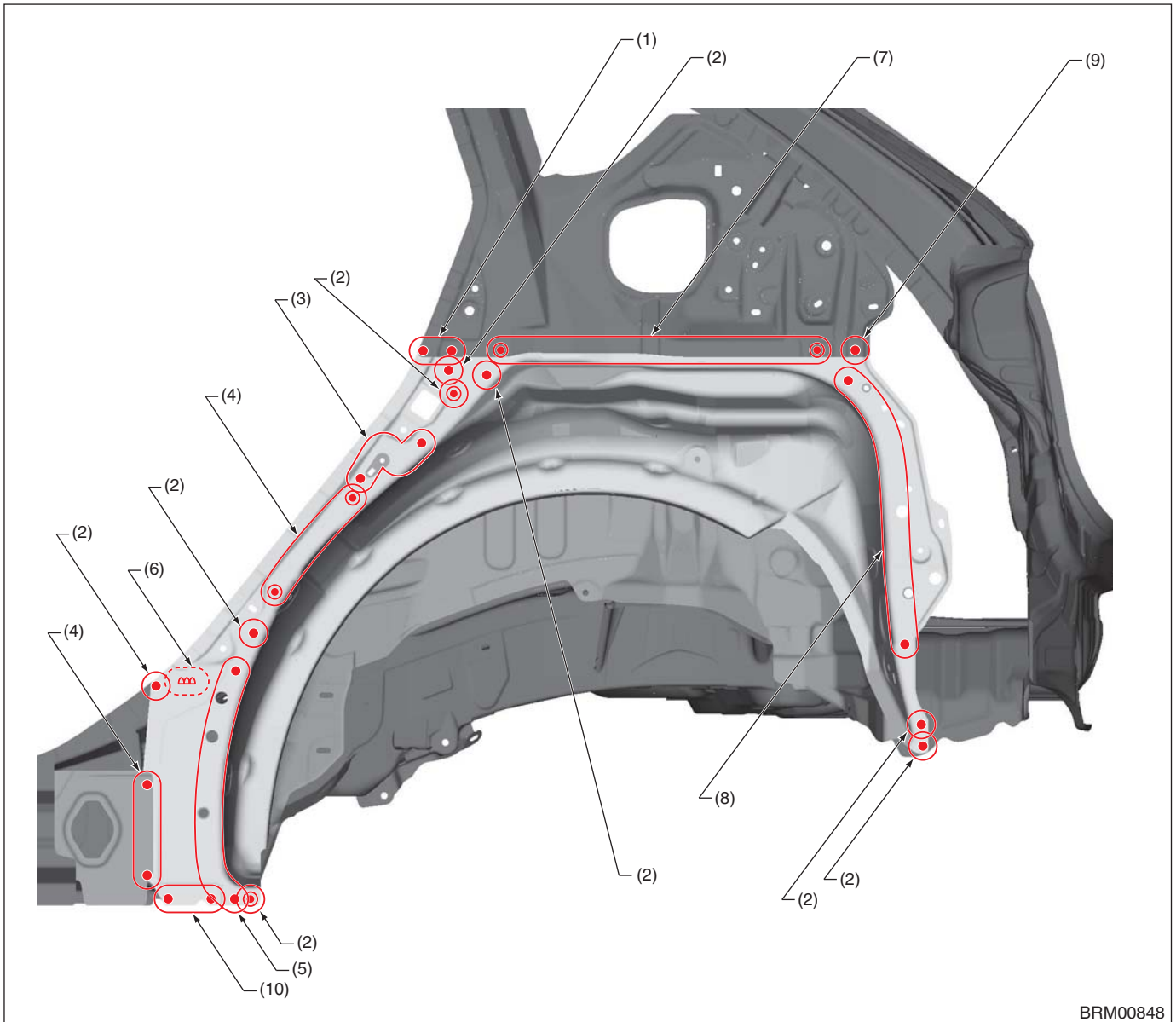
(2) 2 points

Panel Replacement

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

A: REMOVAL

• Overall view



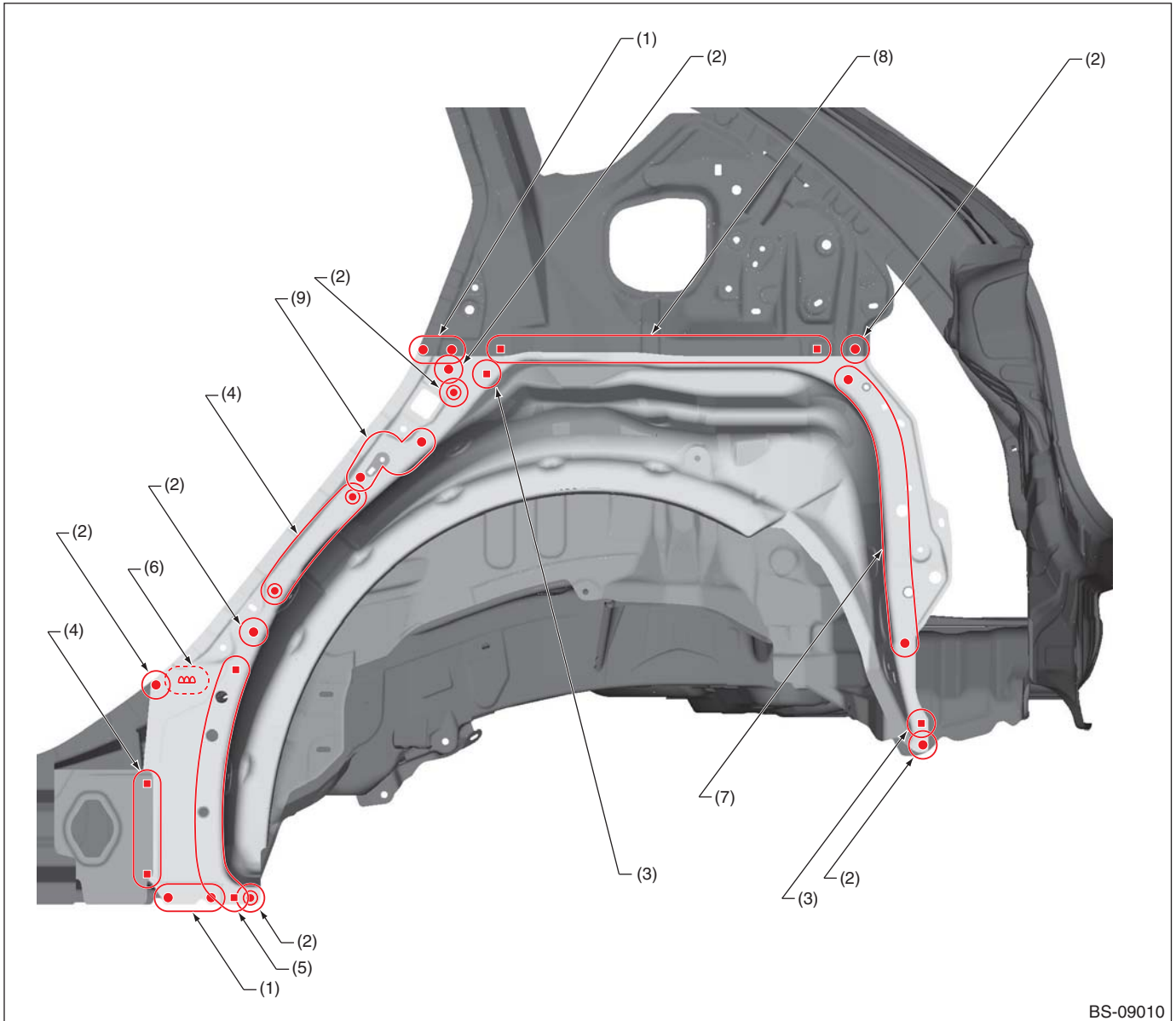
BRM00848

- | | | |
|----------------------------|--------------------------------------|-----------------------------|
| (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



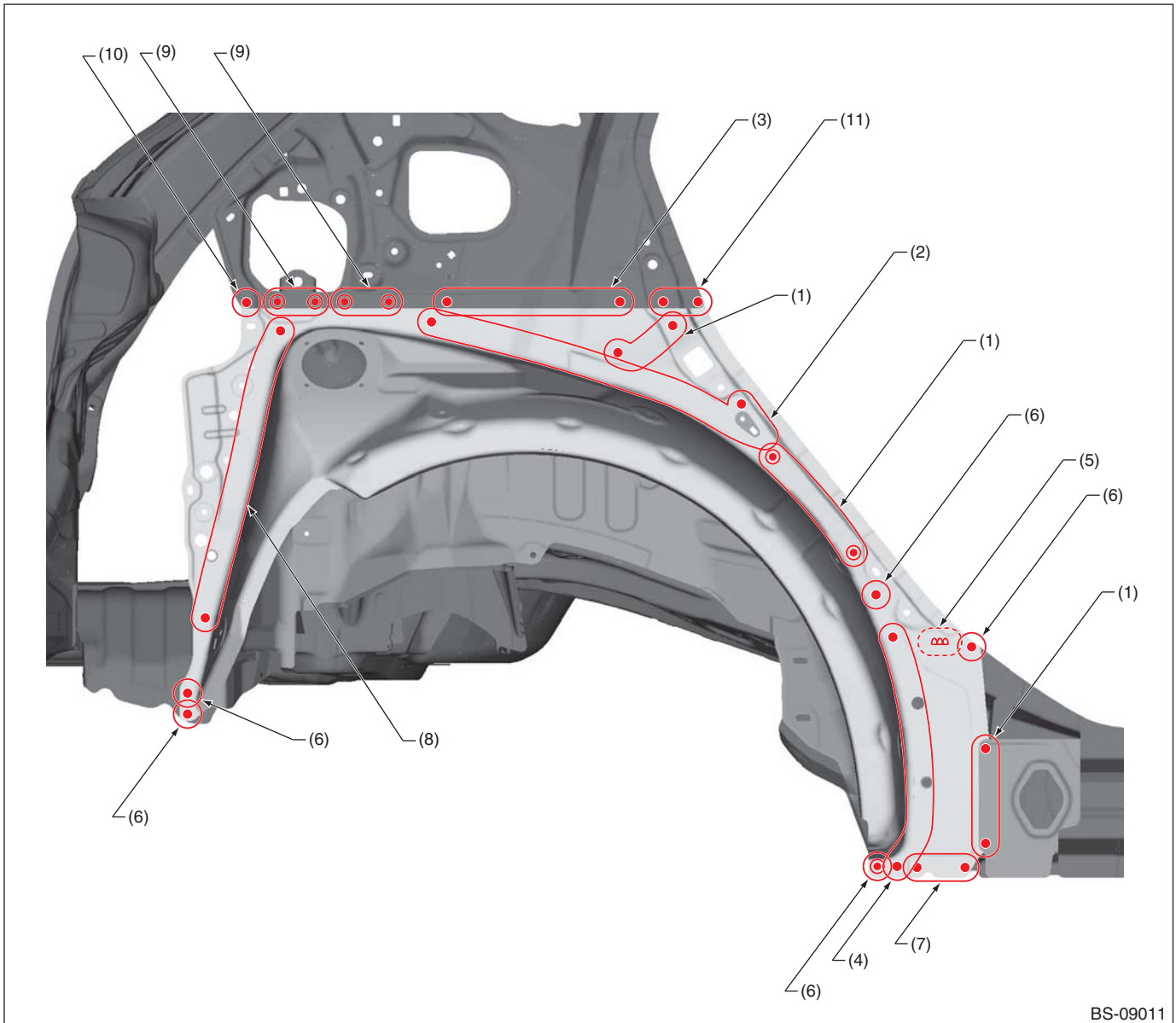
- | | | |
|-----------------------|---|-----------------------------------|
| (1) 2 points | (4) 3 points | (7) 7 points |
| (2) 1 point | (5) 6 points (service) | (8) 7 points (service · matching) |
| (3) 1 point (service) | (6) 1 point (Continuous welding)
[22 mm (0.87 in)] | (9) 4 points |

Panel Replacement

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

A: REMOVAL

• Overall view

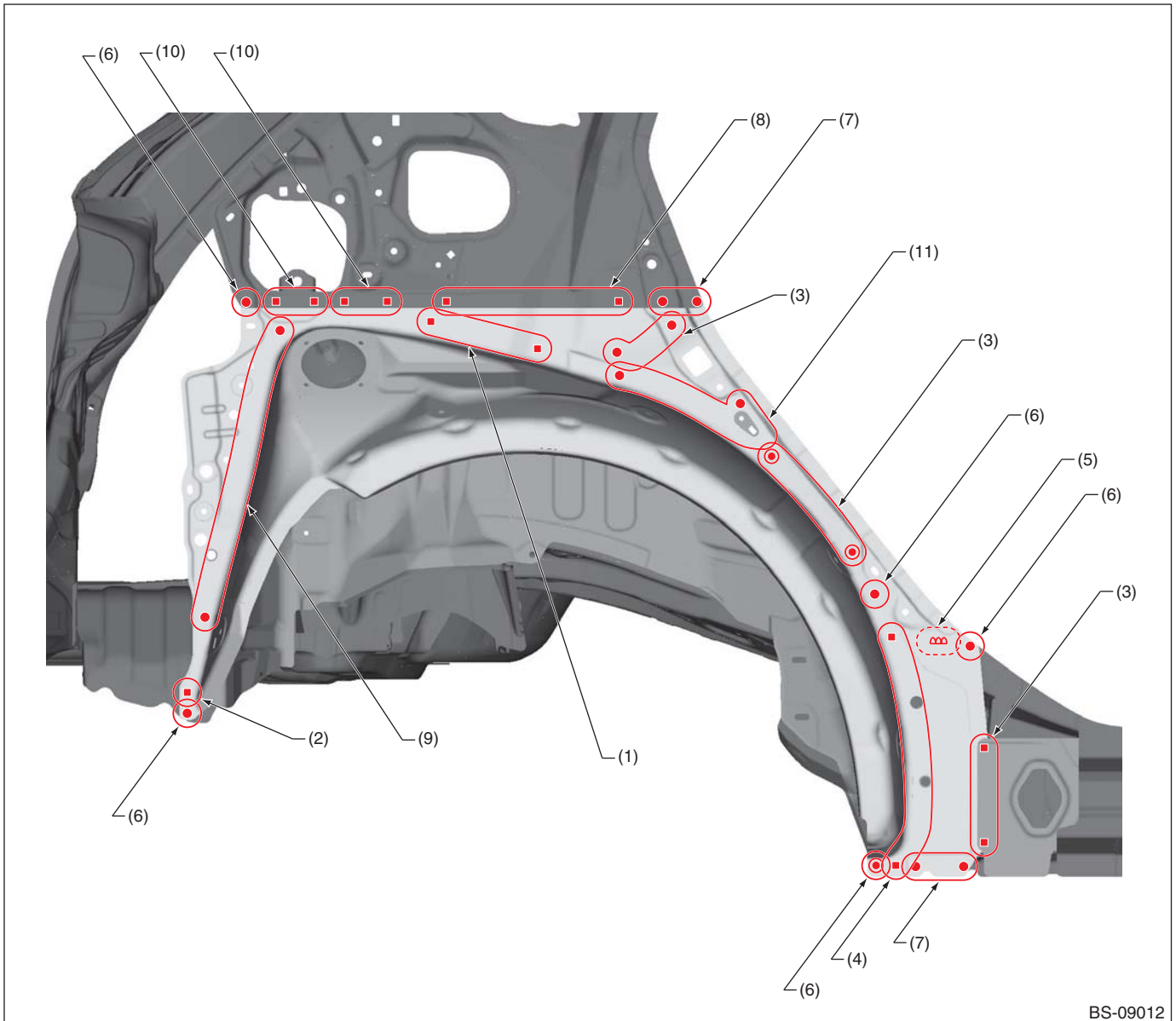


- | | | |
|----------------------------|--------------------------------------|----------------------------|
| (1) 3 points (outside · 1) | (5) 1 point (inside · 1 belt sander) | (9) 2 points (outside · 2) |
| (2) 8 points (outside · 1) | (6) 1 point (outside · 1) | (10) 1 point (inside · 1) |
| (3)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

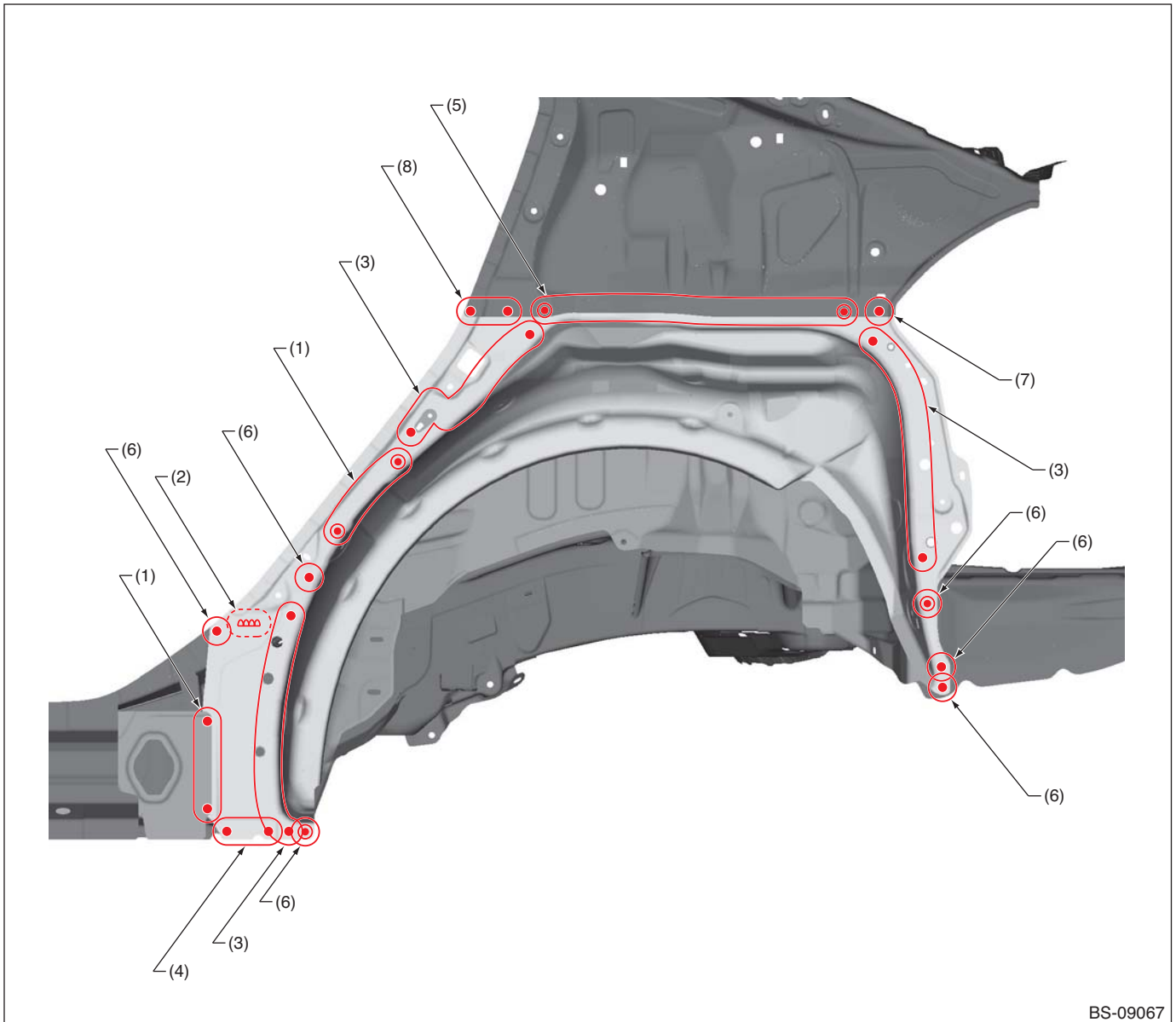


- | | | |
|------------------------|---|------------------------------------|
| (1) 3 points (service) | (5) 1 point (Continuous welding
[22 mm (0.87 in)]) | (9) 7 points |
| (2) 1 point (service) | (6) 1 point | (10) 2 points (service · matching) |
| (3) 3 points | (7) 2 points | (11) 5 points |
| (4) 6 points (service) | (8) 4 points | |

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)

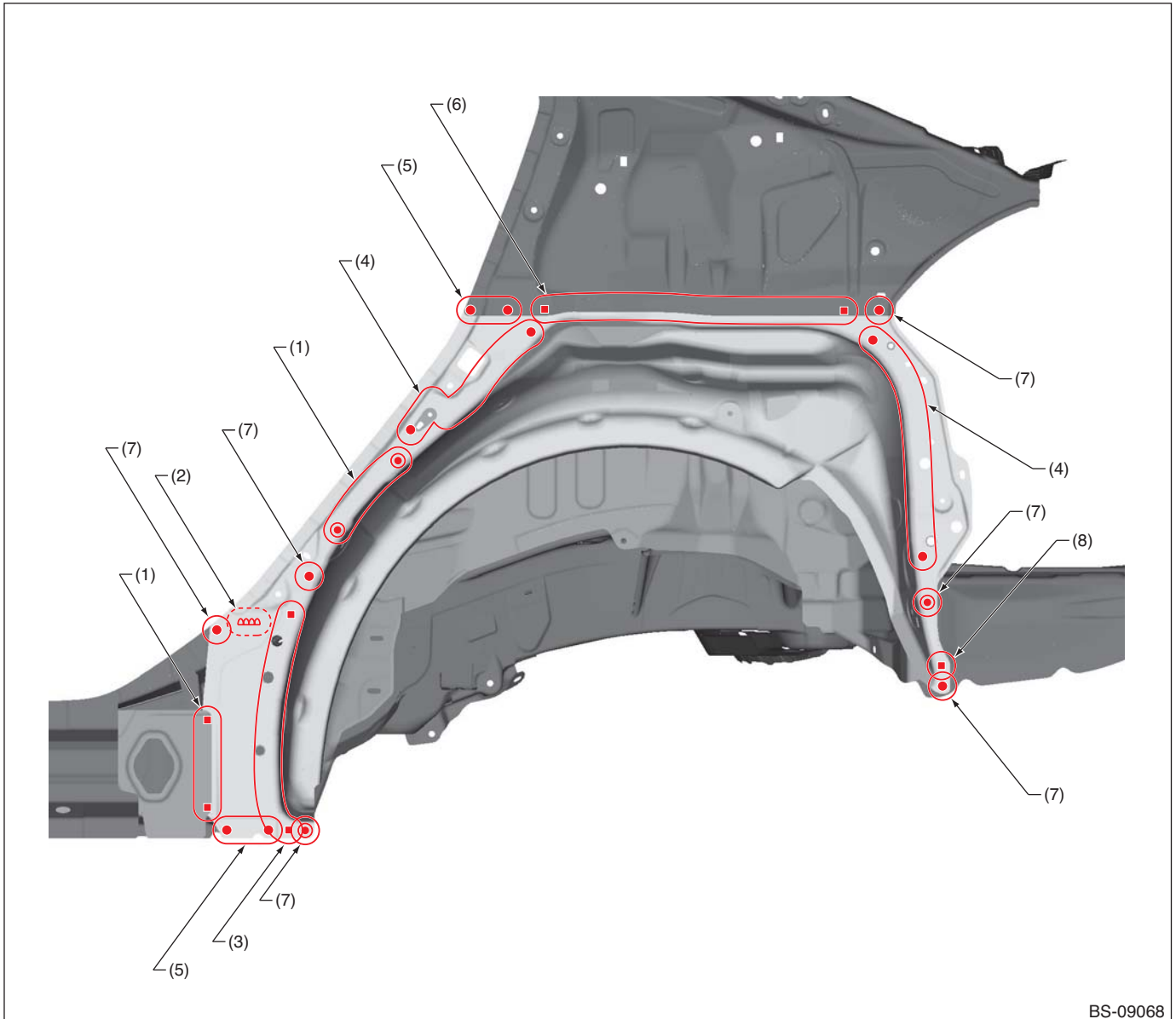
- (4) 2 points (outside · 1)
- (5) 7 points (outside · 2)
- (6) 1 point (outside · 1)

- (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)

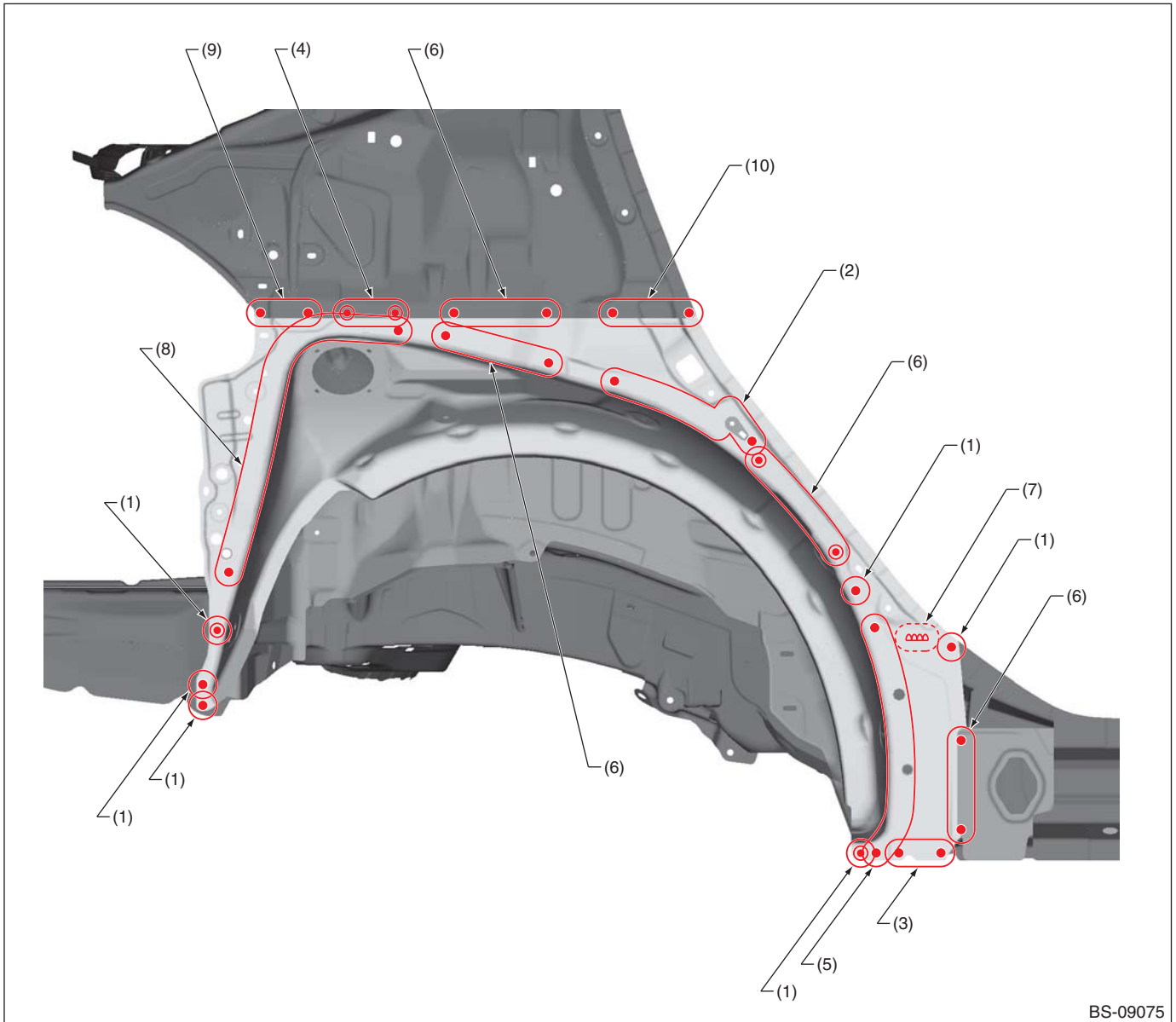
- (7) 1 point
- (8) 1 point (service)

Panel Replacement

8-30. Arch Rear Inner RH (total replacement) / 4D

A: REMOVAL

• Overall view

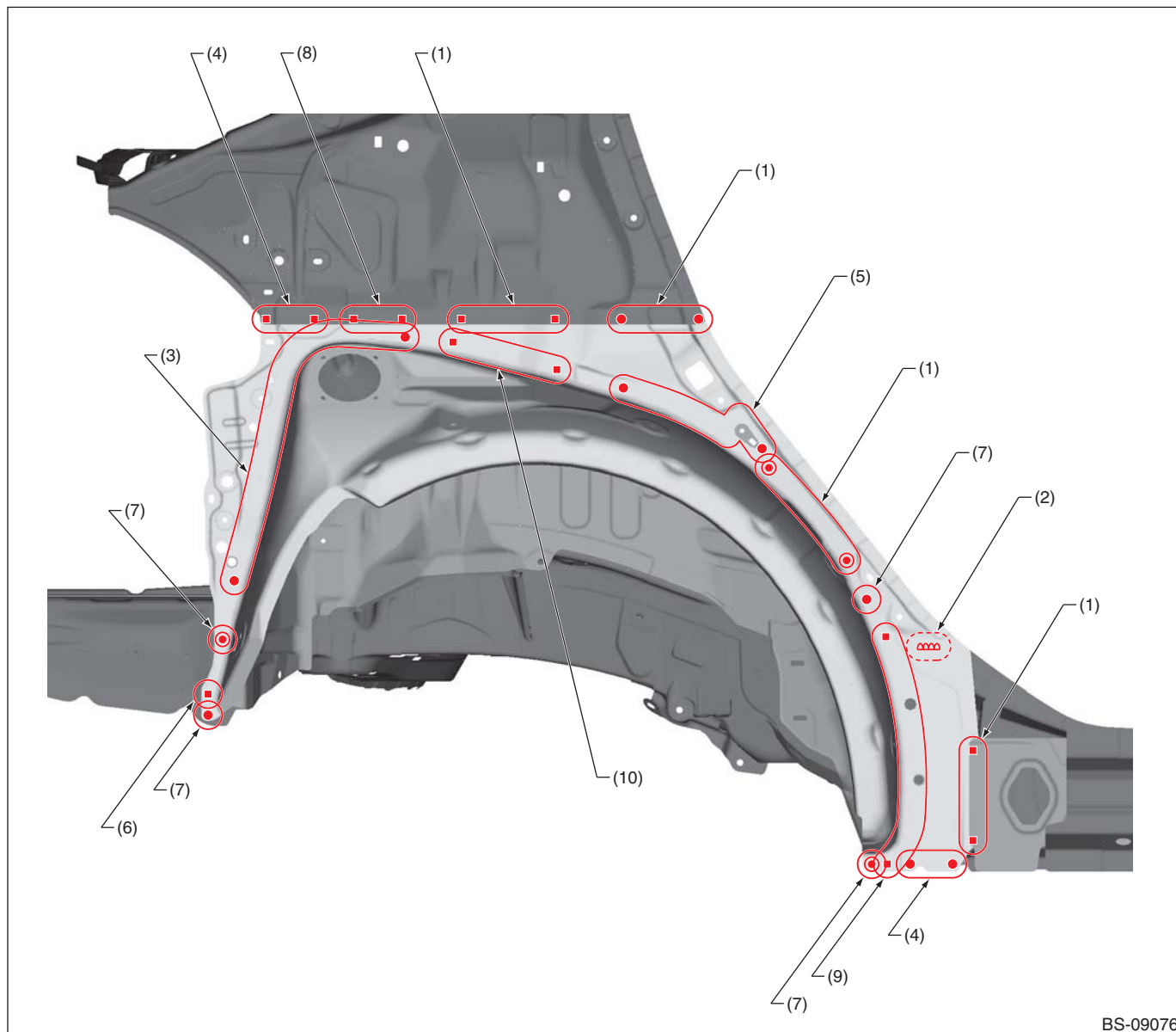


BS-09075

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

B: INSTALLATION

• Overall view



BS-09076

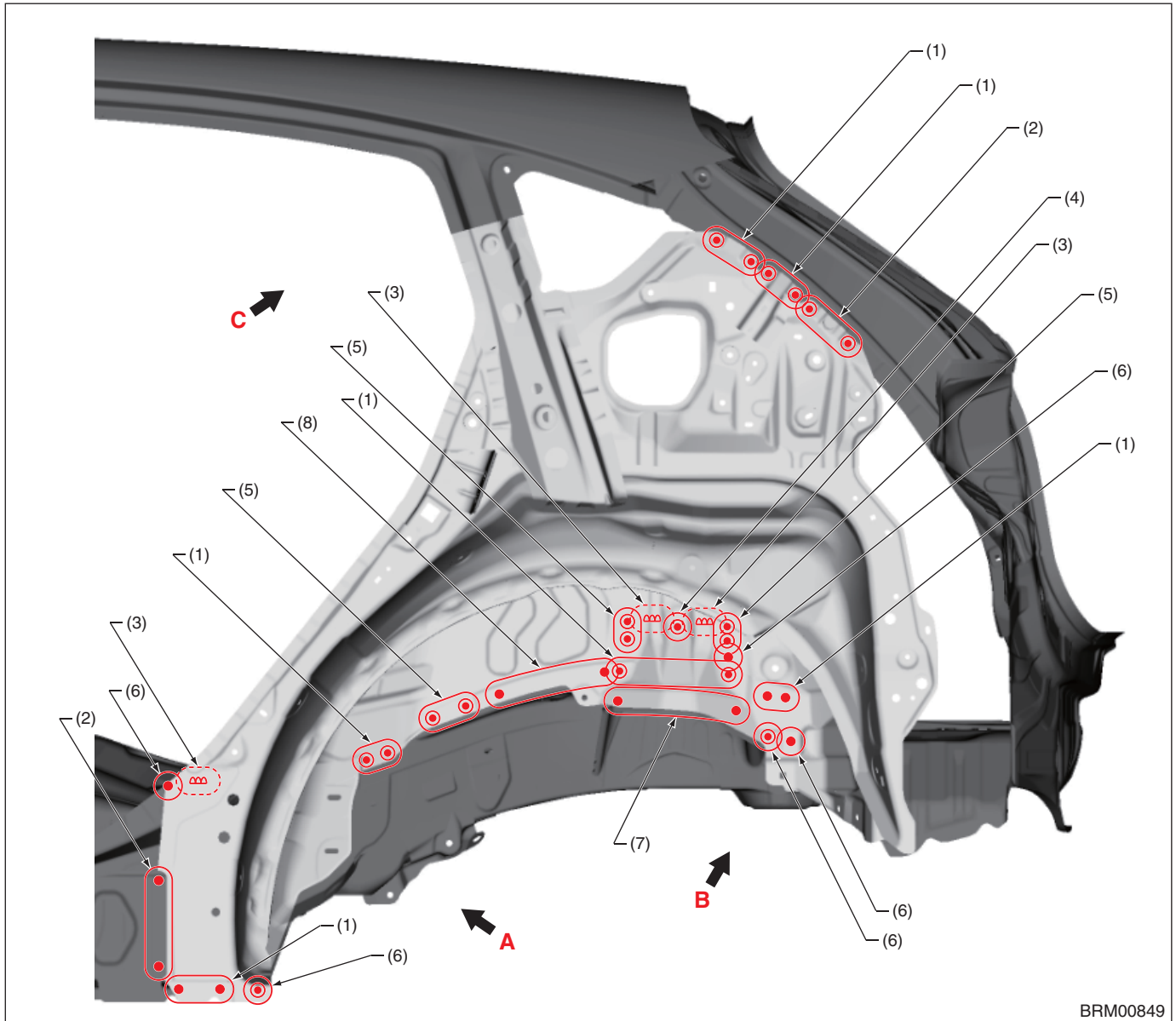
- | | | |
|---|-----------------------------------|-------------------------|
| (1) 3 points | (5) 5 points | (9) 6 points (service) |
| (2) 1 point (Continuous welding)
(30 mm [1.18 in]) | (6) 1 point (service) | (10) 3 points (service) |
| (3) 8 points | (7) 1 point | |
| (4) 2 points | (8) 2 points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

Panel Replacement

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

A: REMOVAL

• Overall view

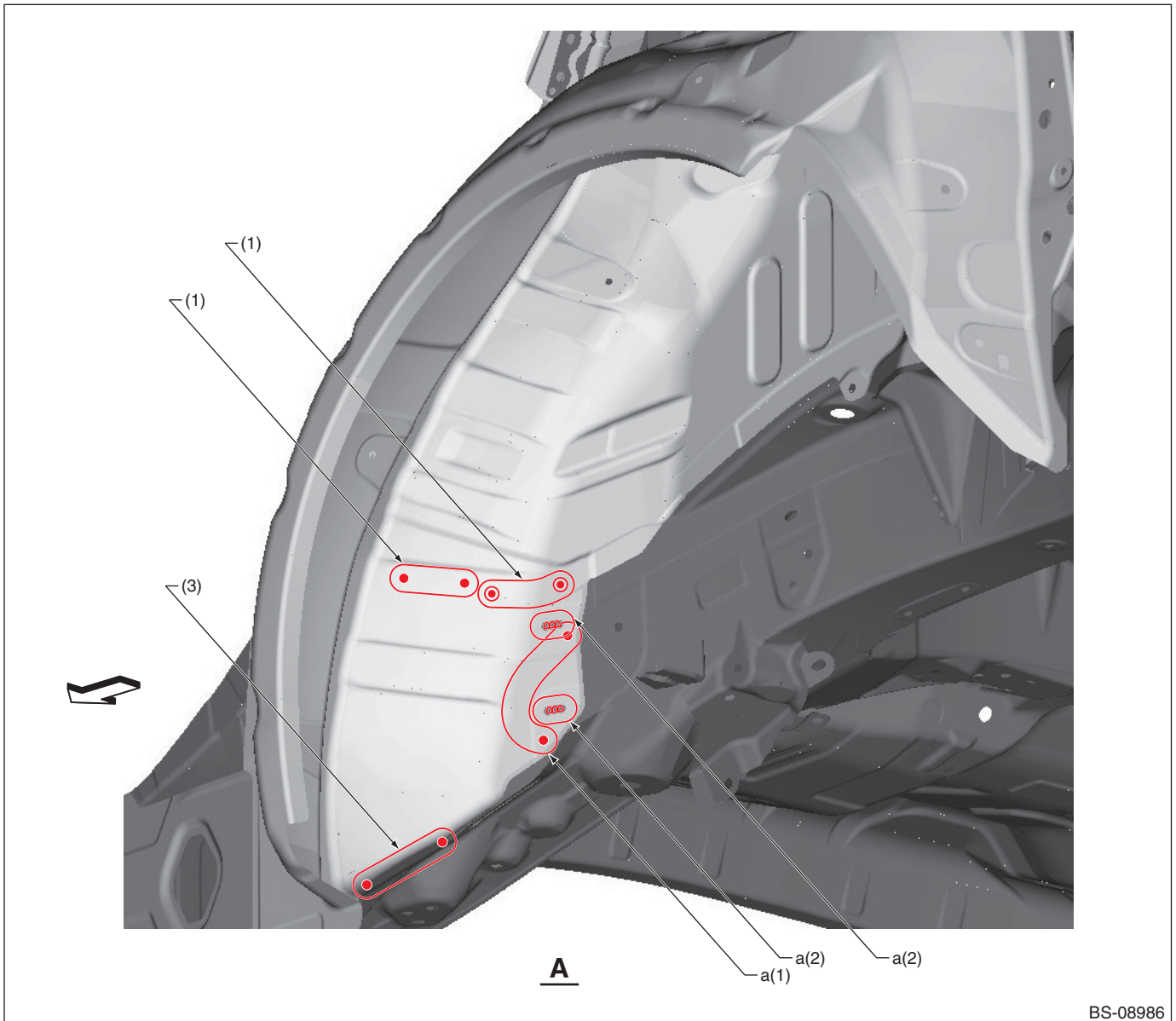


BRM00849

- | | | |
|--------------------------------------|----------------------------|----------------------------|
| (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) | |

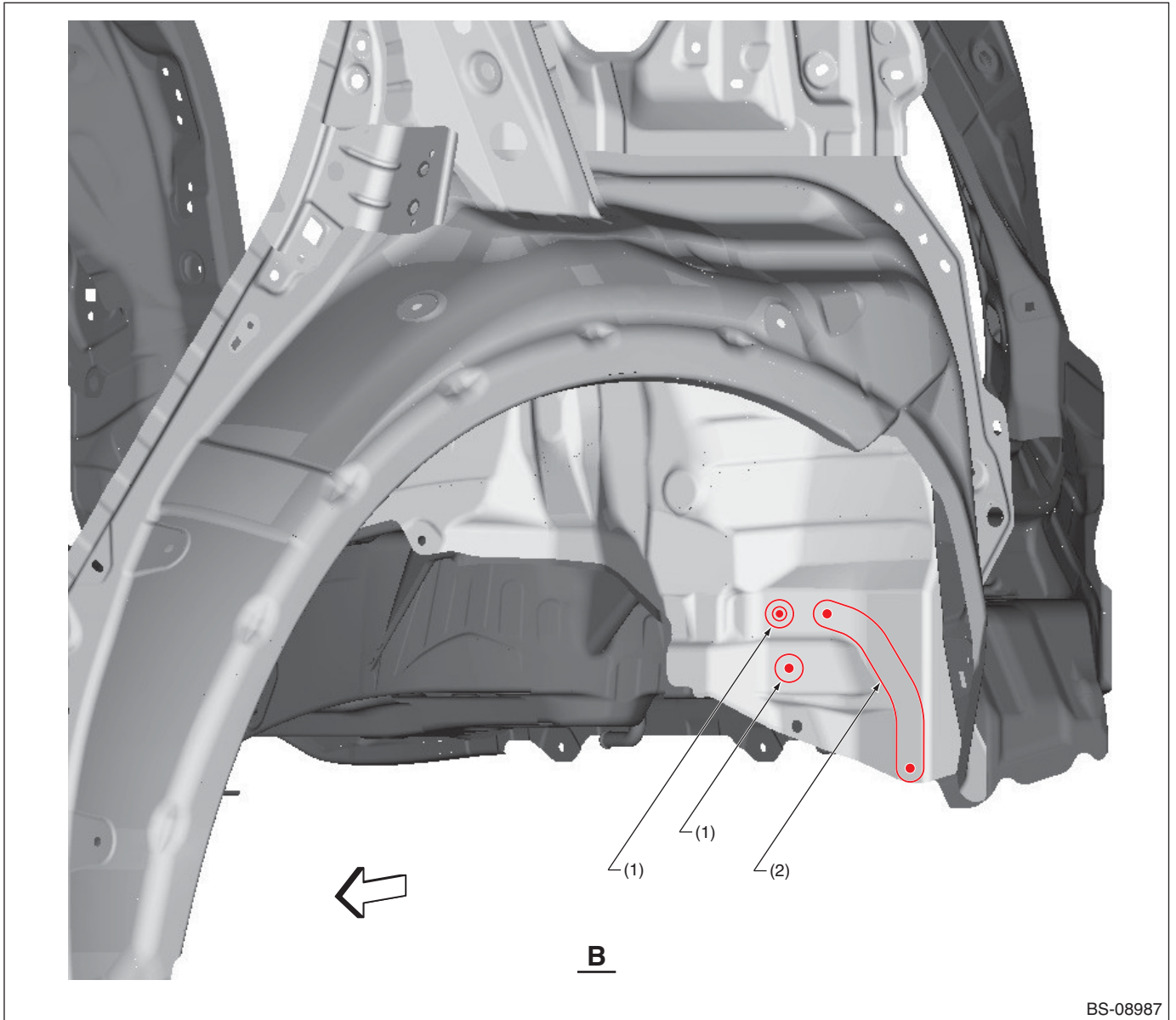
Panel Replacement

• Views A



Panel Replacement

• Views B

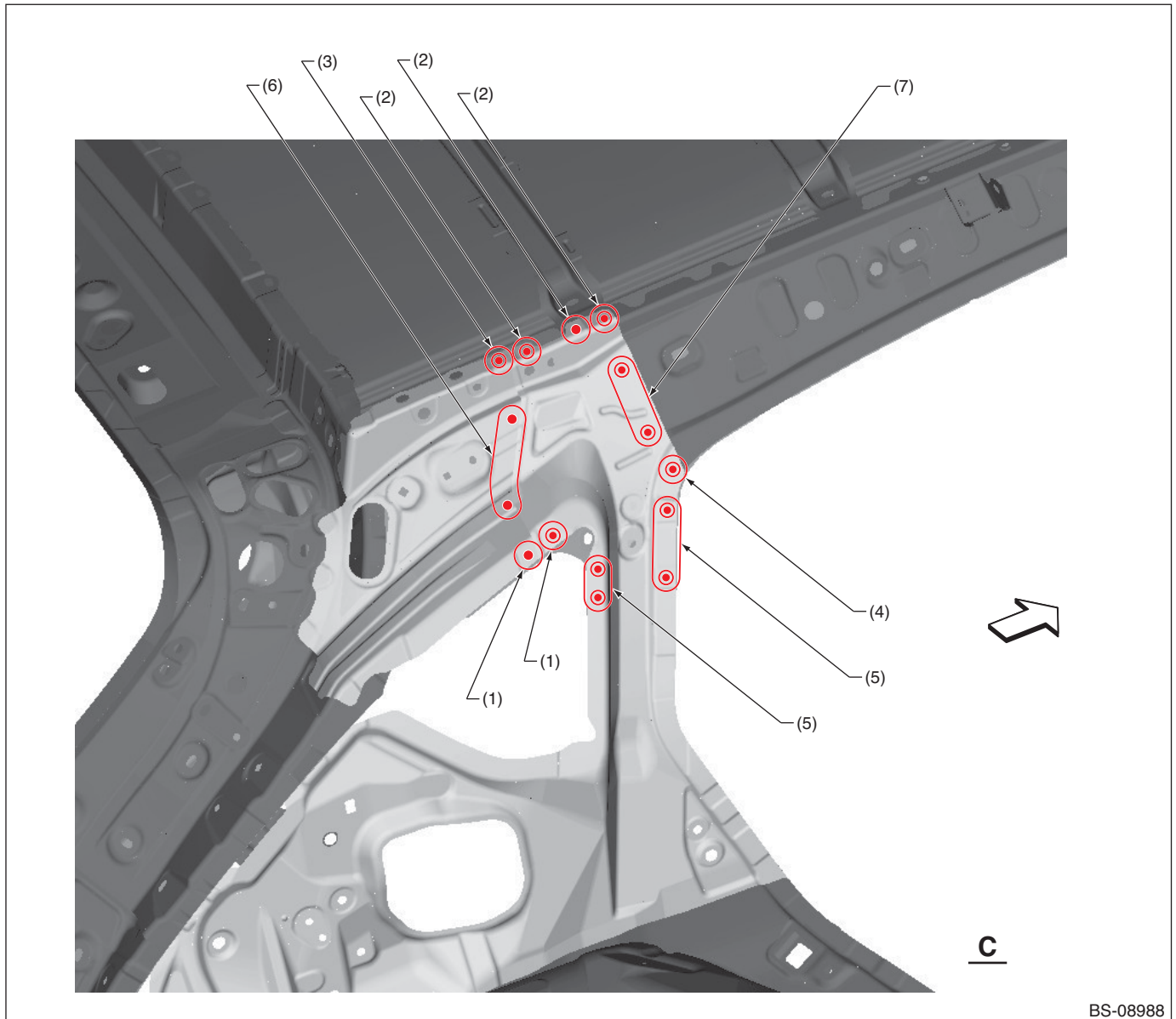


(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

Panel Replacement

• Views C



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

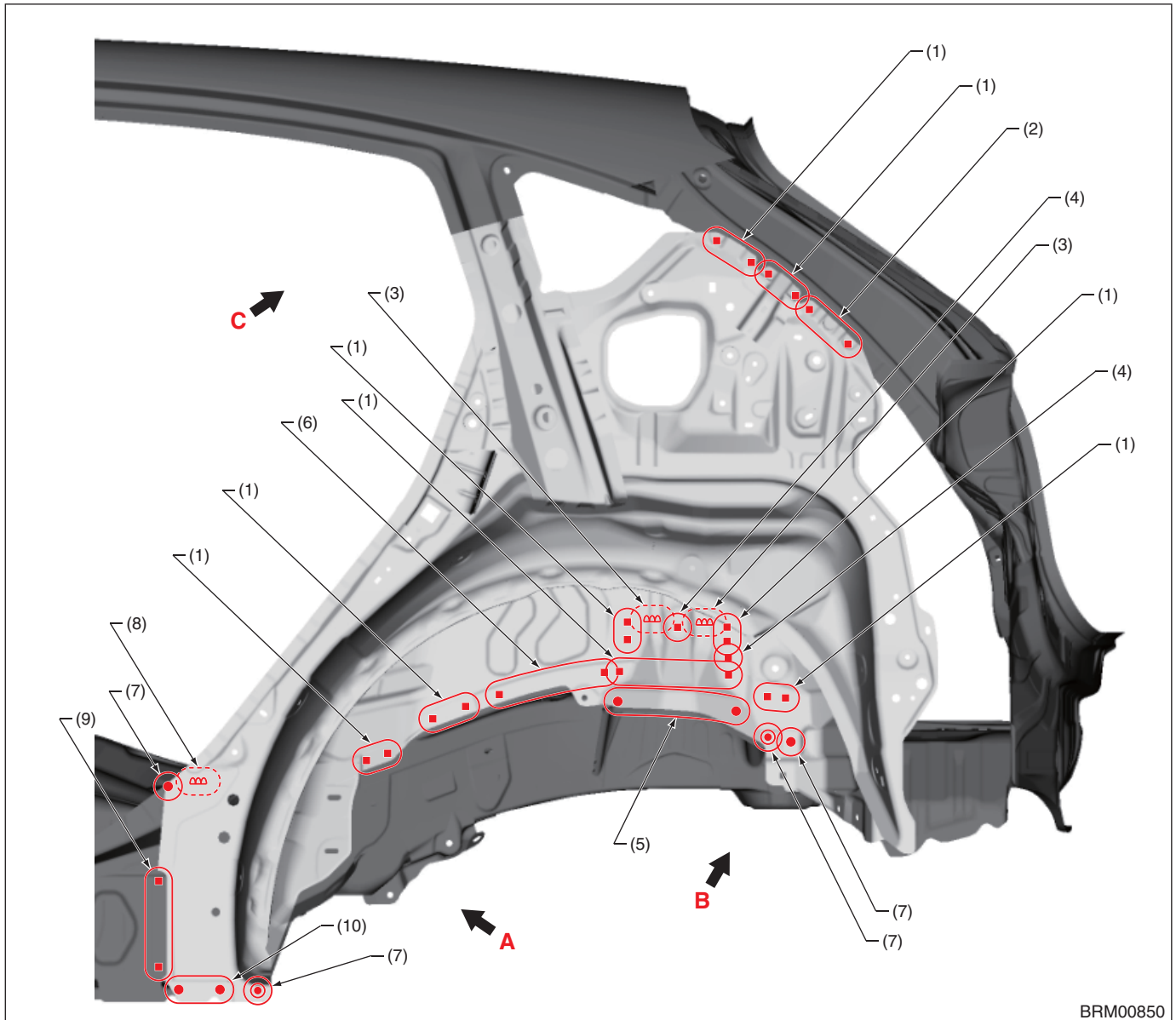
- (4) 1 point (inside · 2)
- (5) 2 points (inside · 2)
- (6) 3 points (inside · 1)

- (7) 3 points (inside · 2)

Panel Replacement

B: INSTALLATION

• Overall view

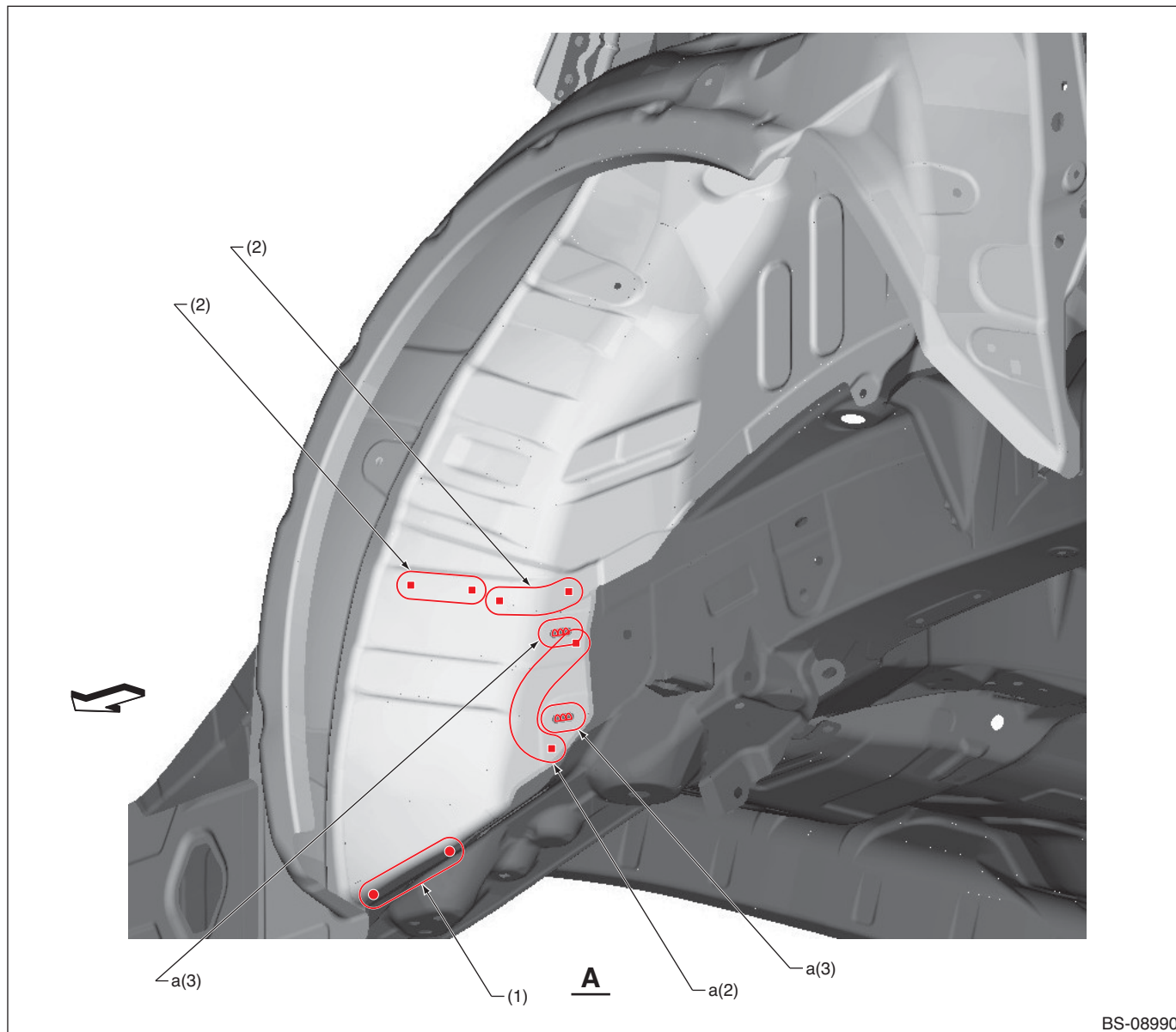


BRM00850

- | | | |
|---|---|---------------|
| (1) 2 points (service) | (5) 5 points | (9) 3 points |
| (2) 3 points (service) | (6) 4 points (service) | (10) 2 points |
| (3) 1 point (Continuous welding)
(5 mm [0.2 in]) | (7) 1 point | |
| (4) 1 point (service) | (8) 1 point (Continuous welding)
(30 mm [1.18 in]) | |

Panel Replacement

• Views A



(1) 2 points

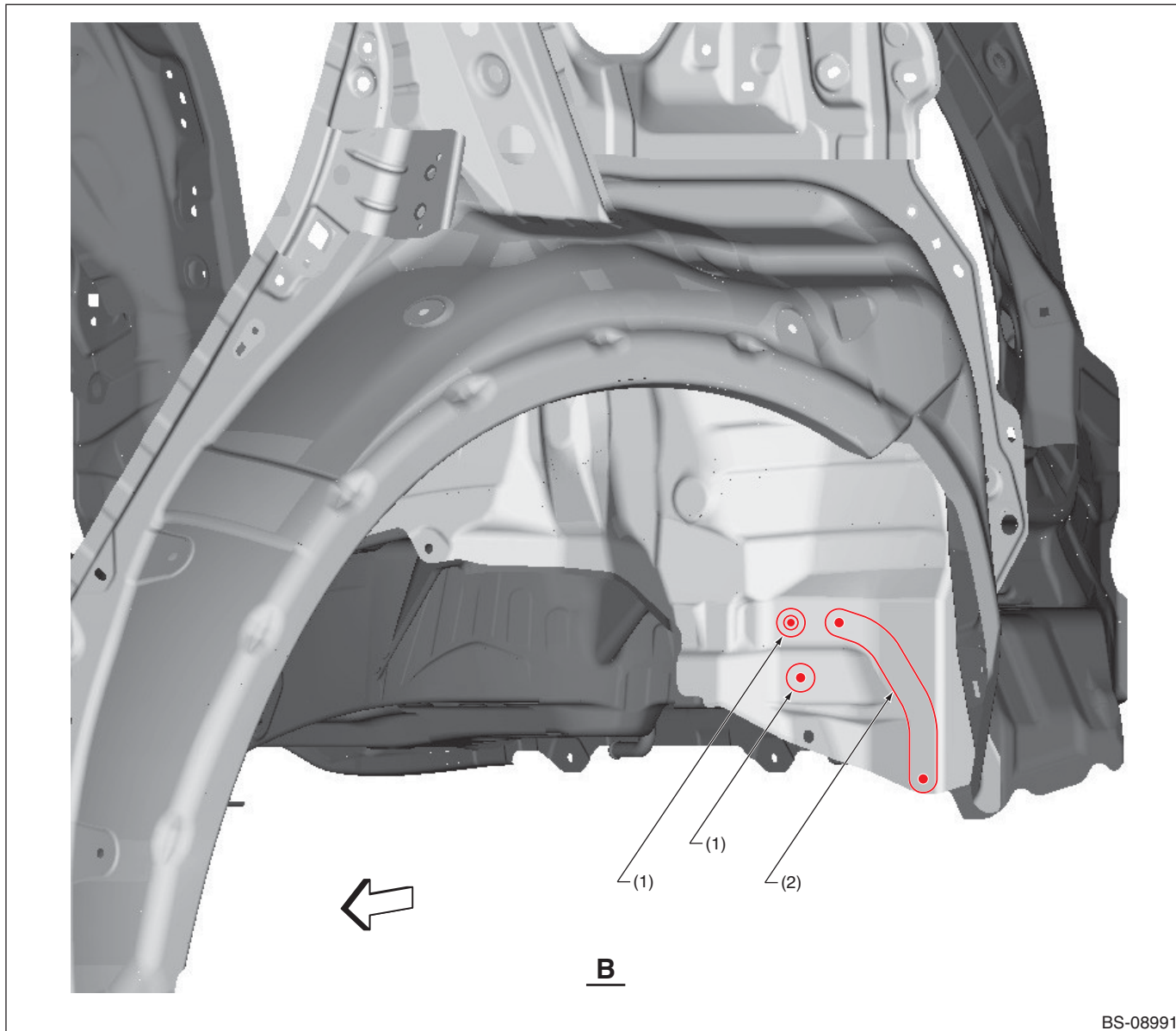
(2) 2 points (service)

(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



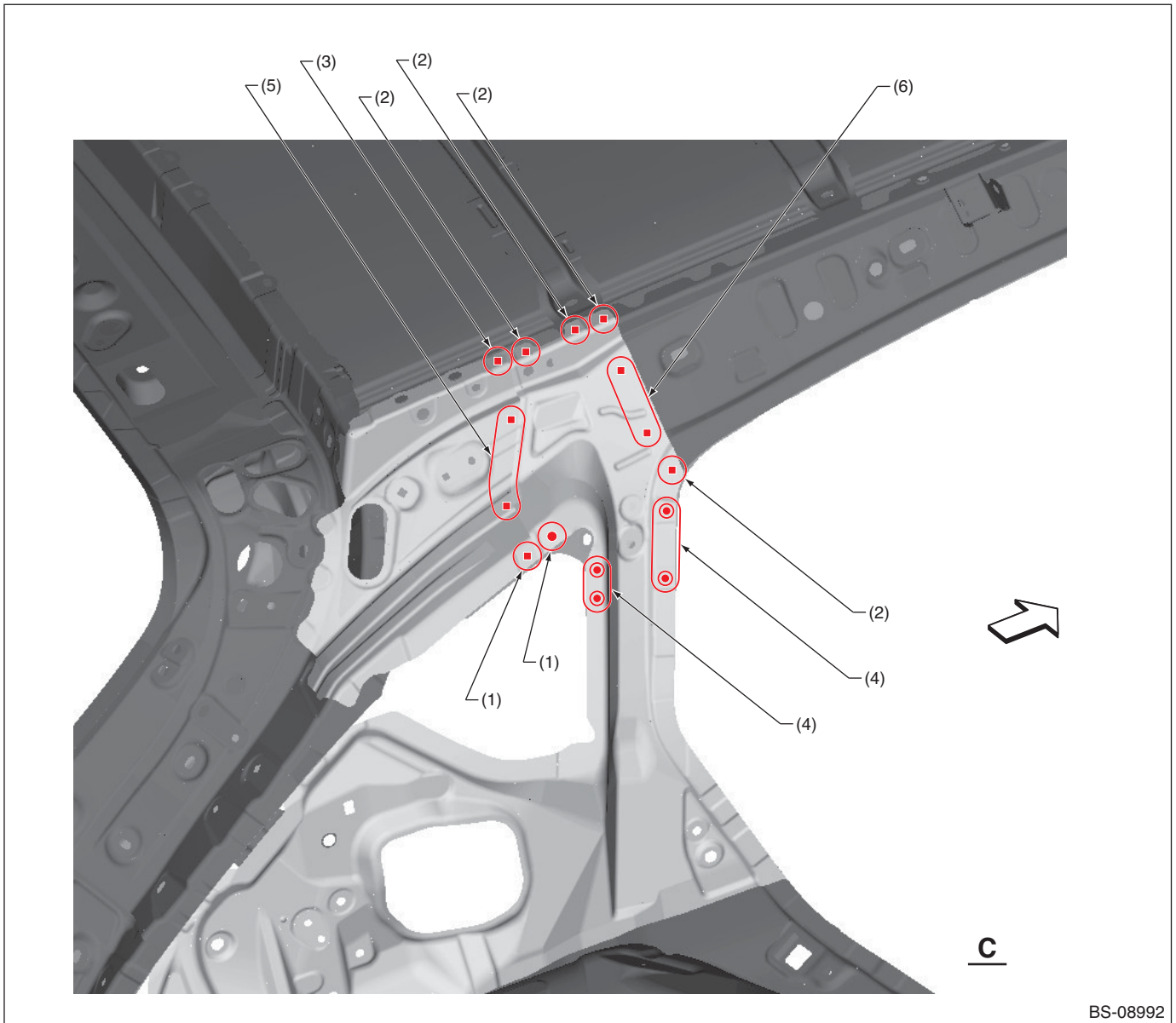
BS-08991

(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

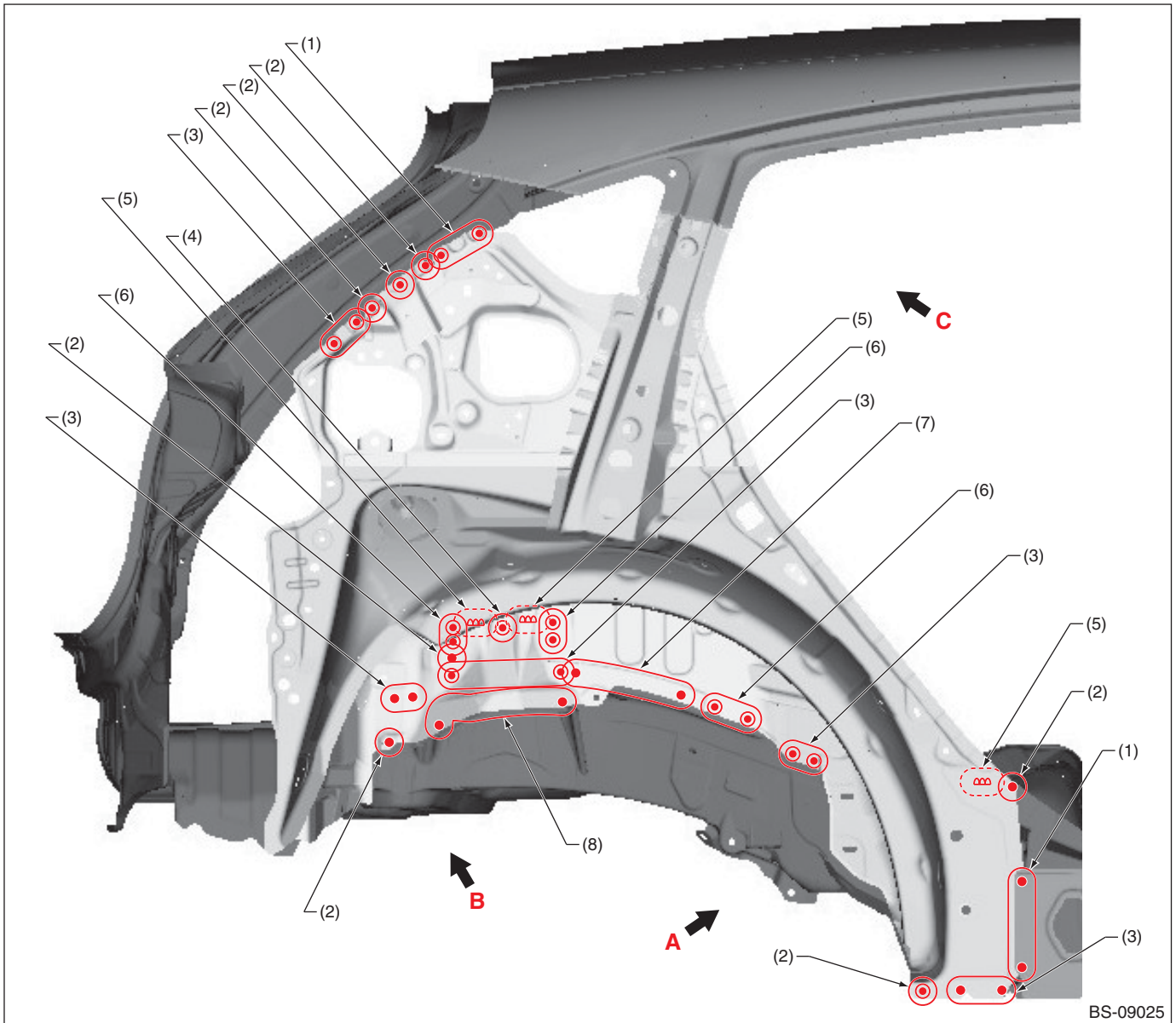
(5) 3 points
(6) 3 points (service)

Panel Replacement

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

A: REMOVAL

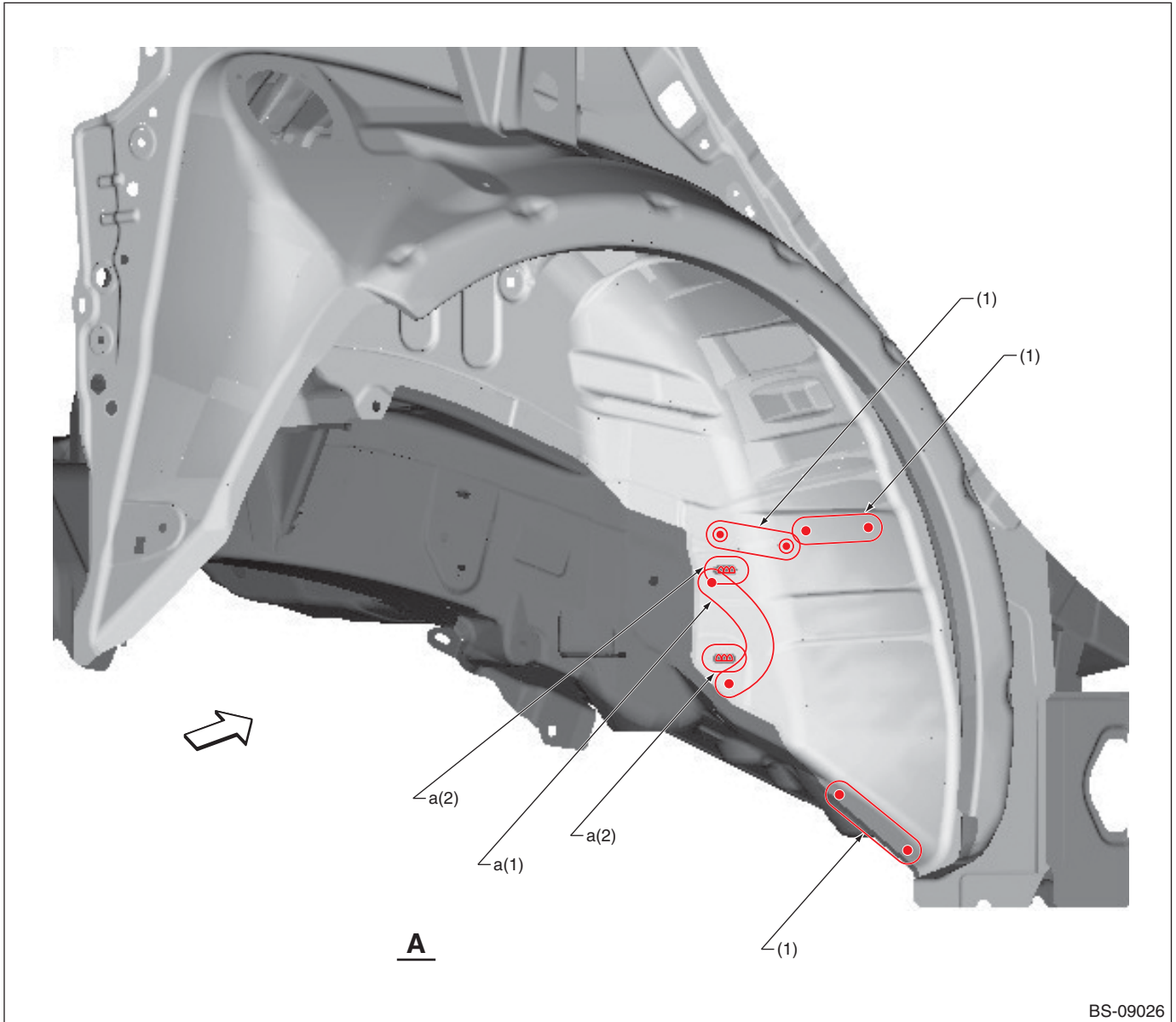
• Overall view



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

Panel Replacement

• Views A



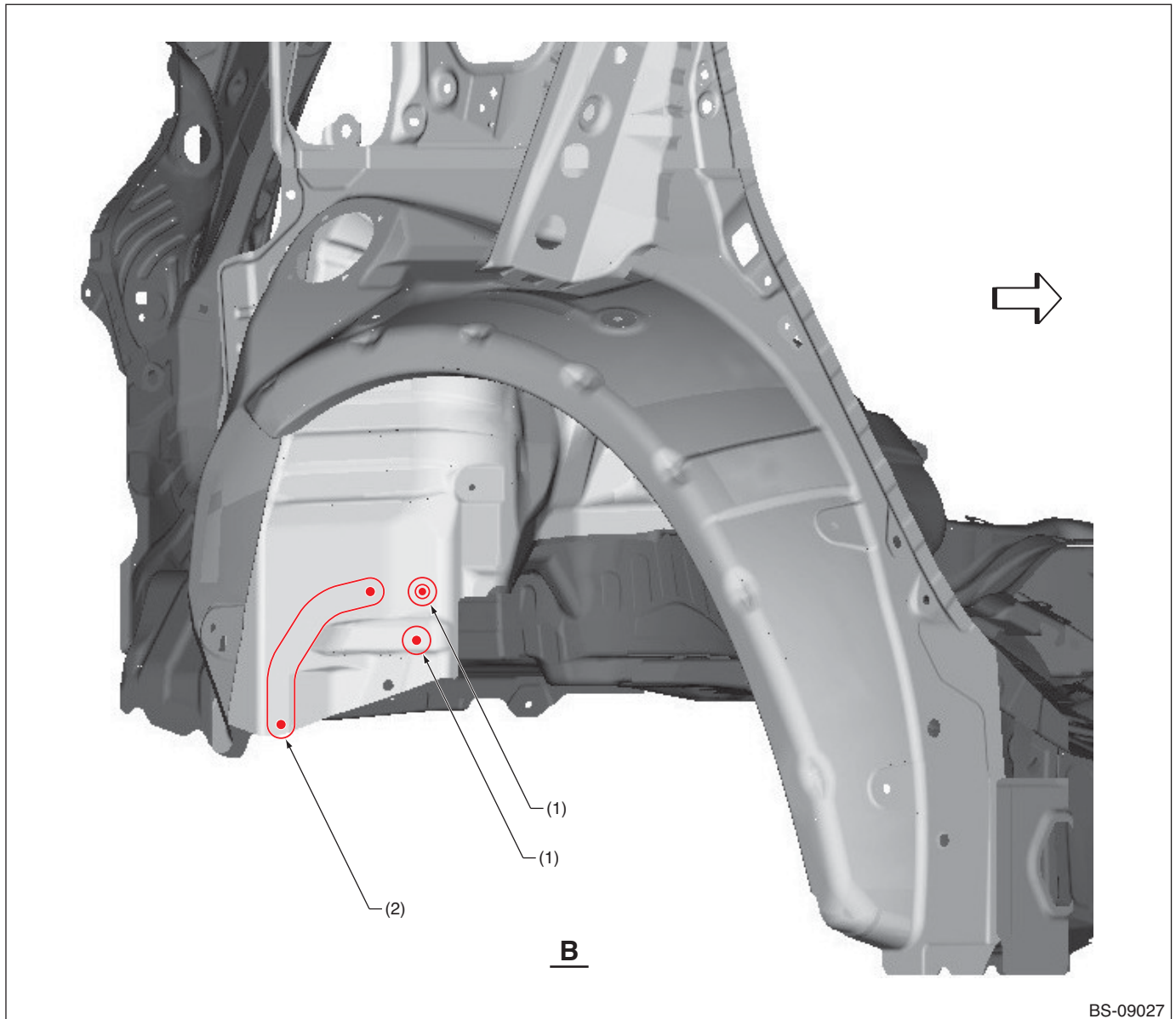
(1) 2 points (outside · 1)

(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

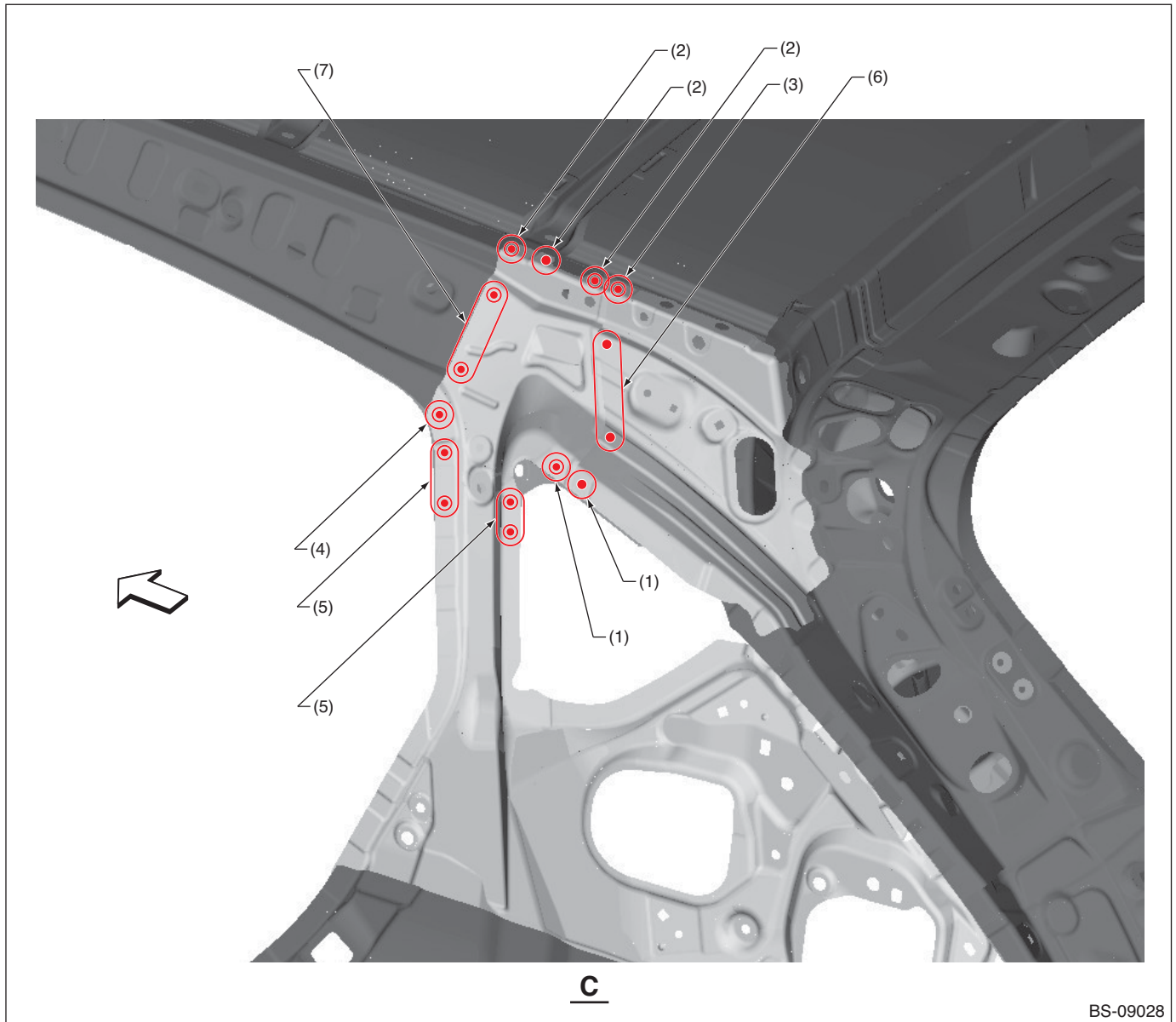


(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

Panel Replacement

• Views C



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

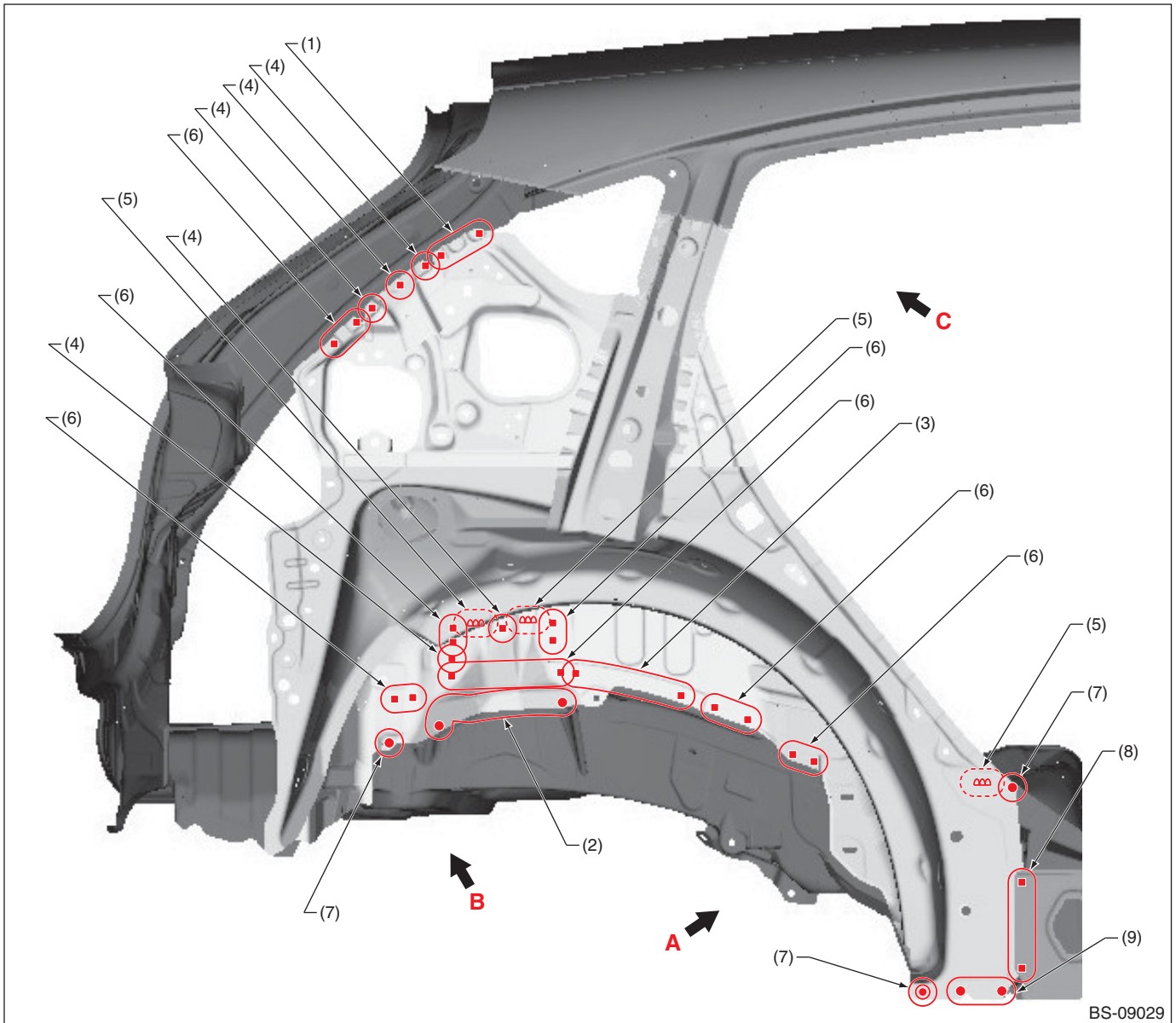
- (4) 1 point (inside · 2)
- (5) 2 points (inside · 2)
- (6) 3 points (inside · 1)

- (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)

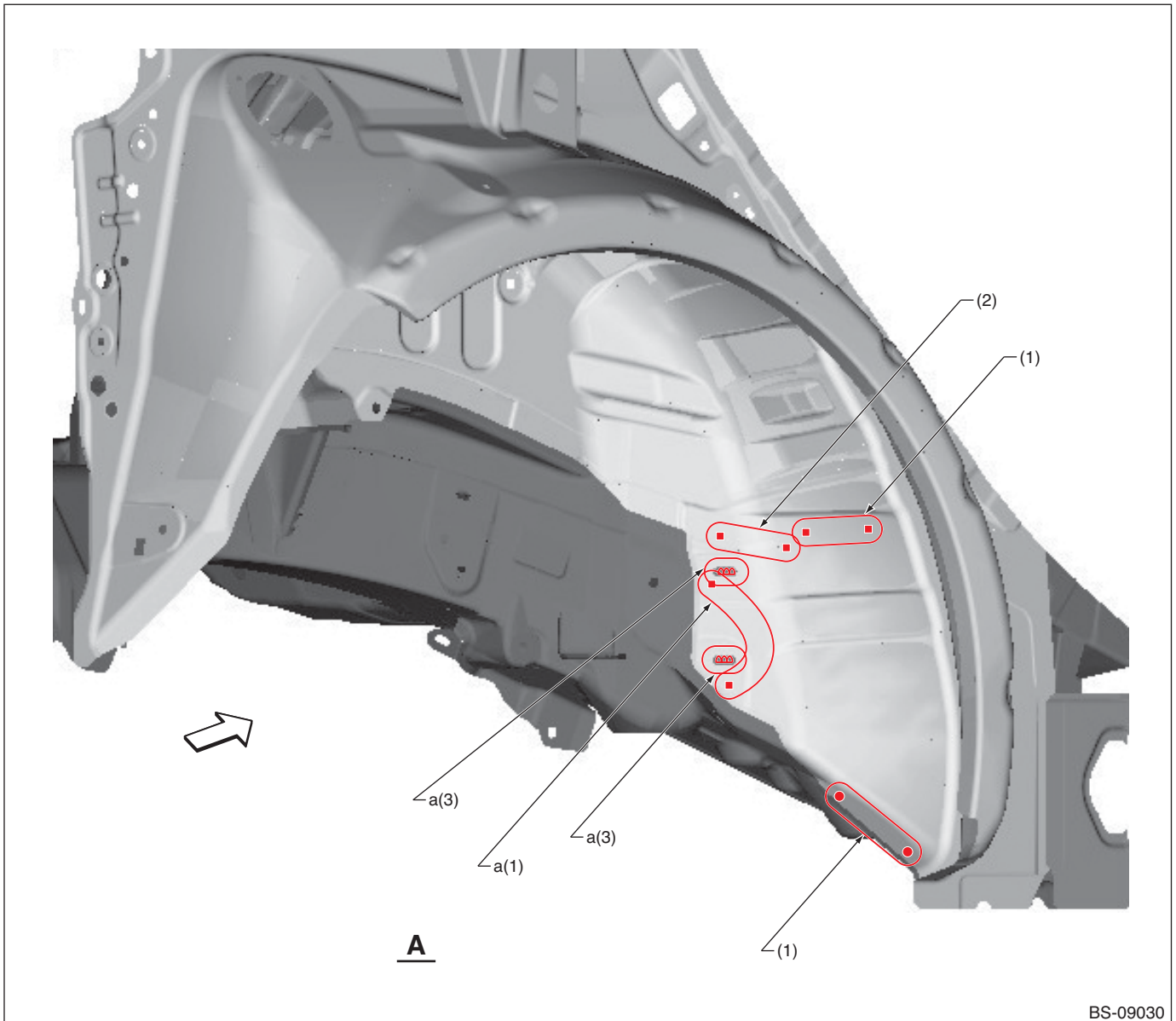
(7) 1 point

(8) 3 points

(9) 2 points

Panel Replacement

• Views A



(1) 2 points

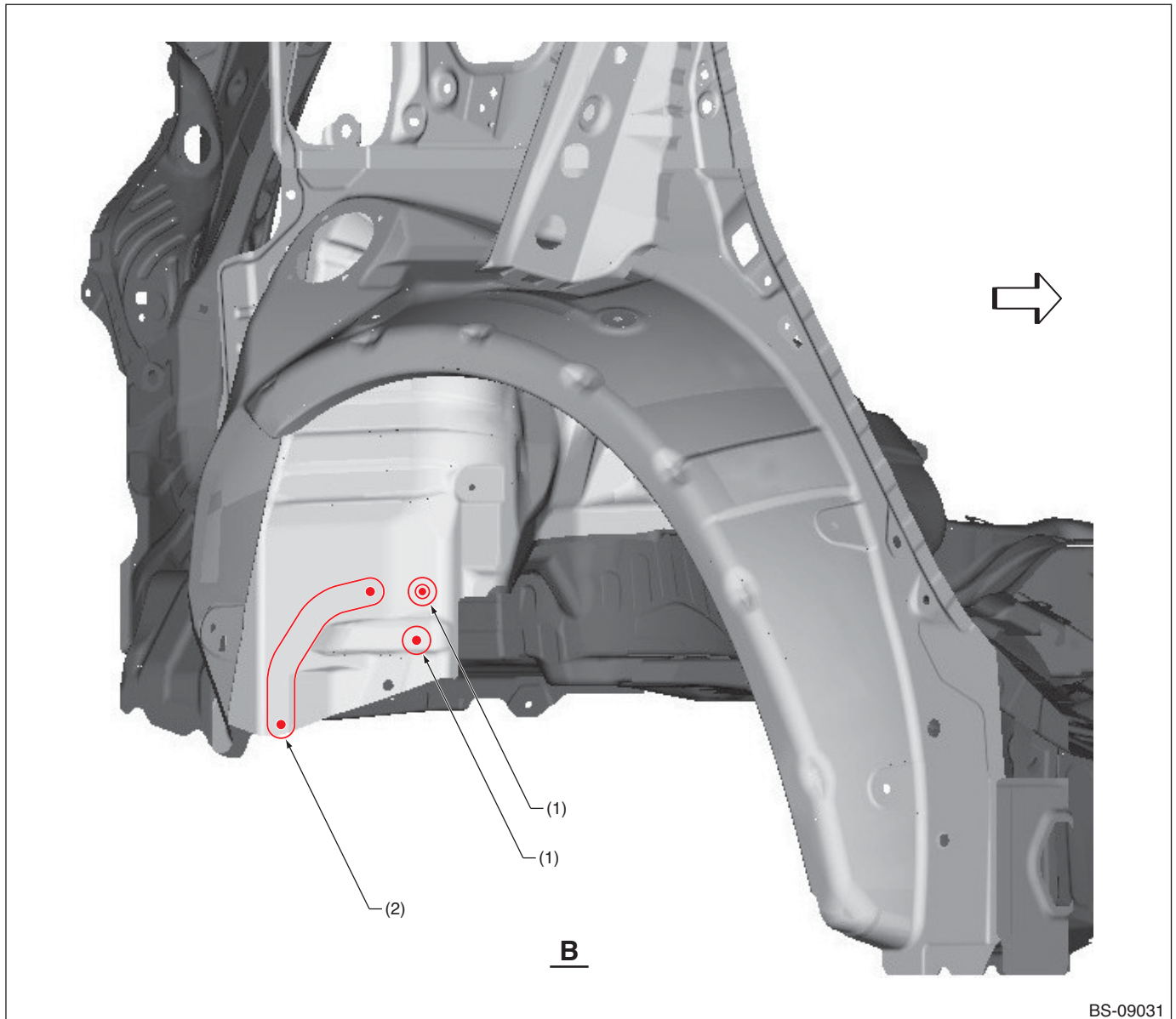
(2) 2 points (service)

(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

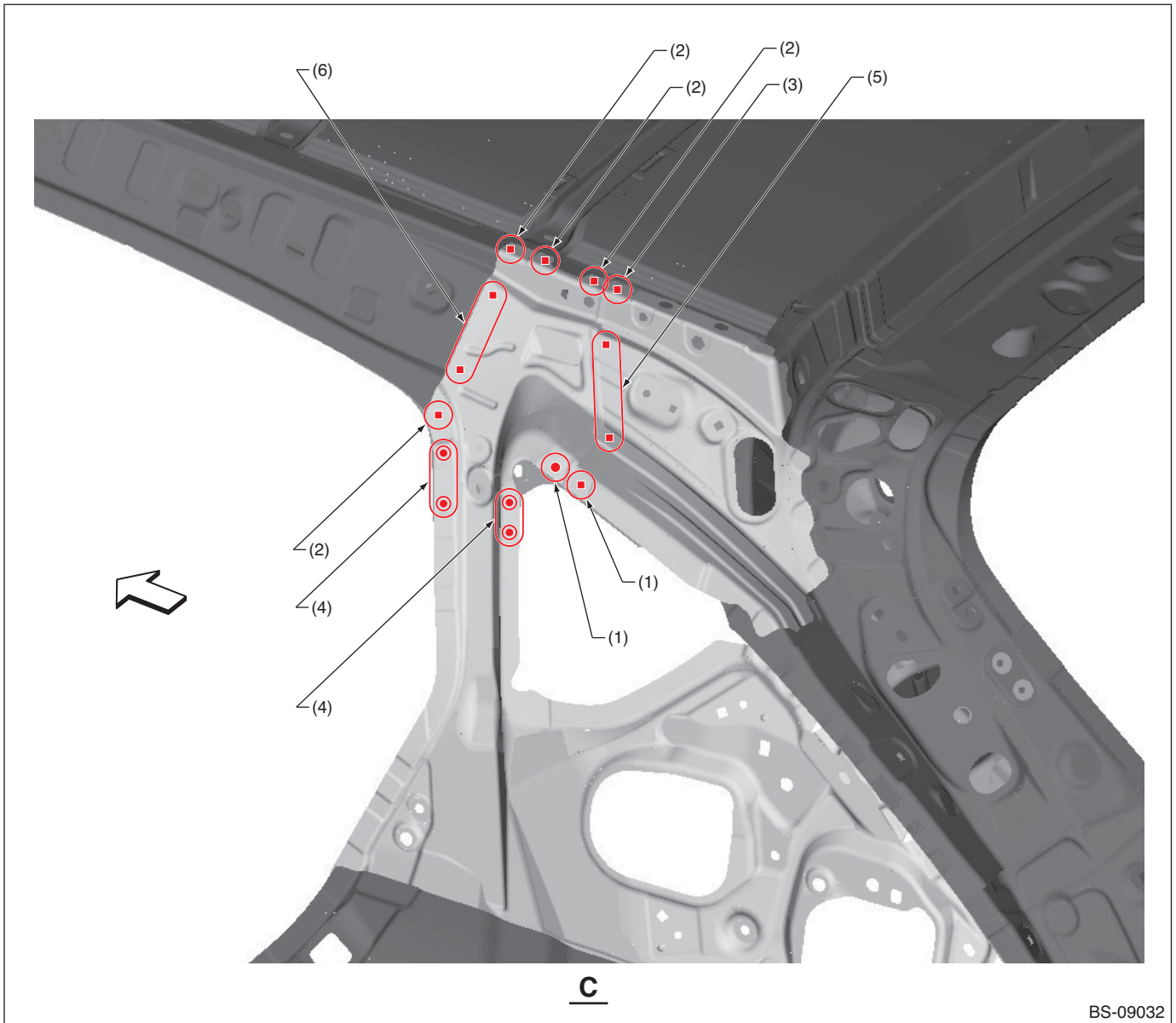


(1) 1 point

(2) 5 points

Panel Replacement

• Views C



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

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

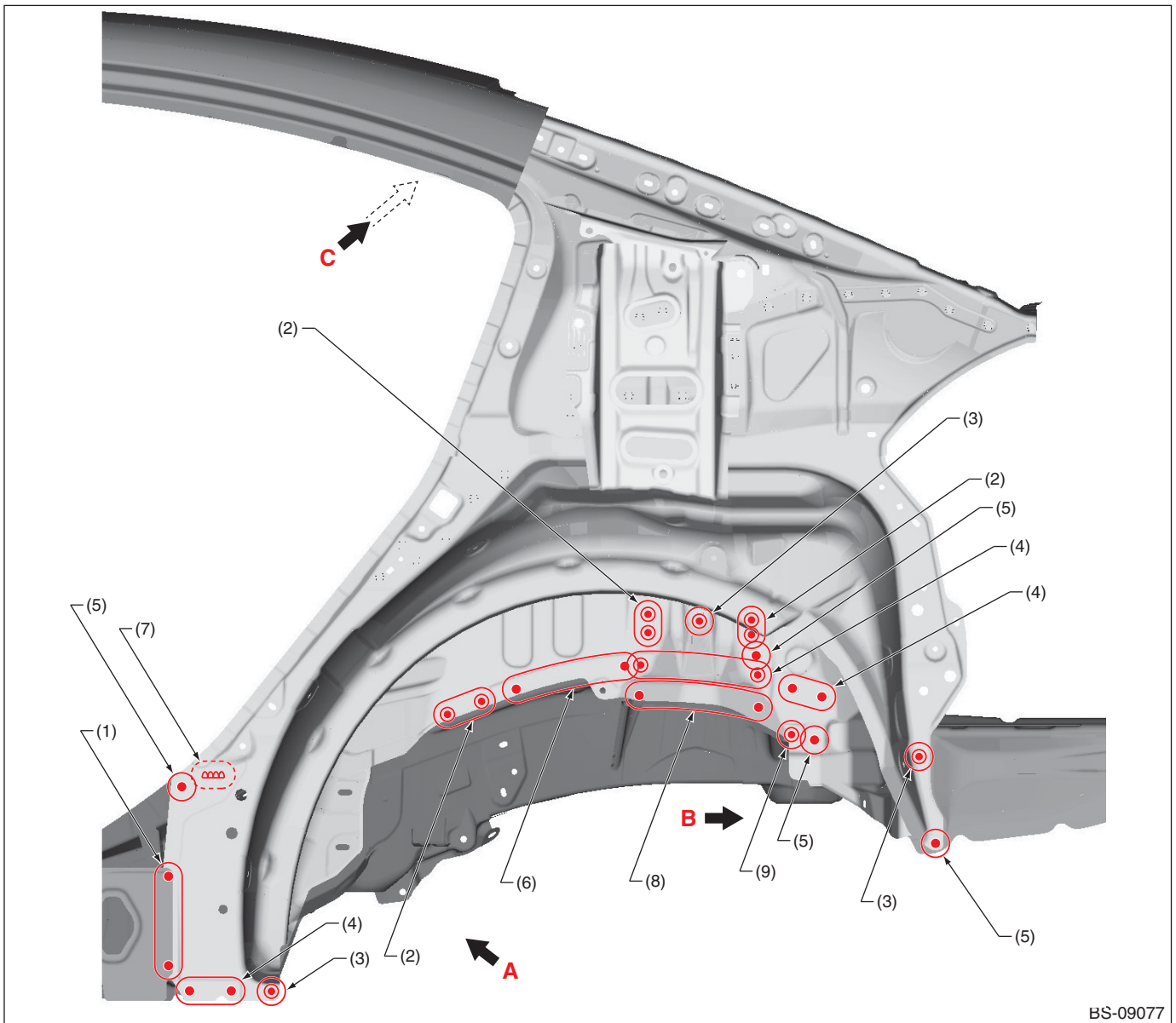
(5) 3 points
(6) 3 points (service)

Panel Replacement

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

A: REMOVAL

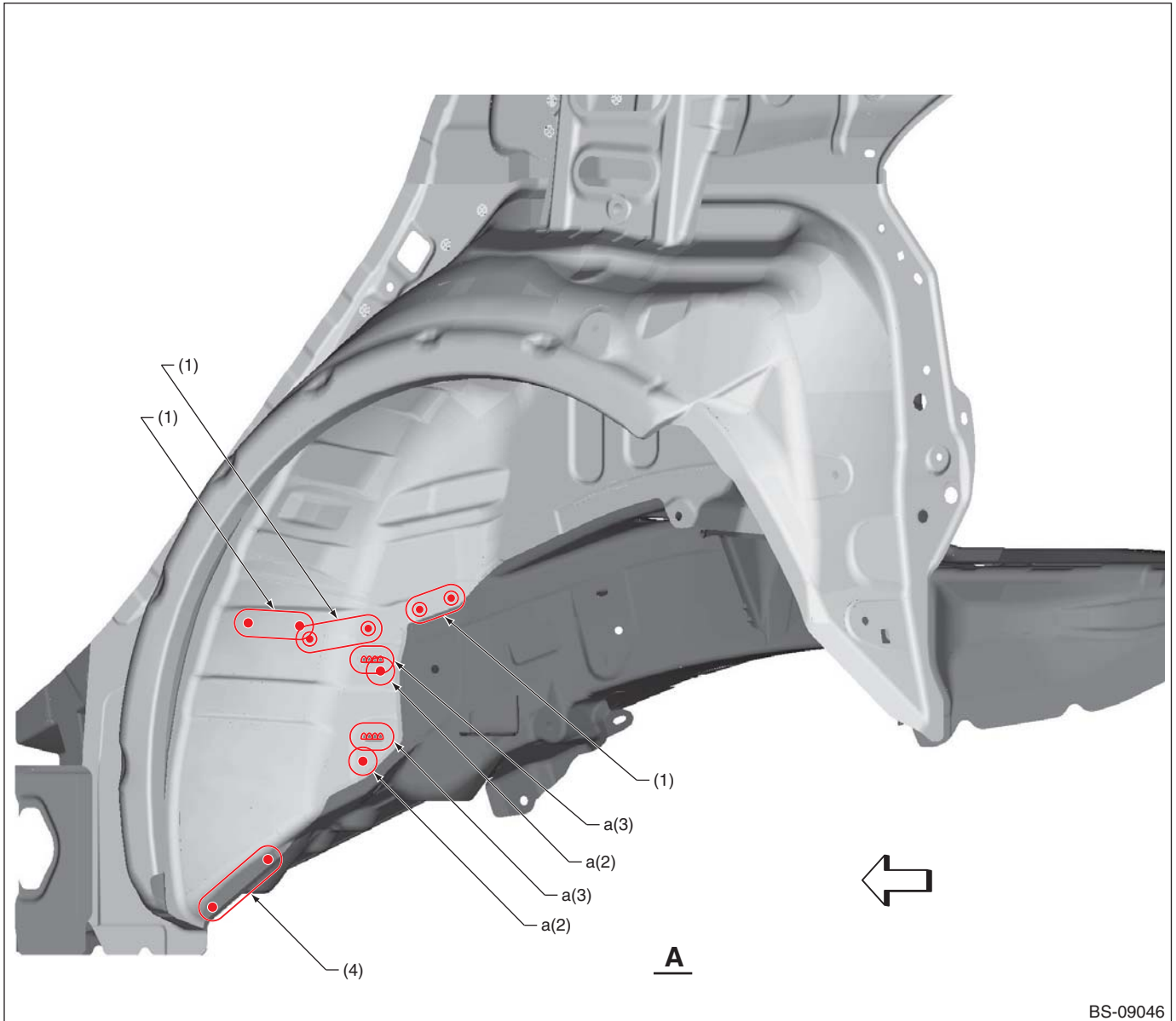
• Overall view



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

Panel Replacement

• Views A



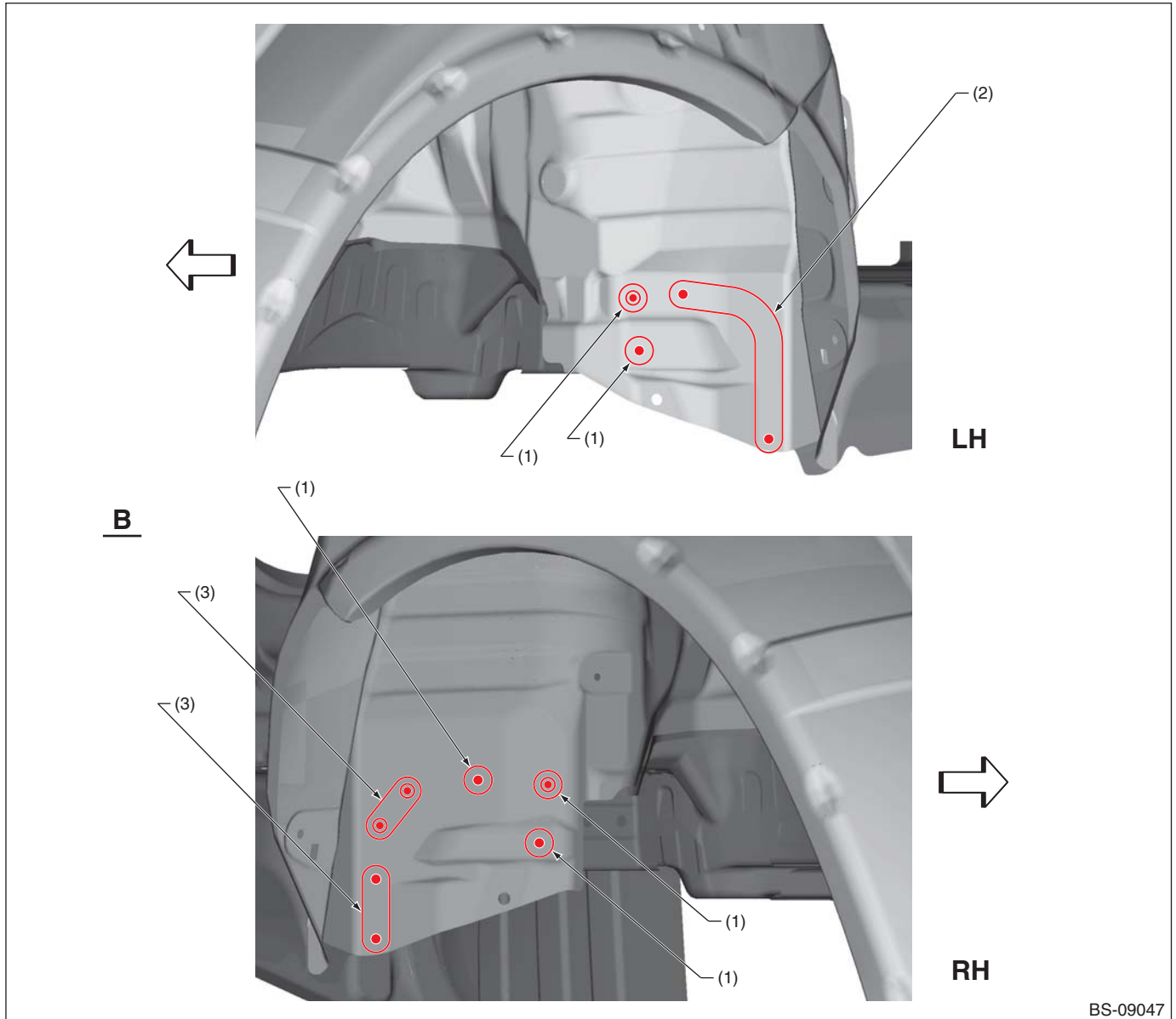
BS-09046

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

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

Panel Replacement

• Views B



BS-09047

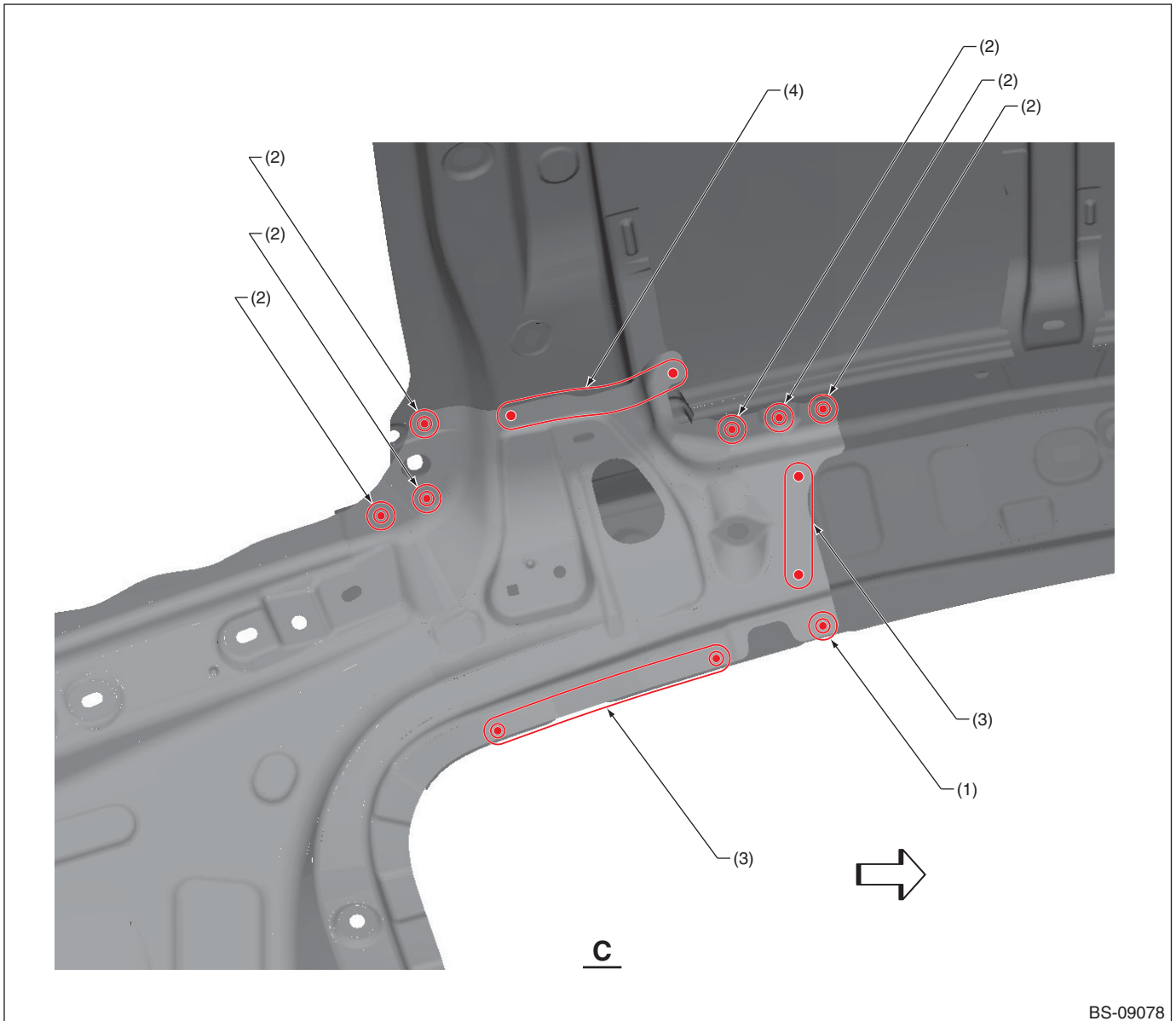
(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

(3) 2 points (outside · 1)

Panel Replacement

• Views C



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

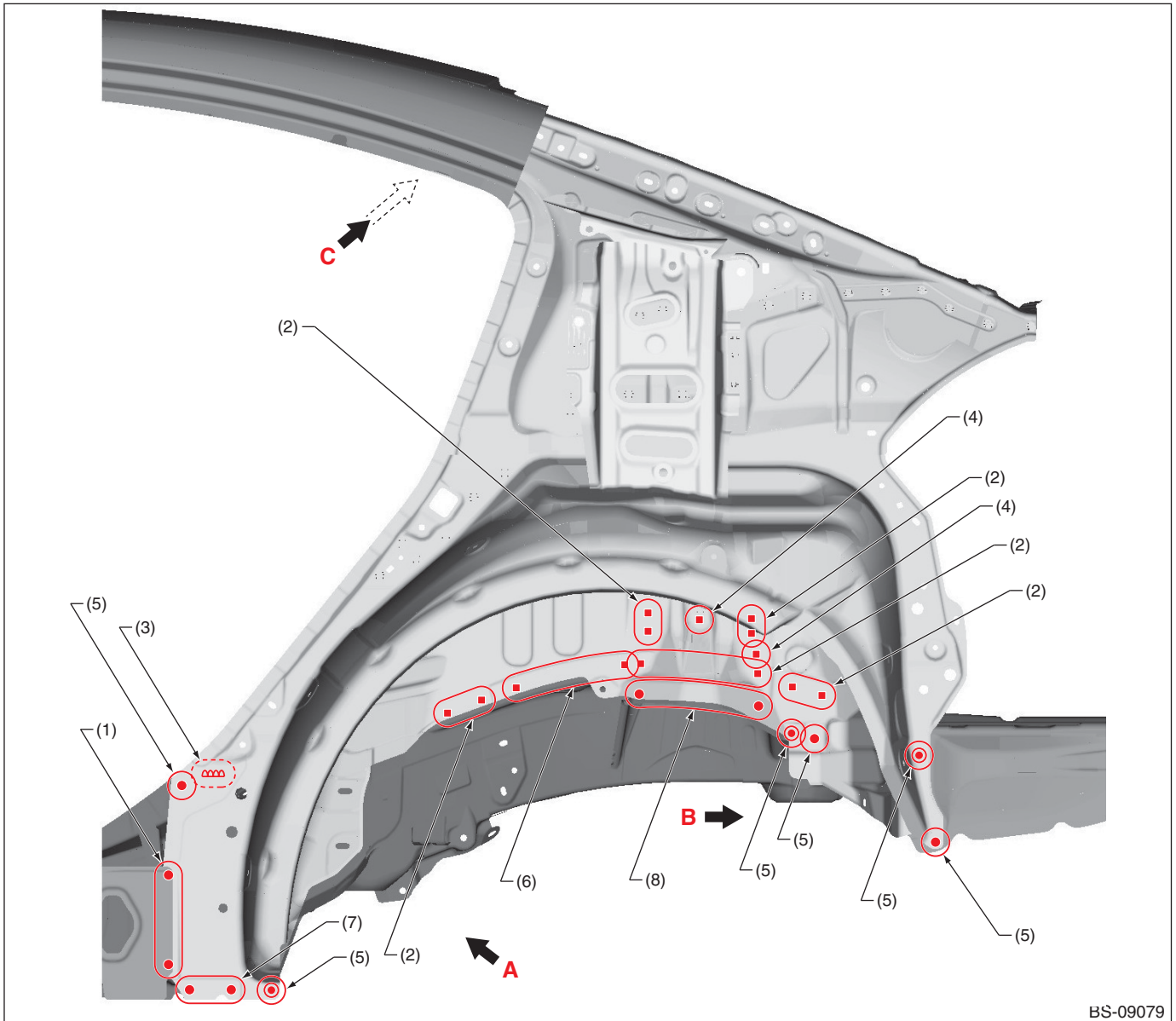
(3) 3 points (inside · 1)

(4) 4 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09079

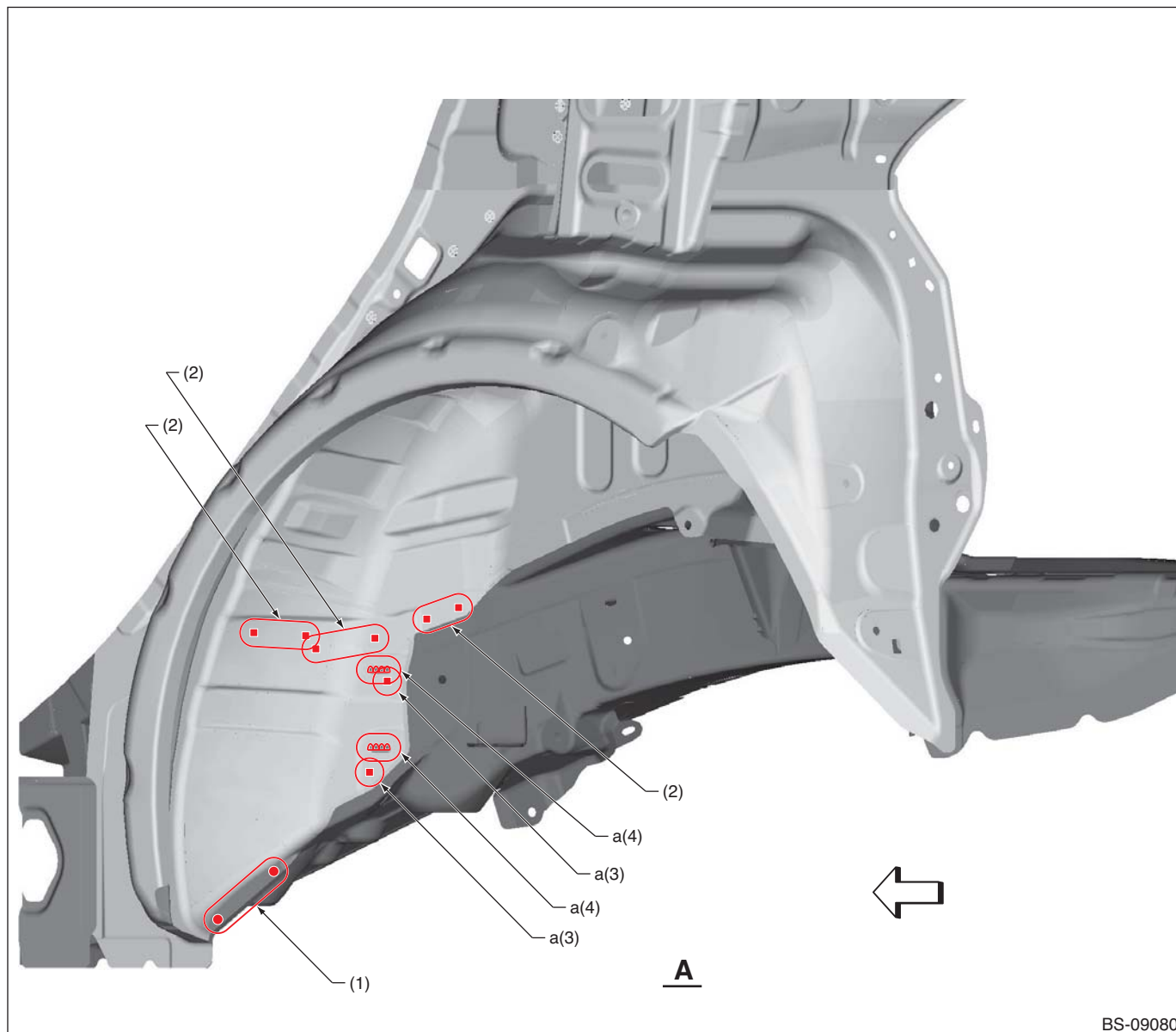
- (1) 3 points
- (2) 2 points (service)
- (3) 1 point (Continuous welding)
(30 mm [1.18 in])

- (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



(1) 2 points

(3) 1 point (service)

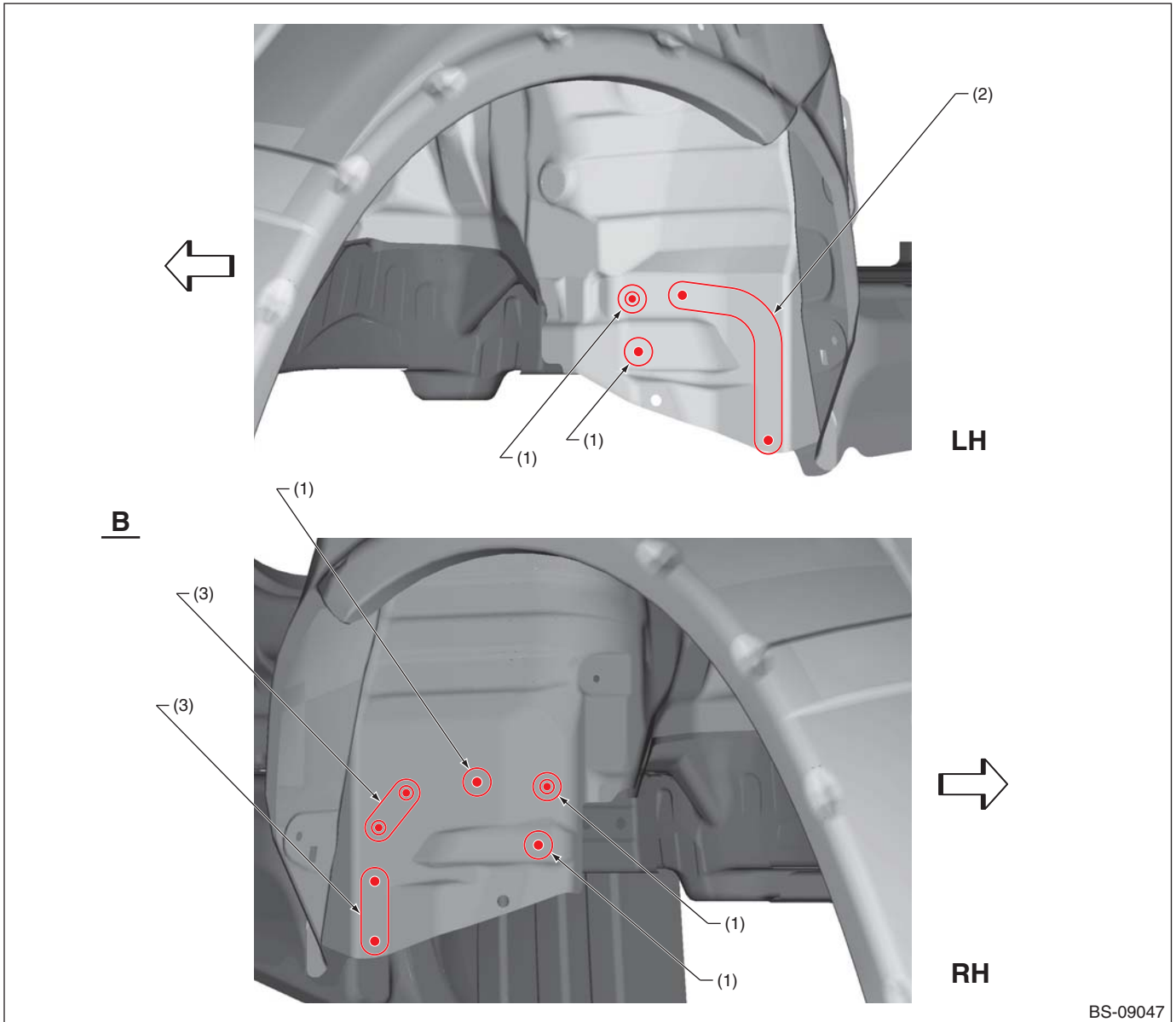
(4) 1 point (Continuous welding)
(5 mm [0.2 in])

(2) 2 points (service)

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

Panel Replacement

• Views B



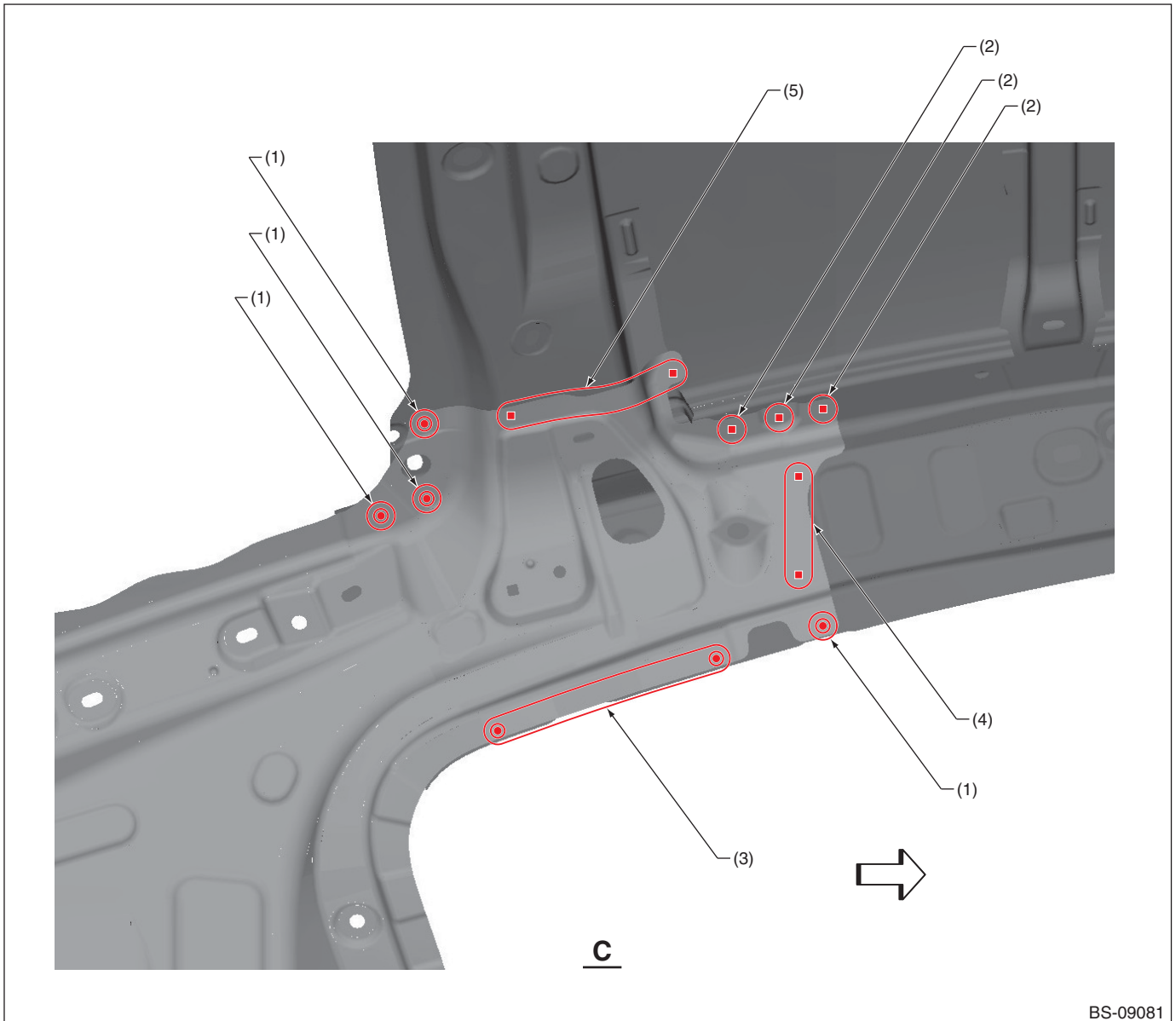
(1) 1 point

(2) 5 points

(3) 2 points

Panel Replacement

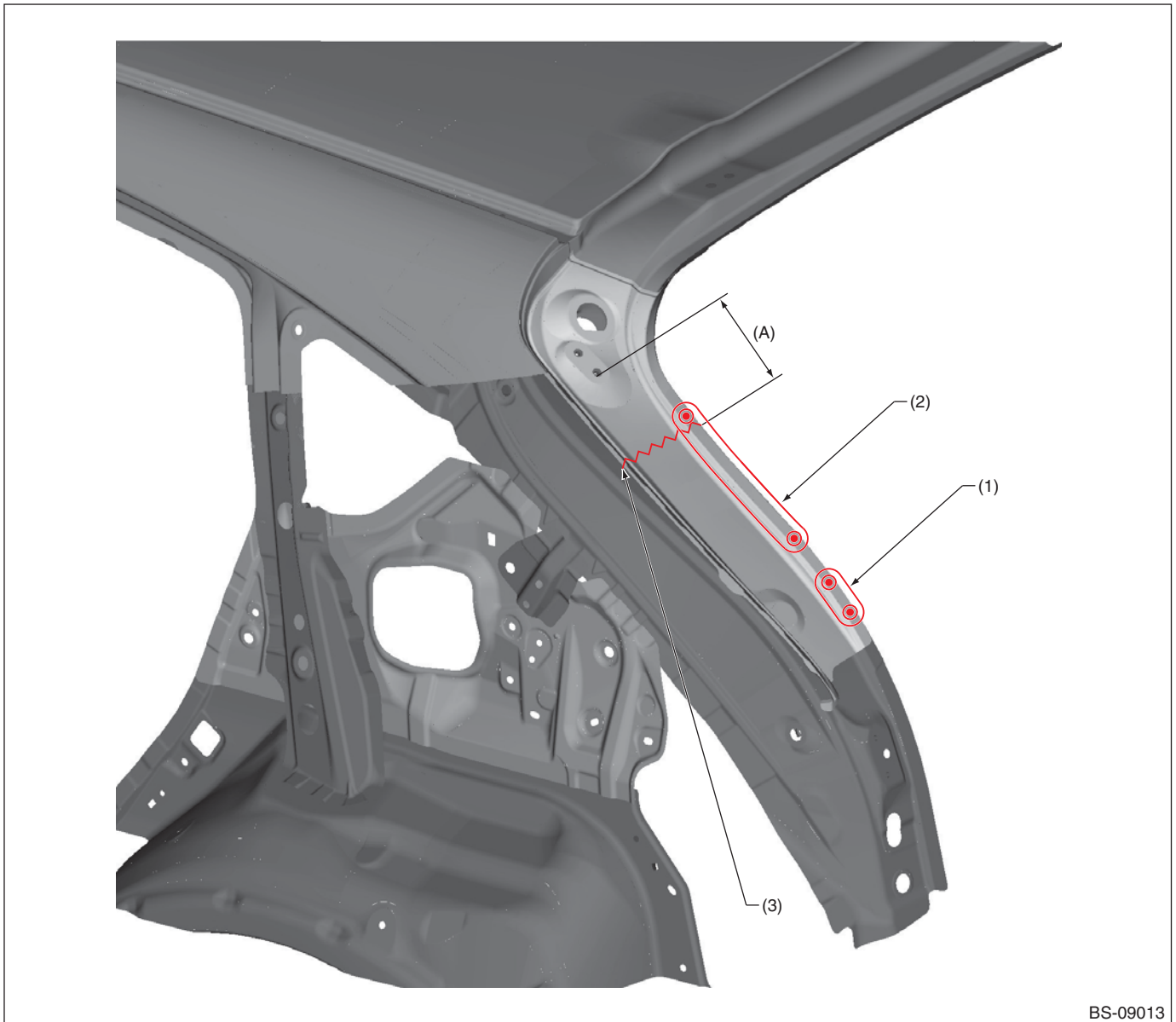
• Views C



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

A: REMOVAL

• Overall view



(A) 90 mm [3.54 in]

(1) 2 points (outside · 1)

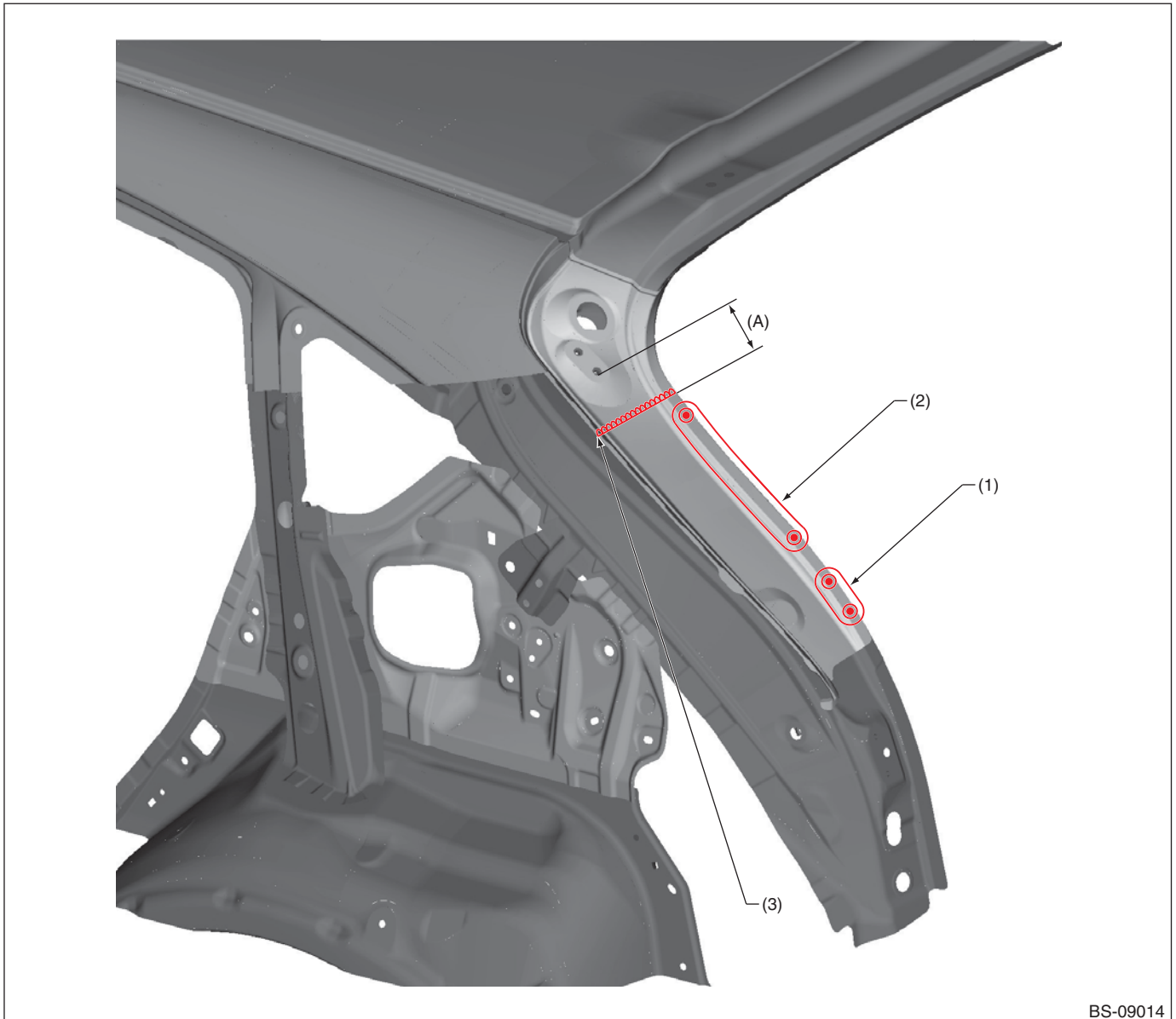
(2) LH: 5 points (outside · 1)
RH: 4 points (outside · 1)

(3) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BS-09014

(A) 70 mm [2.76 in]

(1) 2 points

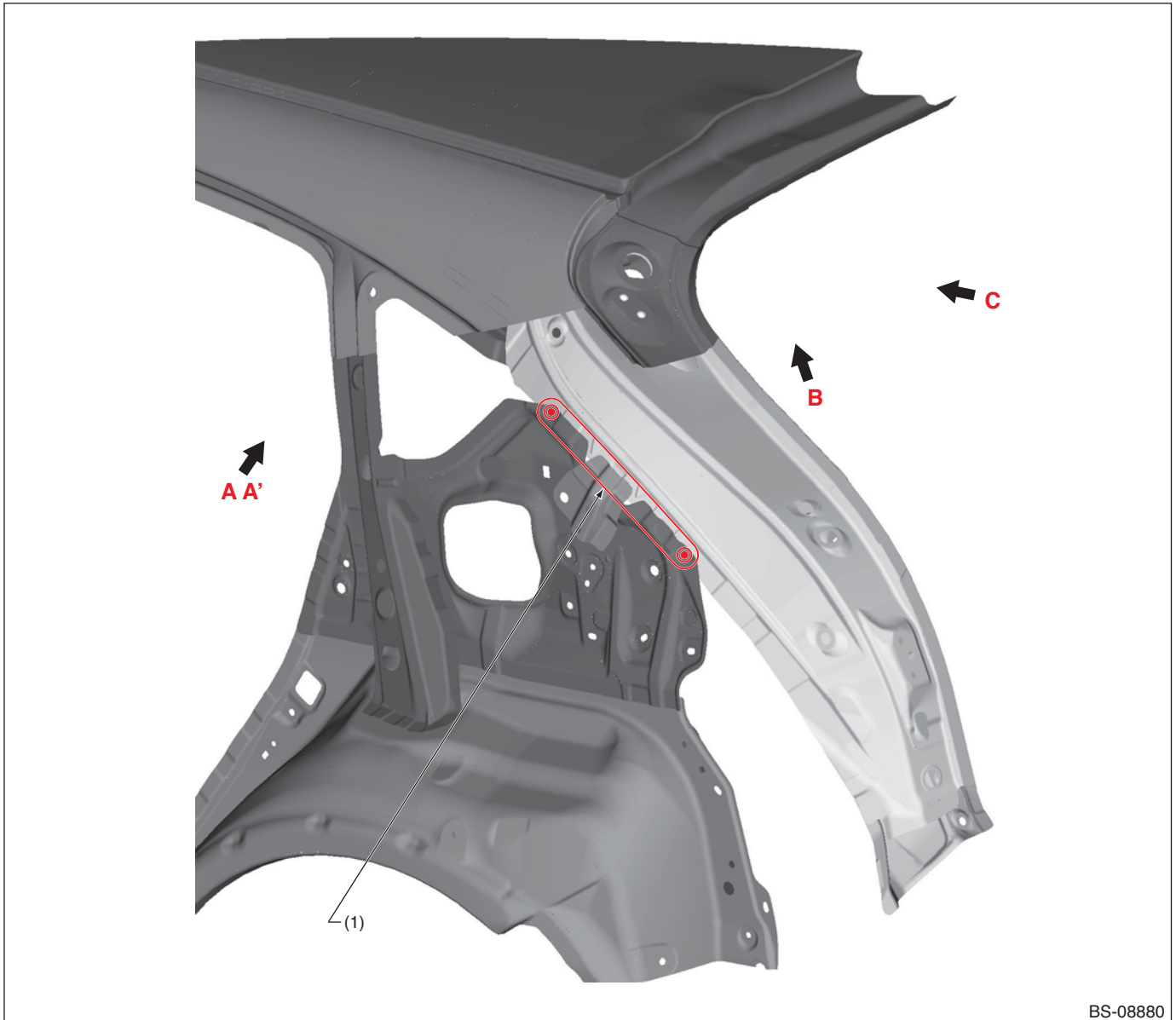
(2) LH: 5 points
RH: 4 points

(3) 1 point (Continuous welding)

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

A: REMOVAL

- Overall view

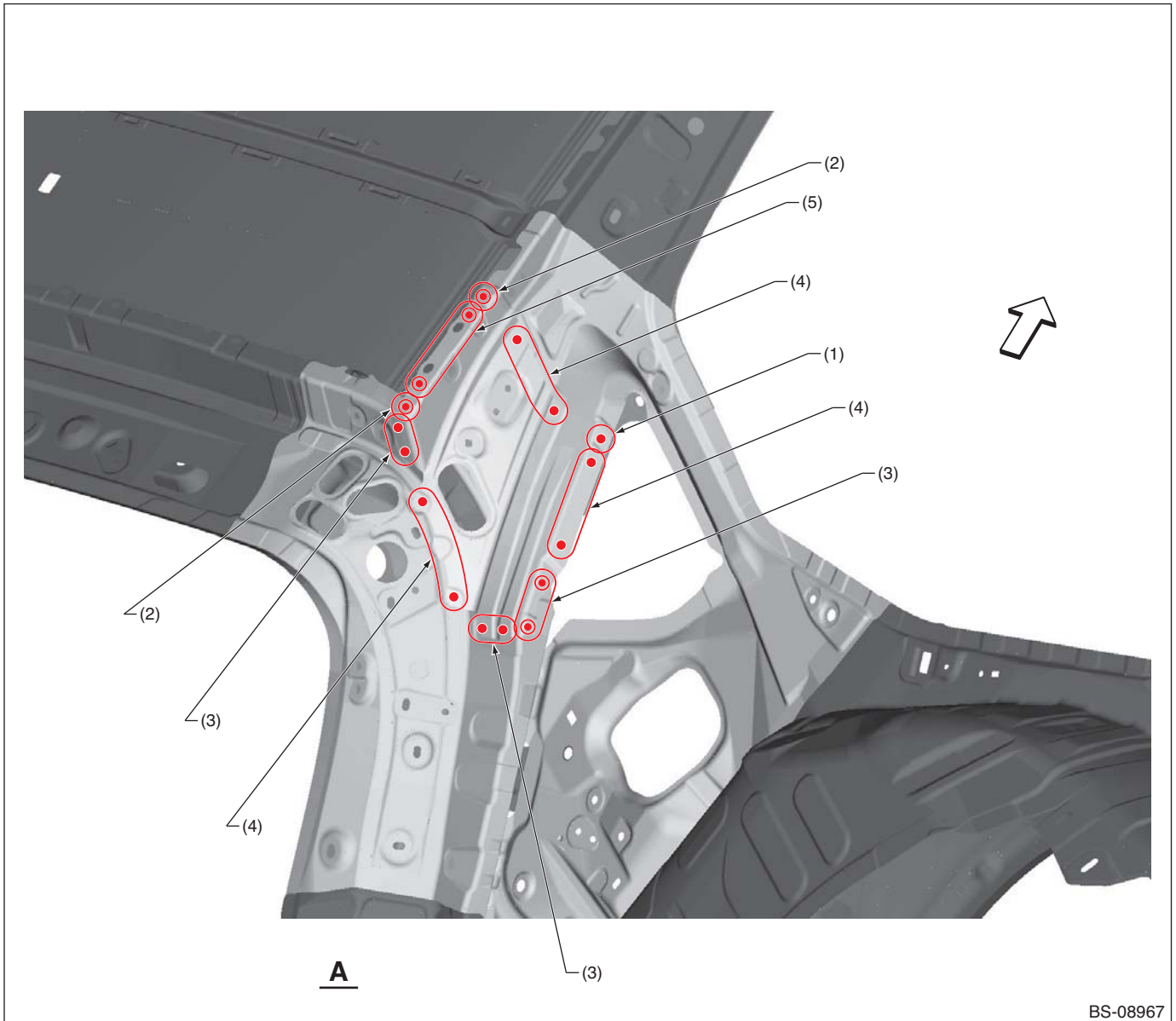


BS-08880

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

Panel Replacement

• Views A



BS-08967

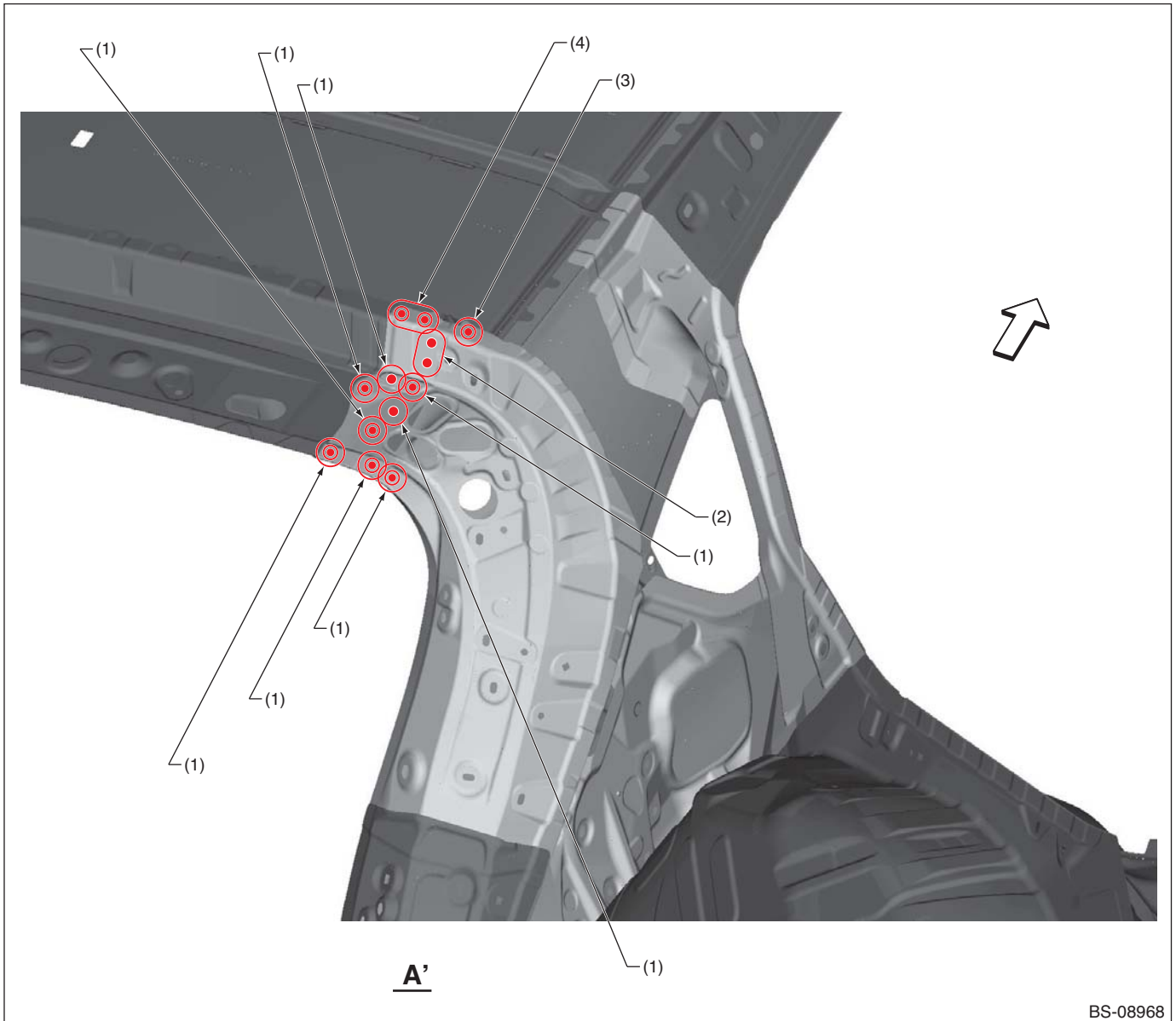
(1) 1 point (inside · 1)
(2) 1 point (bottom · 1)

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

(5) 3 points (bottom · 1)

Panel Replacement

• Views A'



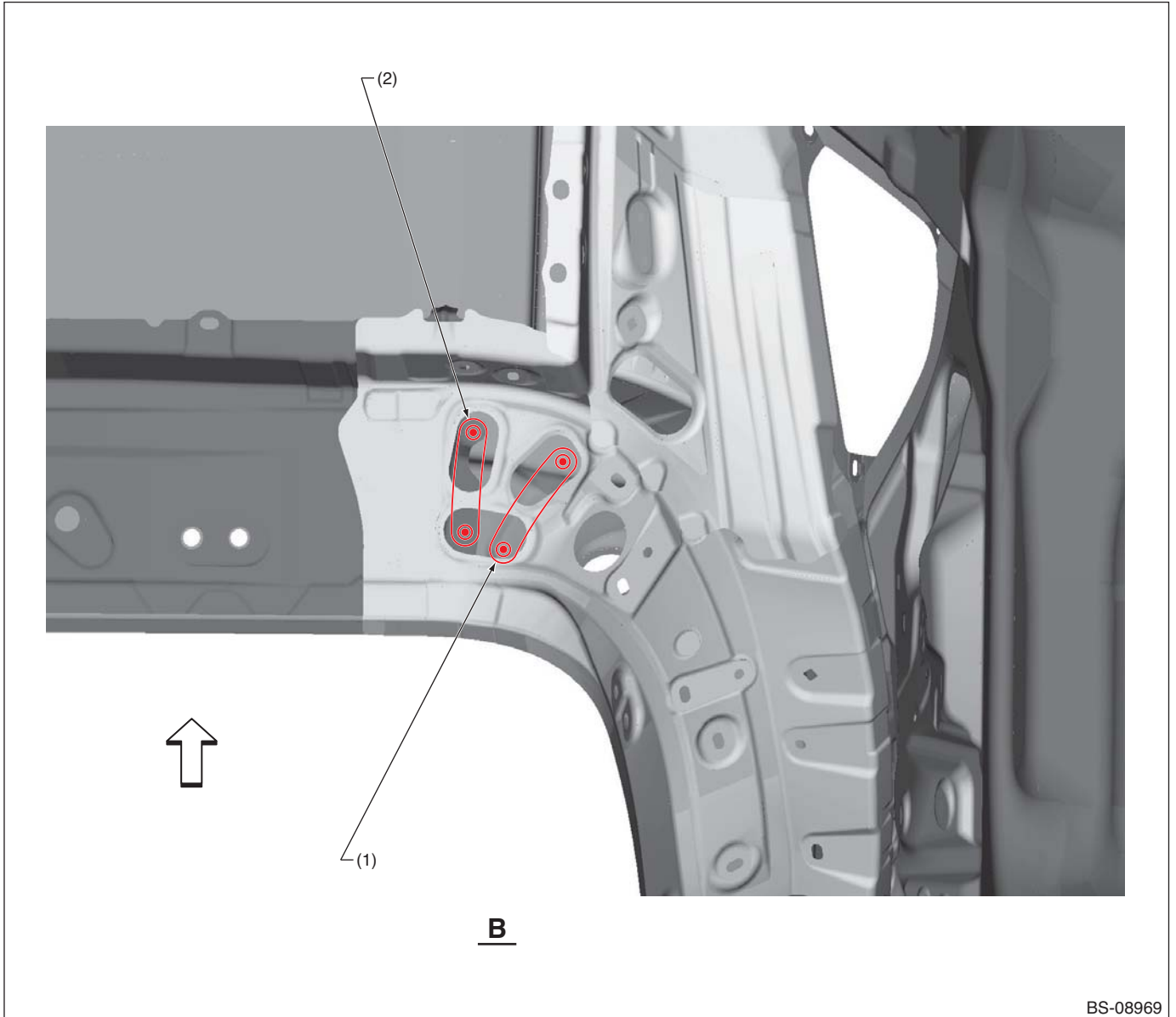
(1) 1 point (bottom · 1)
(2) 2 points (inside · 1)

(3) 1 point (bottom · 2)

(4) 2 points (bottom · 1)

Panel Replacement

• Views B



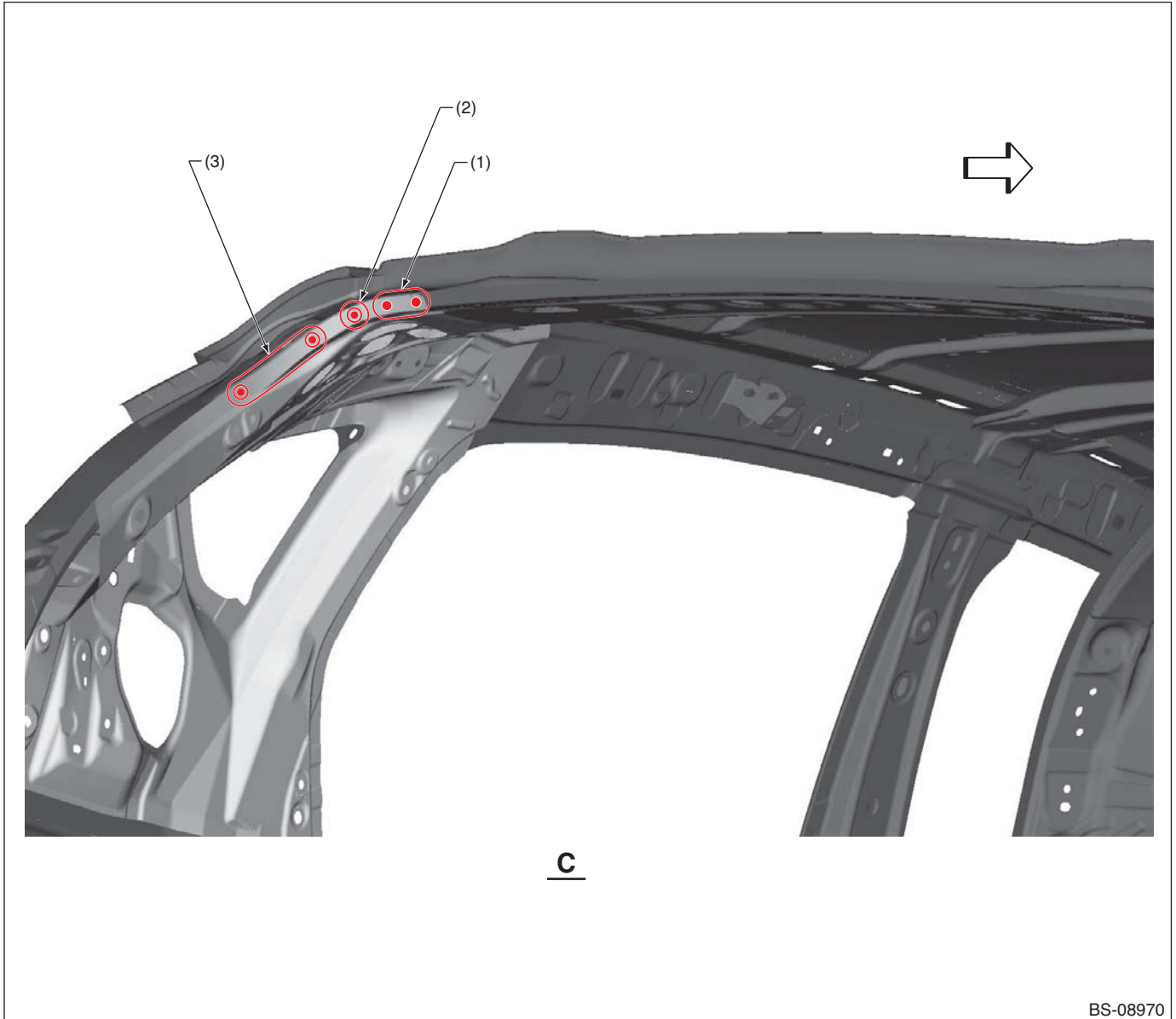
BS-08969

(1) 3 points (bottom · 1)

(2) 3 points (bottom · 2)

Panel Replacement

• Views C



(1) 3 points (outside · 1)

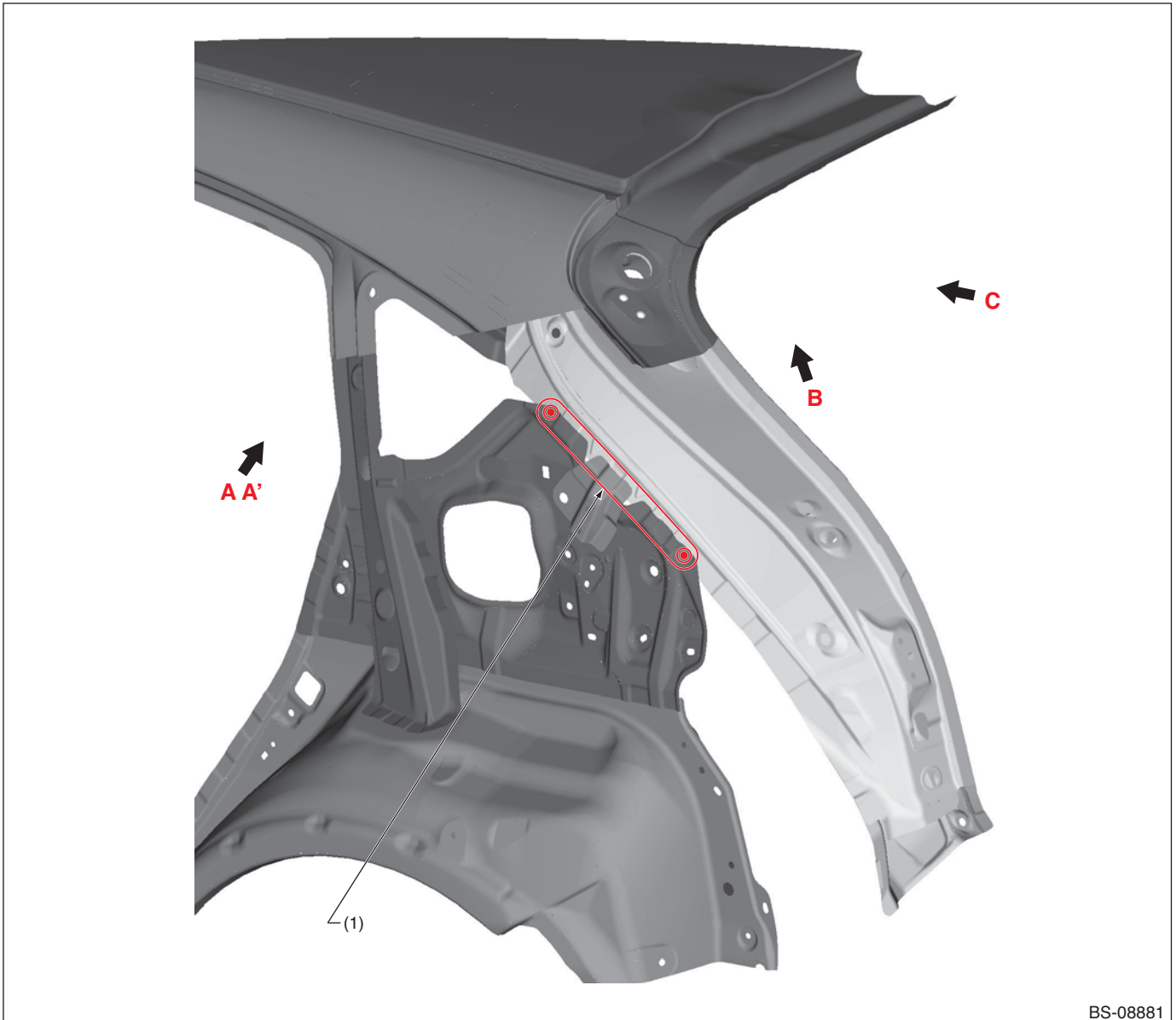
(2) 1 point (outside · 1)

(3) 3 points (inside · 2)

Panel Replacement

B: INSTALLATION

• Overall view

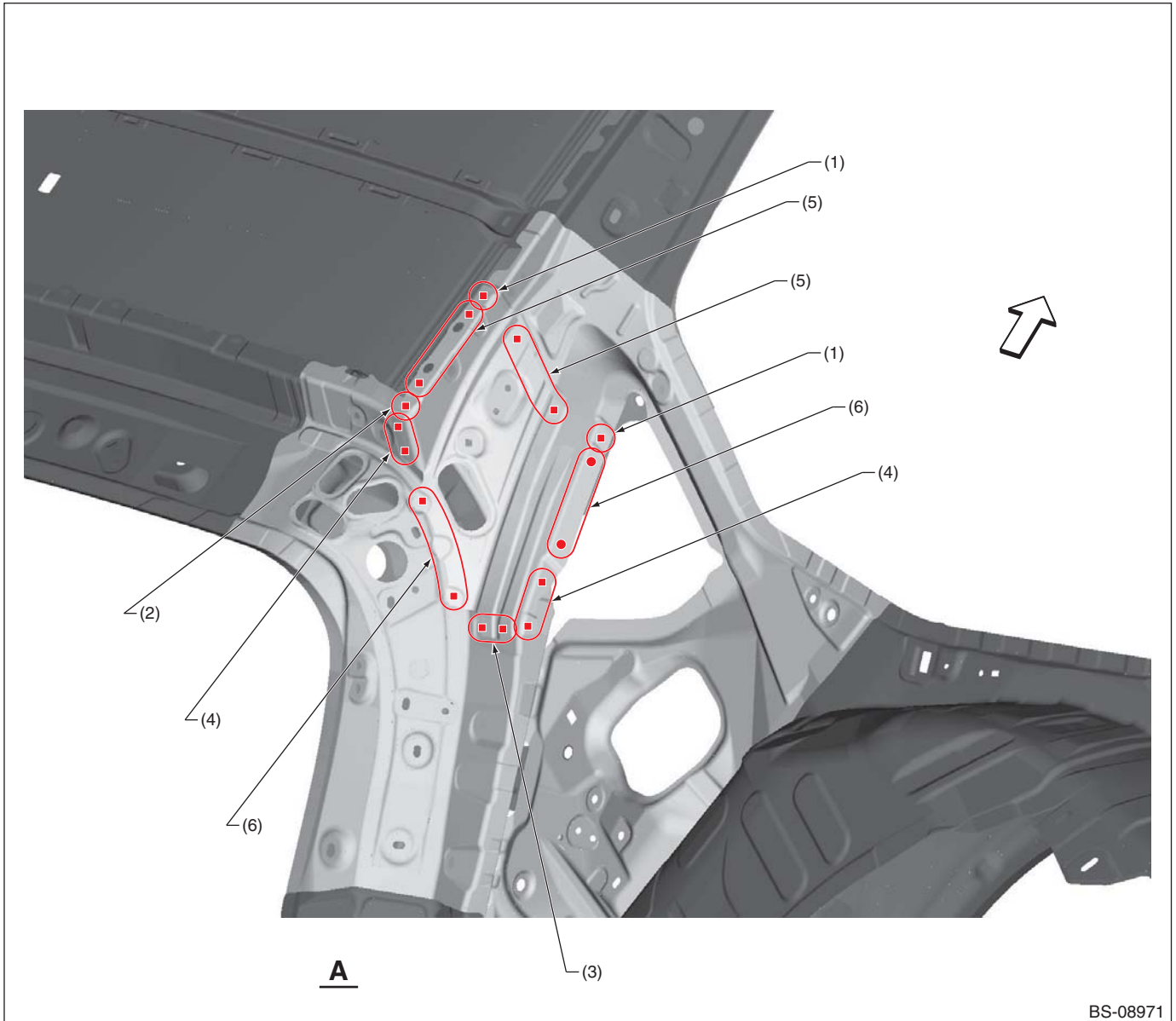


BS-08881

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

Panel Replacement

• Views A



BS-08971

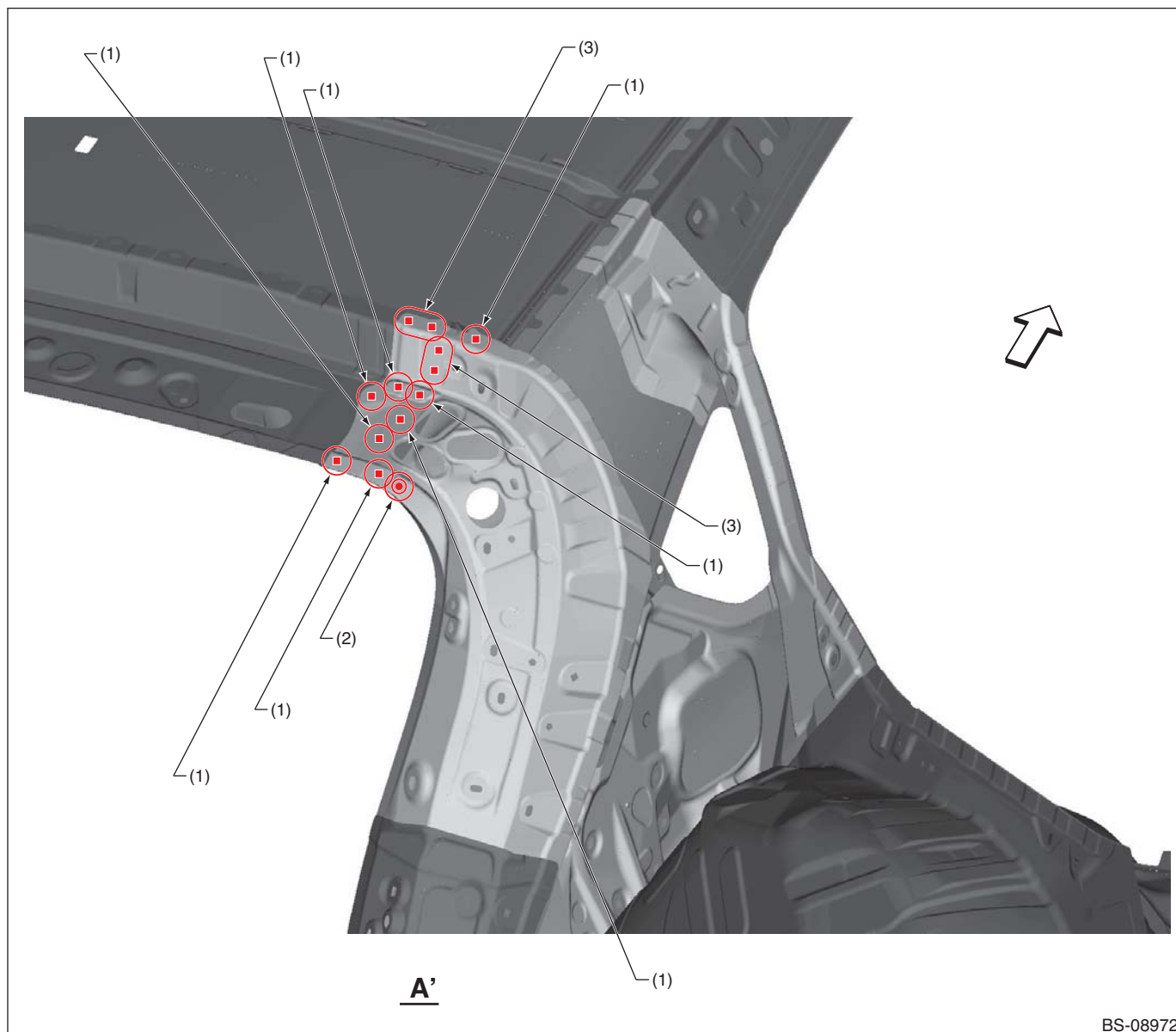
(1) 1 point (service)
(2) 1 point

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

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

Panel Replacement

• Views A'

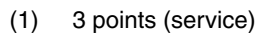


(1) 1 point (service)

(2) 1 point

(3) 2 points (service)

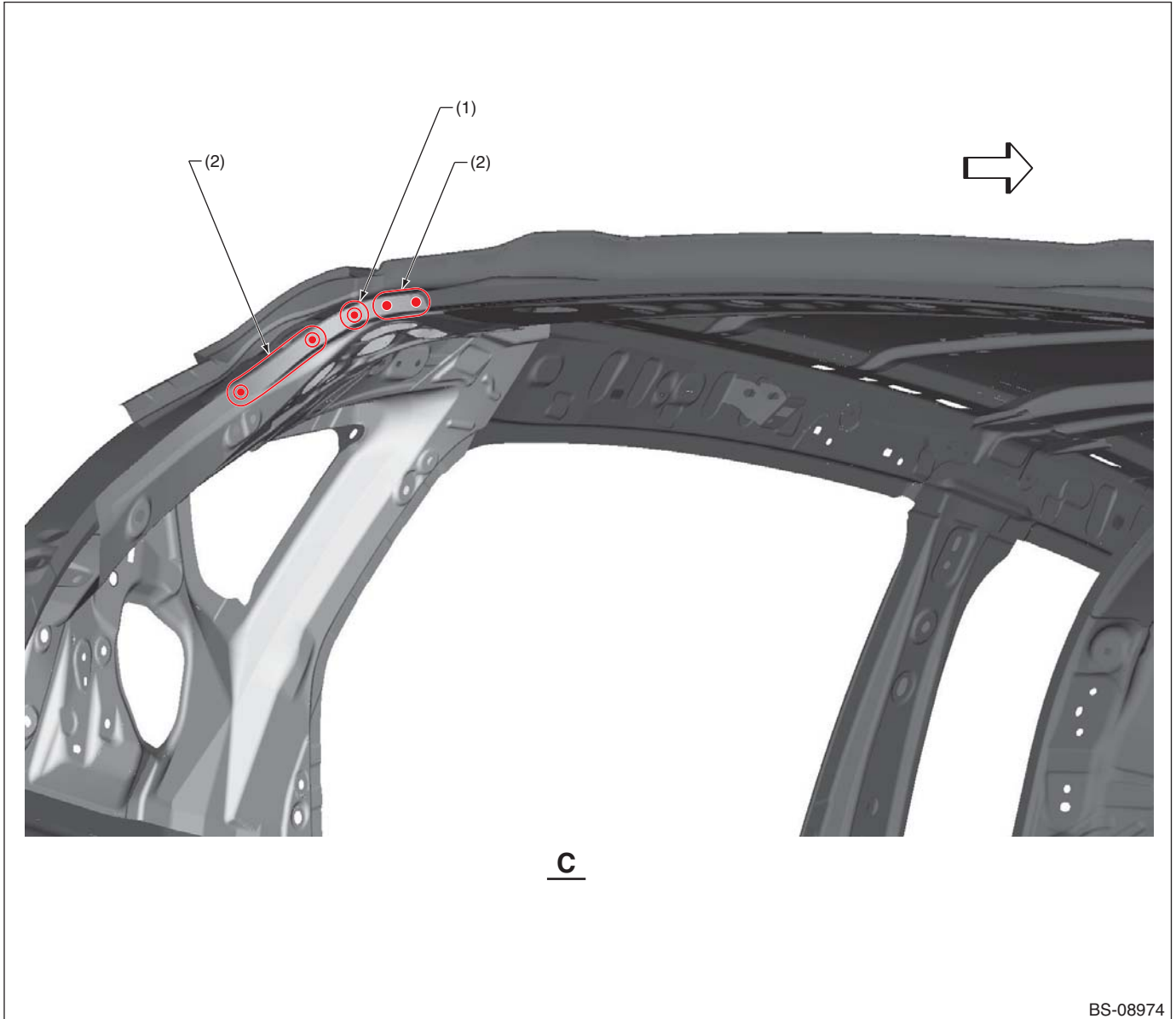
- **Views B**



(2) 3 points (service · matching)

Panel Replacement

• Views C



(1) 1 point

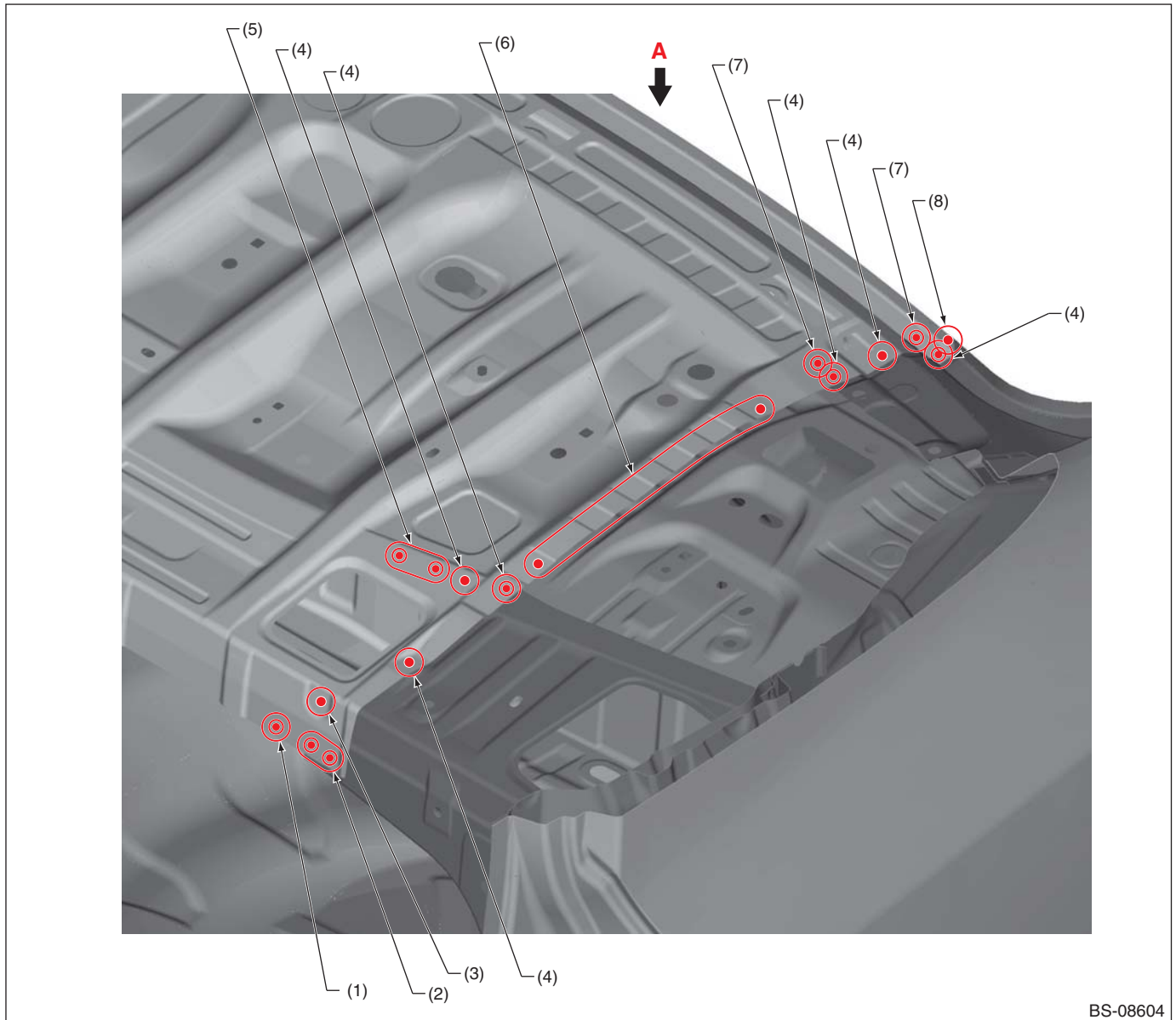
(2) 3 points

Panel Replacement

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

A: REMOVAL

• Overall view



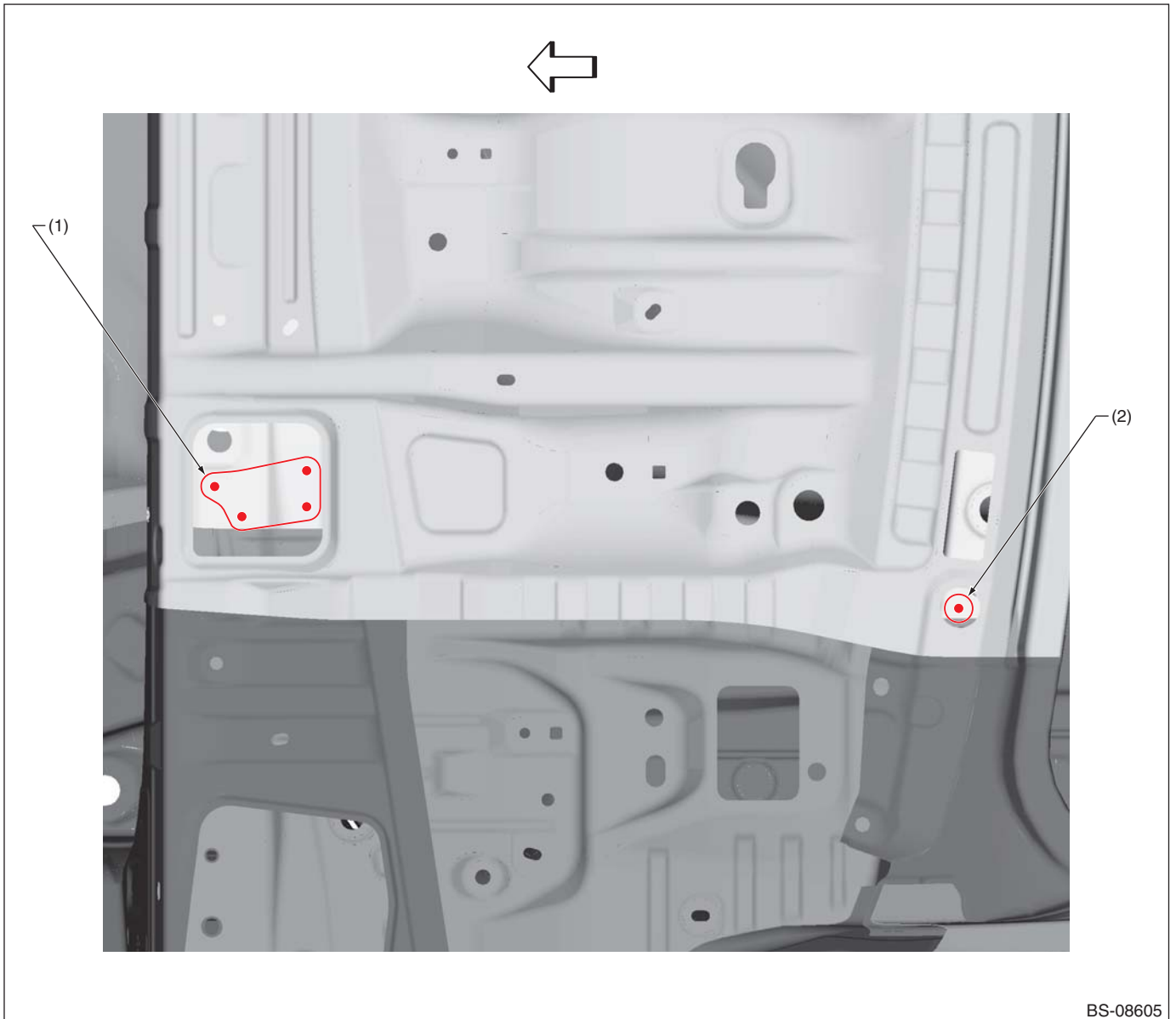
- (1) 1 point (inside · 2)
- (2) 2 points (inside · 1)
- (3) 1 point (inside · 1)

- (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



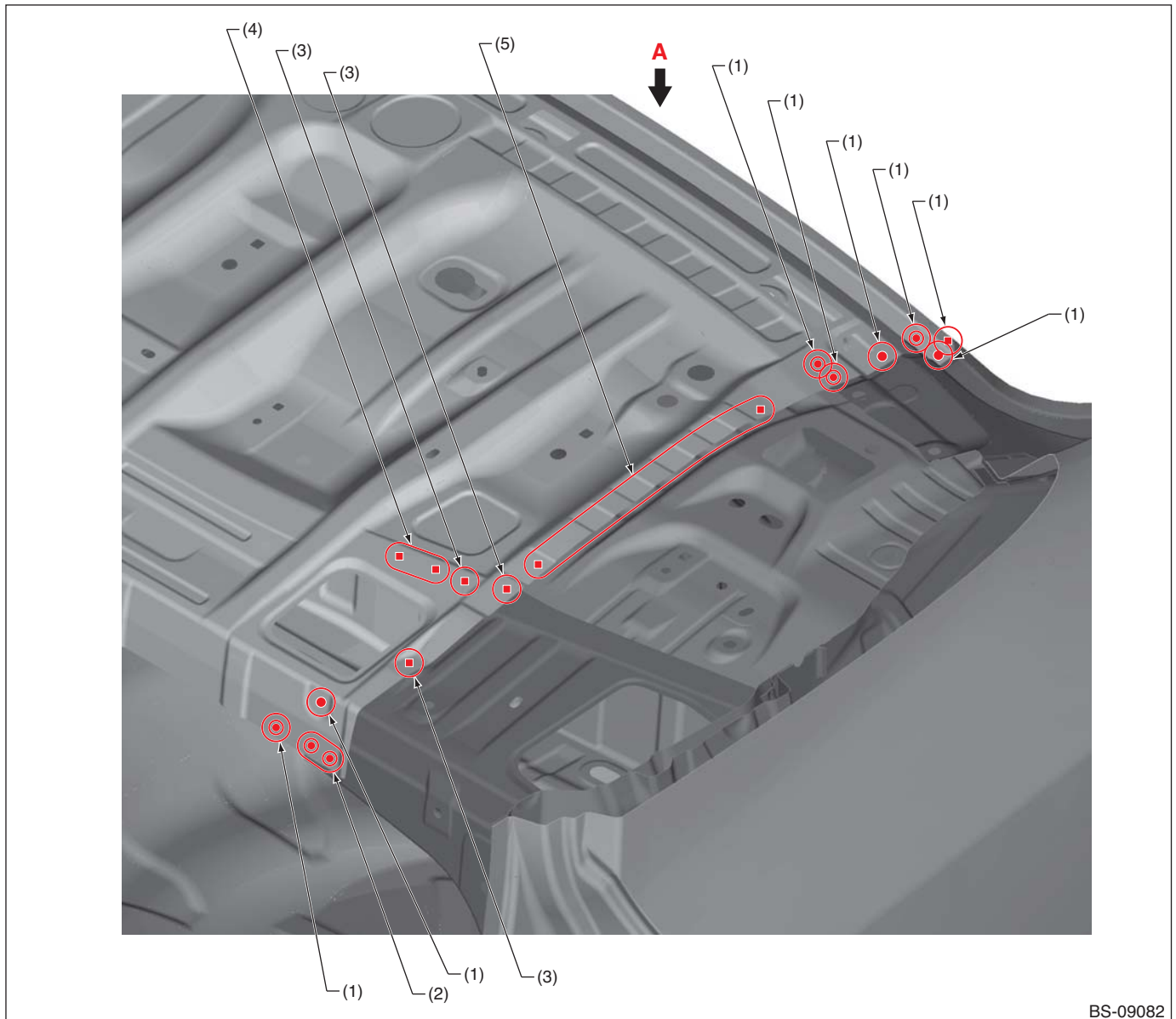
(1) 5 points (top · 1)

(2) 1 point (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



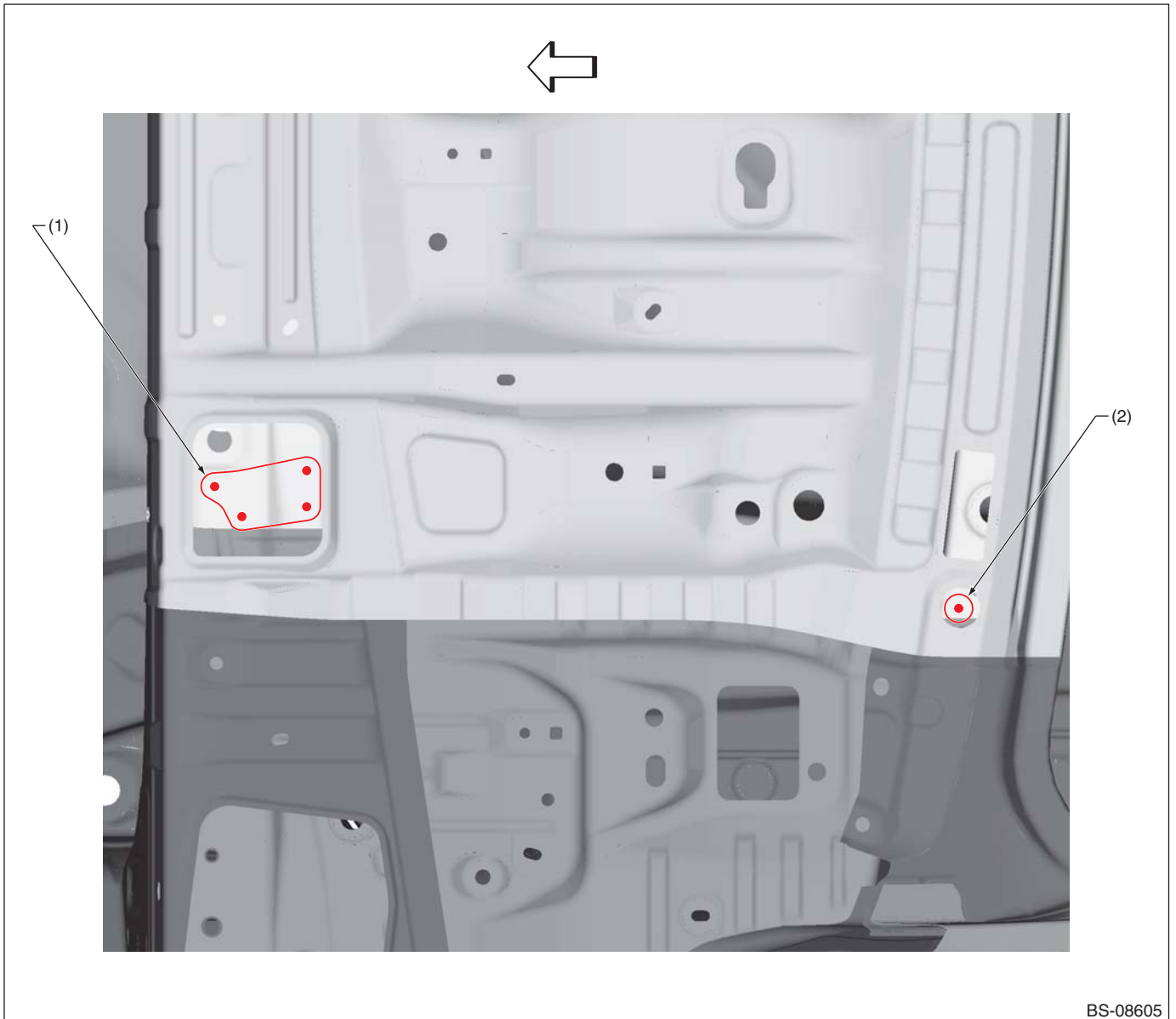
(1) 1 point
(2) 2 points

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

(5) 6 points (service)

Panel Replacement

• Views A



(1) 5 points

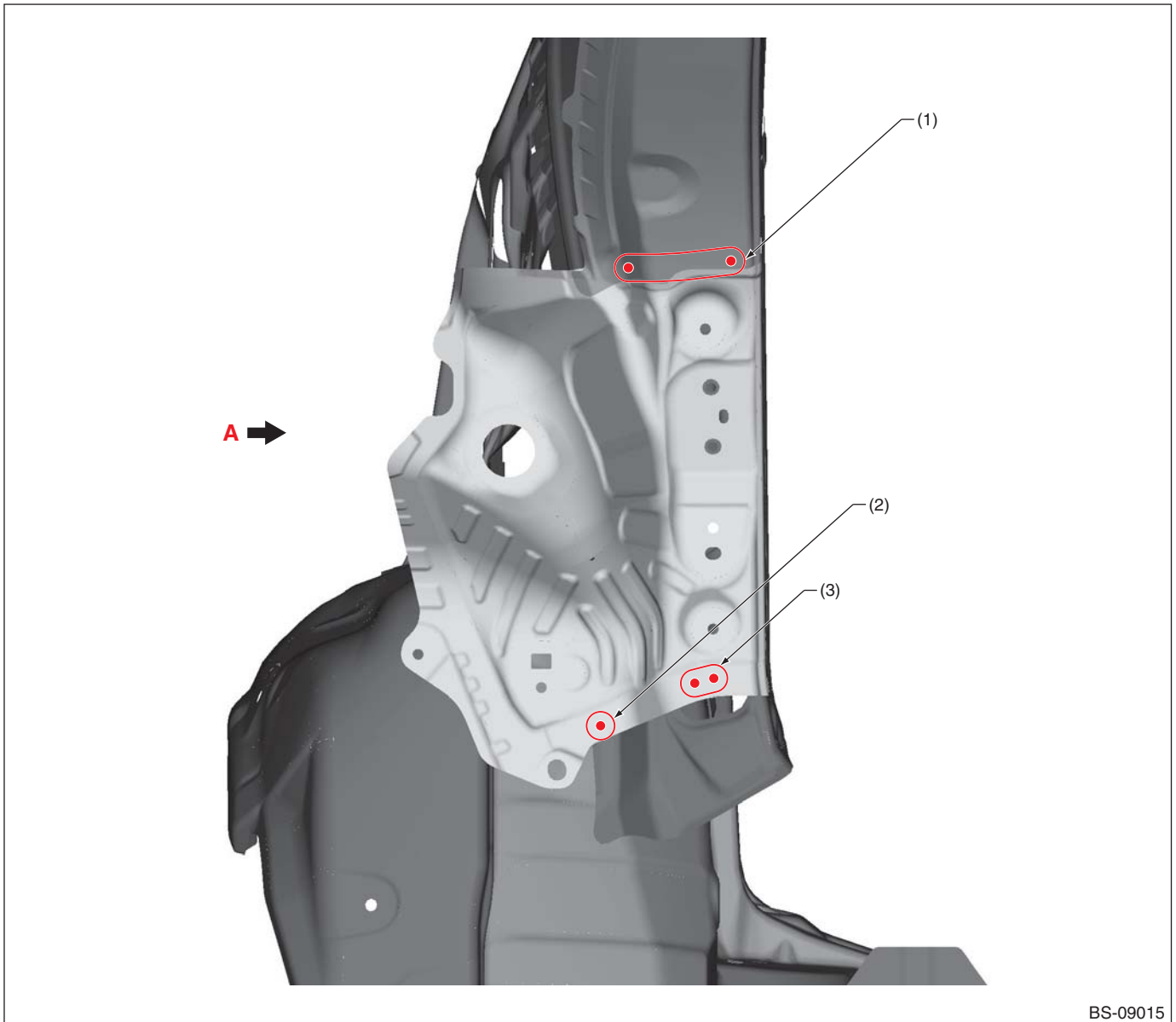
(2) 1 point

Panel Replacement

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

A: REMOVAL

- Overall view



BS-09015

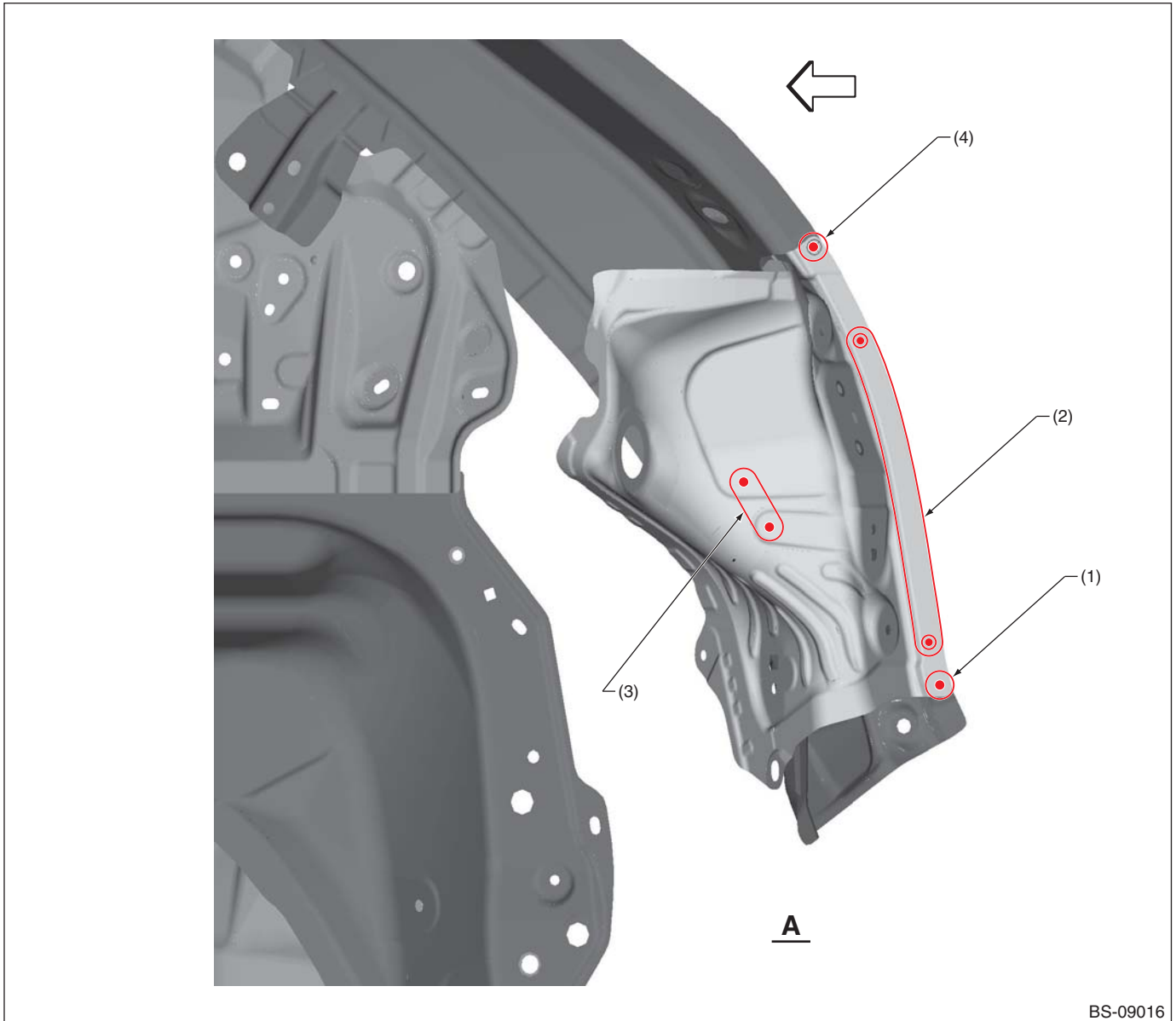
(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

(3) 2 points (outside · 1)

Panel Replacement

• Views A



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

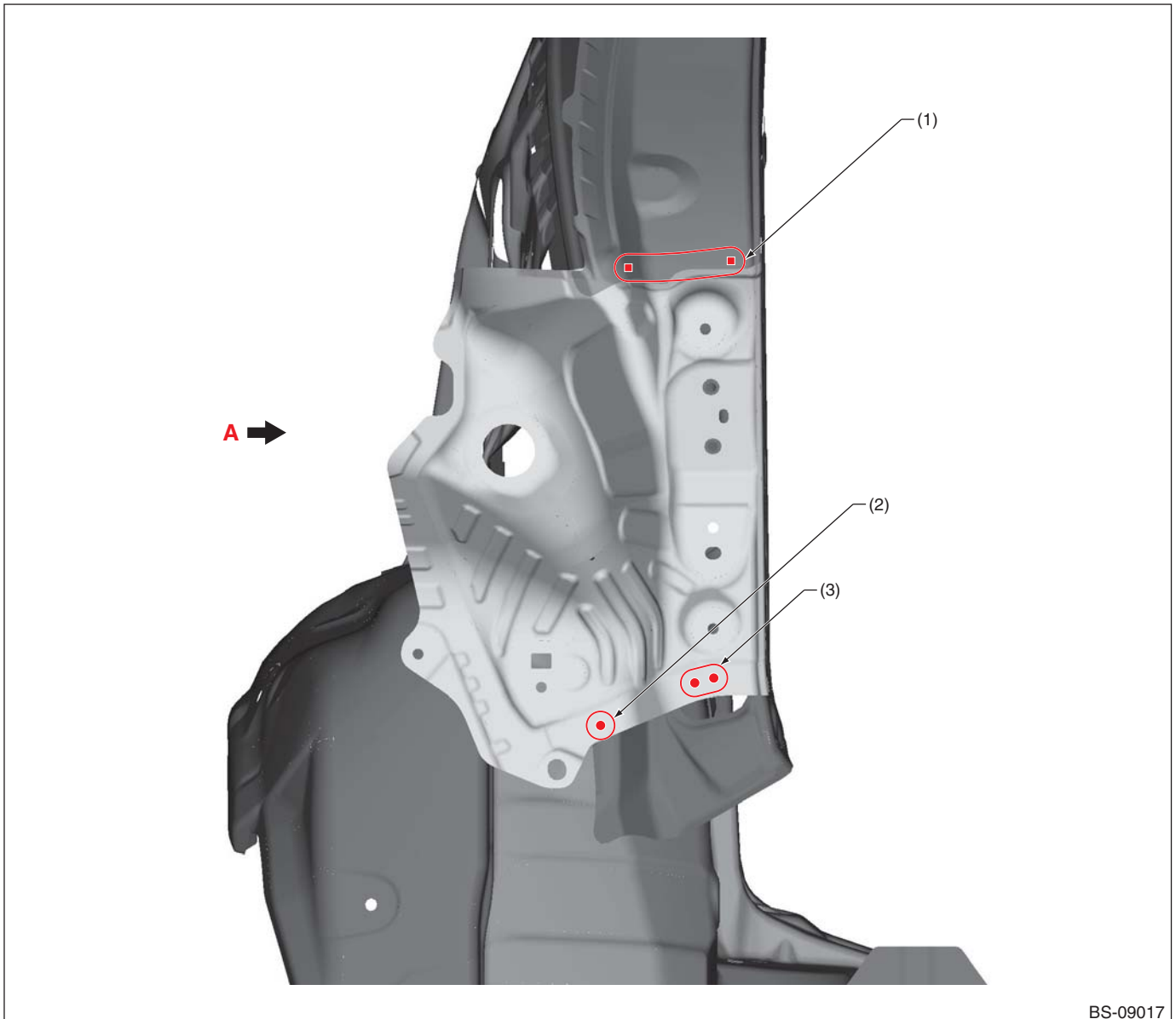
(3) 2 points (outside · 1)

(4) 1 point (outside · 1 belt sander)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09017

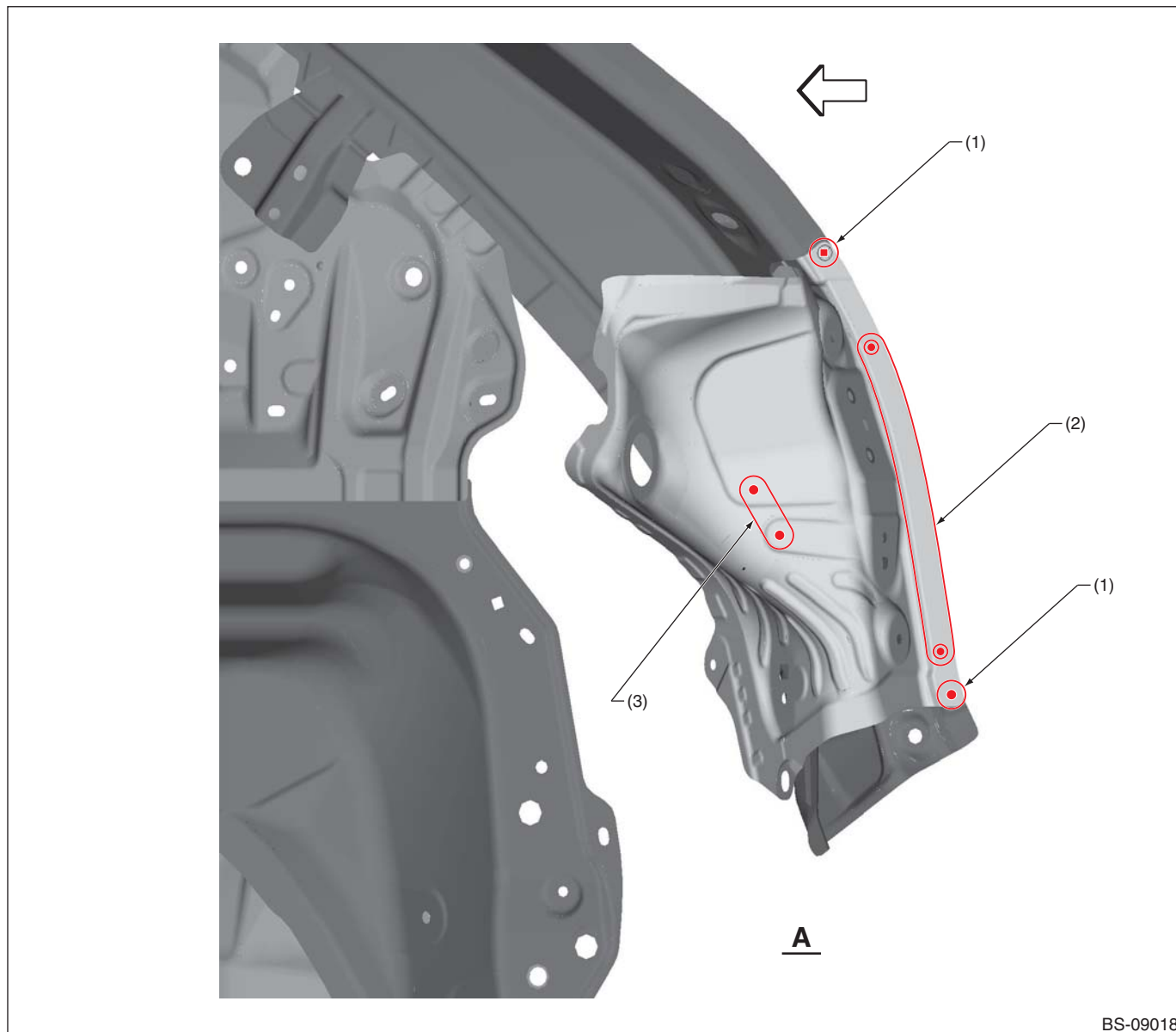
(1) 3 points

(2) 1 point

(3) 2 points

Panel Replacement

• Views A



(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

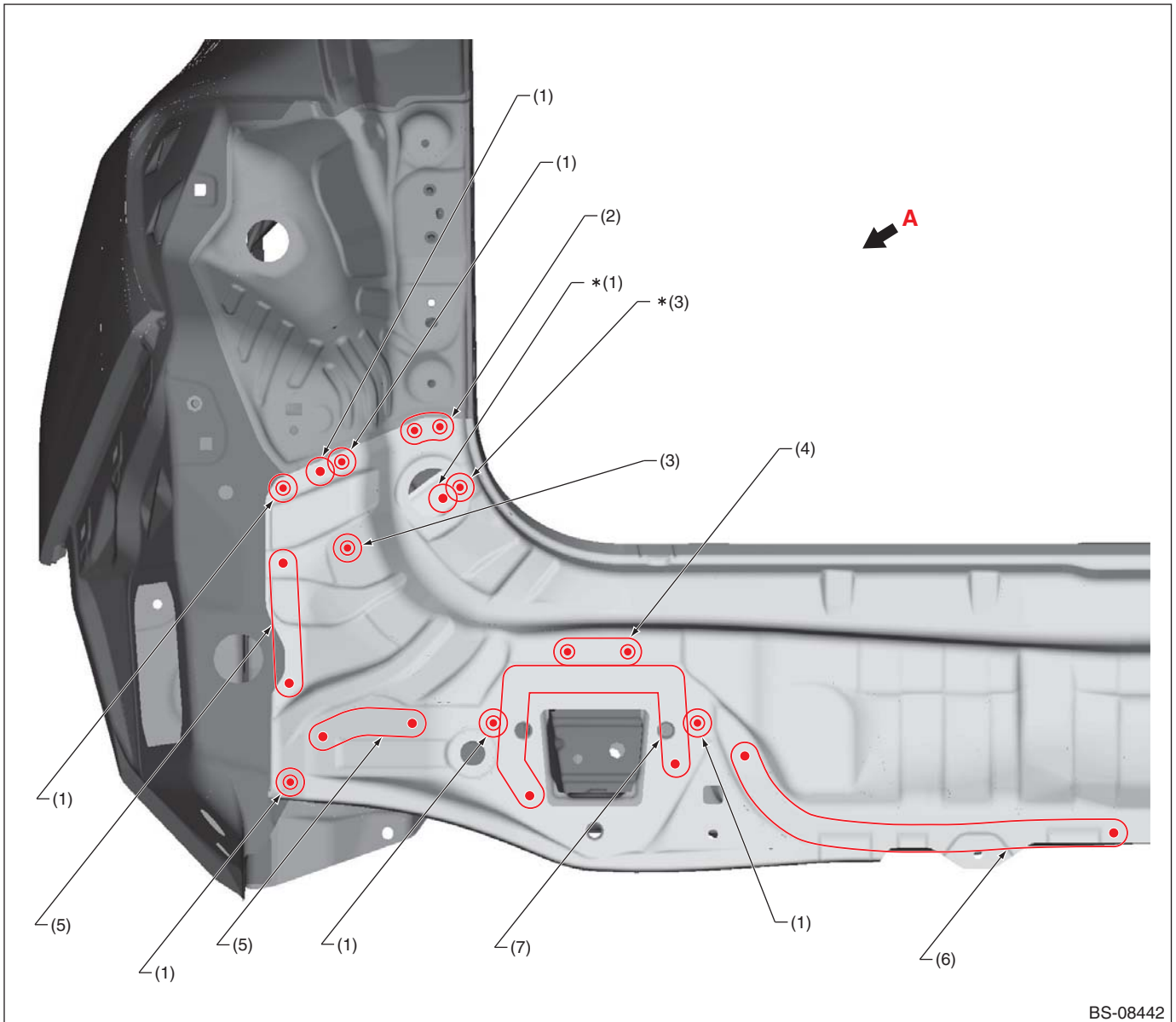
(2) 12 points

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)

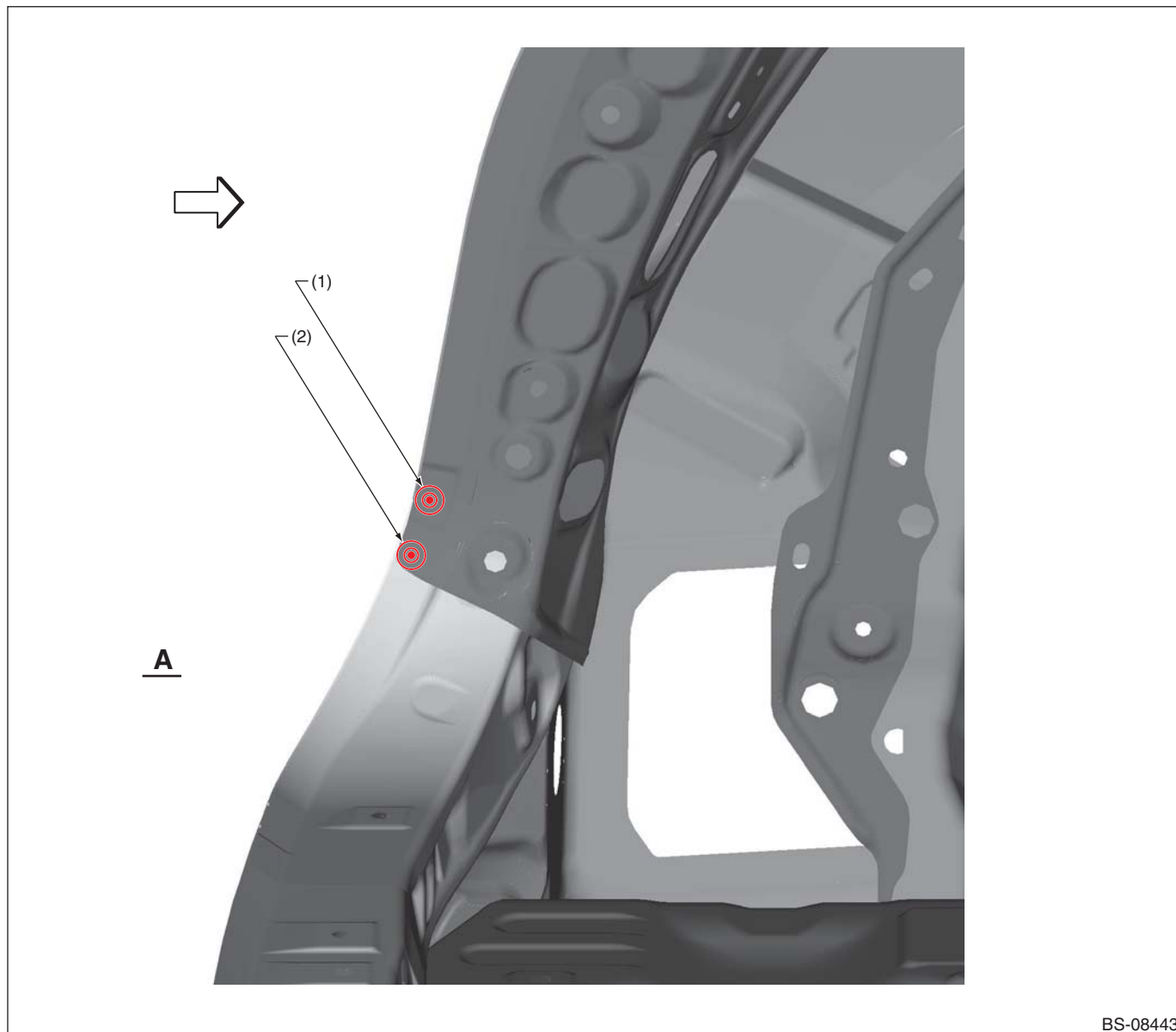
(6) 7 points (outside · 1)

(7) 5 points (outside · 1)

* : Spots are provided in the back.

Panel Replacement

• Views A



BS-08443

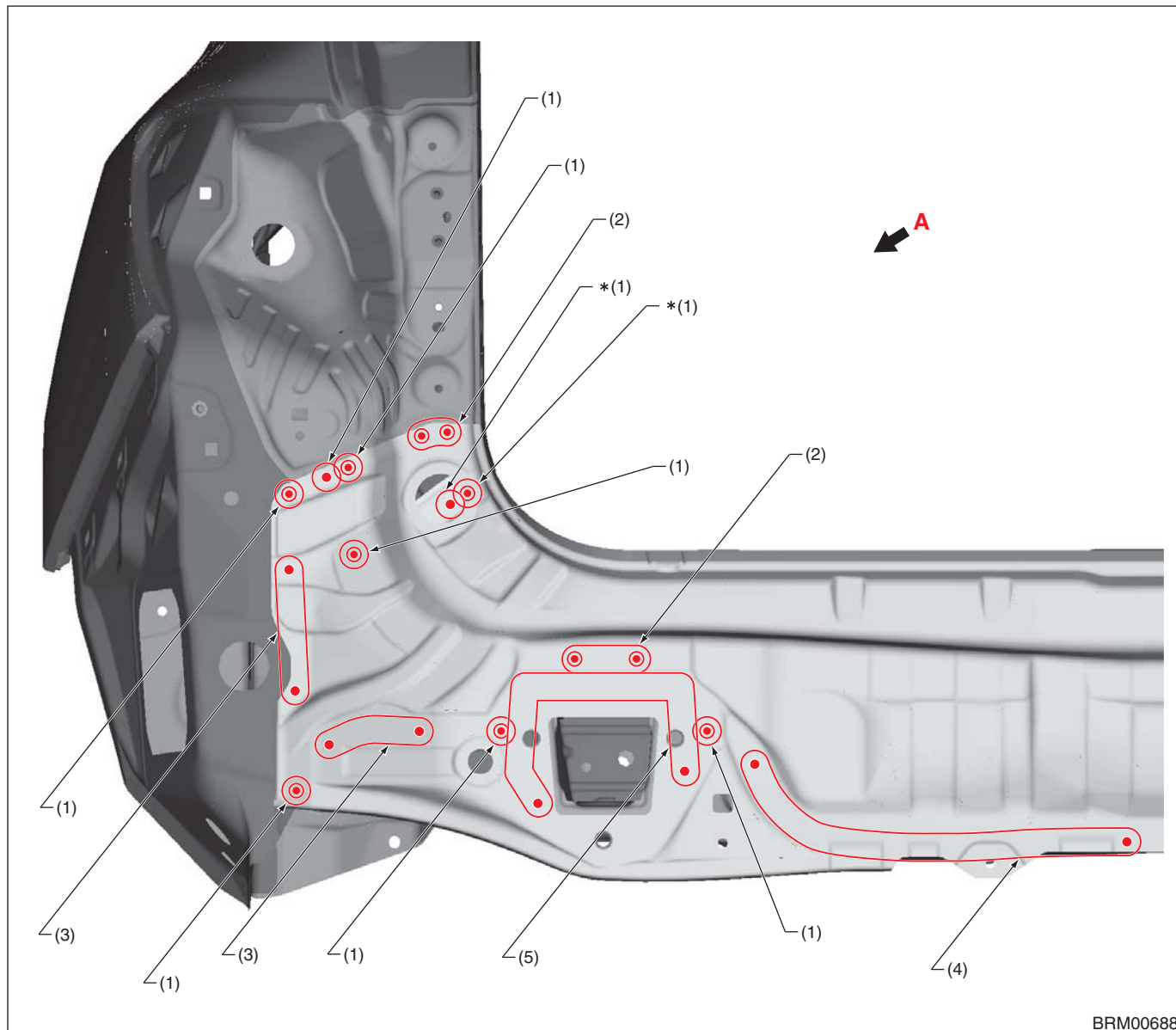
(1) 1 point (outside · 1)

(2) 1 point (outside · 2)

Panel Replacement

B: INSTALLATION

• Overall view



BRM00688

(1) 1 point
(2) 2 points

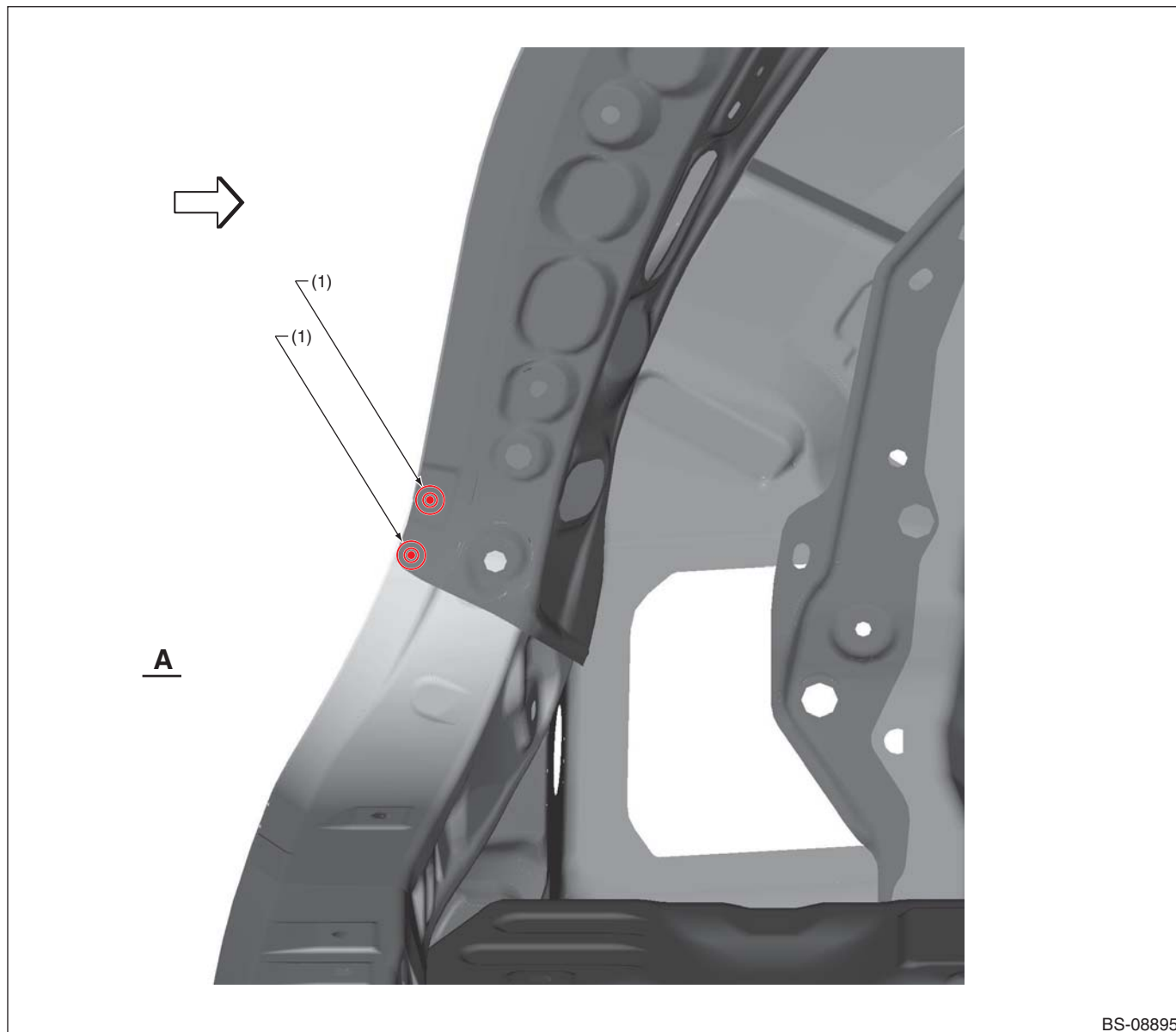
(3) 3 points
(4) 7 points

(5) 5 points

* : Spots are provided in the back.

Panel Replacement

• Views A



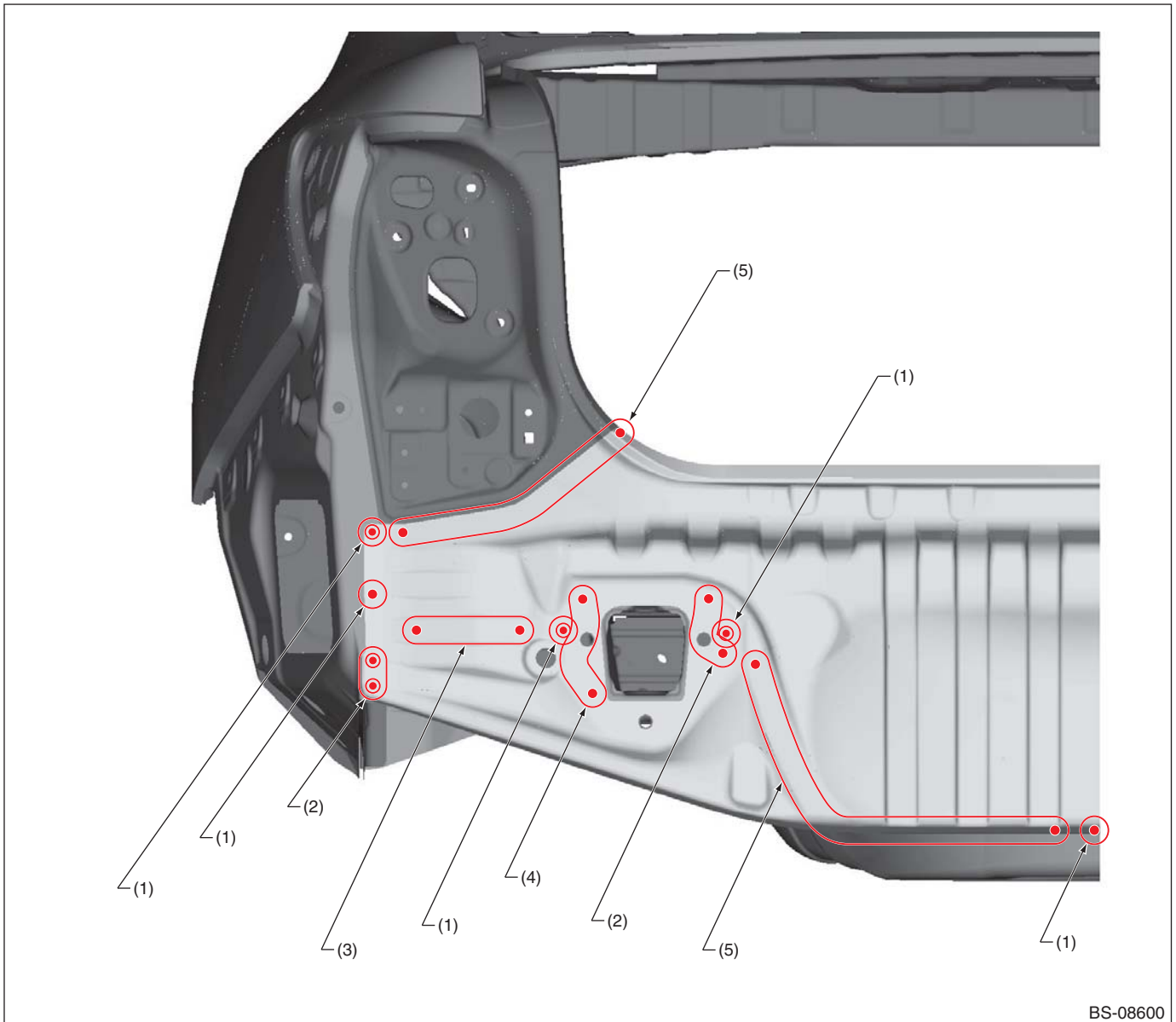
(1) 1 point

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)

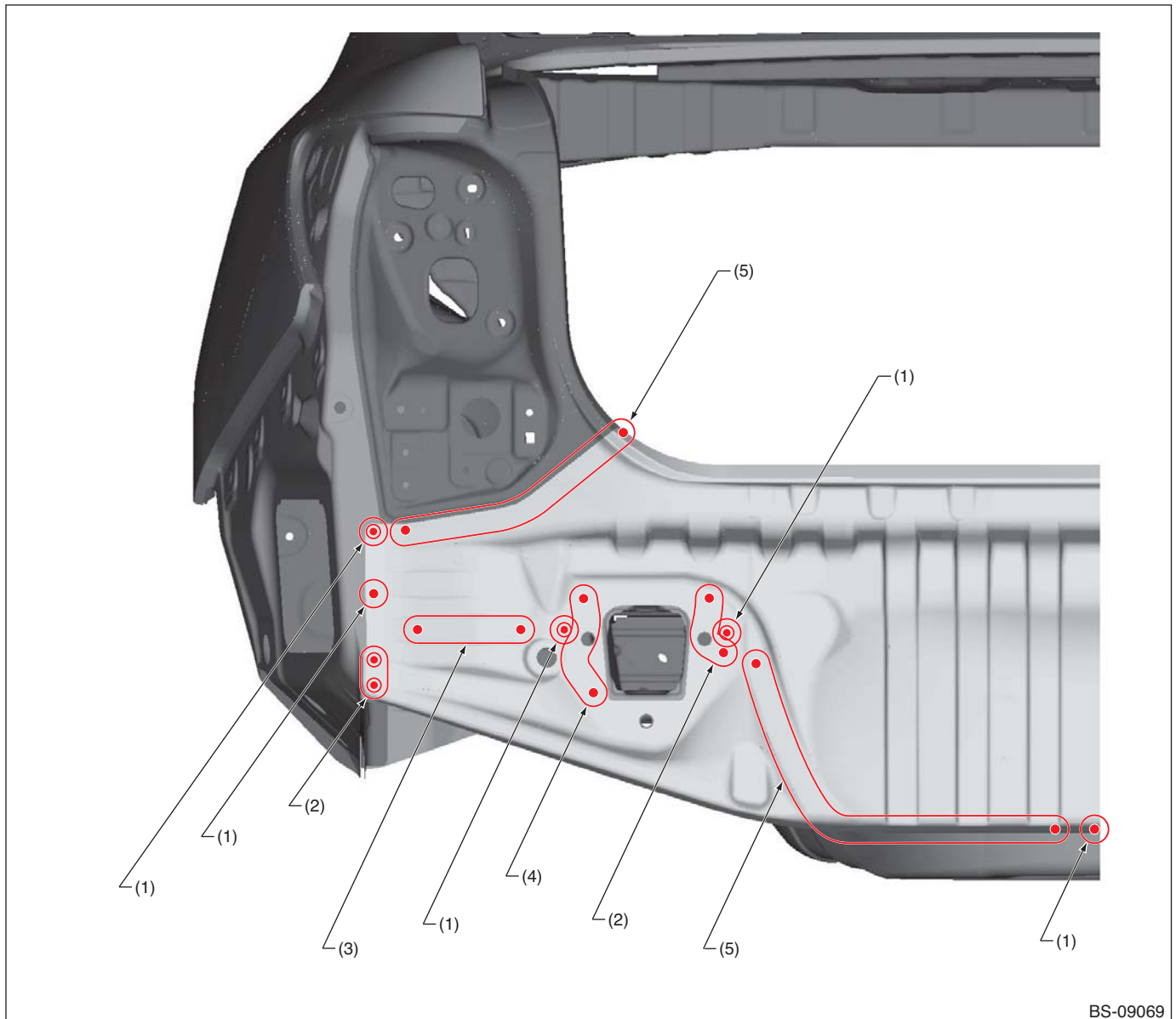
(3) 4 points (outside · 1)
(4) 3 points (outside · 1)

(5) 9 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point
(2) 2 points

(3) 4 points
(4) 3 points

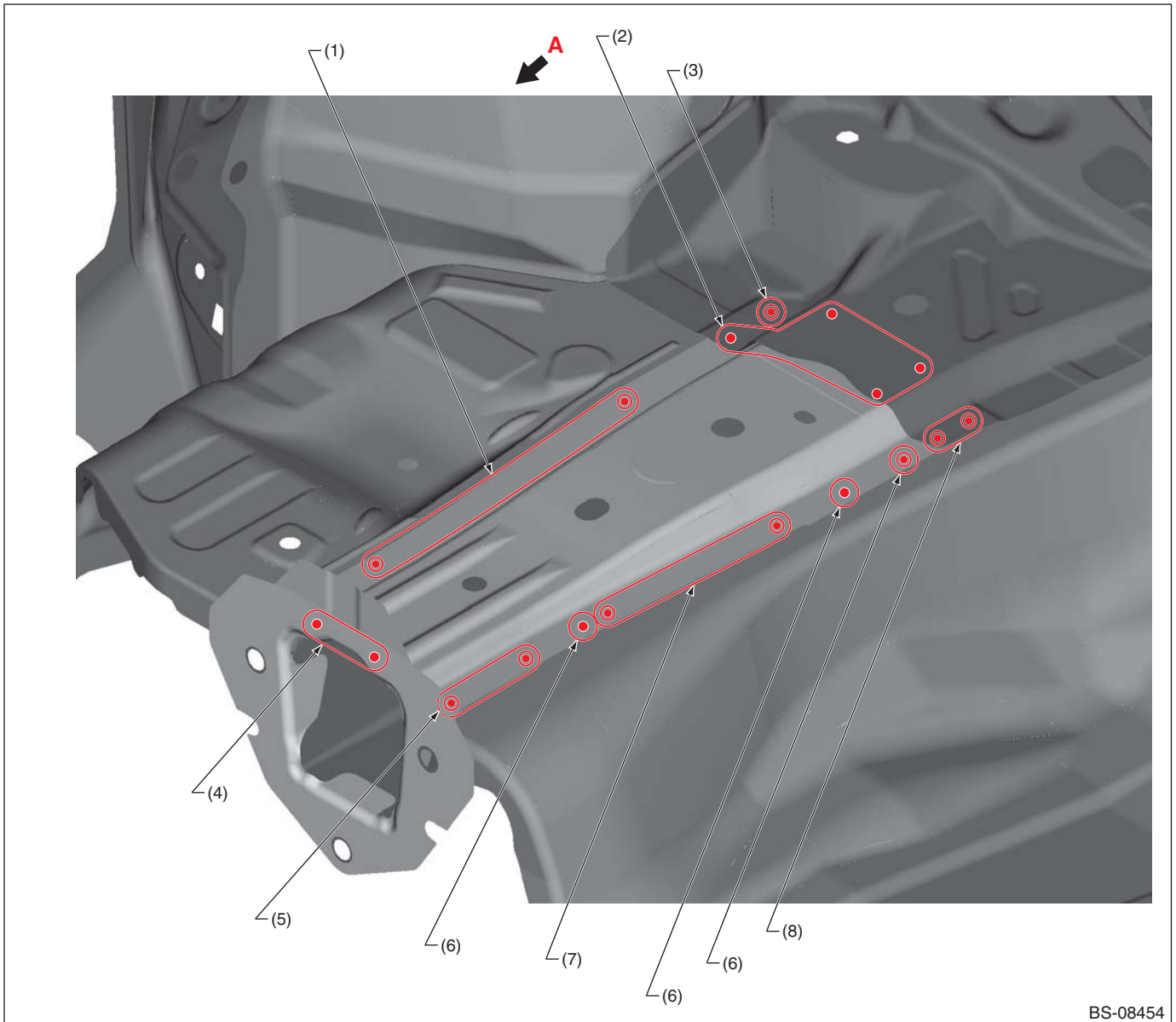
(5) 9 points

Panel Replacement

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

A: REMOVAL

- Overall view (Gasoline model)



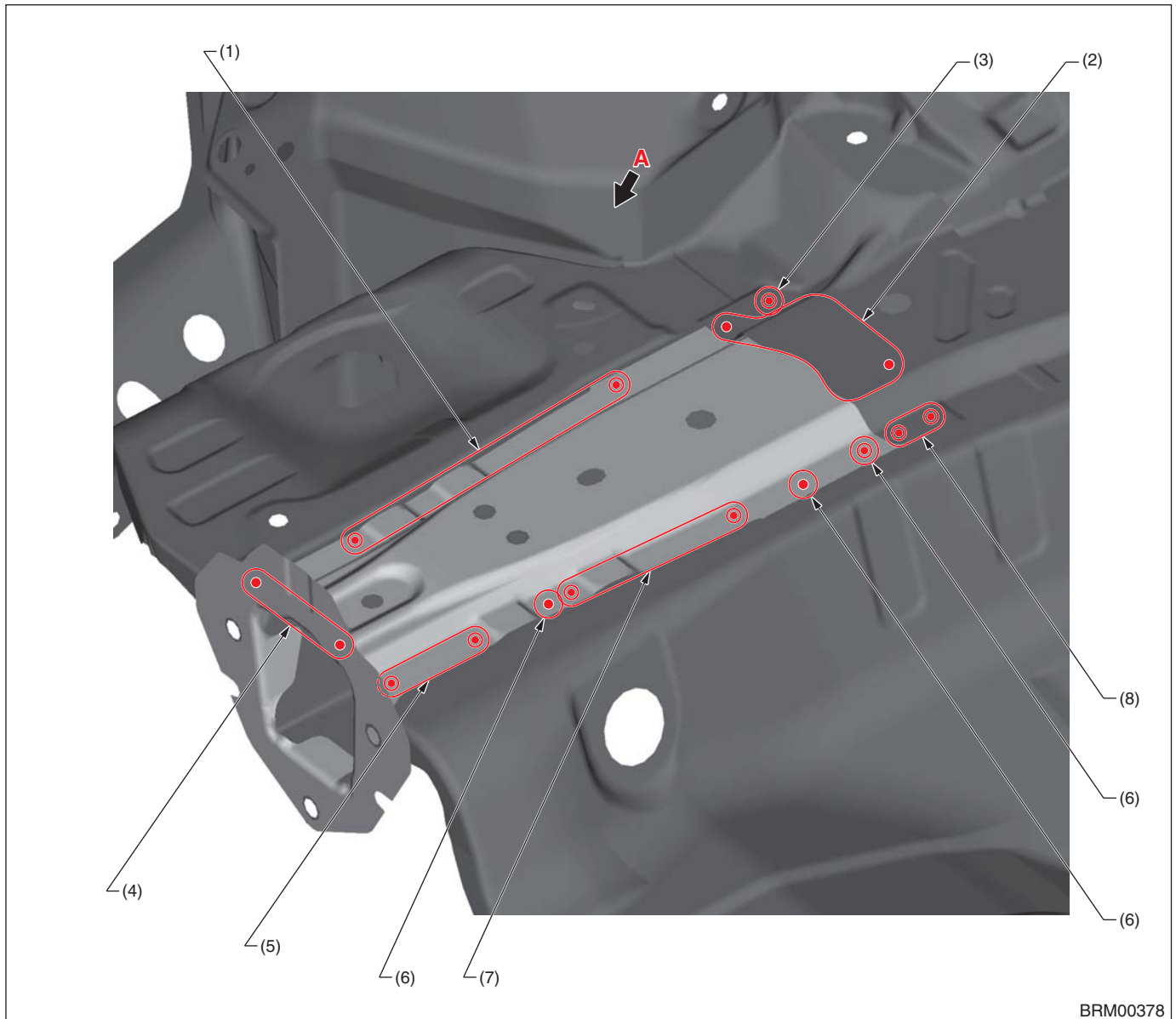
- (1) 5 points (top - 1)
- (2) 6 points (top - 1)
- (3) 1 point (top - 2)

- (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

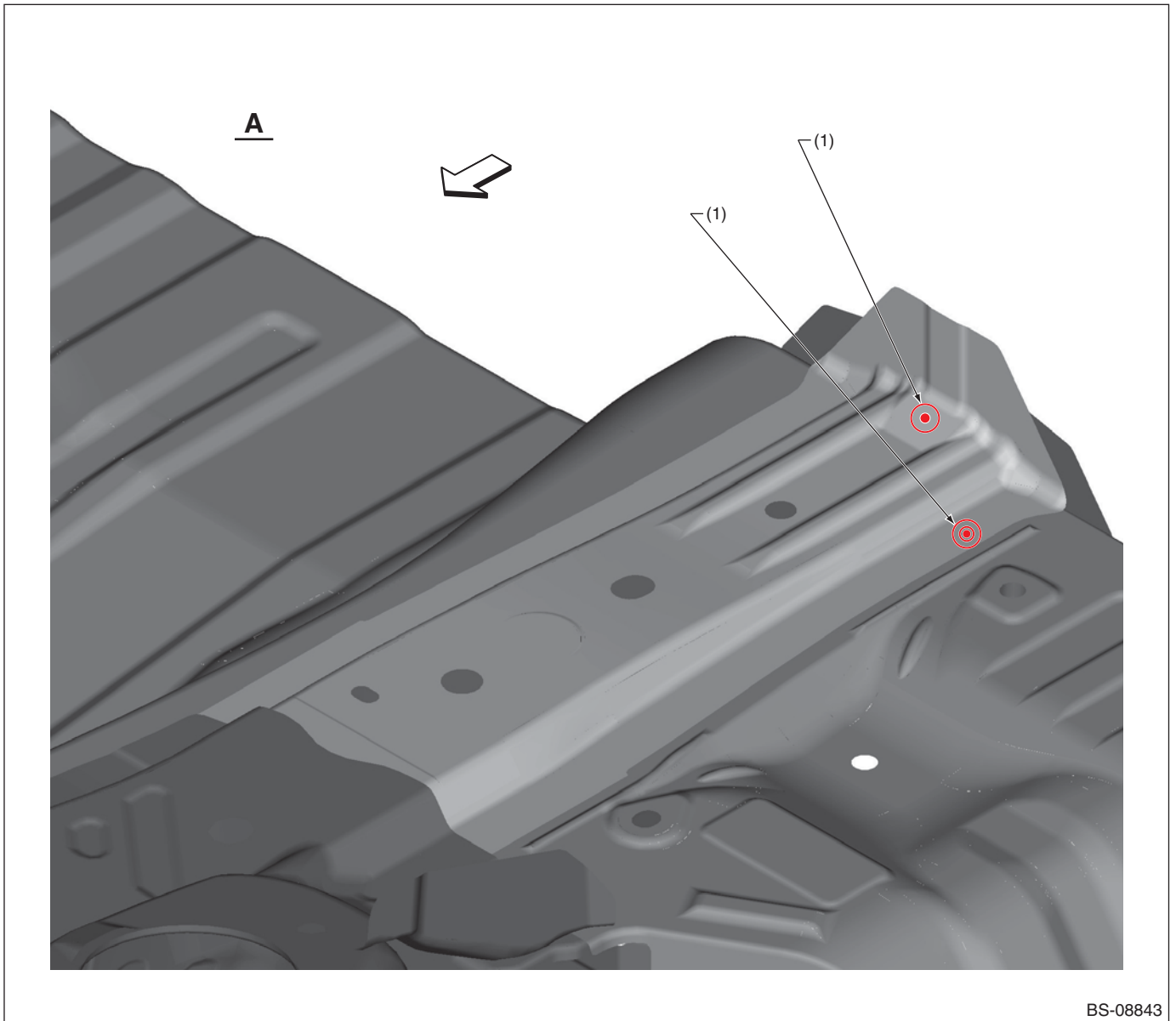
- (1) 5 points (top · 1)
- (2) 6 points (top · 1)
- (3) 1 point (top · 2)

- (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)

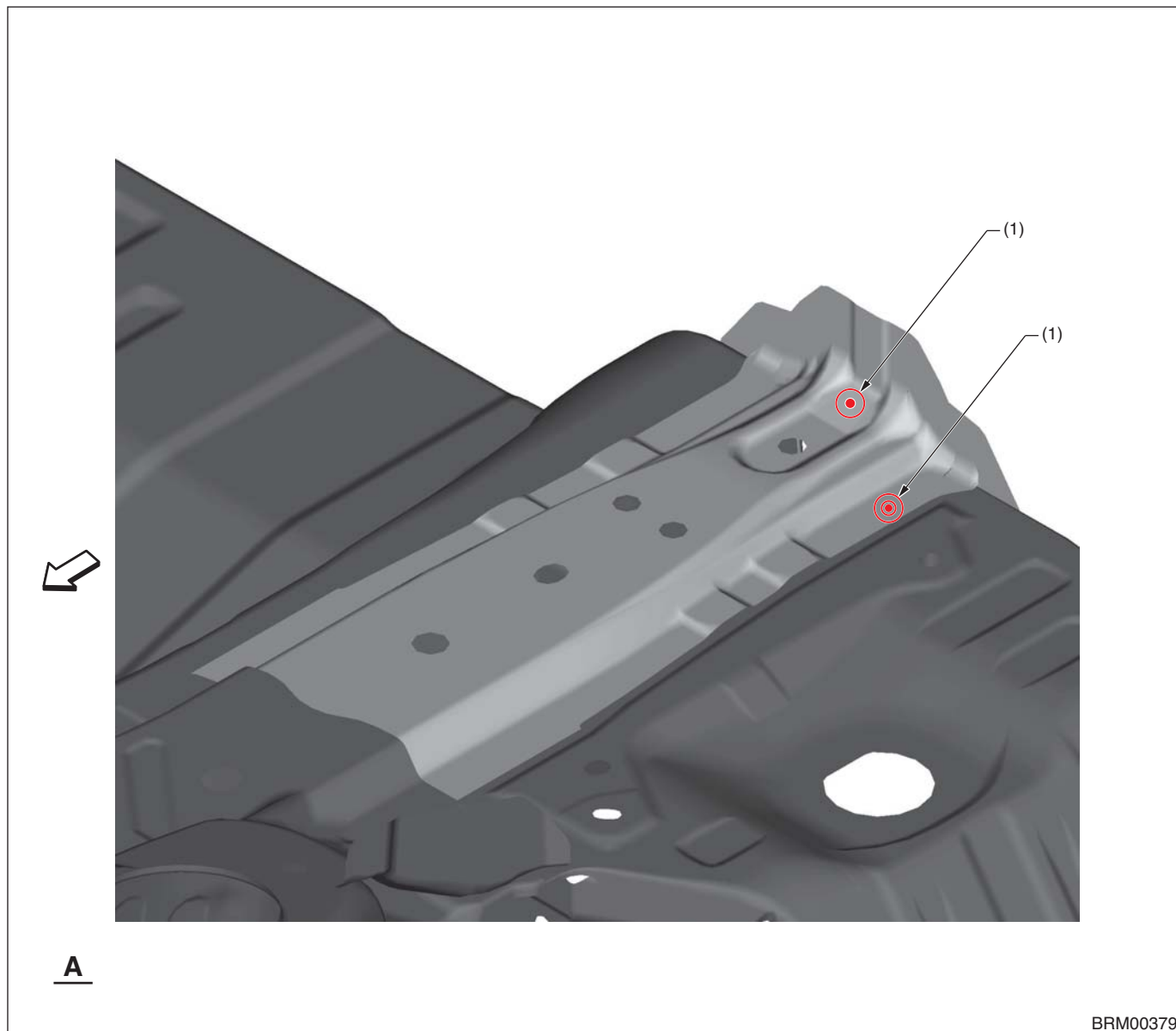


(1) 1 point (top · 1)

BS-08843

Panel Replacement

- Views A (Hybrid model)

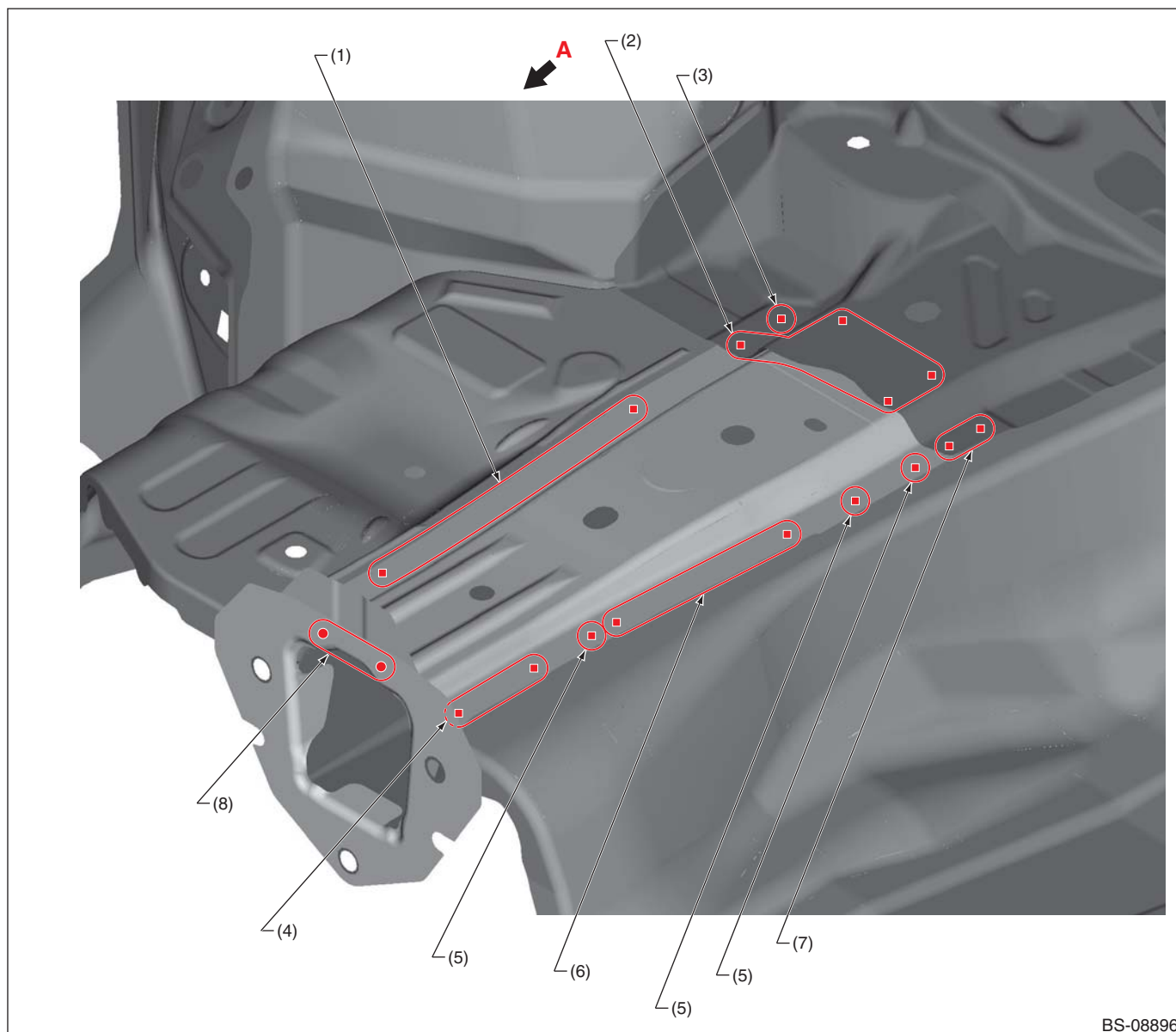


(1) 1 point (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view (Gasoline model)

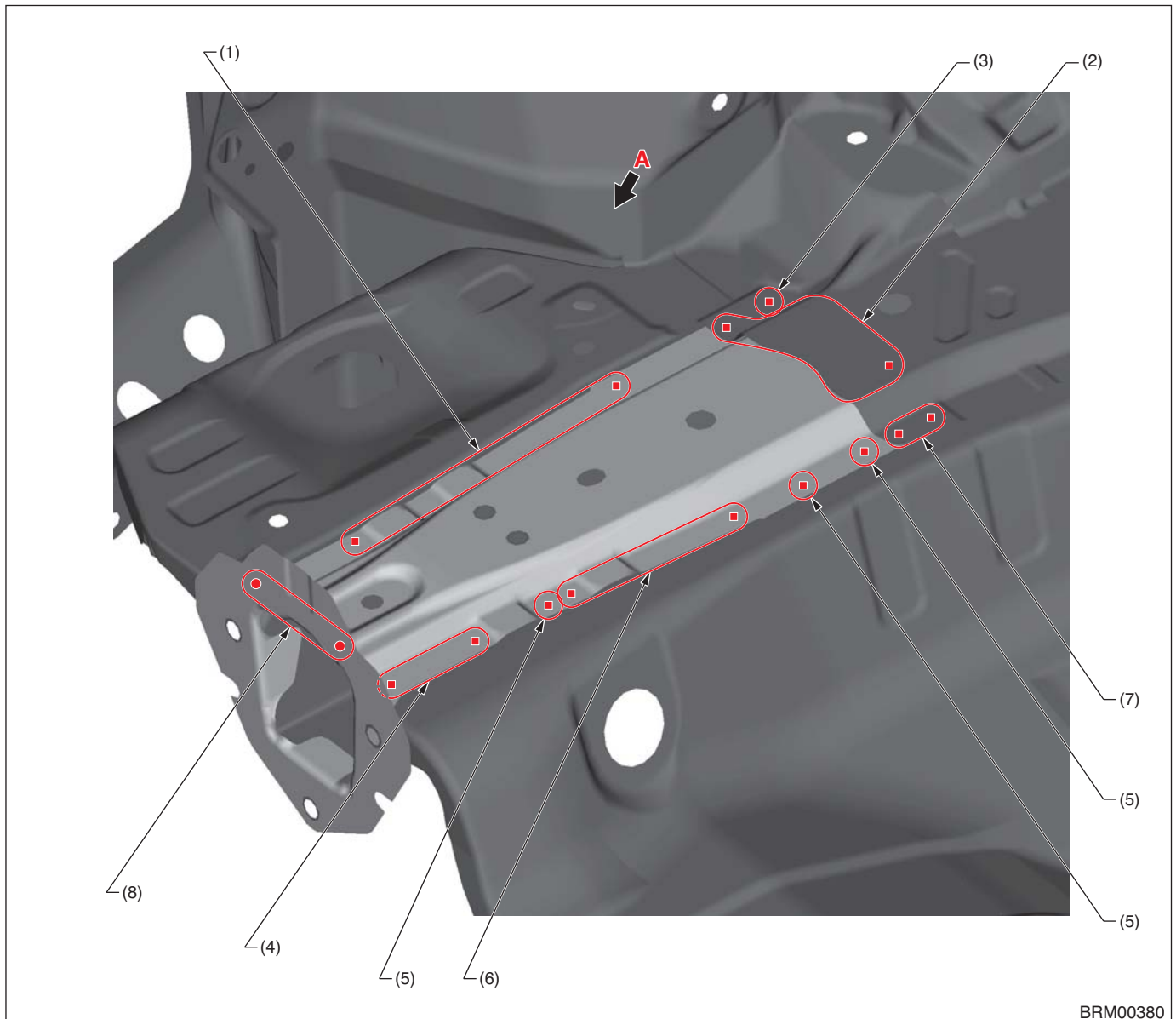


BS-08896

- | | | |
|----------------------------------|------------------------|-----------------------------------|
| (1) 5 points (service) | (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

- (Hybrid model)



(1) 5 points (service)

(2) 6 points

(3) 1 point (service · matching)

(4) 2 points (service)

(5) 1 point (service)

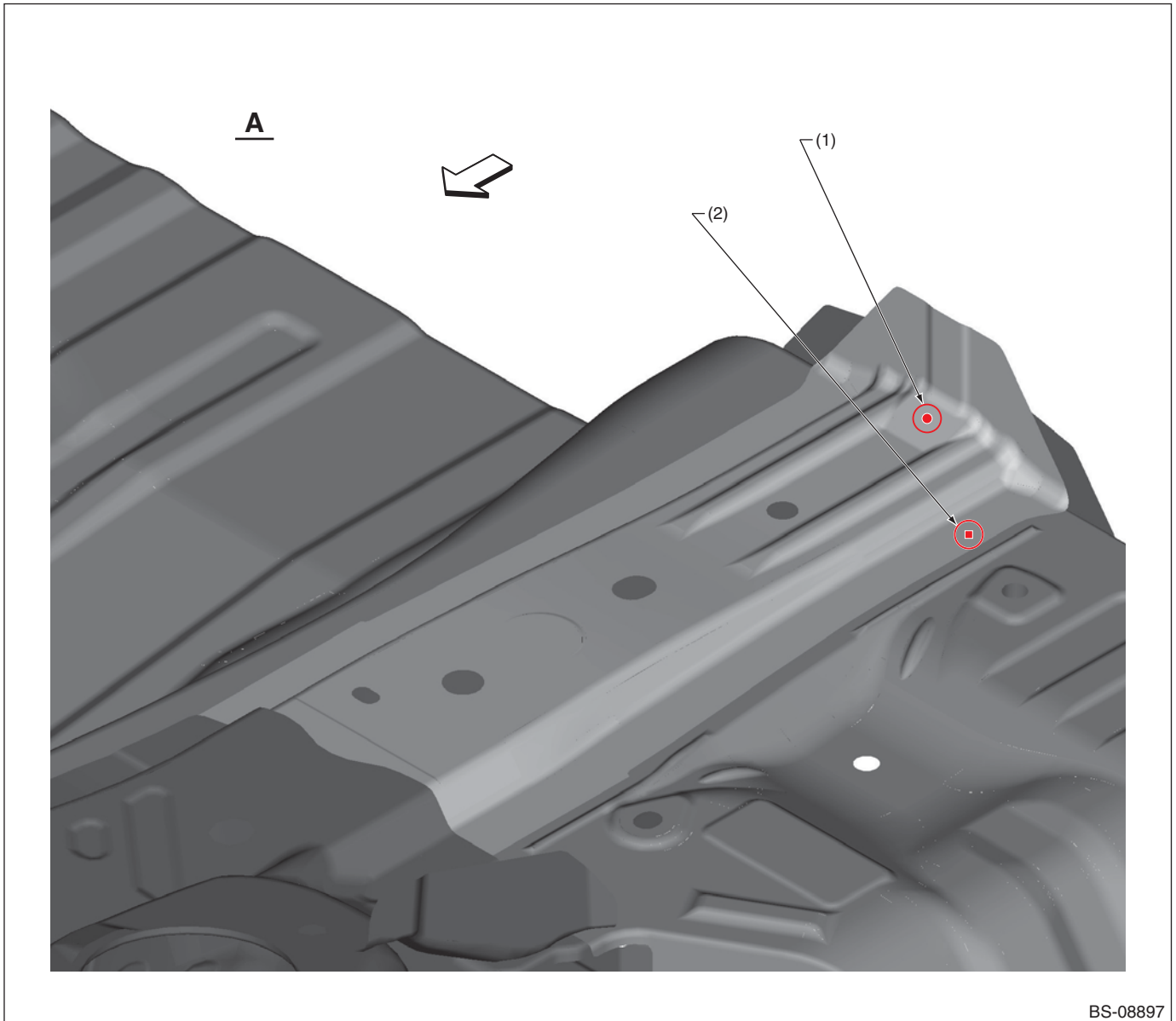
(6) 3 points (service)

(7) 2 points (service · matching)

(8) 2 points

Panel Replacement

- Views A (Gasoline model)



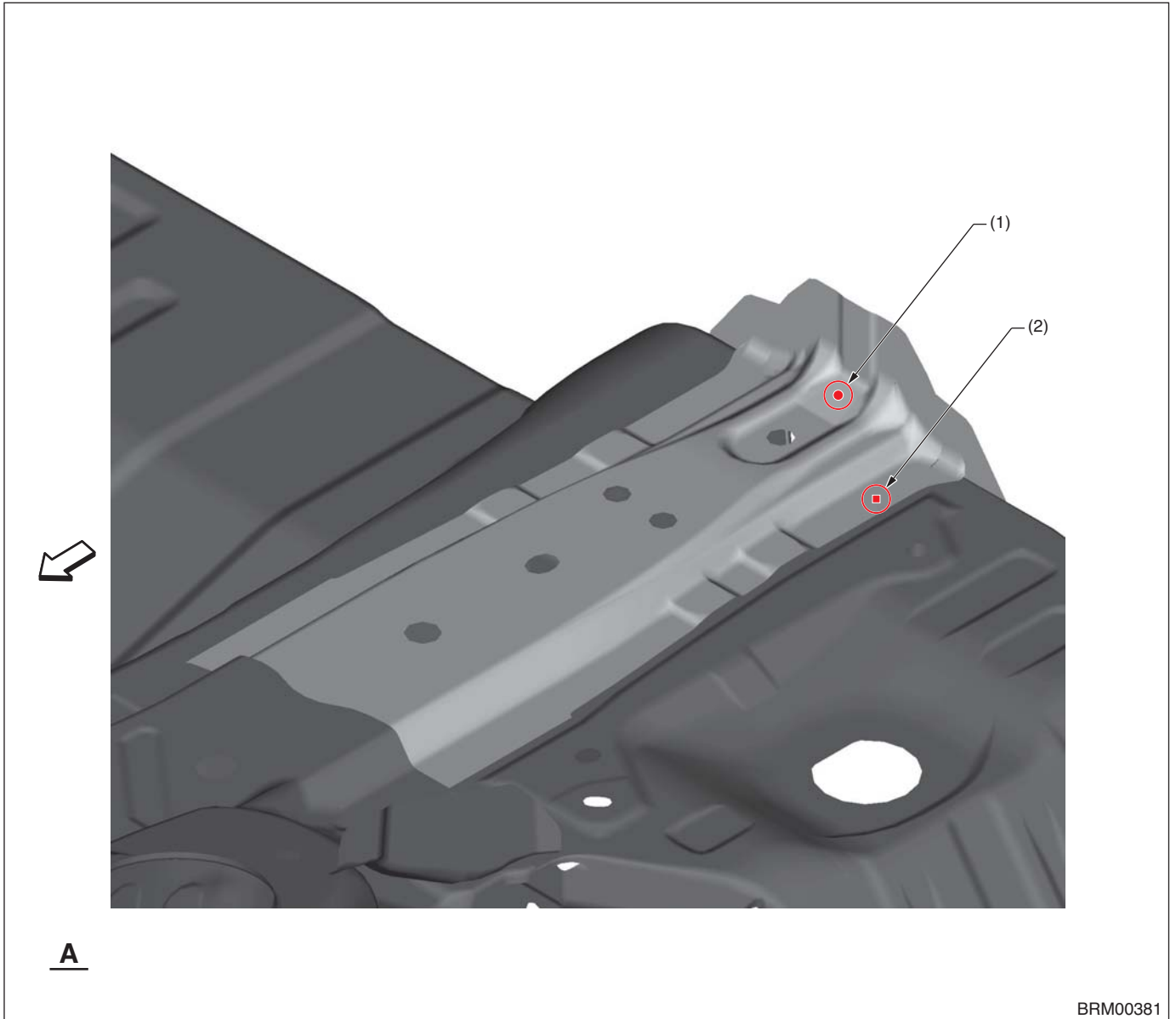
BS-08897

(1) 1 point

(2) 1 point (service)

Panel Replacement

- Views A (Hybrid model)



(1) 1 point

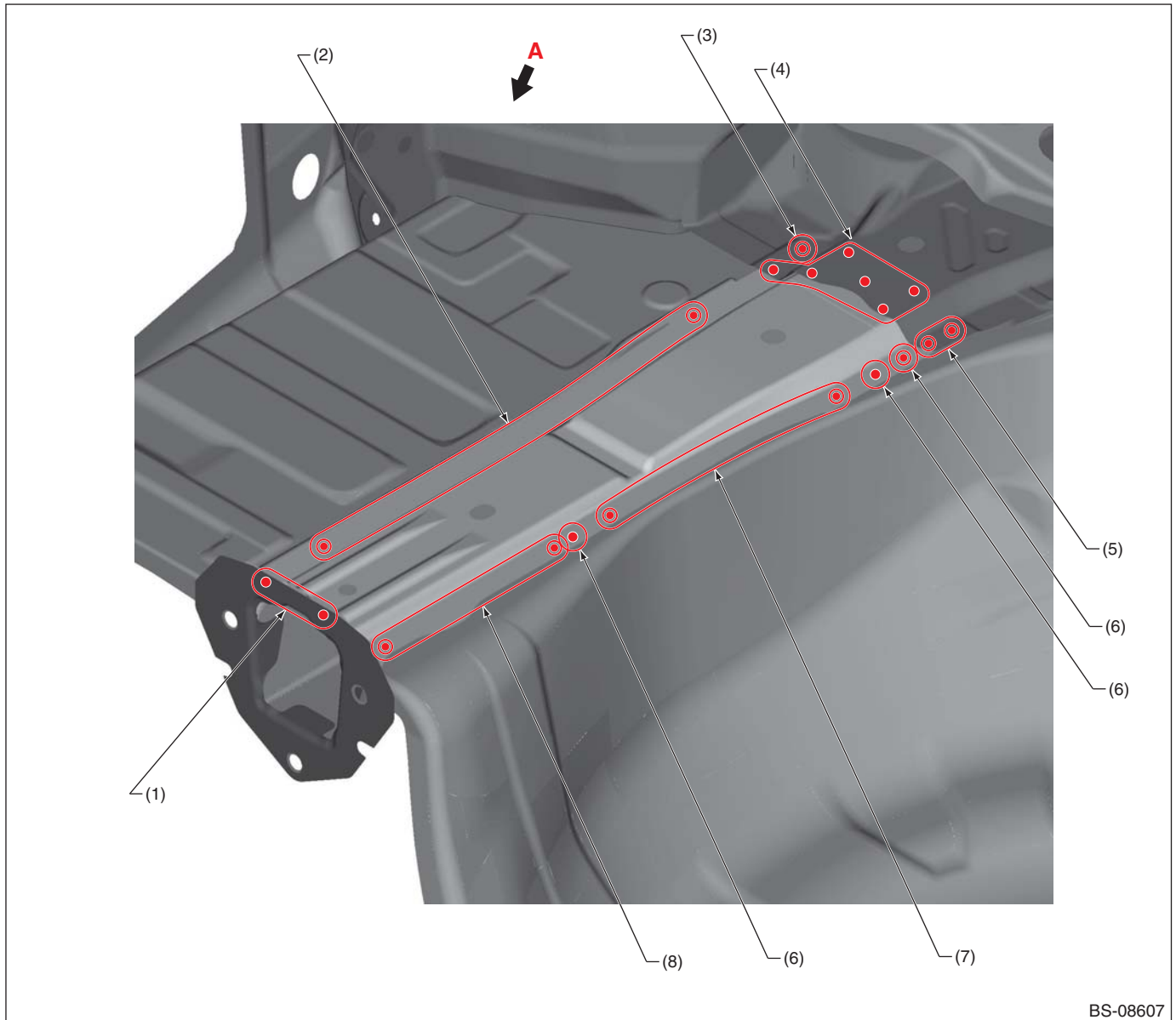
(2) 1 point (service)

Panel Replacement

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

A: REMOVAL

• Overall view



BS-08607

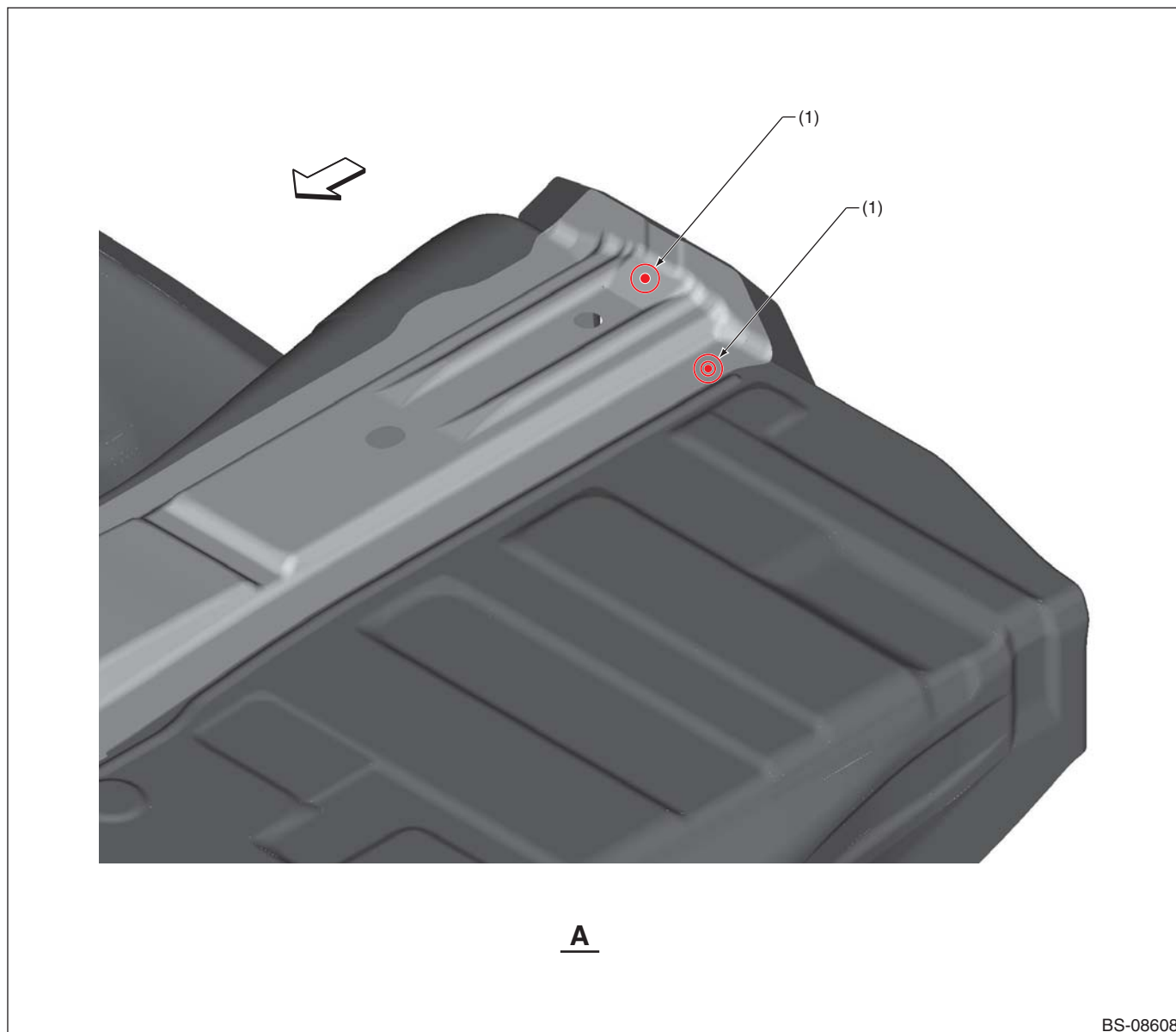
- (1) 2 points (inside · 1)
- (2) 8 points (top · 1)
- (3) 1 point (top · 2)

- (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

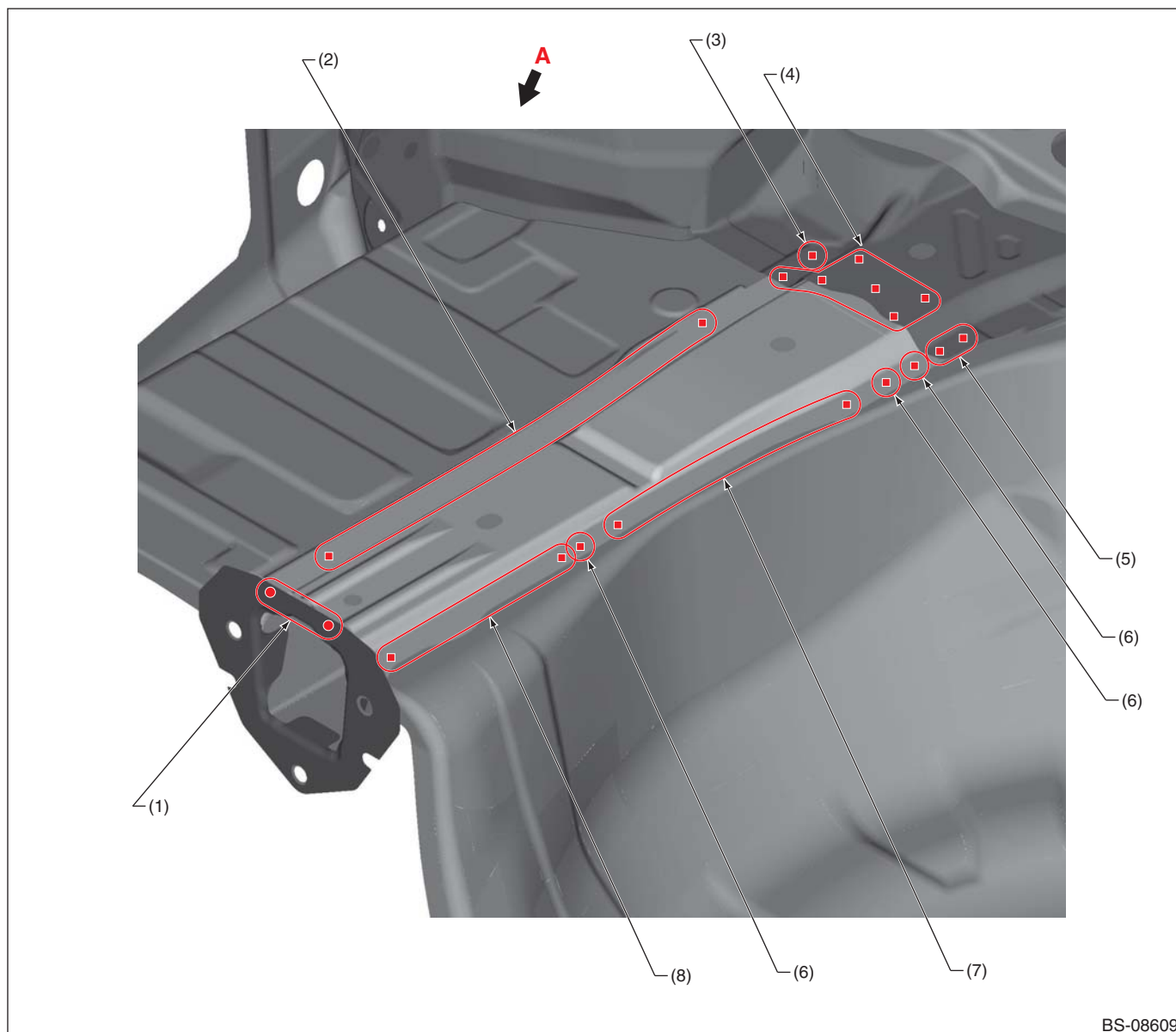


(1) 1 point (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



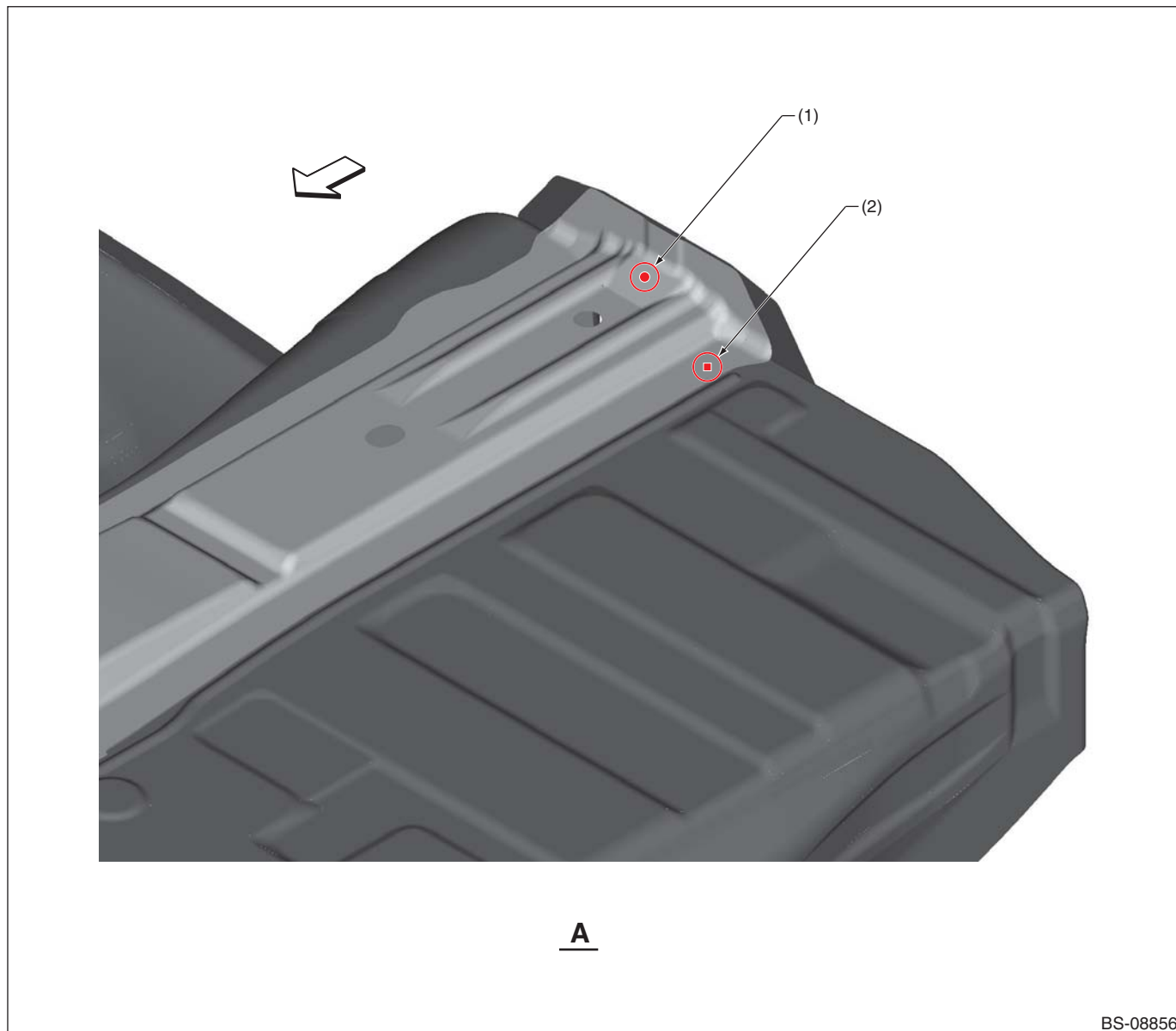
- (1) 2 points
- (2) 8 points (service)
- (3) 1 point (service · matching)

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

- (7) 5 points (service)
- (8) 4 points (service)

Panel Replacement

• Views A



(1) 1 point

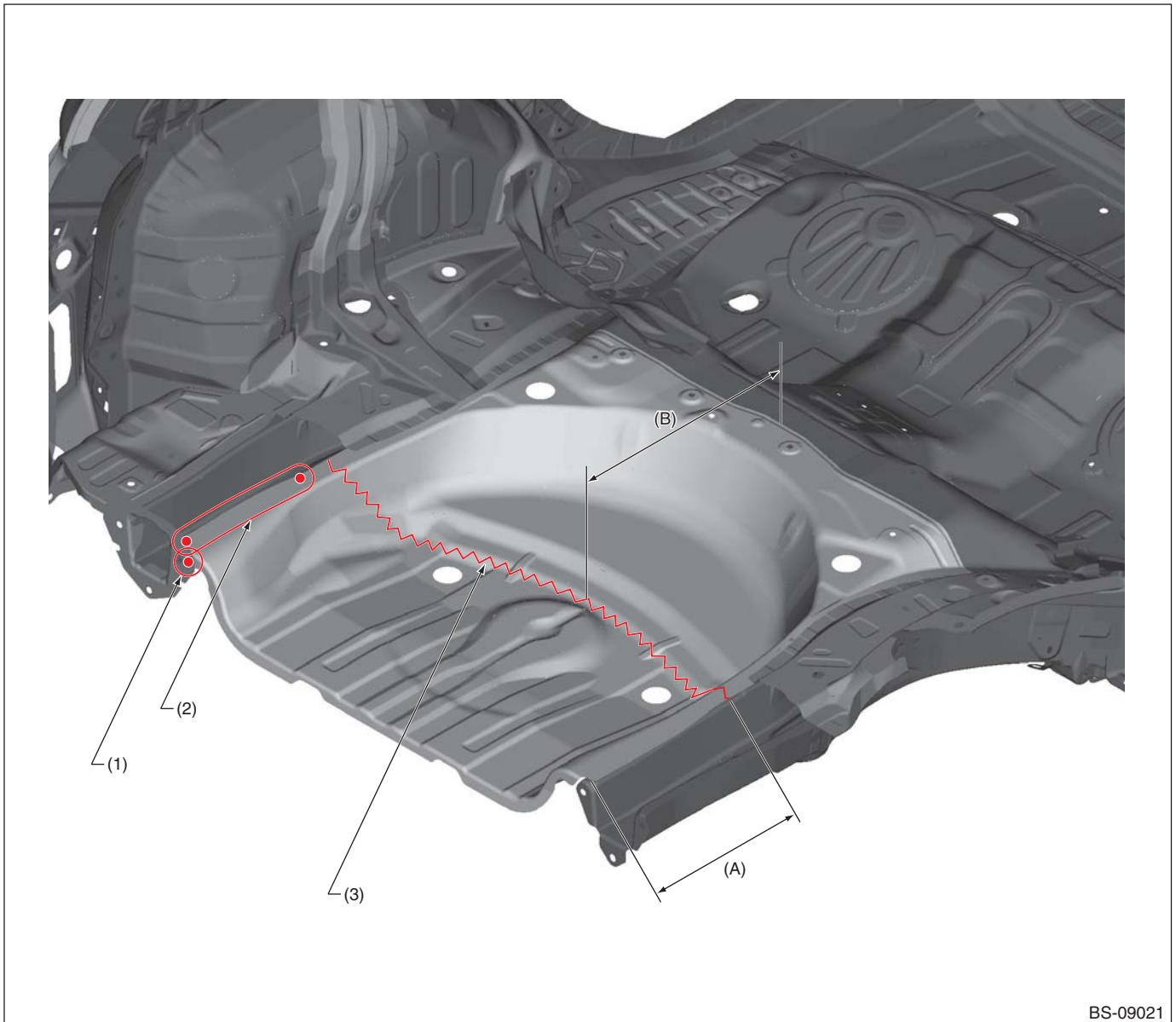
(2) 1 point (service)

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]

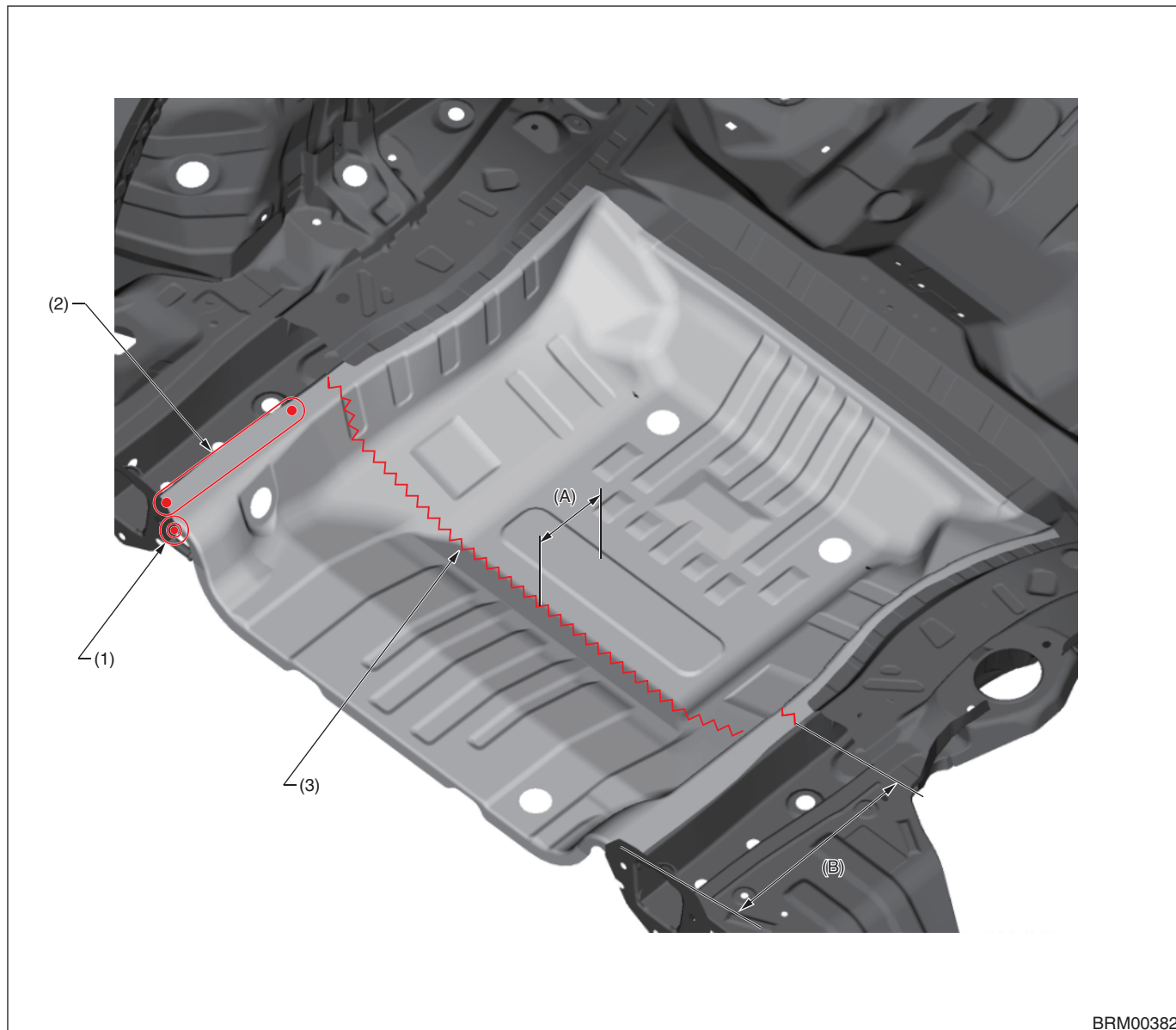
(1) 1 point (inside · 1 belt sander)

(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)

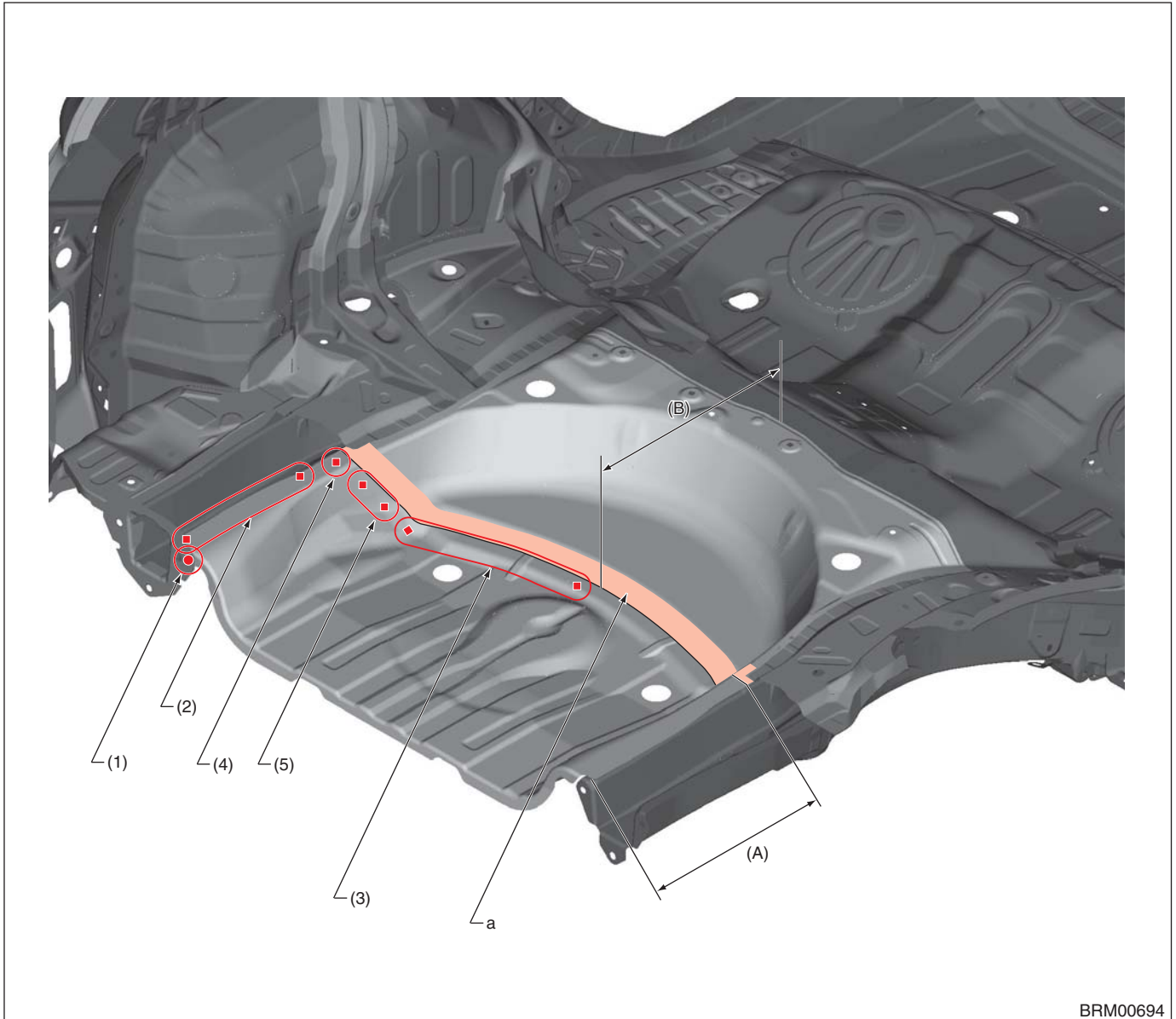
(2) 5 points (top · 1)

(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)

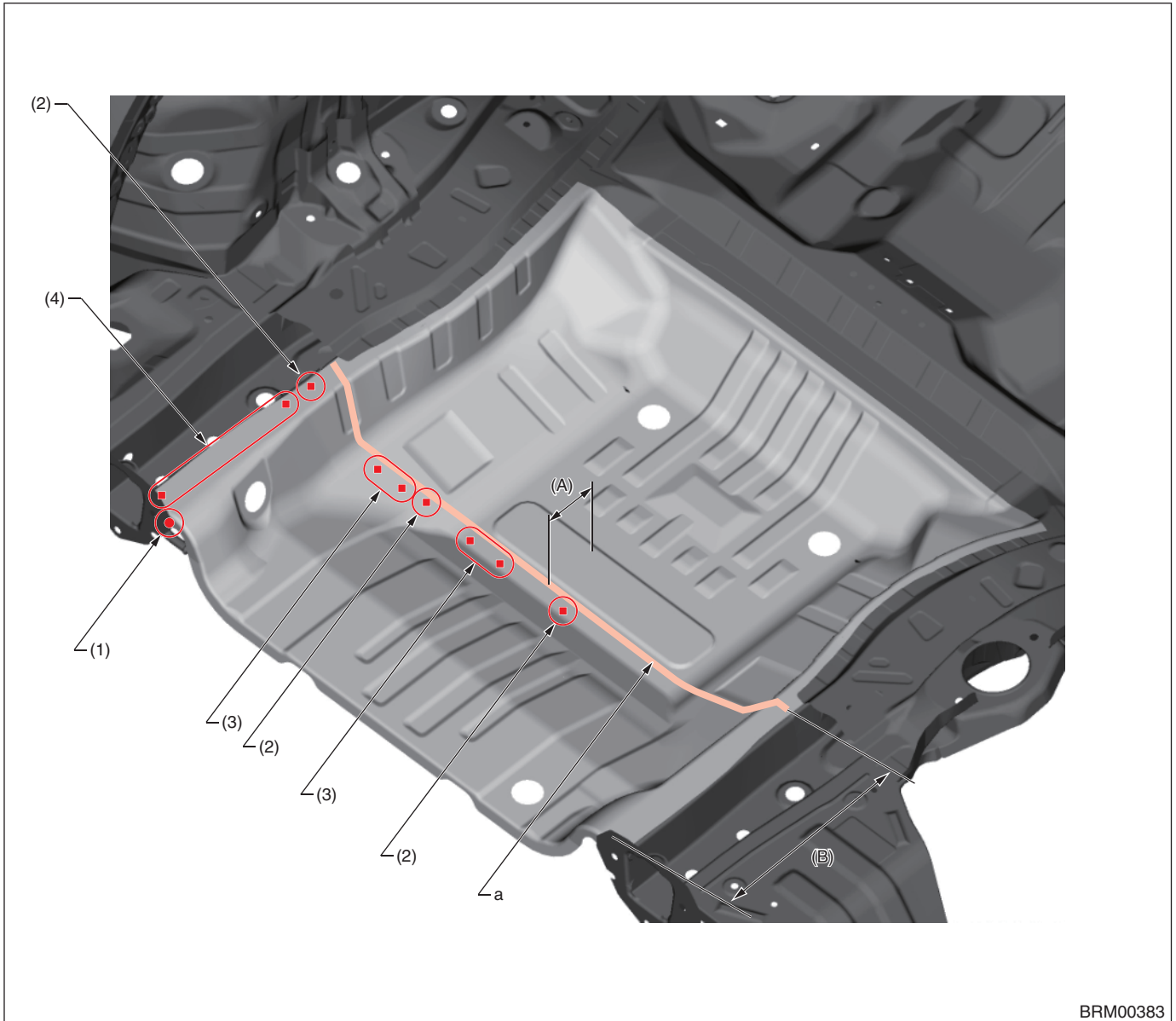
(2) 5 points (service)

(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)

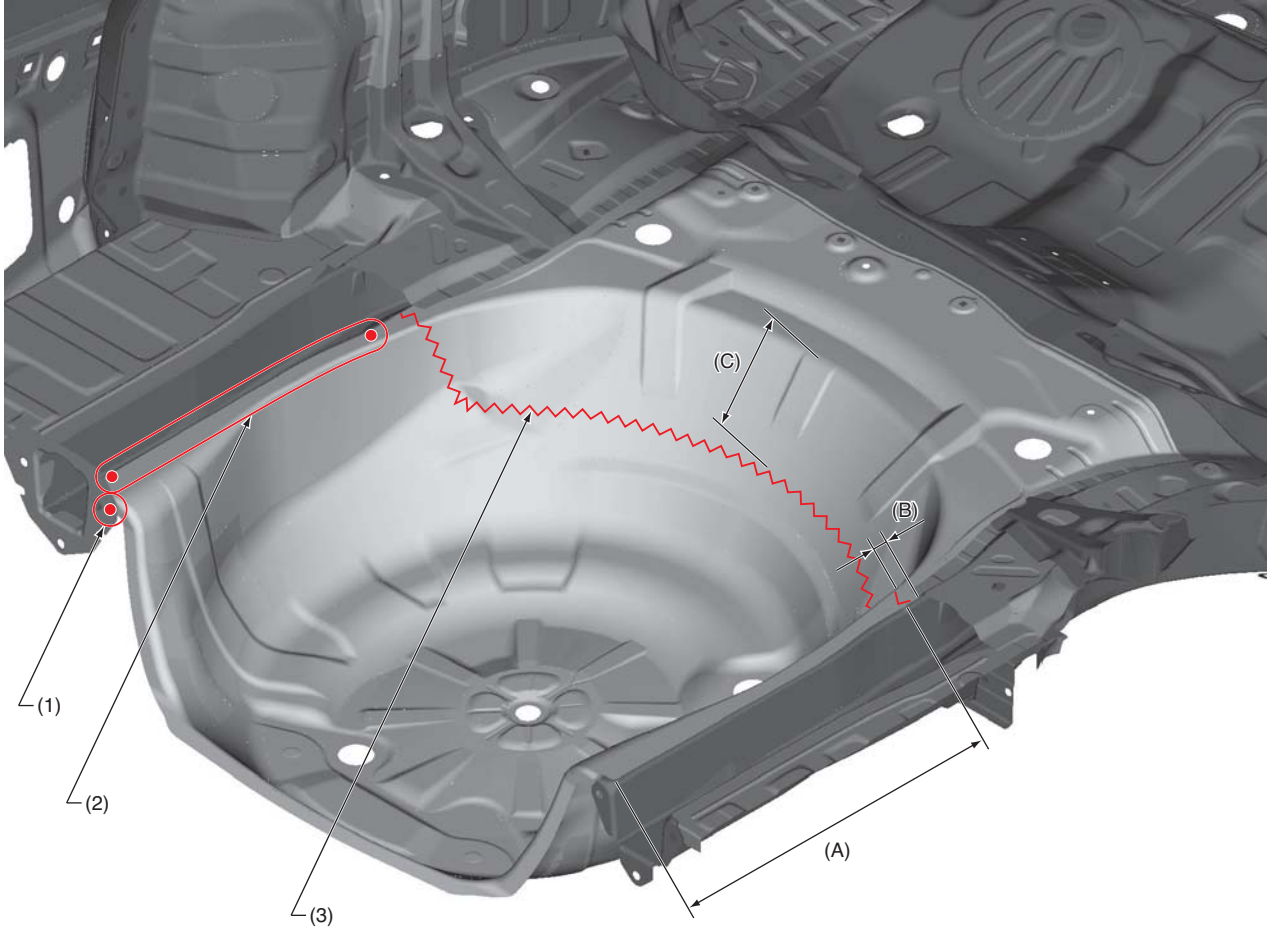
(2) 1 point (service)

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

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)

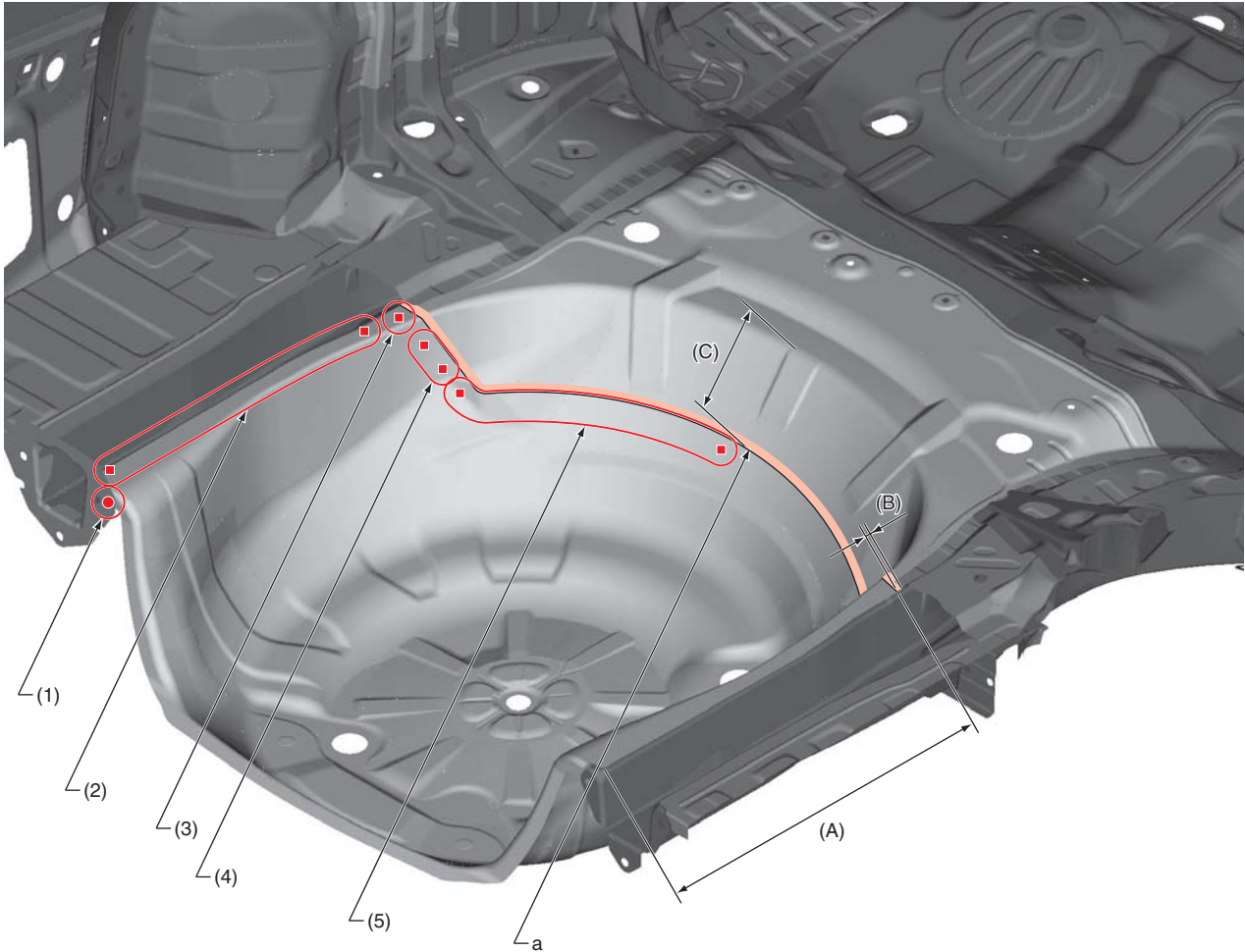
(2) 9 points (top · 1)

(3) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BS-09071

(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)

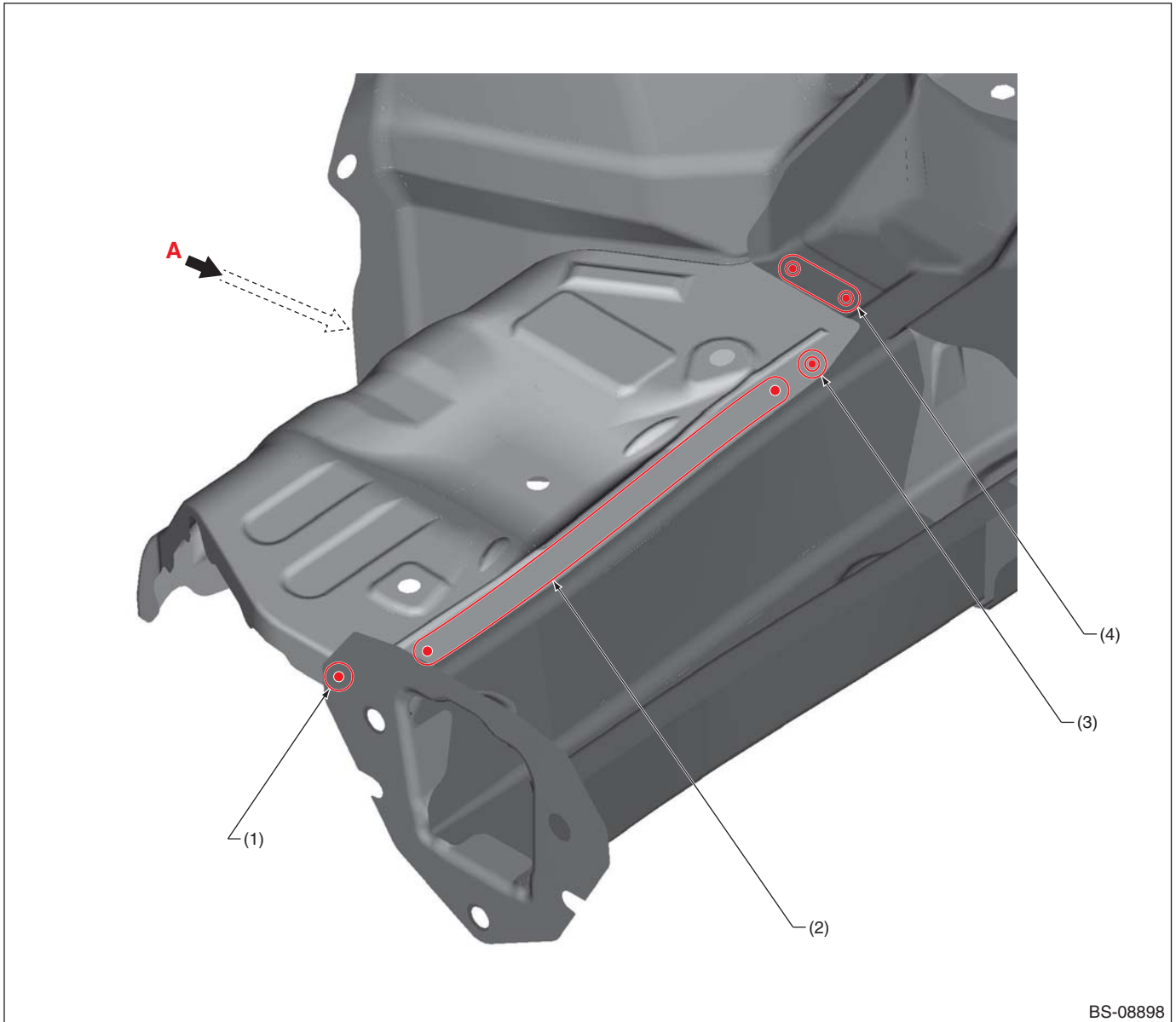
Note: Apply sealing agent to the floor pan fitting parts (front and rear) of section "a".

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)

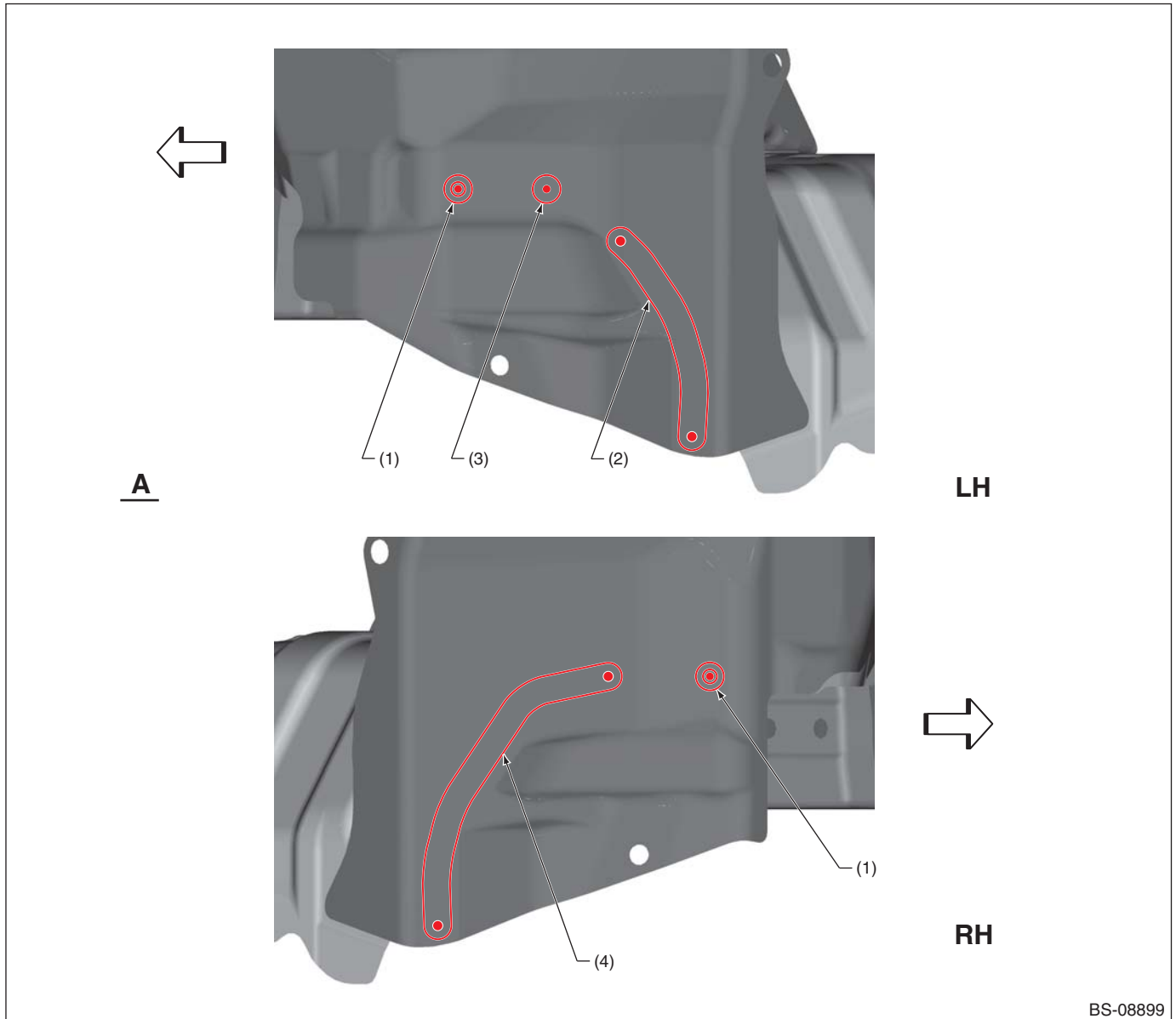
(4) LH: 2 points (top · 2)

(2) 7 points (top · 1)

RH: 1 point (top · 2)

Panel Replacement

• Views A



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

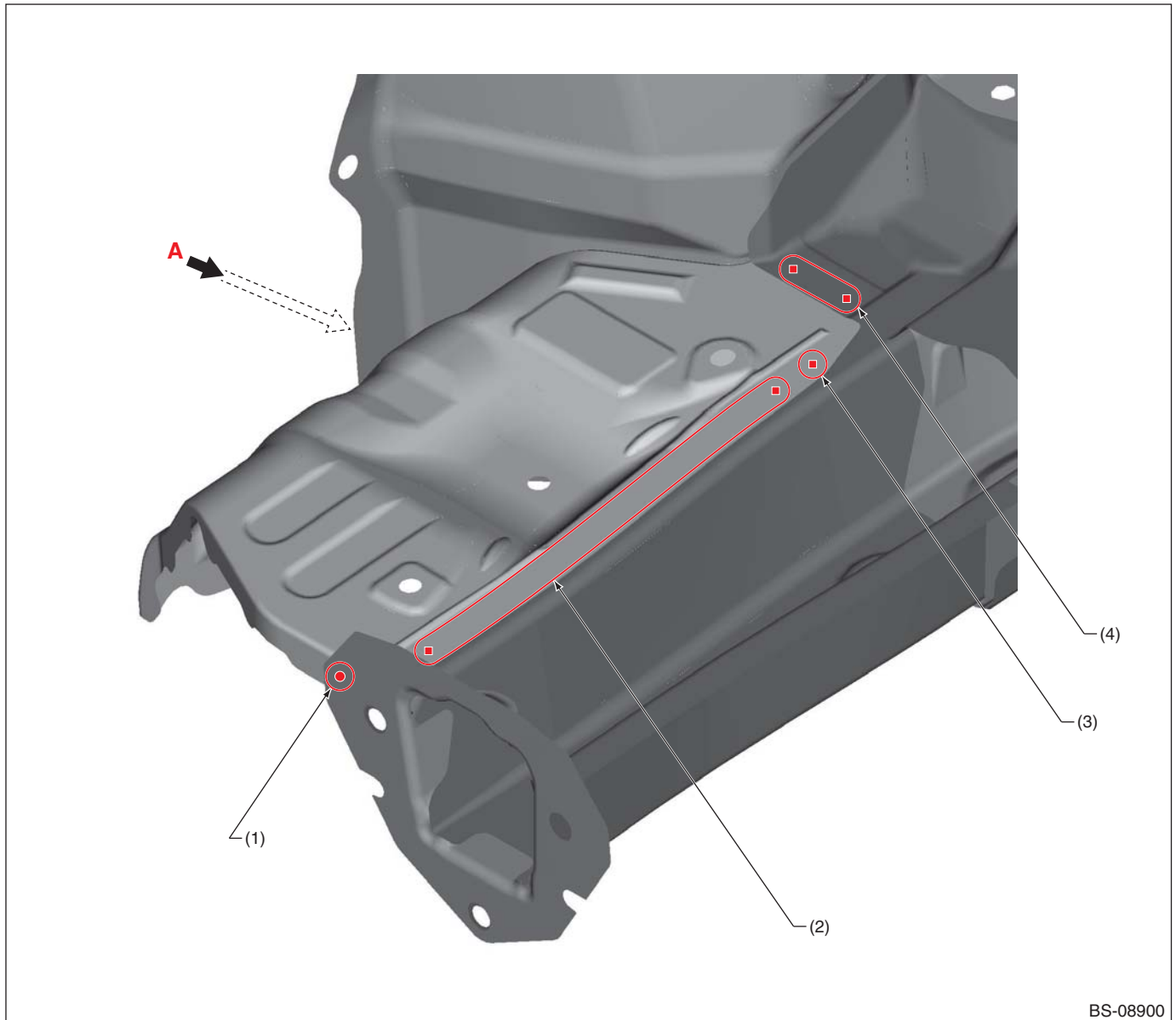
(3) 1 point (outside · 1)

(4) 5 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-08900

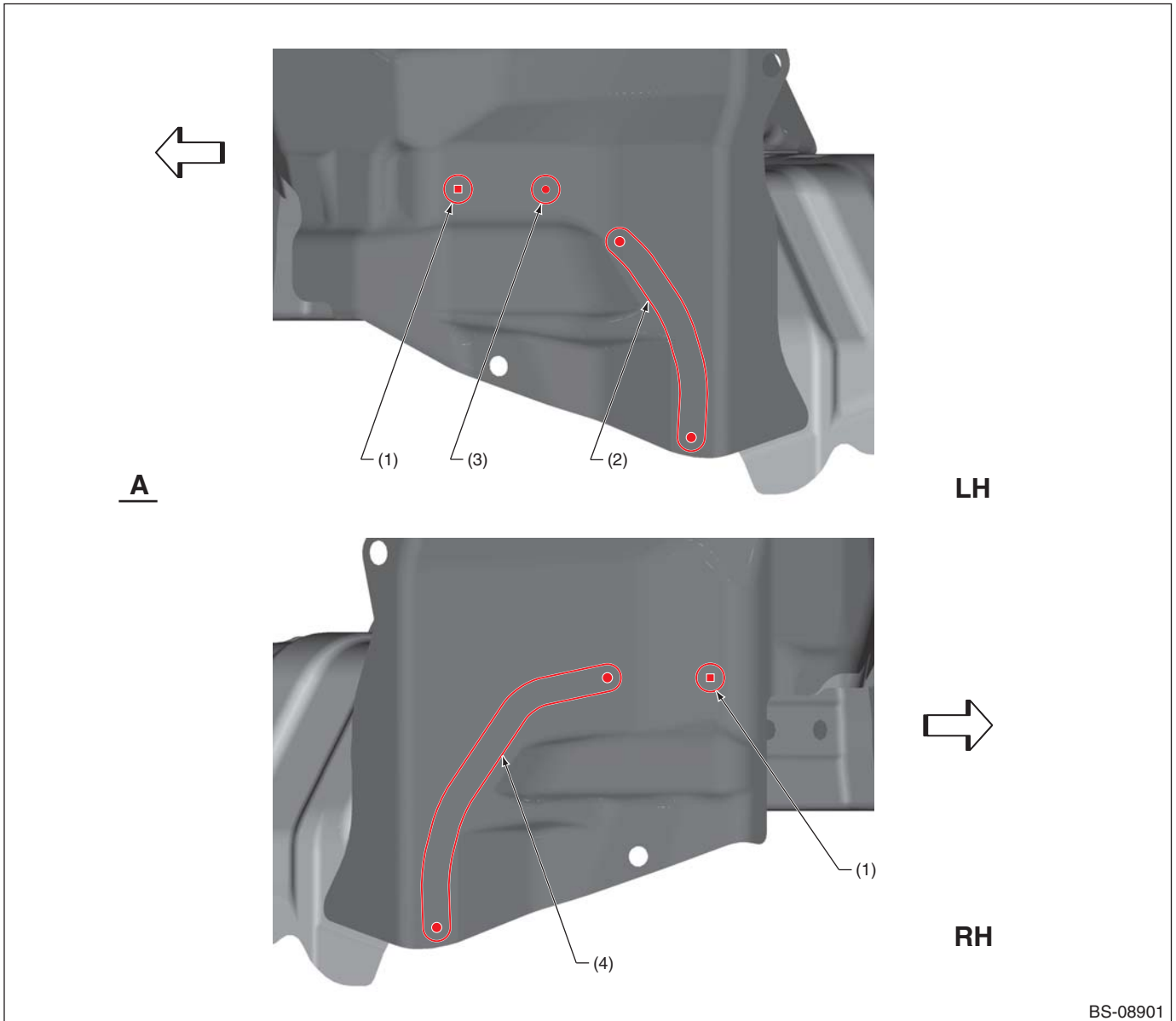
- (1) 1 point
- (2) 7 points (service)

- (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

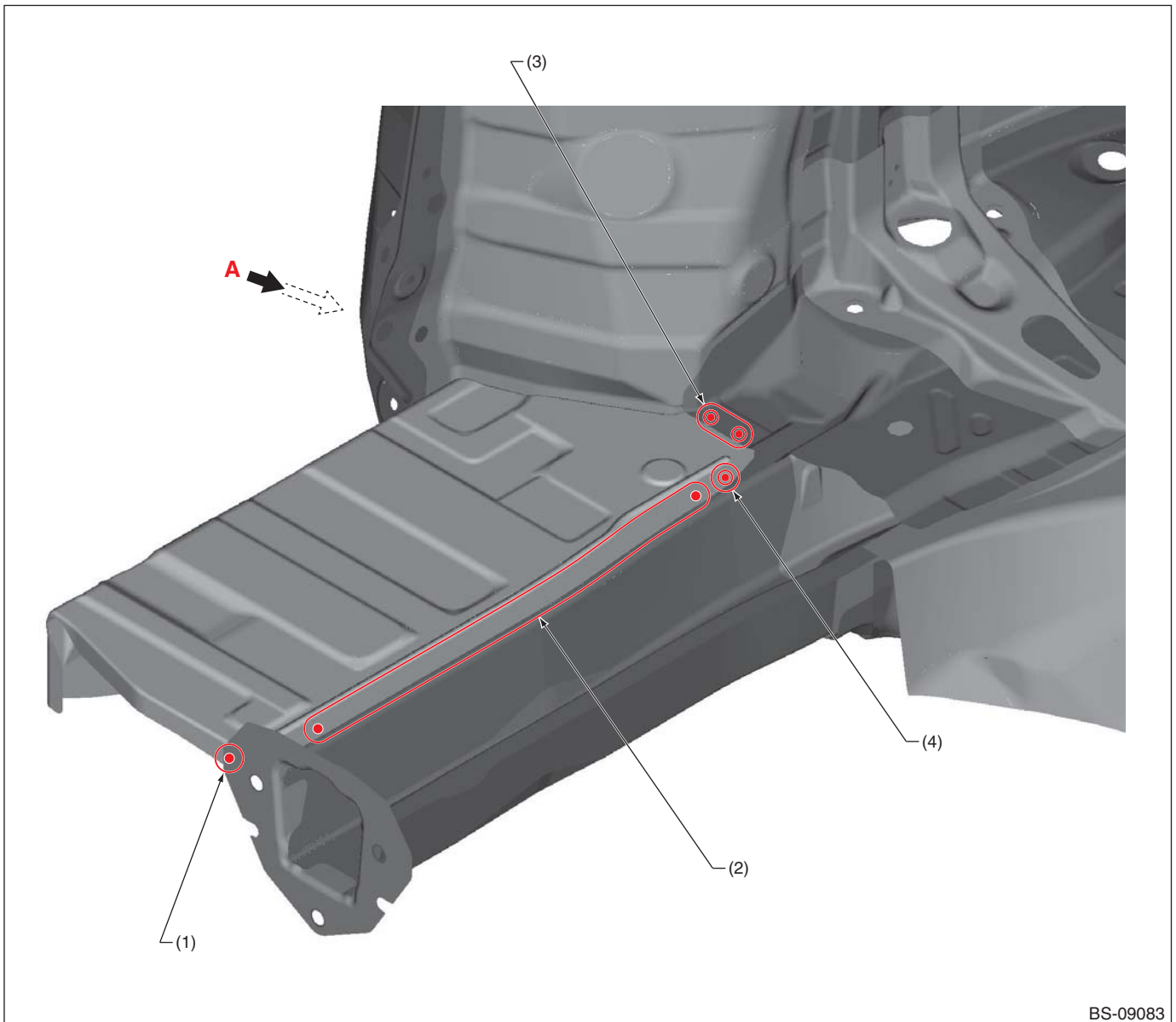
(4) 5 points

Panel Replacement

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

A: REMOVAL

• Overall view



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

(2) 10 points (top - 1)

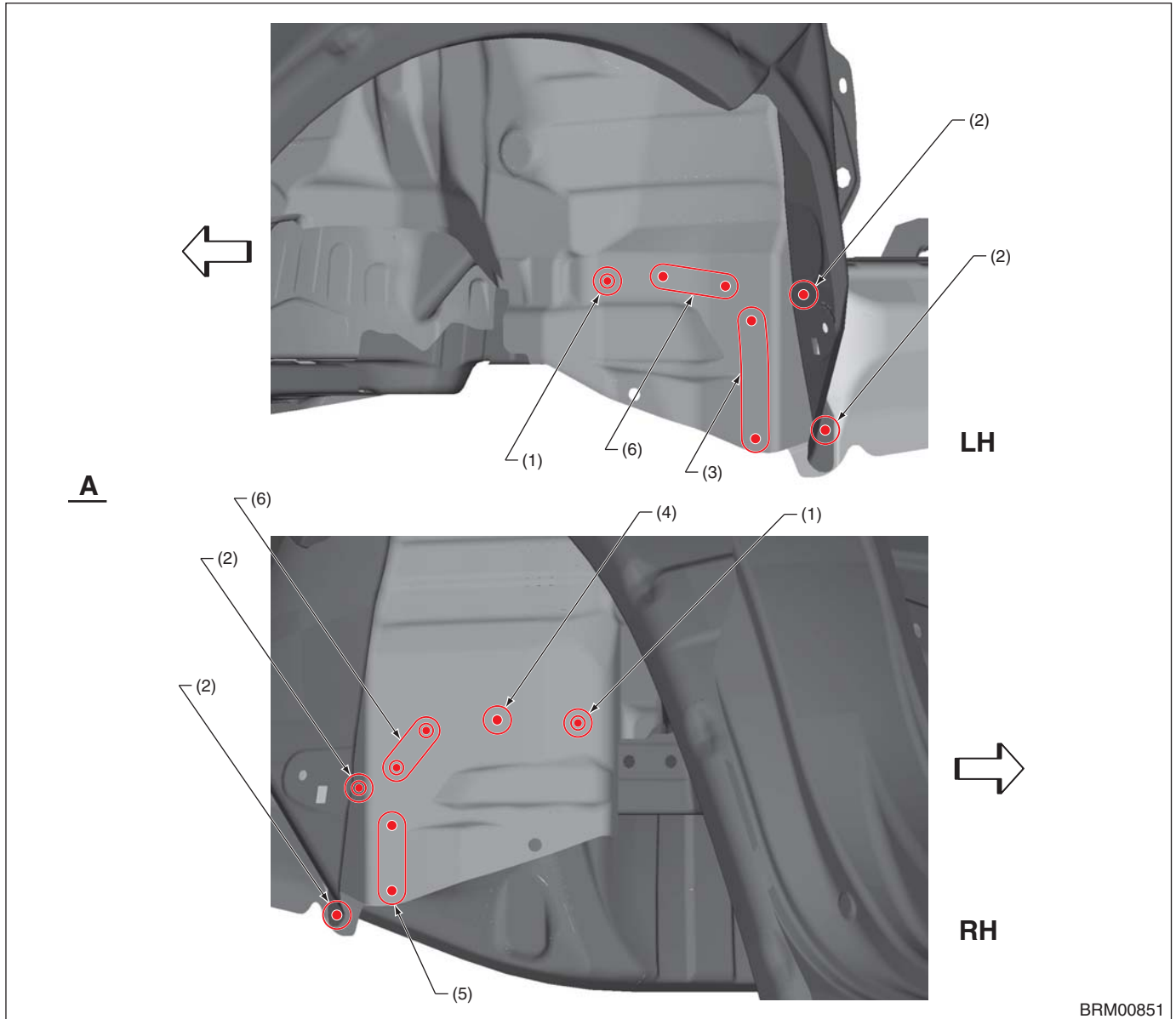
(3) LH: 2 points (top - 2)

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)

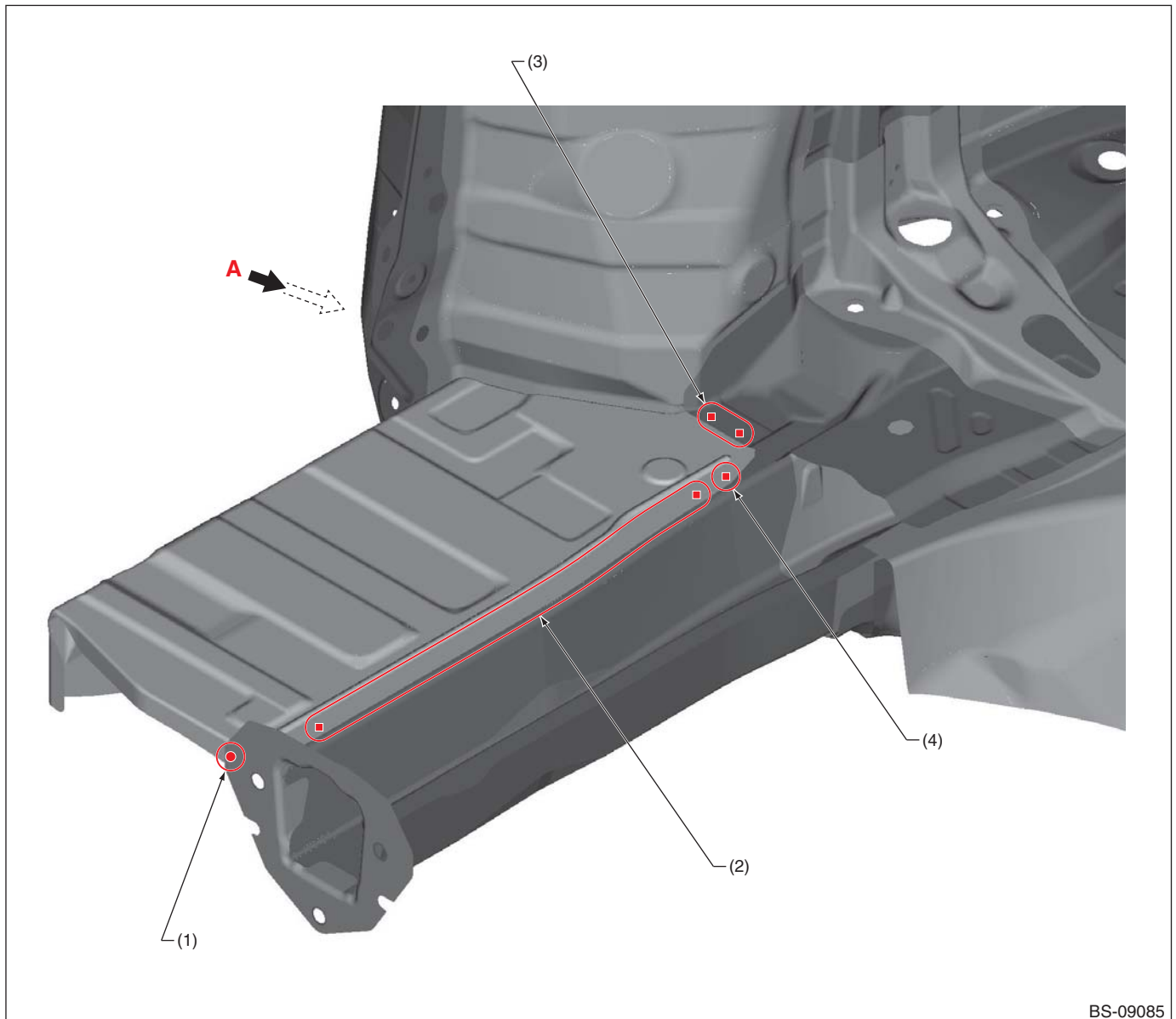
(3) 3 points (inside · 1)
(4) 1 point (outside · 1)

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

Panel Replacement

B: INSTALLATION

• Overall view



BS-09085

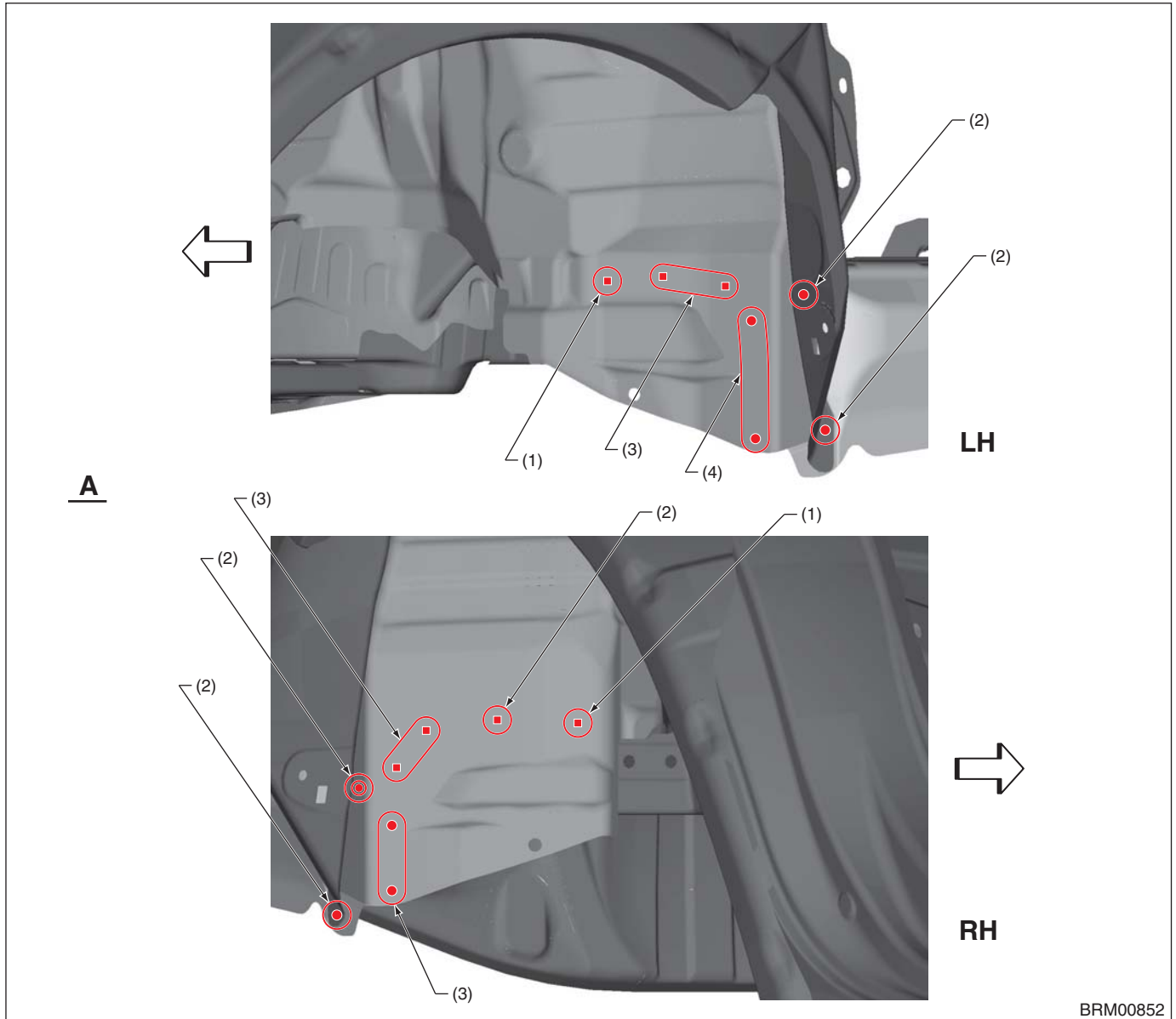
- (1) 1 point
- (2) 10 points (service)

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

- (4) 1 point (service)

Panel Replacement

• Views A



BRM00852

(1) 1 point (service · matching)

(2) 1 point

(3) 2 points

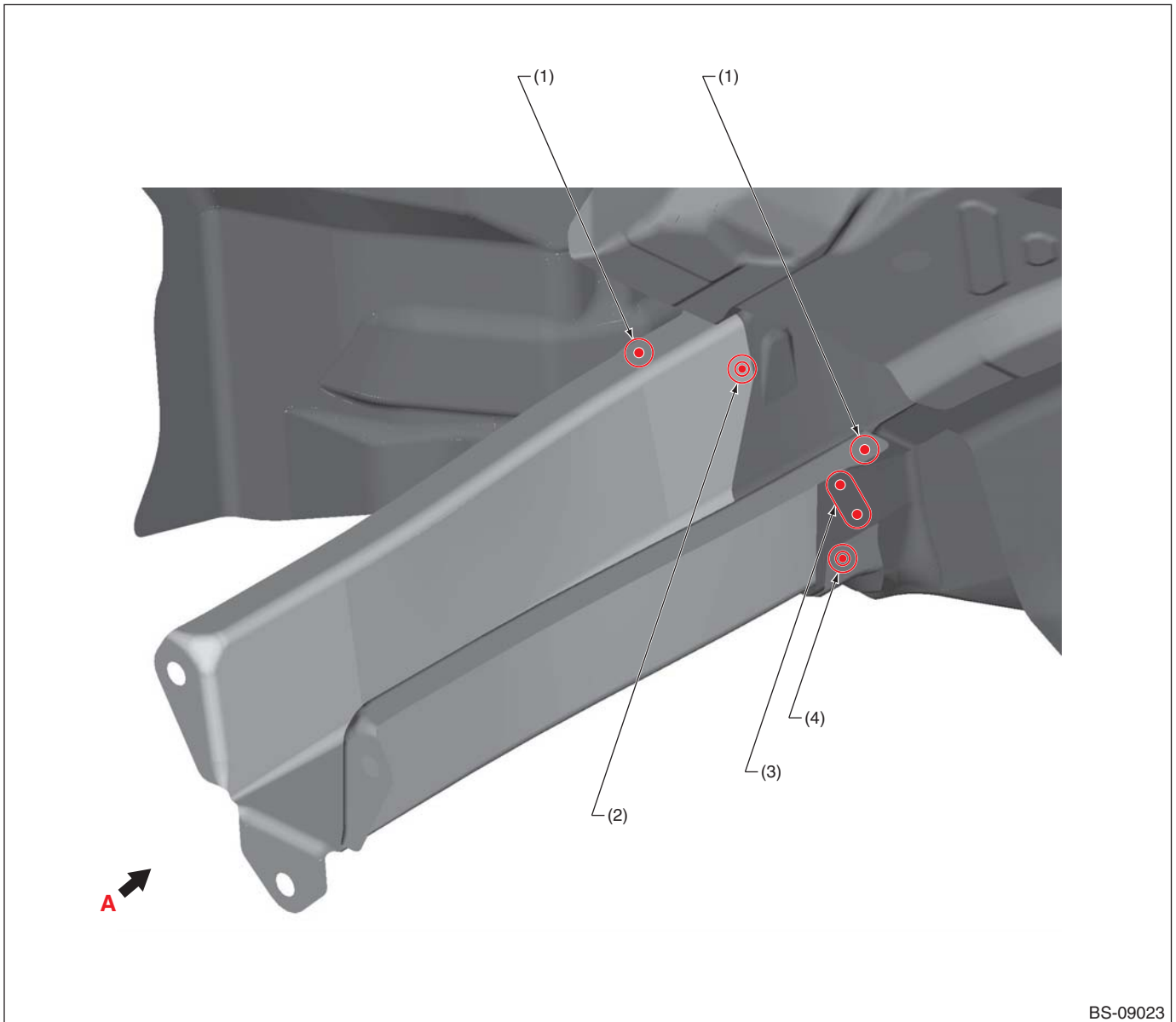
(4) 3 points

Panel Replacement

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

A: REMOVAL

• Overall view



BS-09023

(1) 1 point (top · 1)

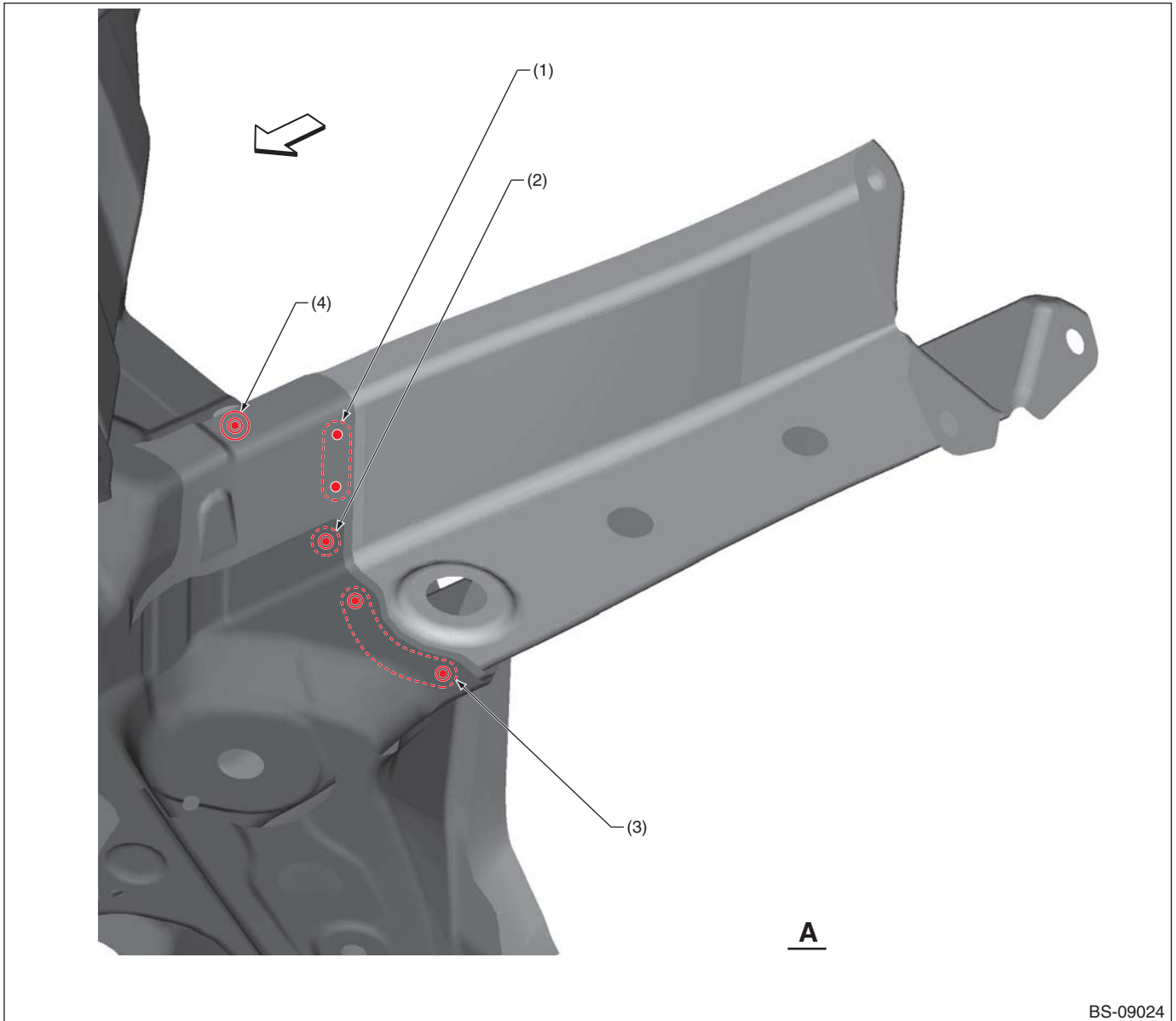
(2) 1 point (inside · 1 belt sander)

(3) 2 points (inside · 1)

(4) 1 point (inside · 2)

Panel Replacement

• Views A



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

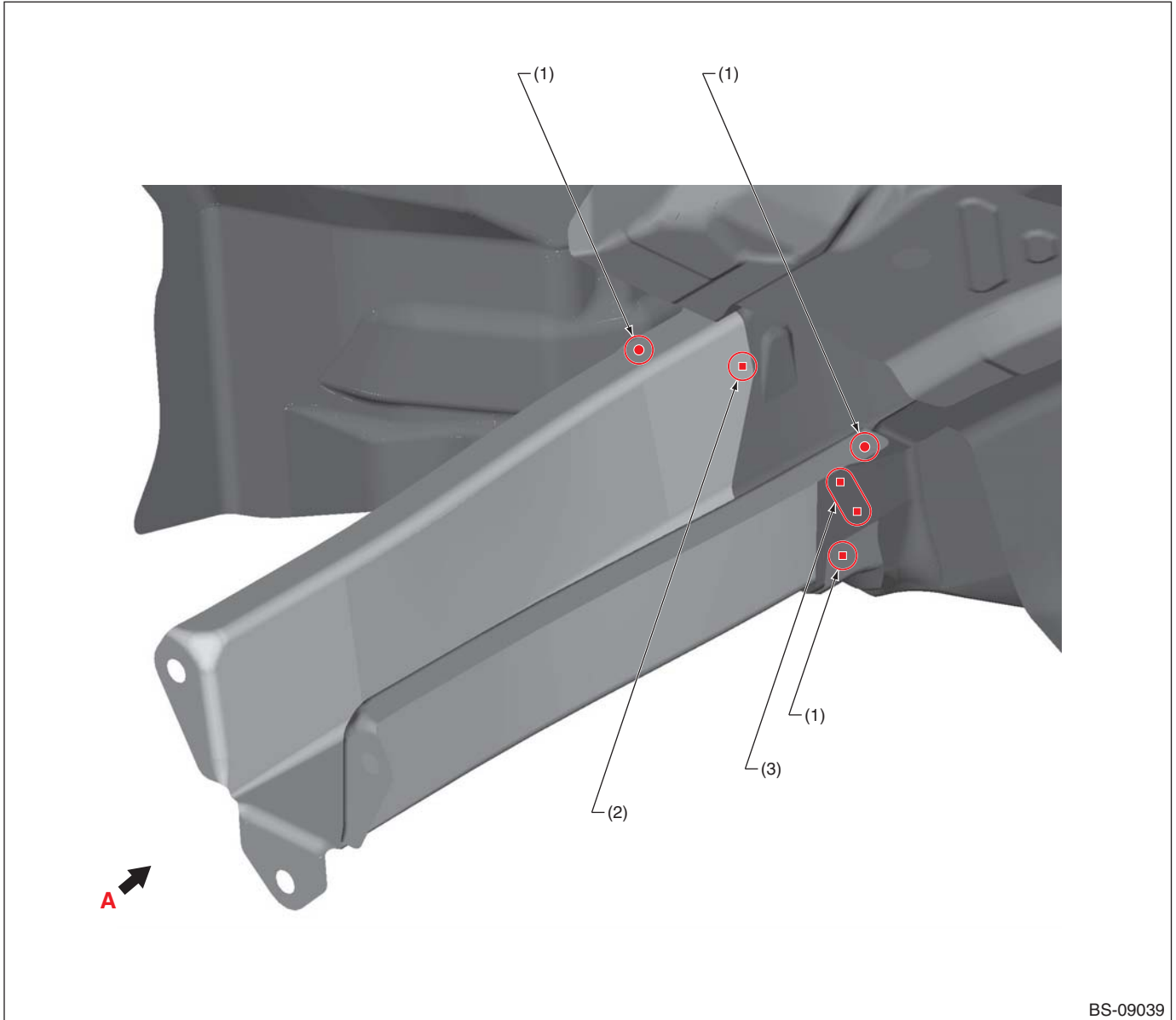
(3) 3 points (top · 1)

(4) 1 point (bottom · 2)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09039

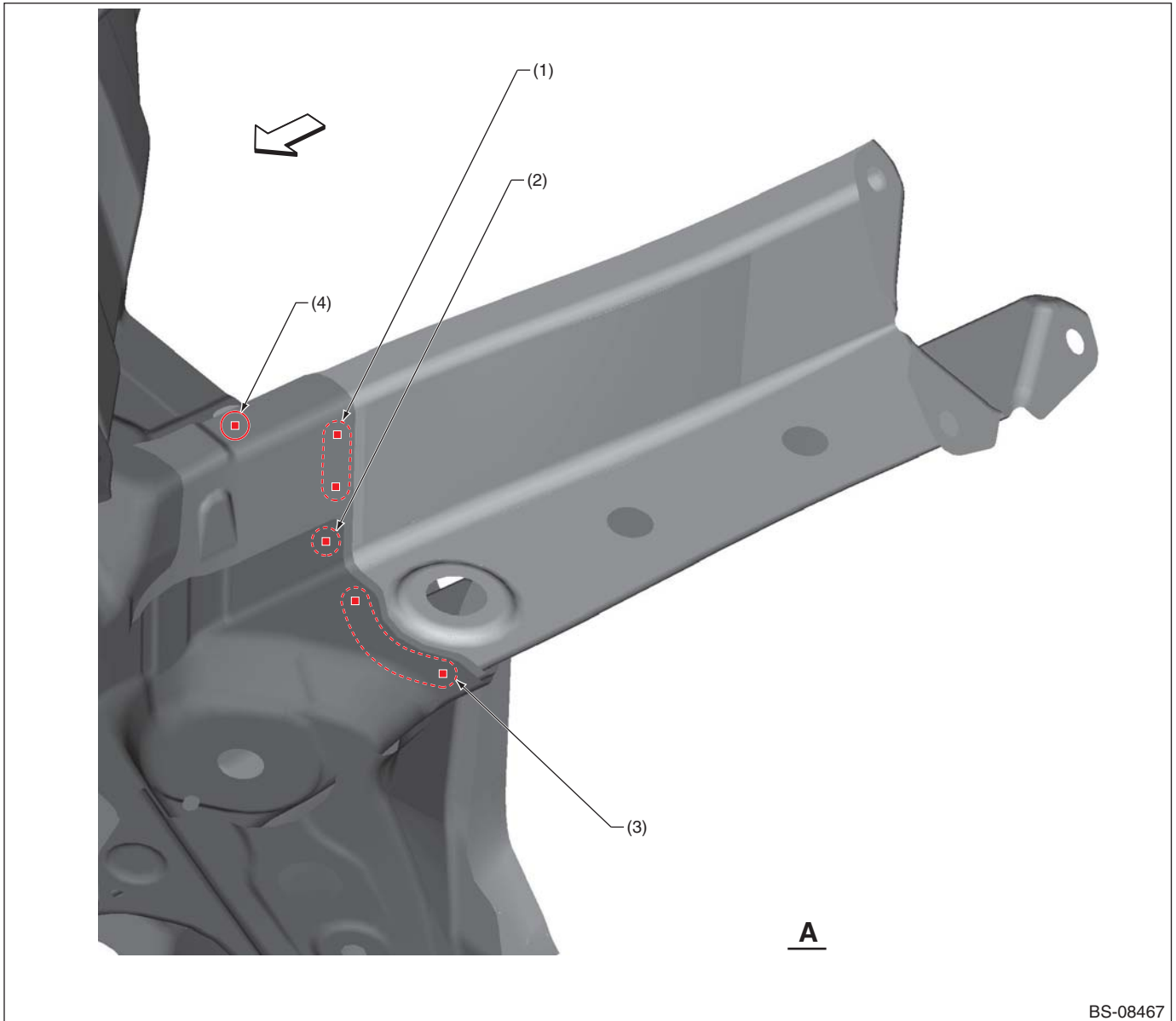
(1) 1 point

(2) 1 point (service)

(3) 2 points

Panel Replacement

• Views A



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

(3) 3 points (service)

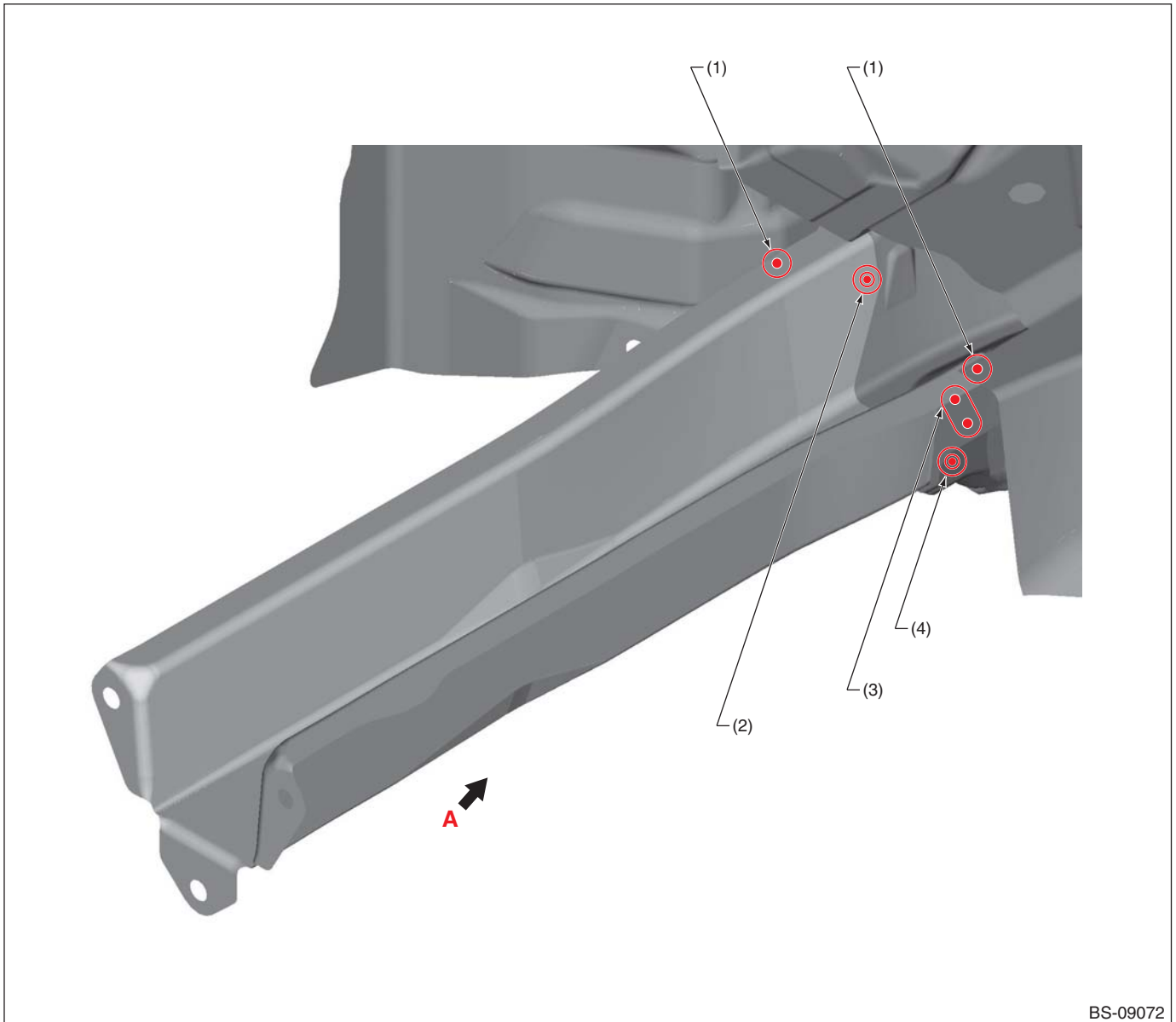
(4) 1 point

Panel Replacement

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

A: REMOVAL

• Overall view



(1) 1 point (top · 1)

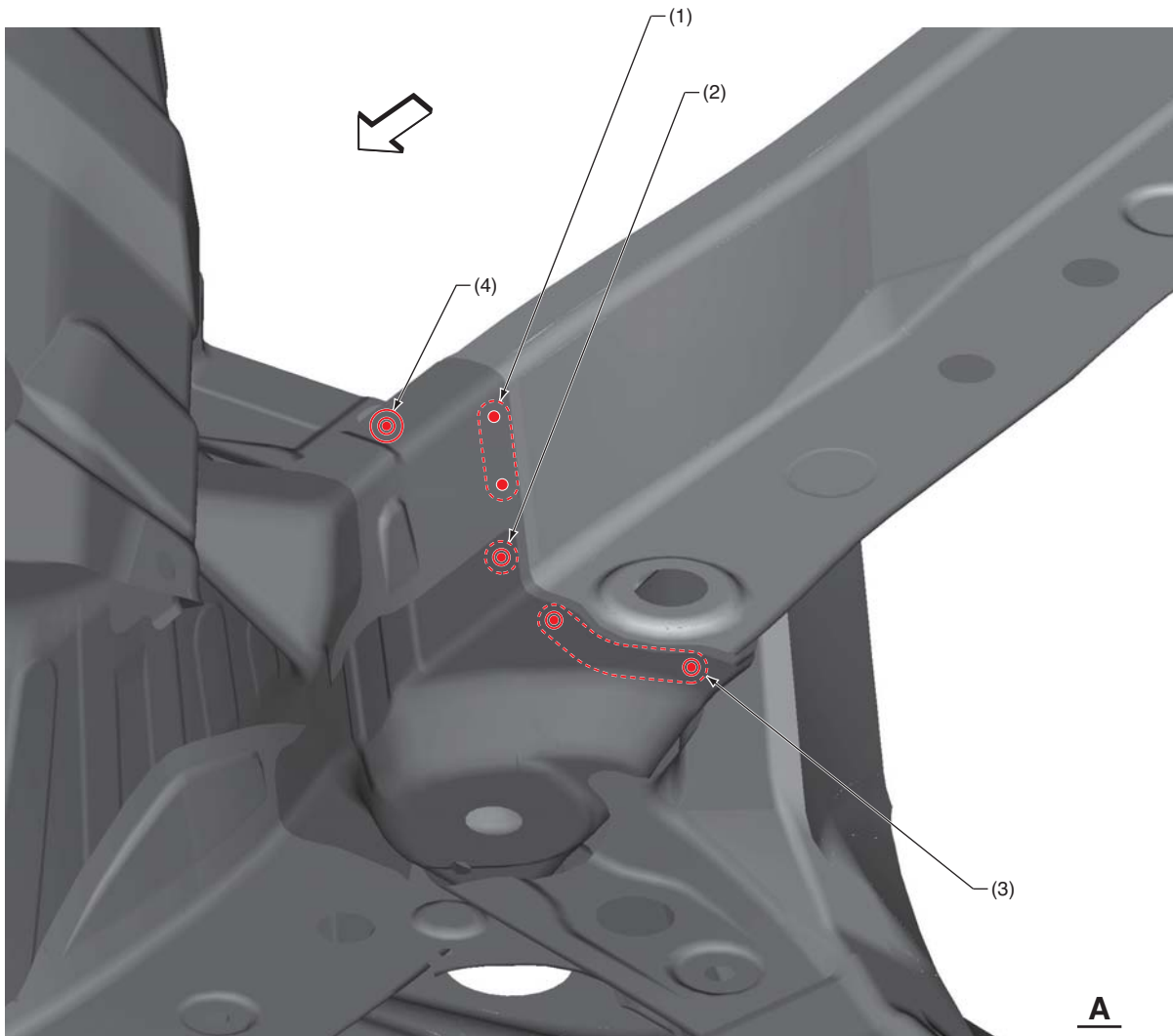
(2) 1 point (inside · 1 belt sander)

(3) 2 points (inside · 1)

(4) 1 point (inside · 2)

Panel Replacement

• Views A



BS-09073

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

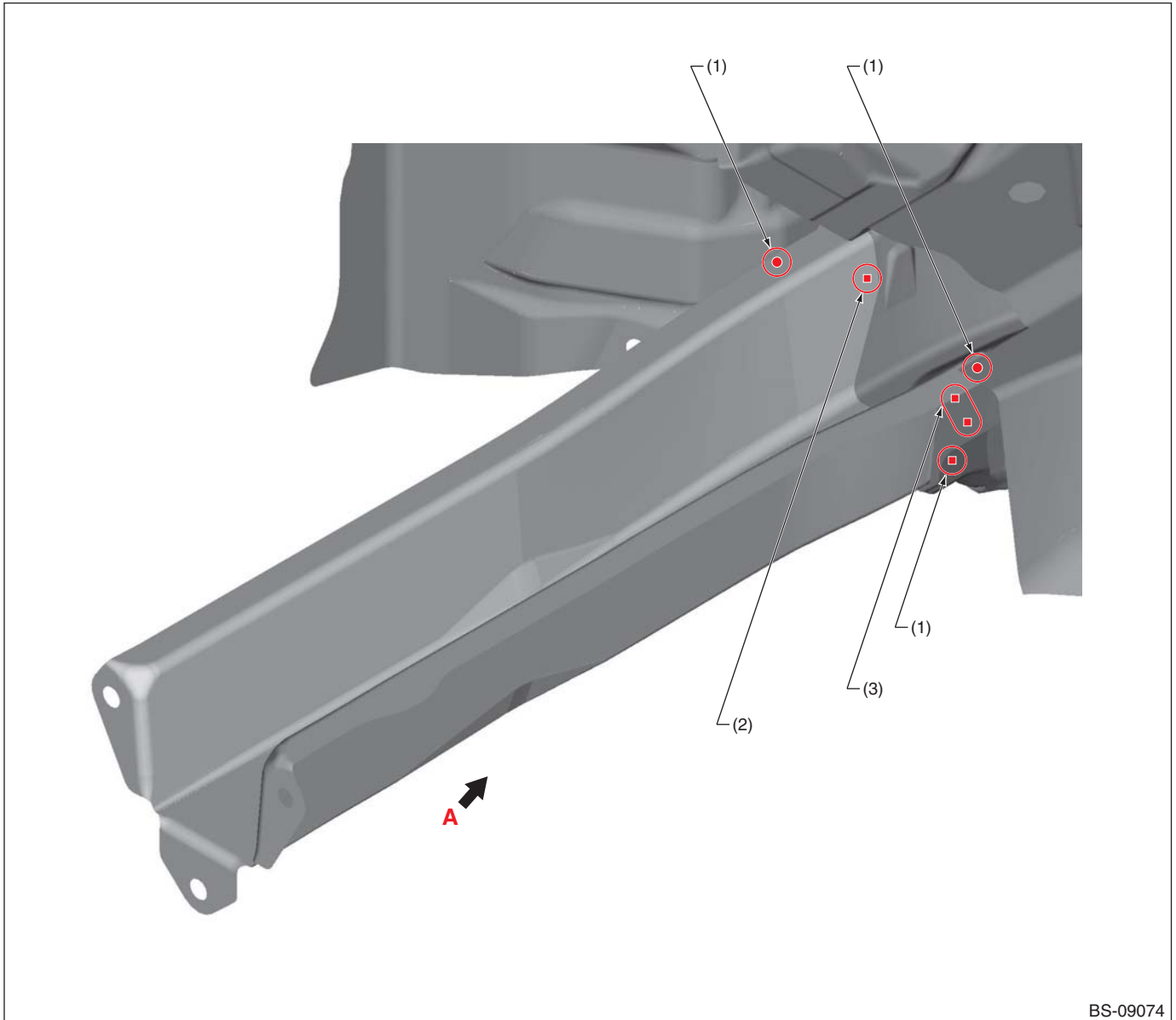
(3) 3 points (top · 1)

(4) 1 point (bottom · 2)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09074

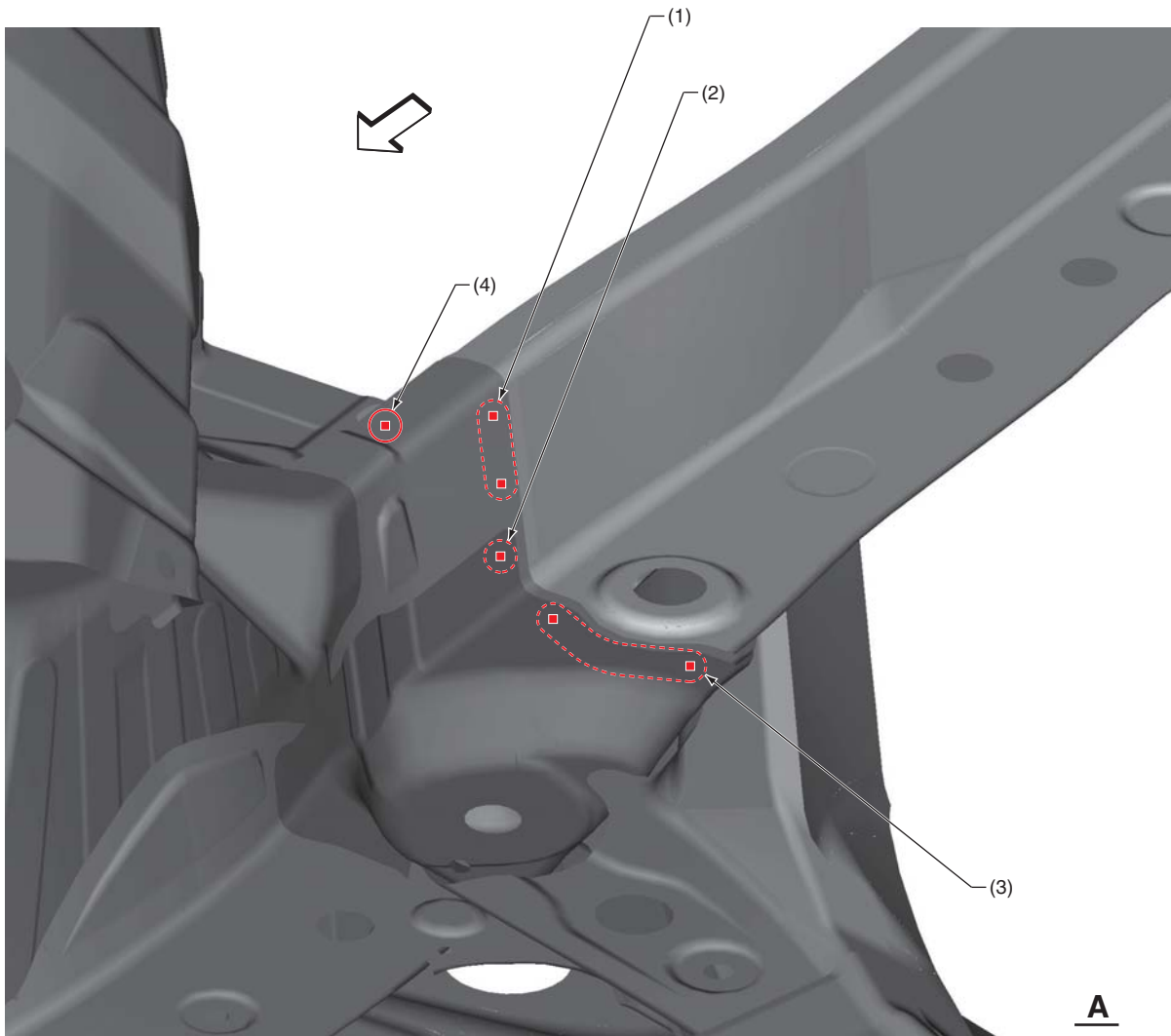
(1) 1 point

(2) 1 point (service)

(3) 2 points

Panel Replacement

• Views A



BS-08621

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

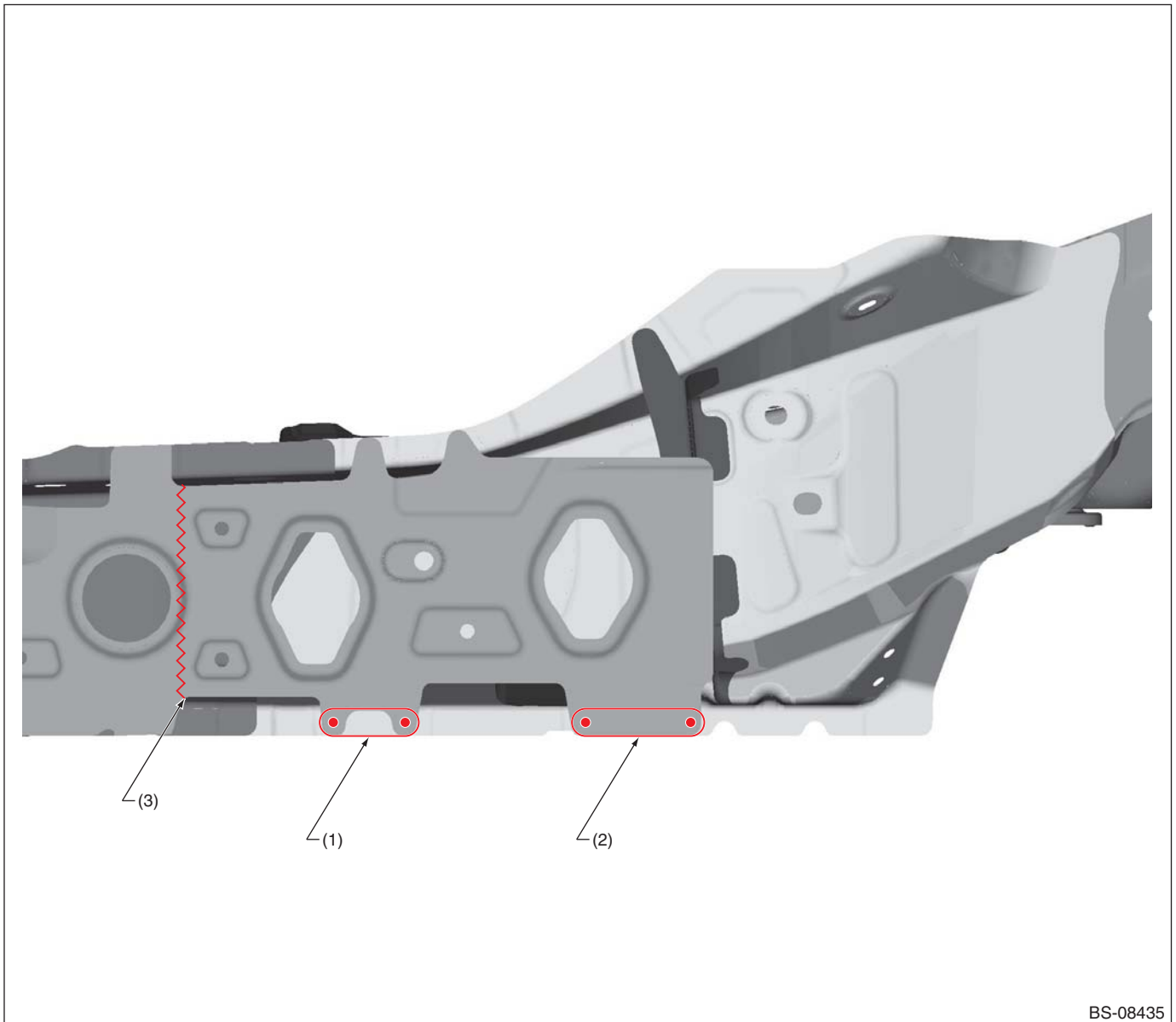
(3) 3 points (service)

(4) 1 point

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

A: REMOVAL

• Overall view1



BS-08435

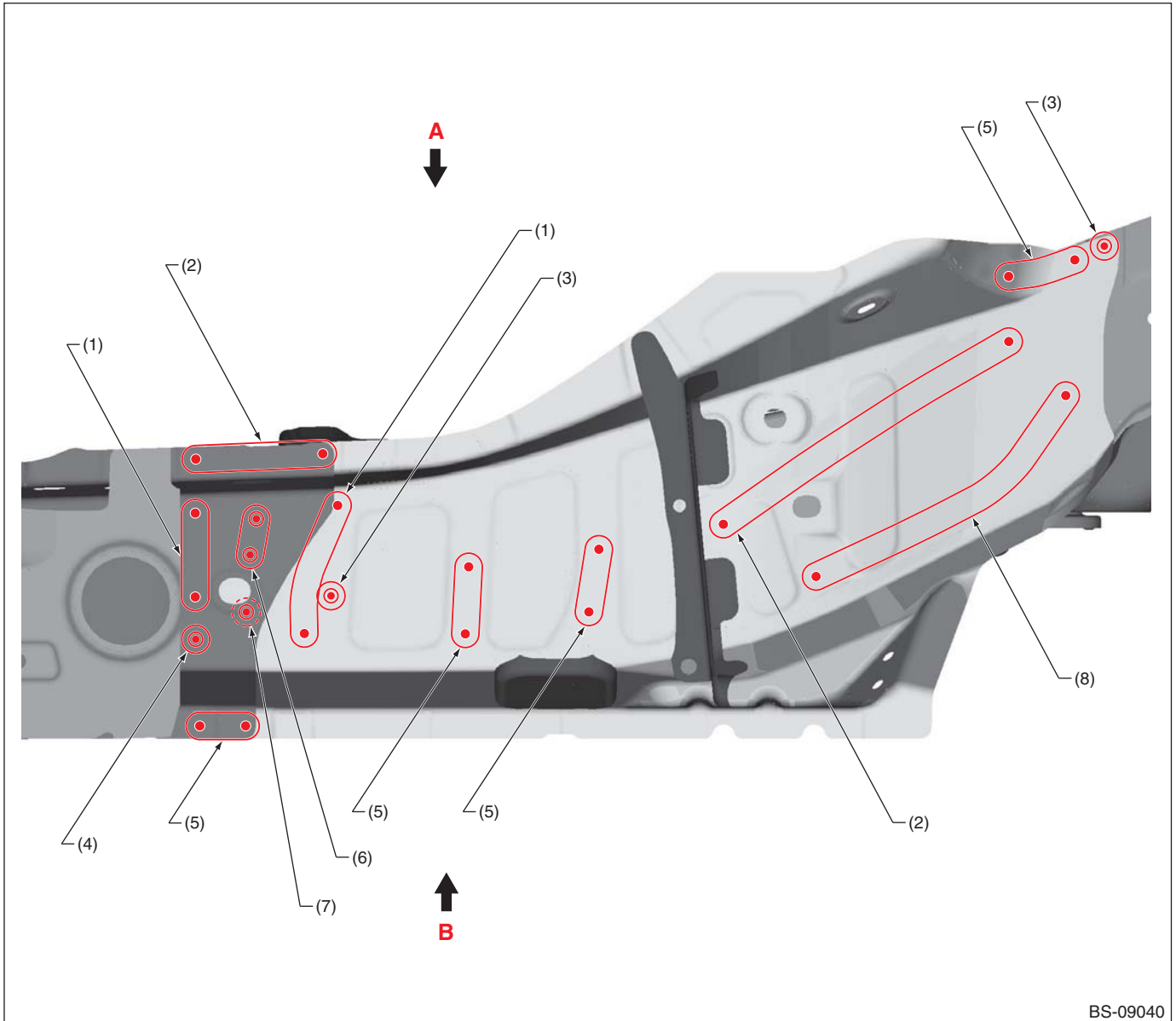
(1) 2 points (outside · 1)

(2) 3 points (outside · 1)

(3) Rough cutting

Panel Replacement

• Overall view2

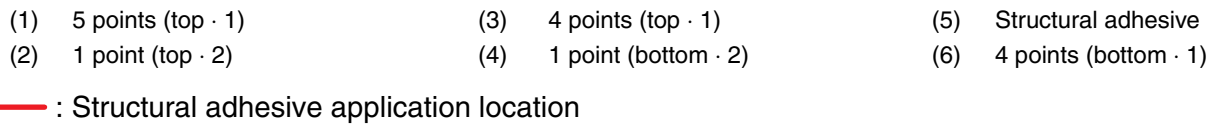


- (1) 3 points (outside · 1)
- (2) 4 points (outside · 1)
- (3) 1 point (outside · 1)

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

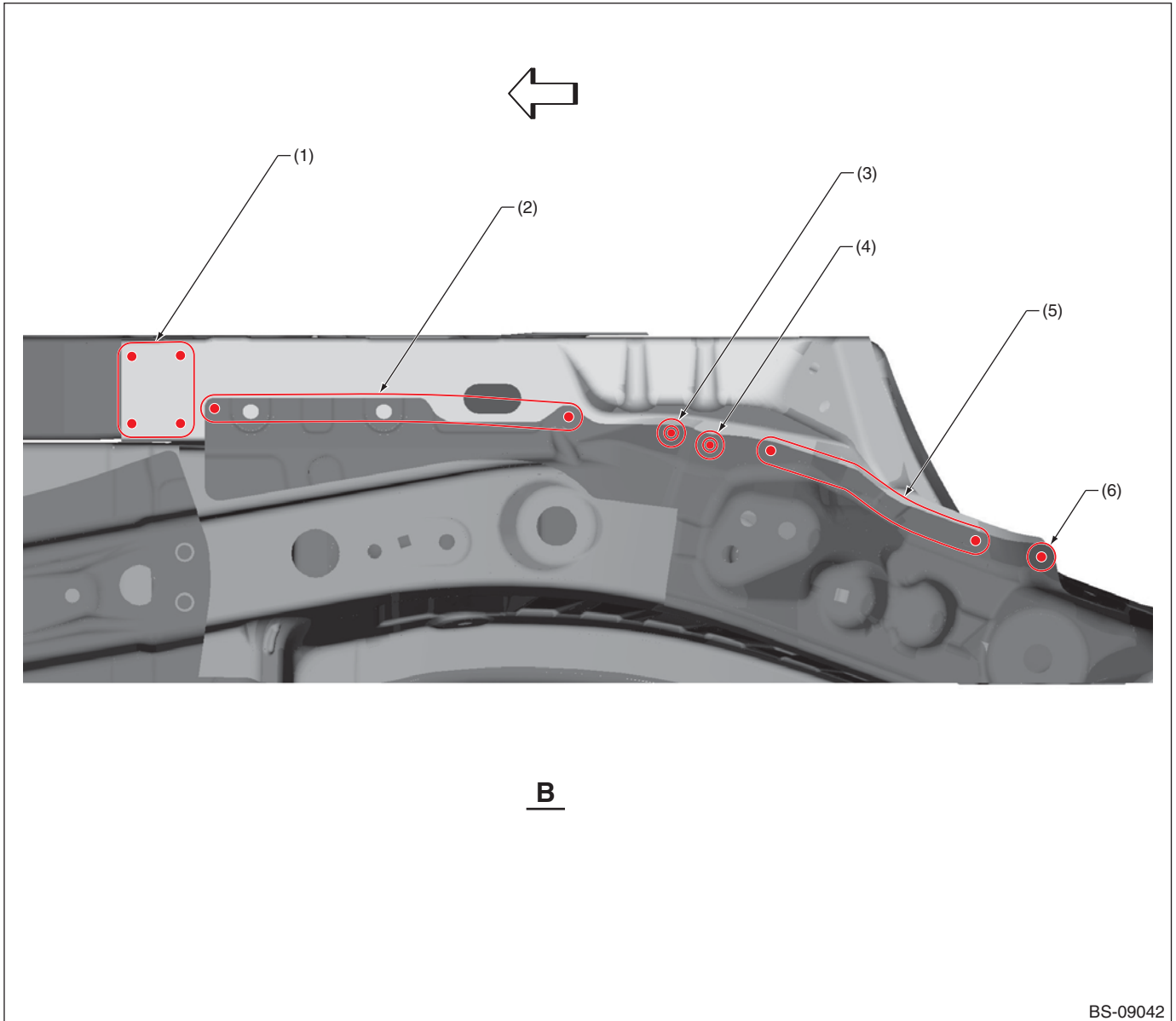
- (7) 1 point (inside · 2)
- (8) 4 points (outside · 1)

- **Views A**



Panel Replacement

• Views B



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

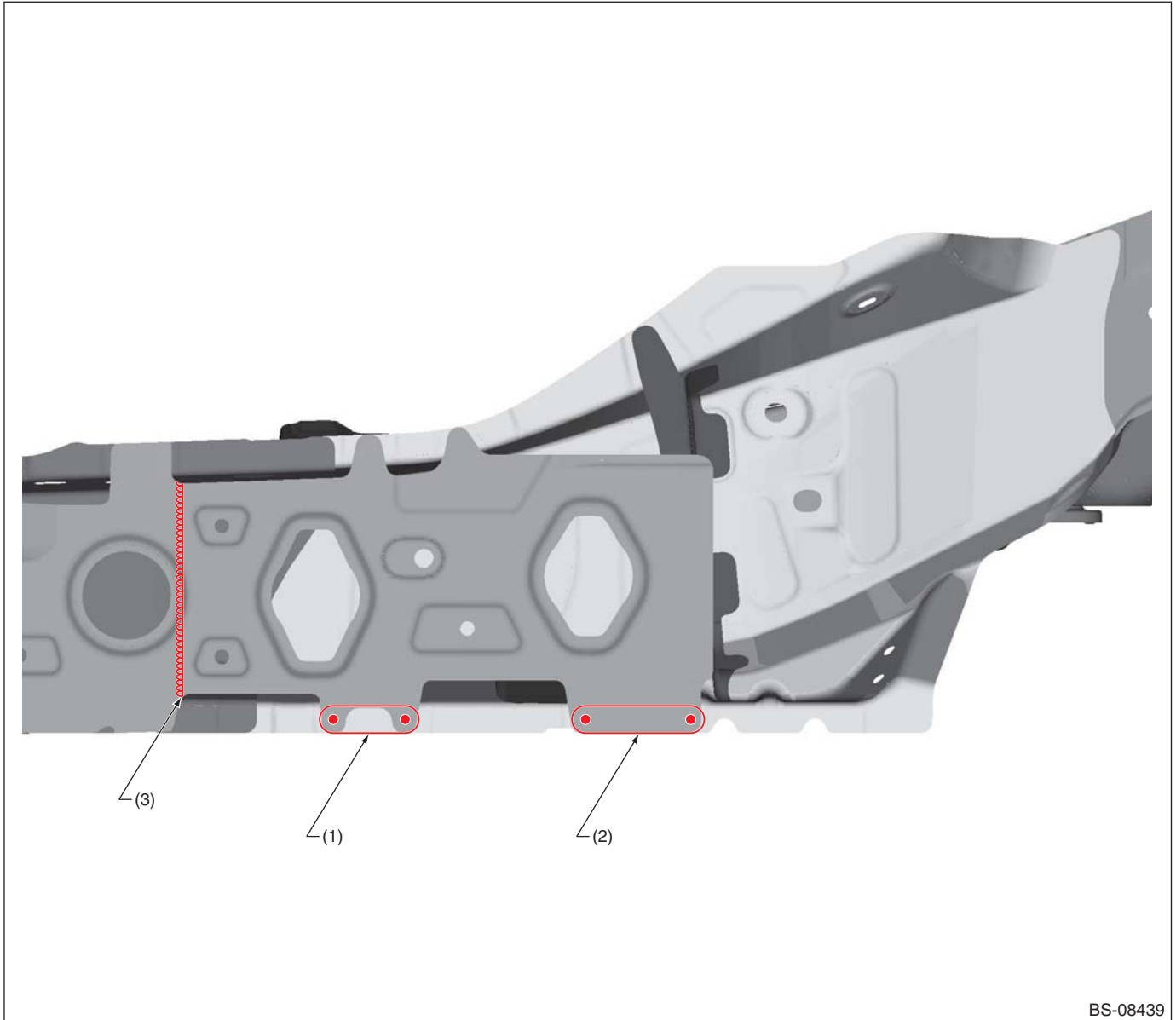
(3) 1 point (top · 2)
(4) 1 point (top · 1)

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

Panel Replacement

B: INSTALLATION

• Overall view¹



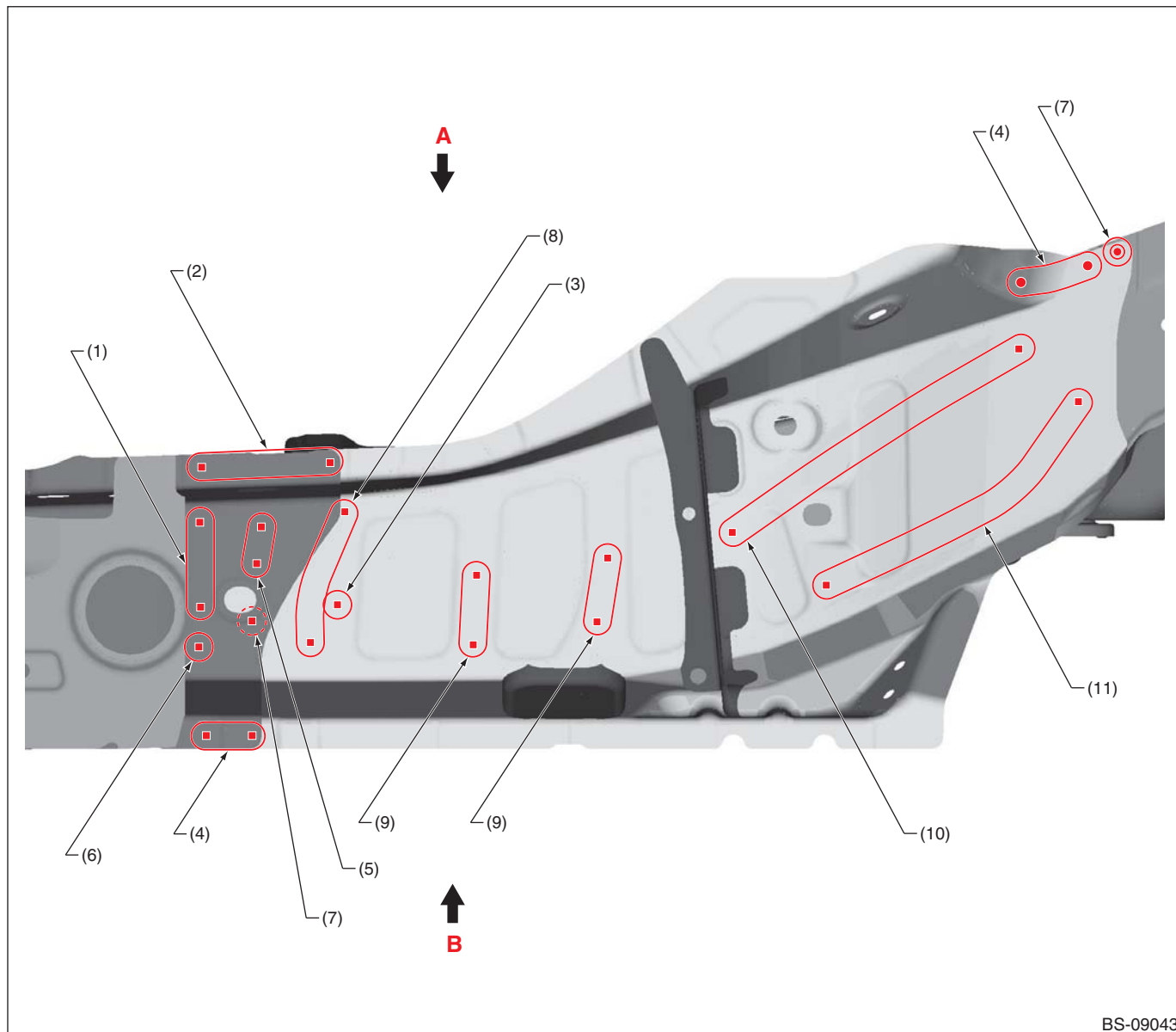
(1) 2 points

(2) 3 points

(3) 1 point (Continuous welding)

Panel Replacement

• Overall view2

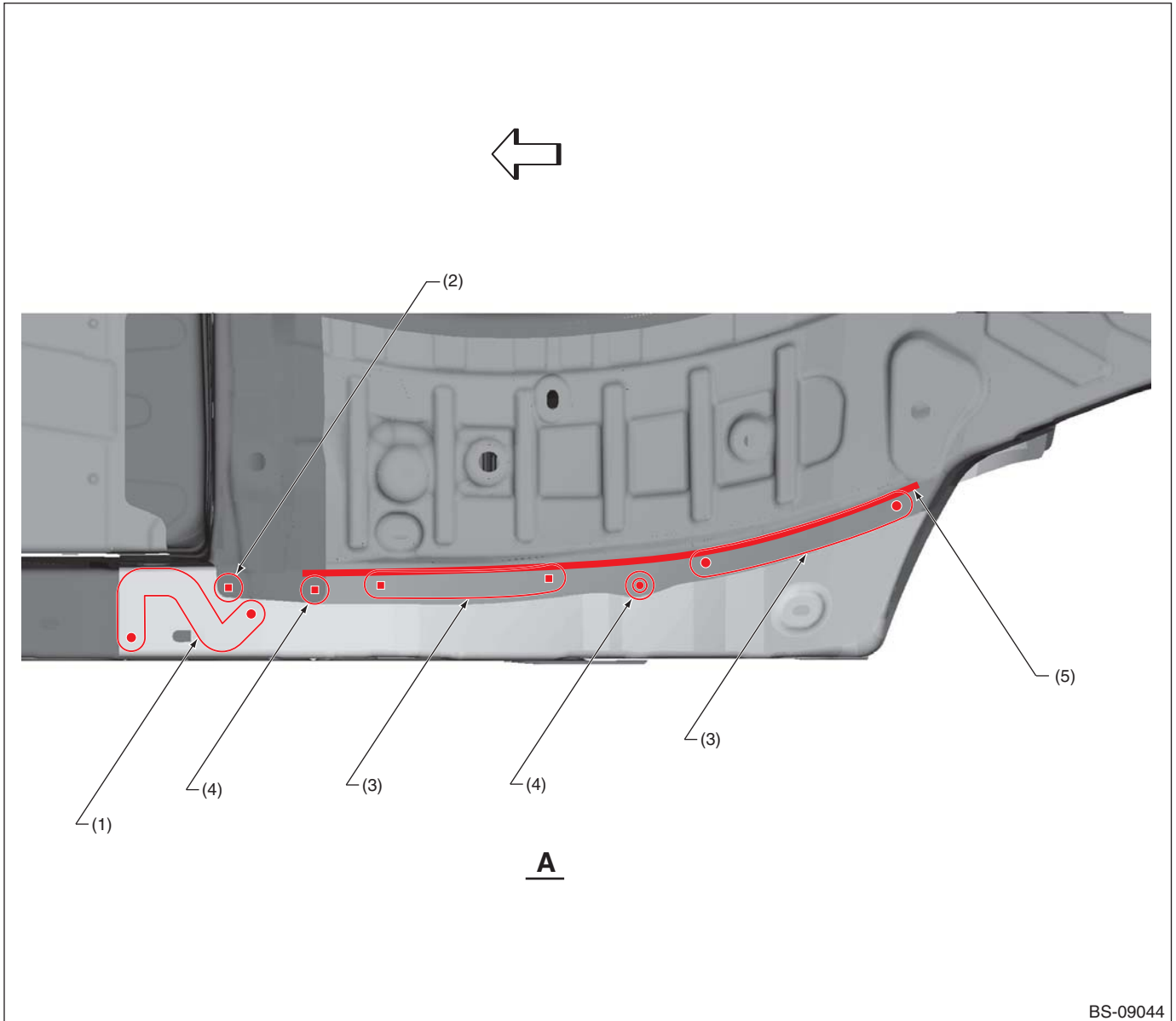


BS-09043

- | | | |
|-----------------------|-----------------------------------|-------------------------|
| (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) | |

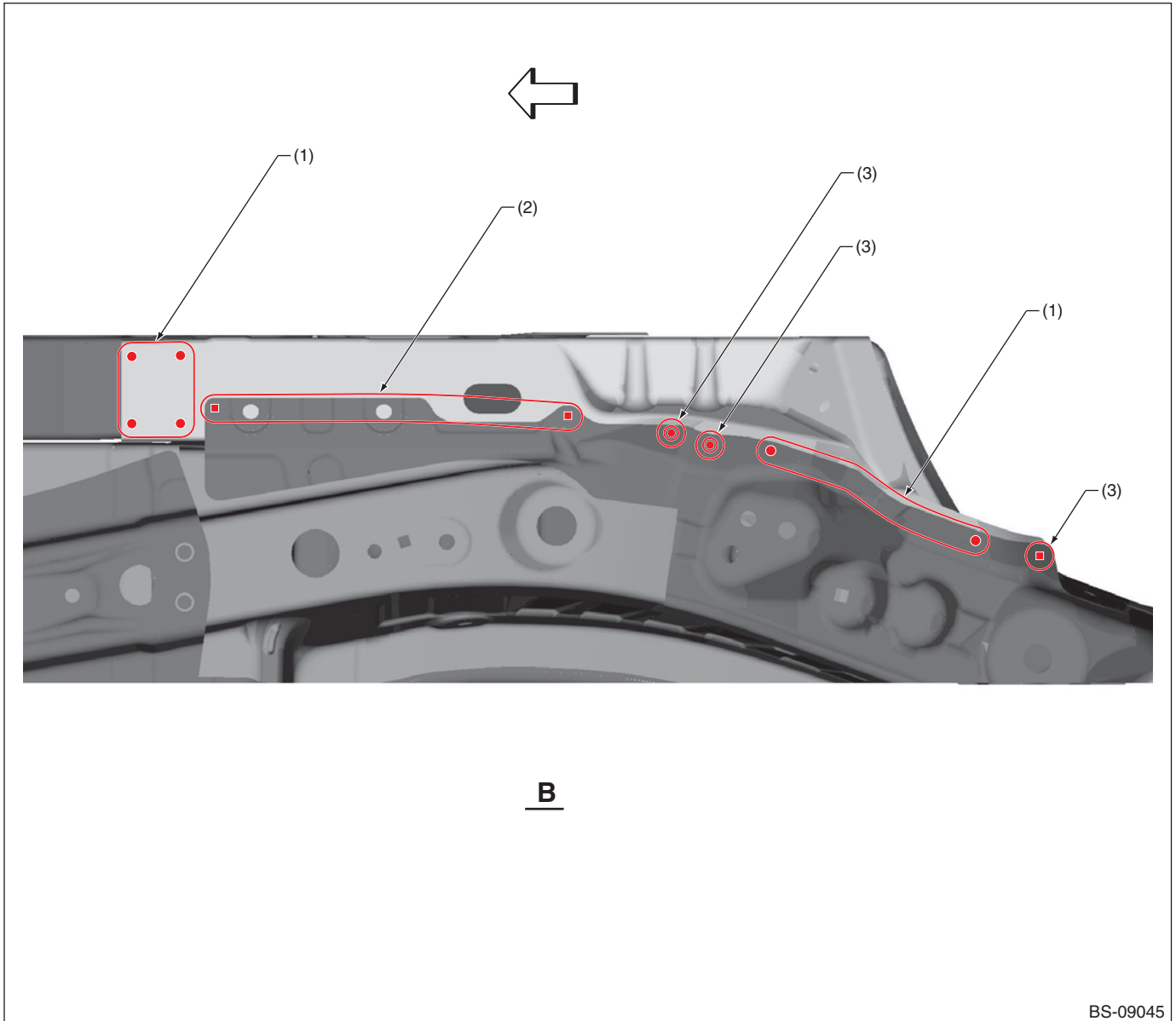
Panel Replacement

• Views A



Panel Replacement

• Views B



(1) 4 points

(2) 5 points

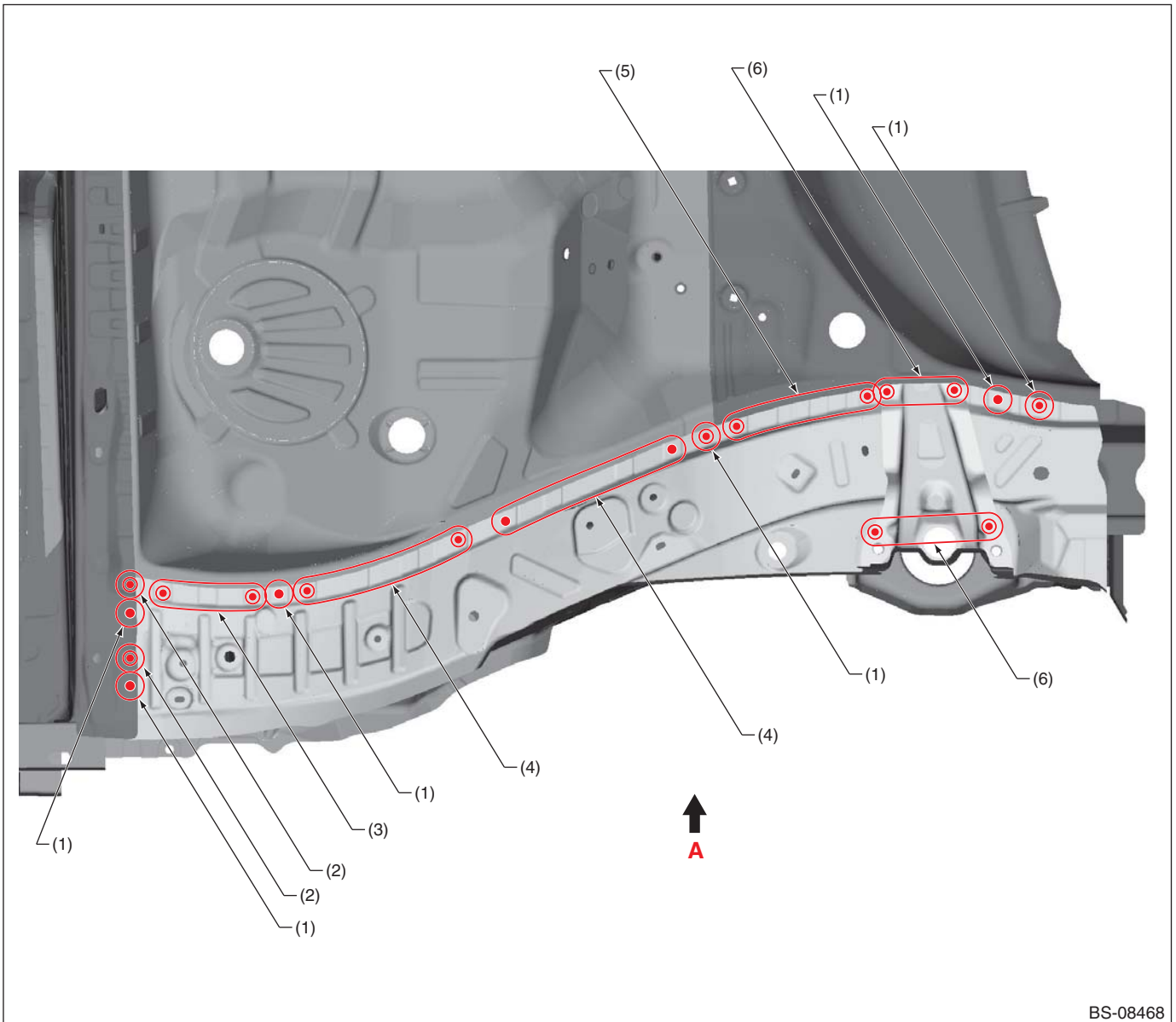
(3) 1 point

Panel Replacement

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

A: REMOVAL

• Overall view



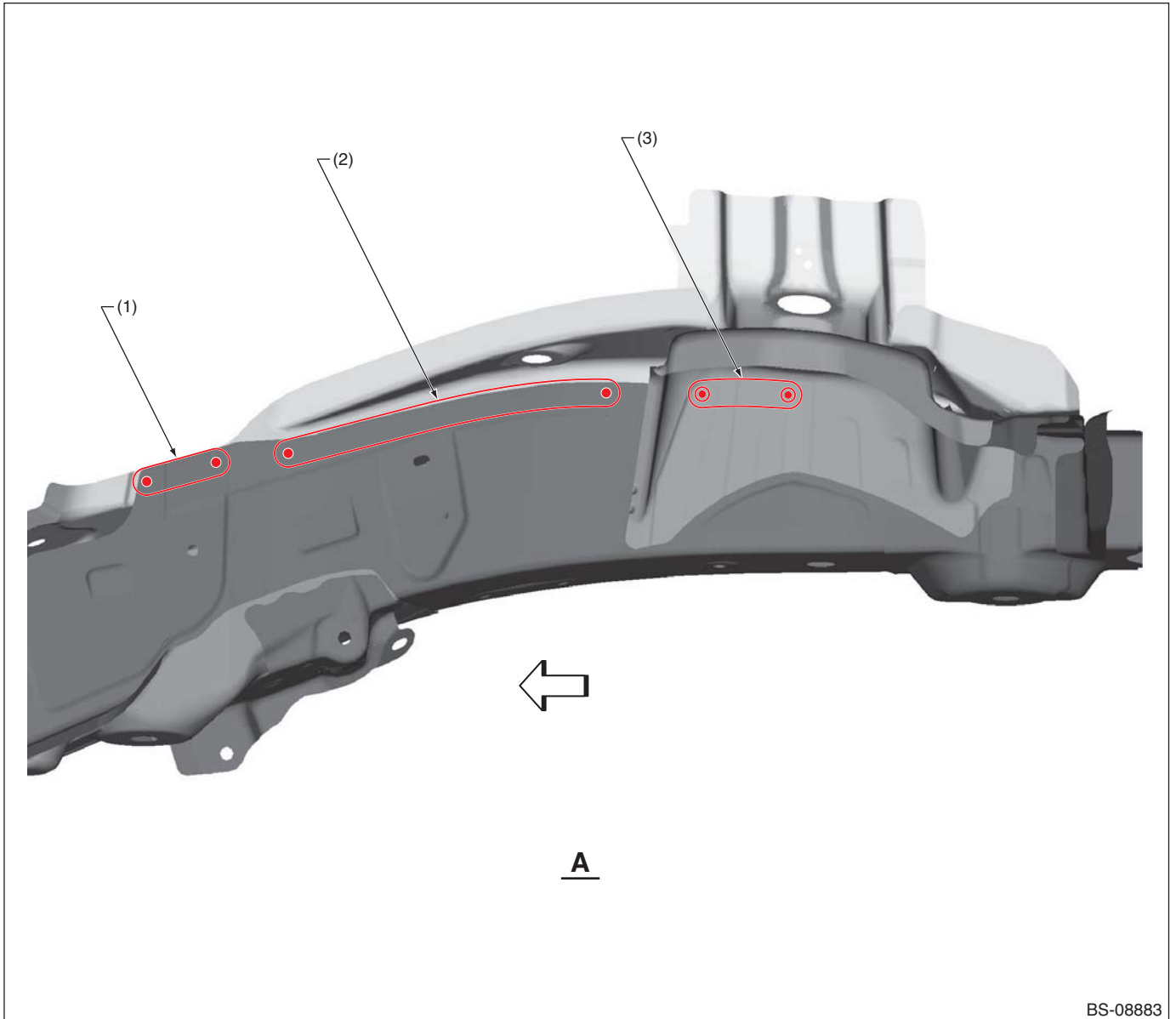
(1) 1 point (top · 1)
(2) 1 point (top · 2)

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

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

Panel Replacement

• Views A



(1) 3 points (inside · 1)

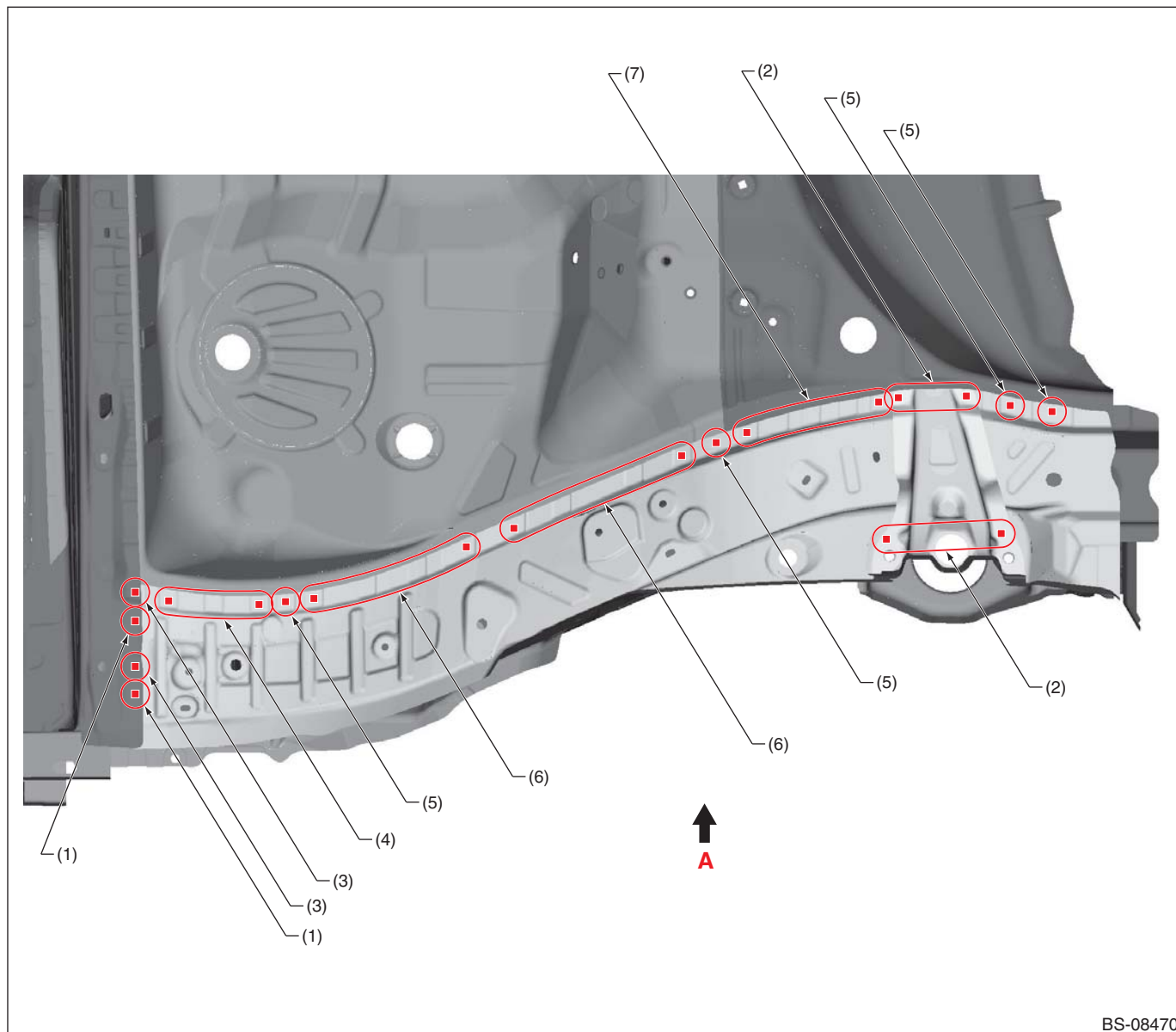
(2) 6 points (outside · 1)

(3) 2 points (outside · 2)

Panel Replacement

B: INSTALLATION

• Overall view

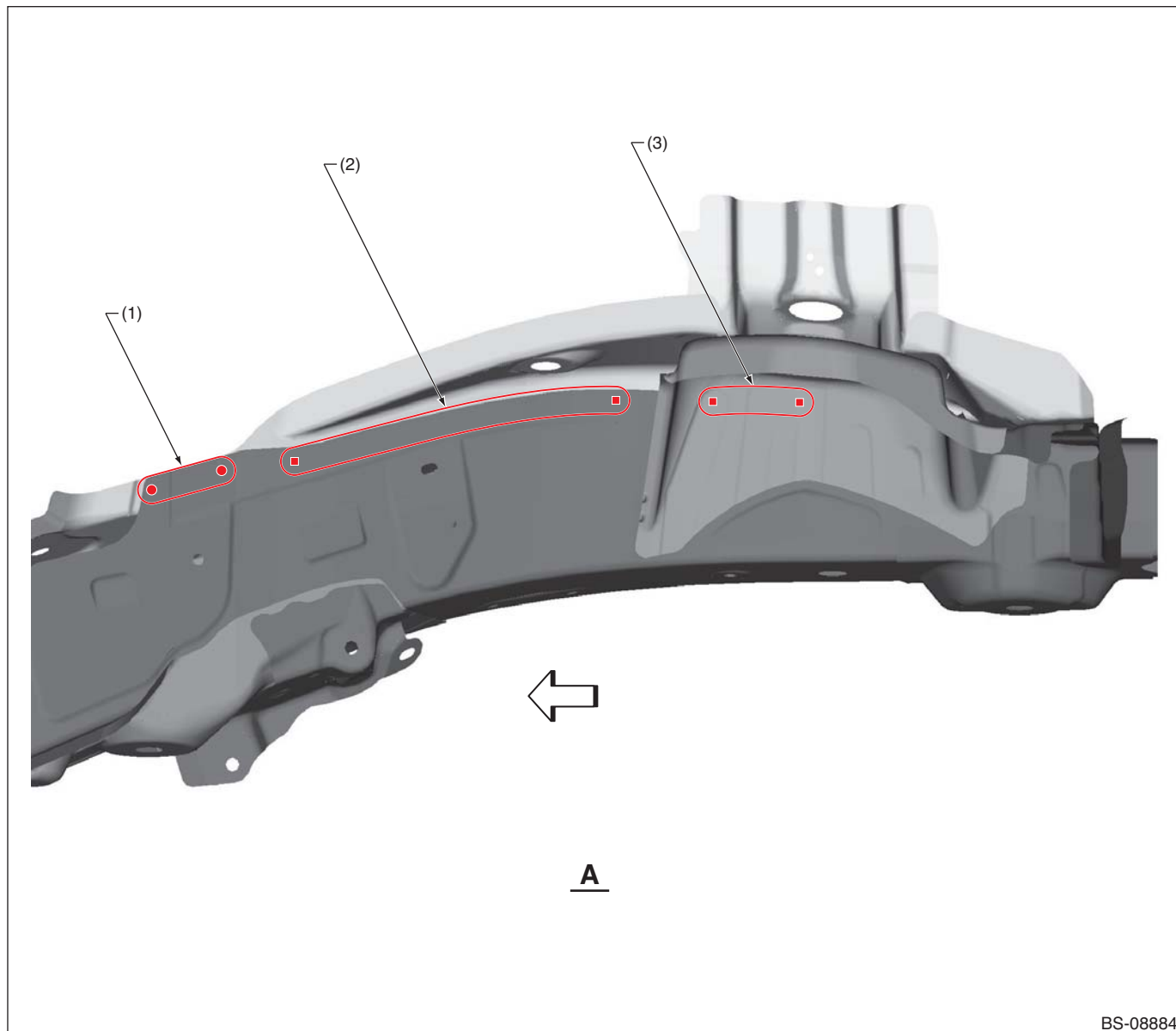


BS-08470

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

Panel Replacement

• Views A



BS-08884

(1) 3 points

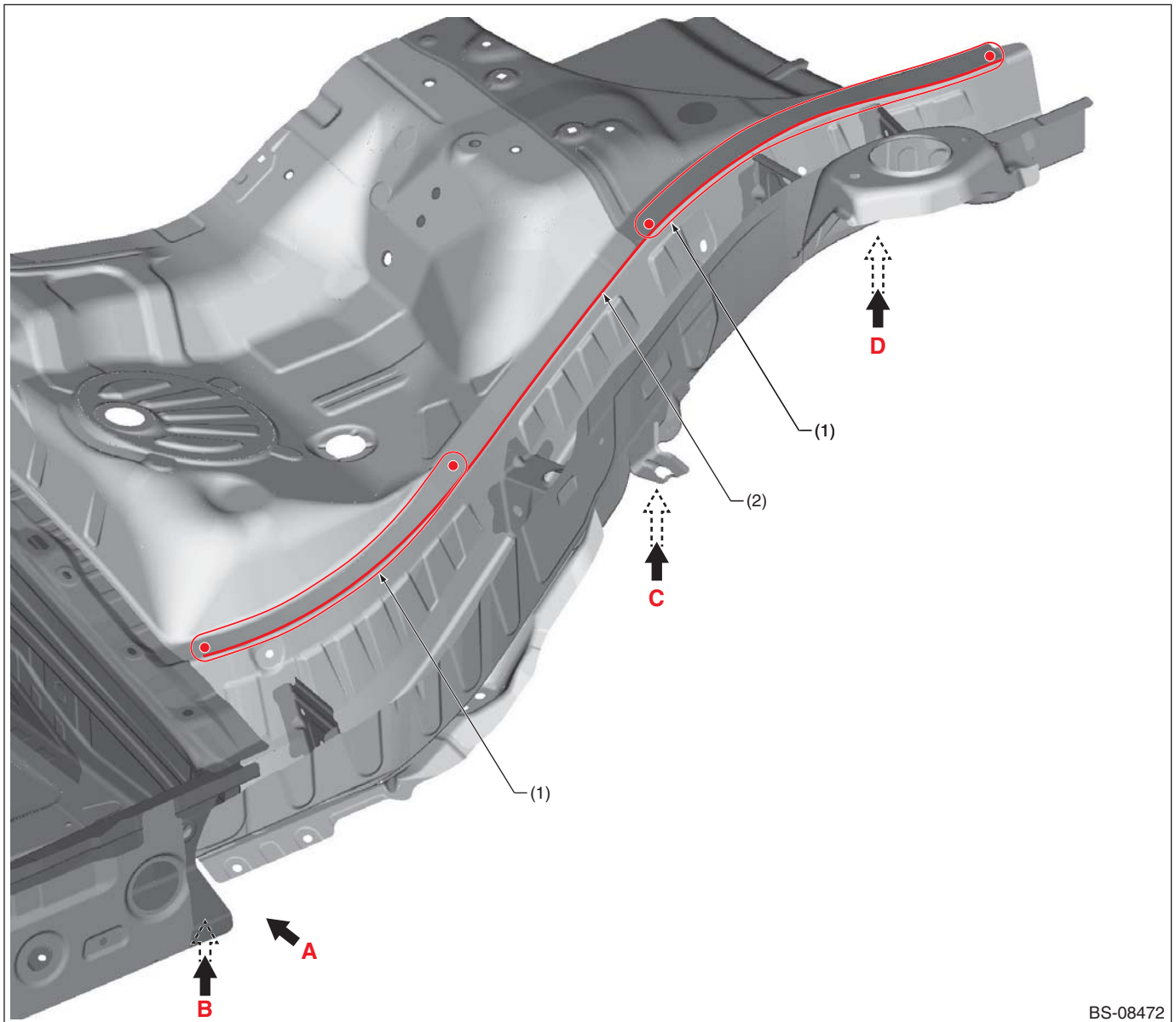
(2) 6 points

(3) 2 points

8-51. Rear Side Frame

A: REMOVAL

• Overall view



BS-08472

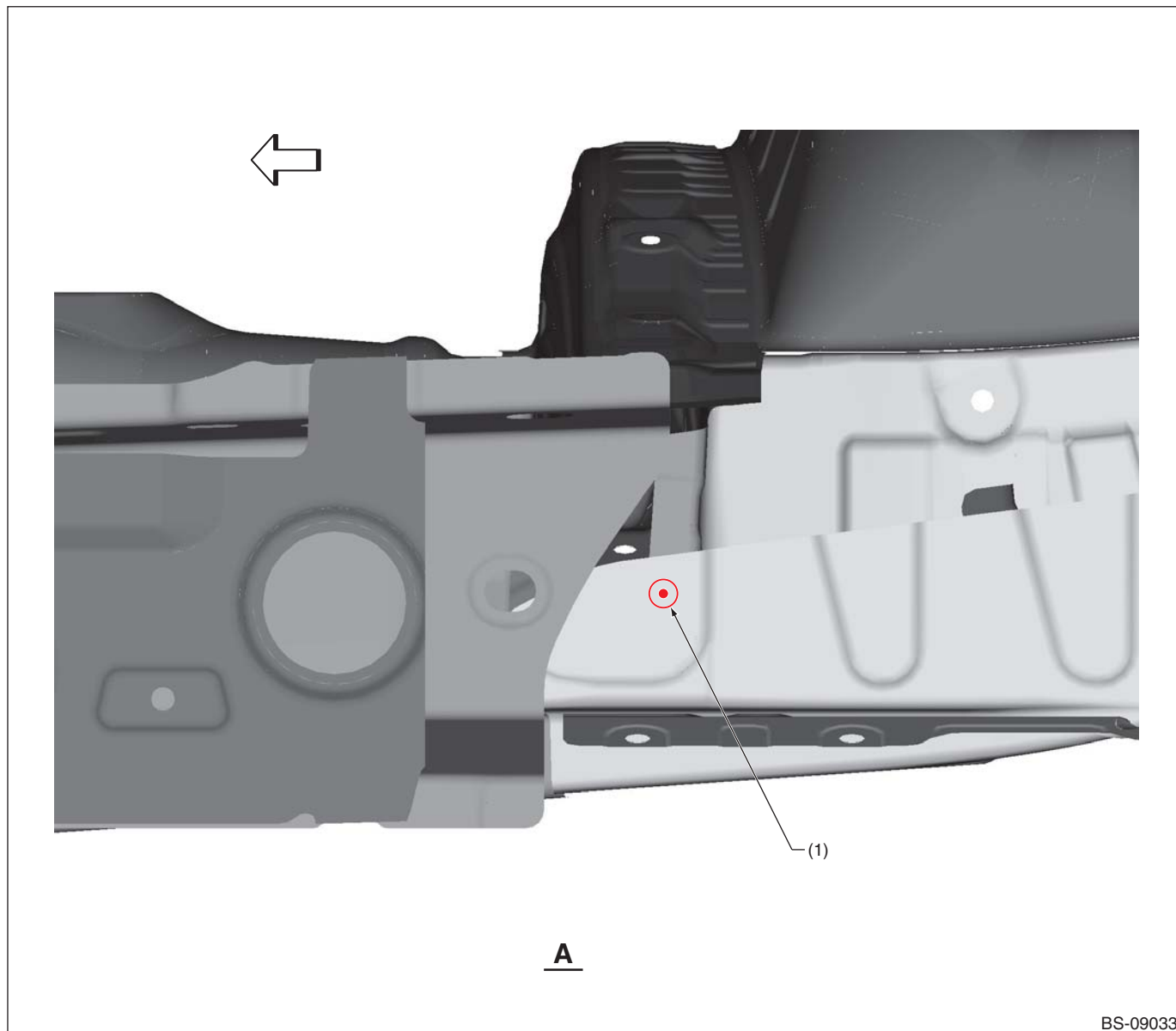
(1) 7 points (top · 1)

(2) Structural adhesive

— : Structural adhesive application location

Panel Replacement

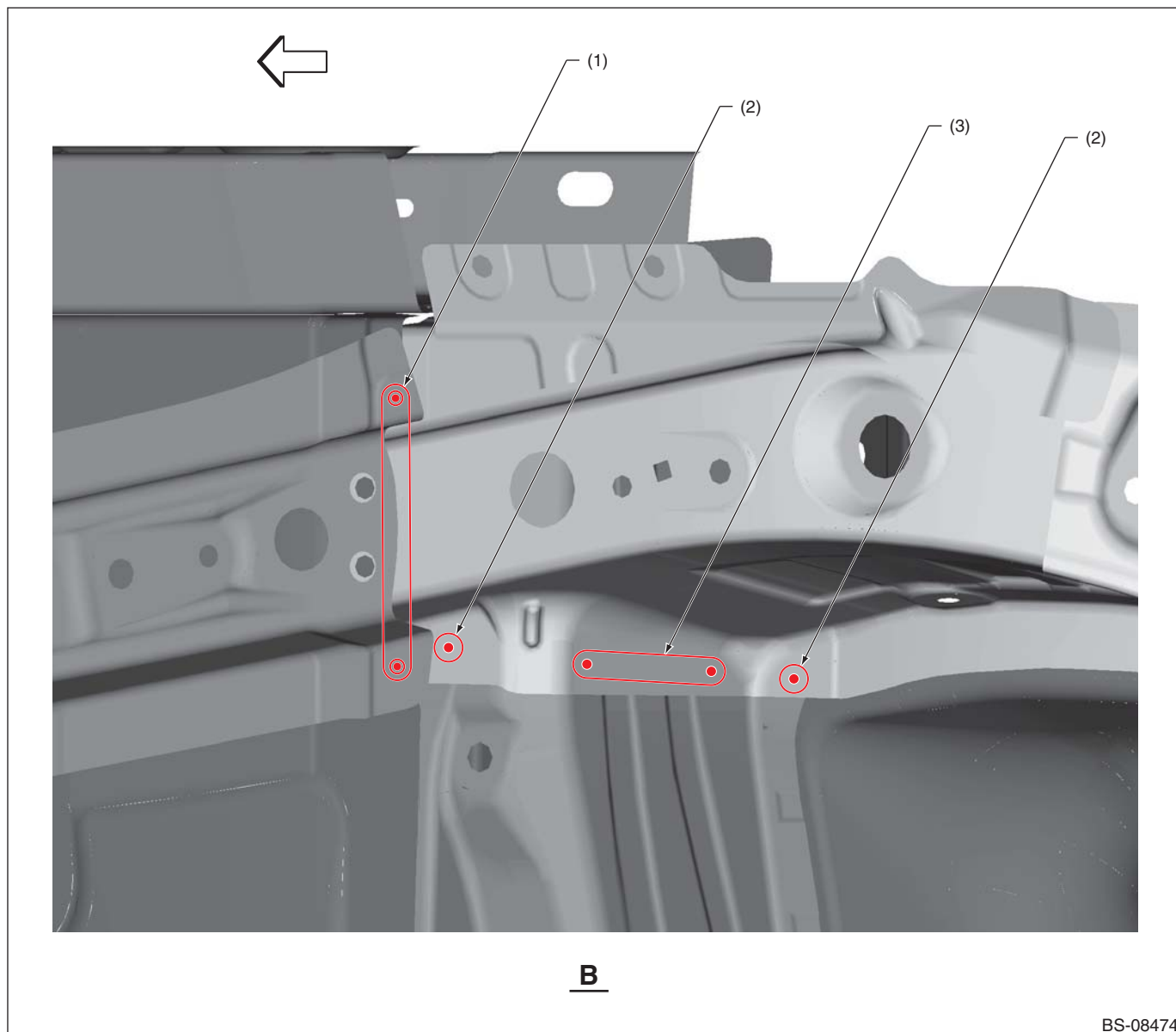
• Views A



(1) 1 point (outside · 1)

Panel Replacement

• Views B



BS-08474

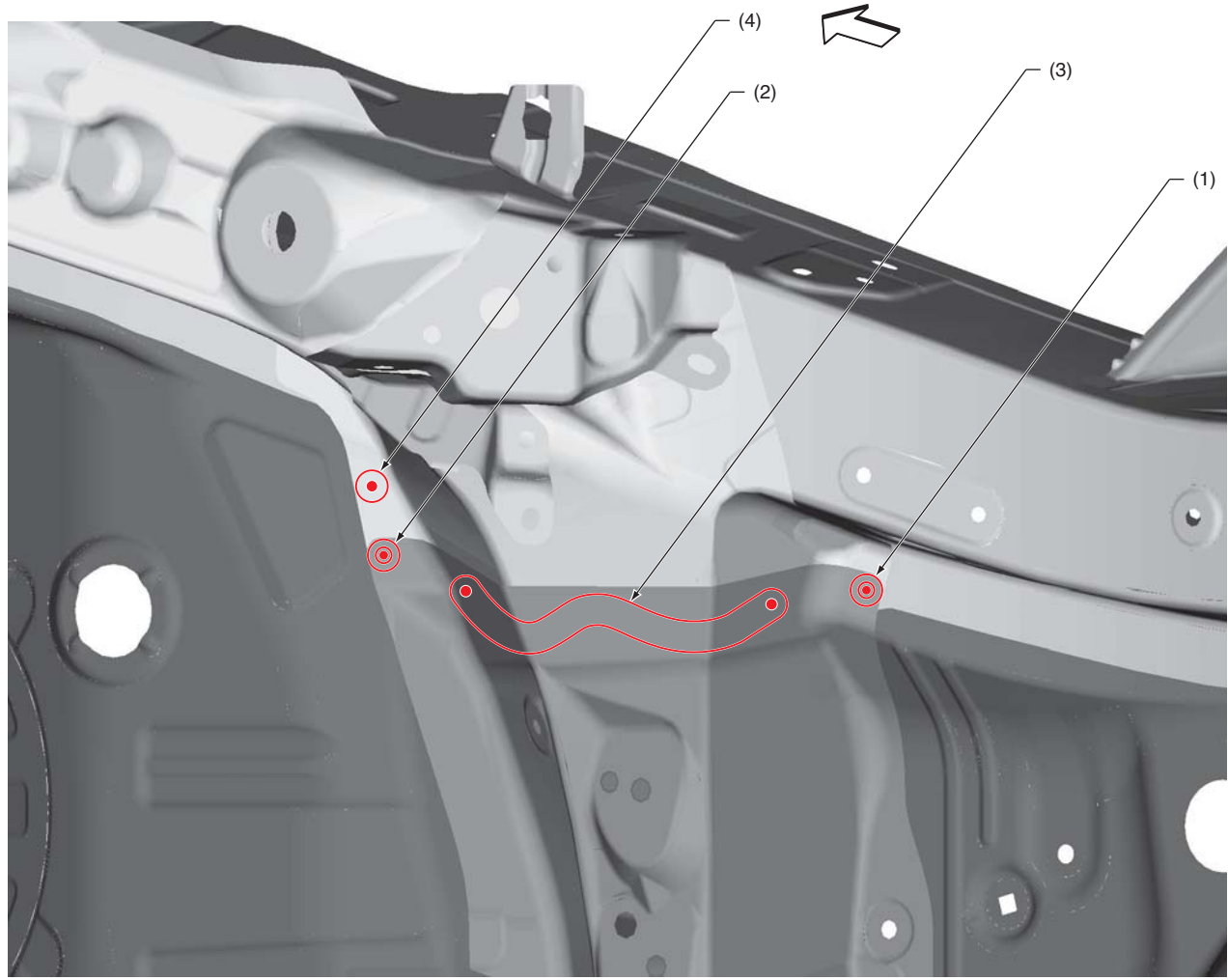
(1) 2 points (bottom · 2)

(2) 1 point (bottom · 1)

(3) 3 points (outside · 1)

Panel Replacement

• Views C



C

BS-09034

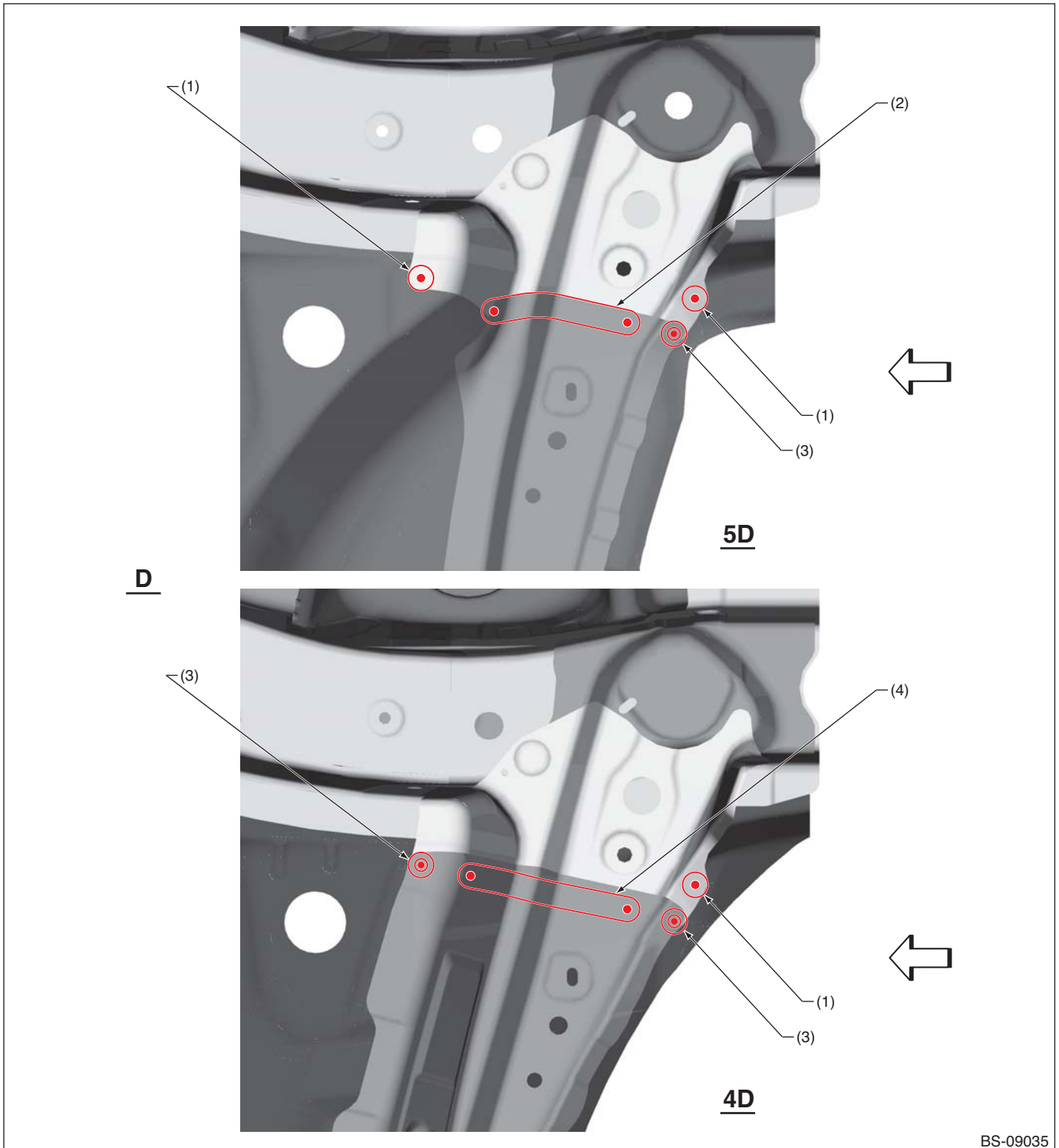
(1) 1 point (bottom · 1)
(2) 1 point (top · 2)

(3) 7 points (bottom · 1)

(4) 1 point (top · 1)

Panel Replacement

• Views D (Gasoline model)



BS-09035

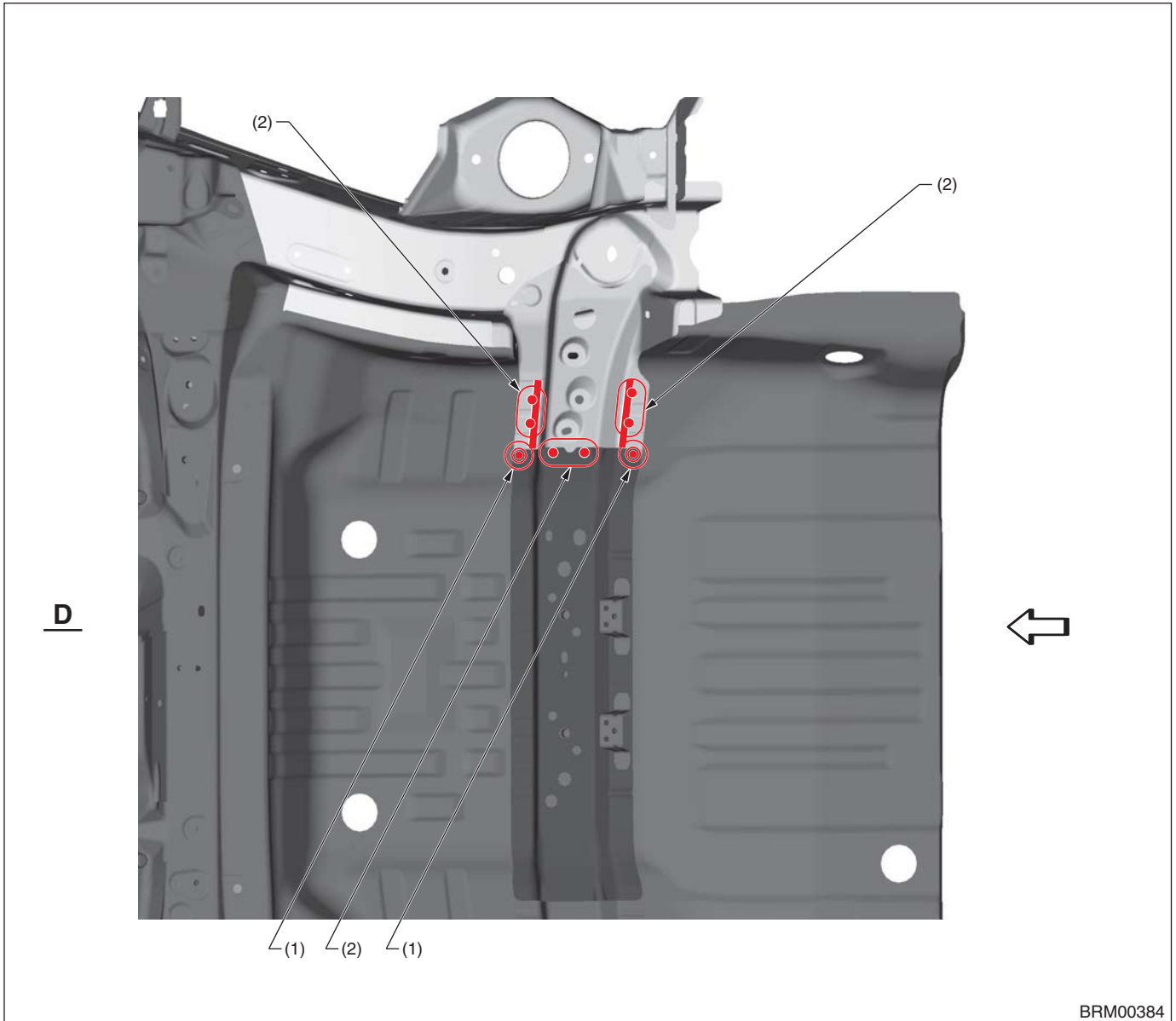
- (1) 1 point (top · 1)
(2) 4 points (bottom · 1)

- (3) 1 point (top · 1, bottom · 1)

- (4) 5 points (bottom · 1)

Panel Replacement

• Views D (Hybrid model)



(1) 1 point (bottom · 2)

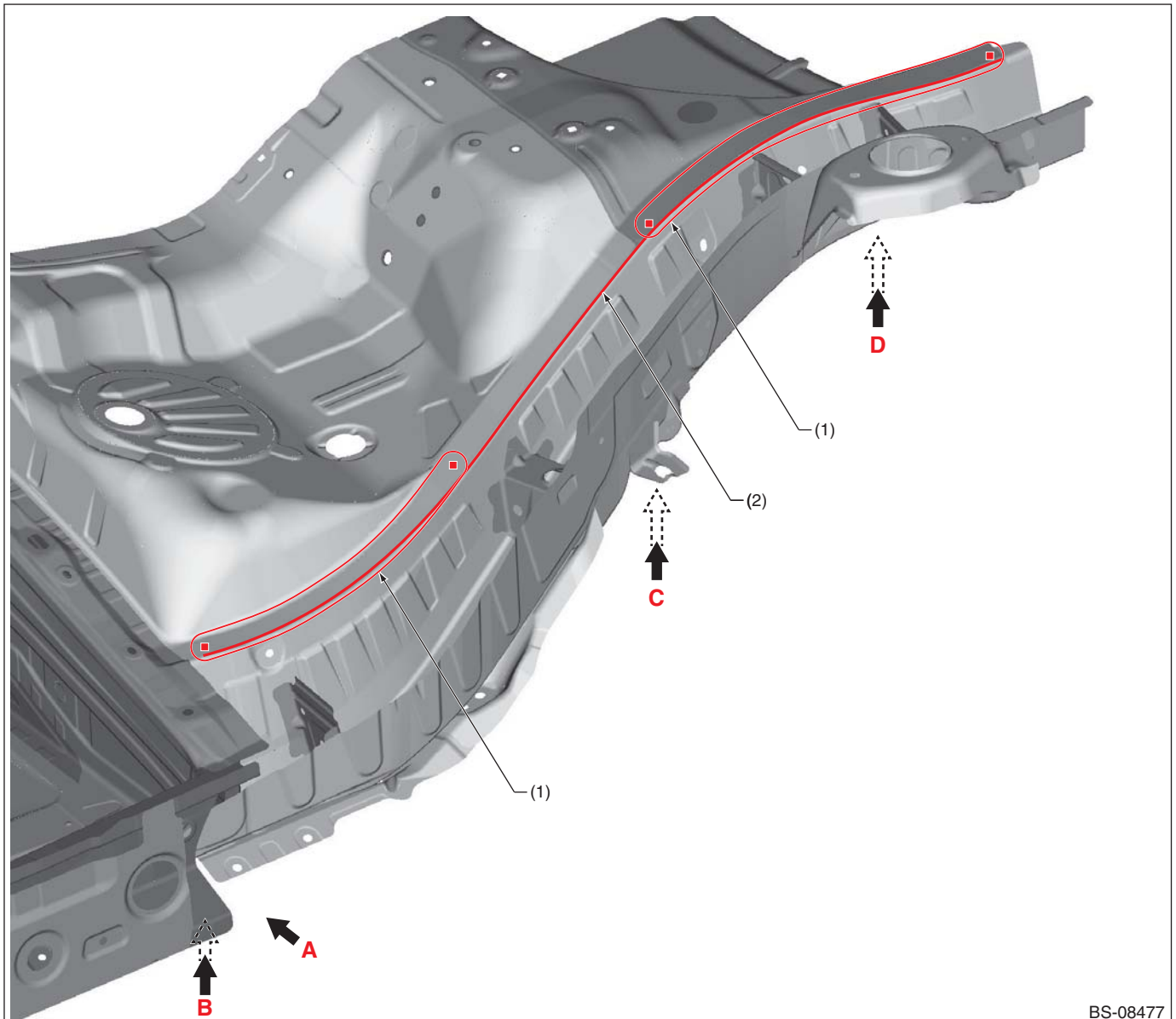
(2) 2 points (bottom · 1)

— : Structural adhesive application location

Panel Replacement

B: INSTALLATION

• Overall view



BS-08477

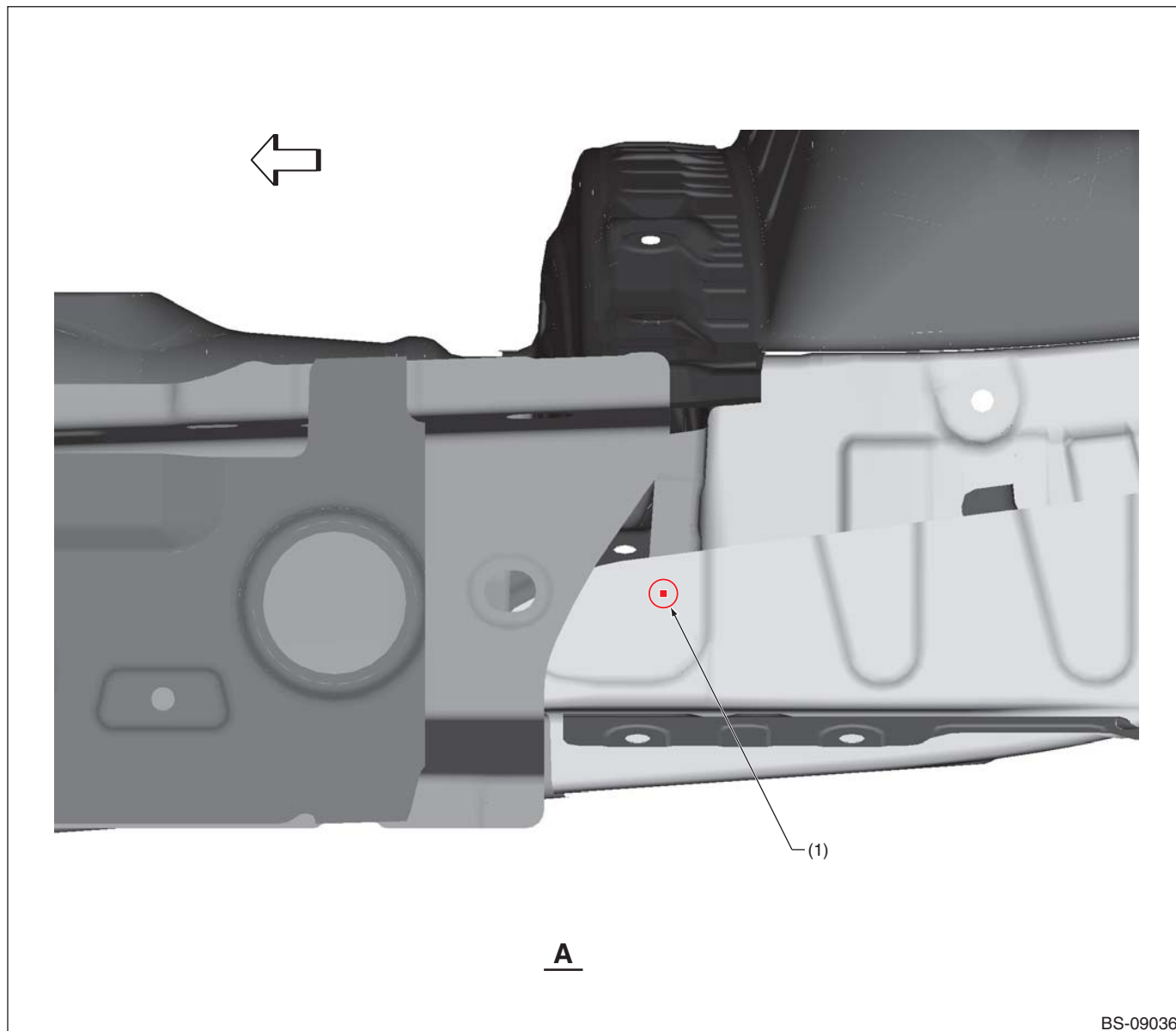
(1) 7 points

(2) Structural adhesive

— : Structural adhesive application location

Panel Replacement

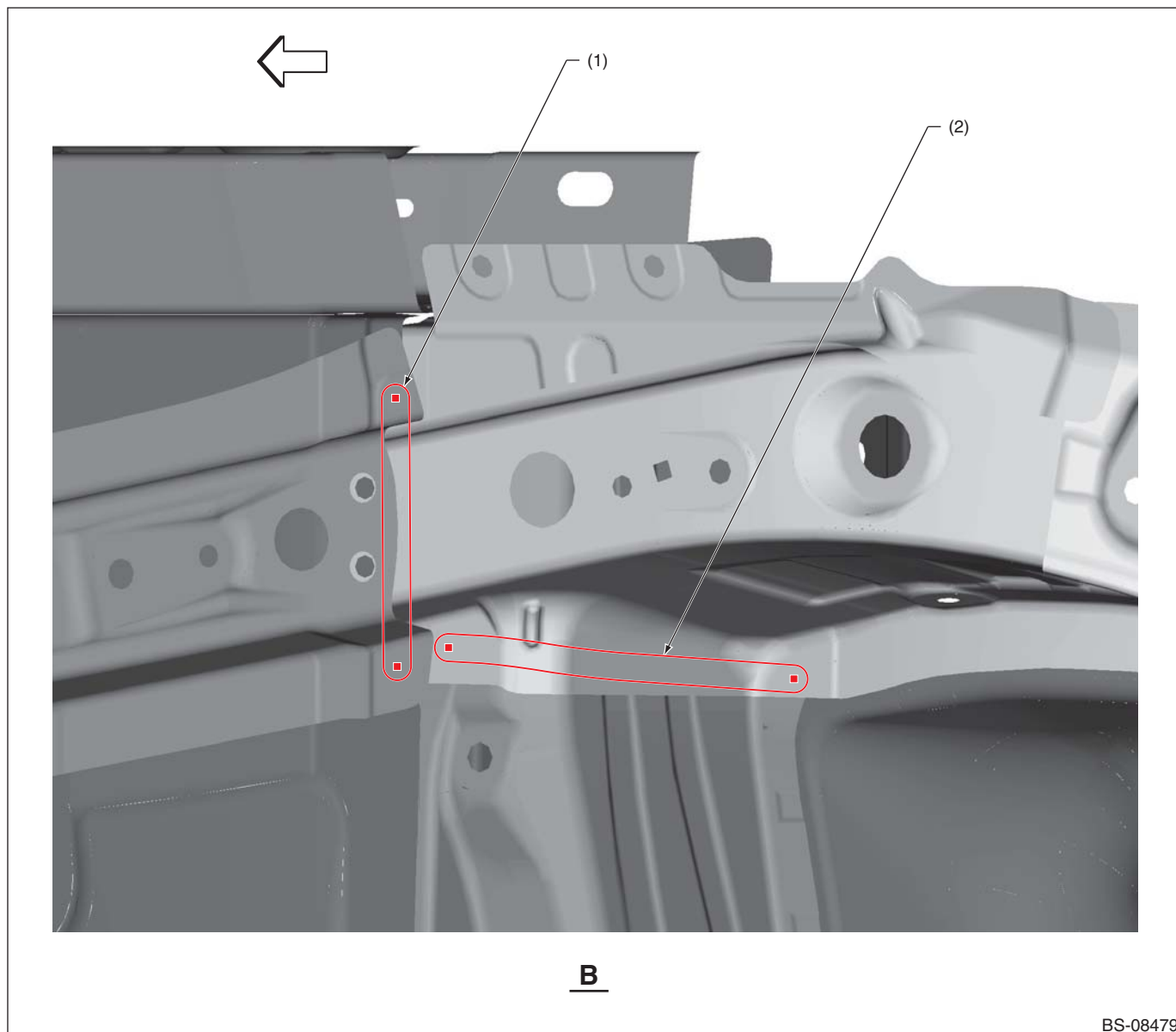
• Views A



(1) 1 point (service)

Panel Replacement

• Views B



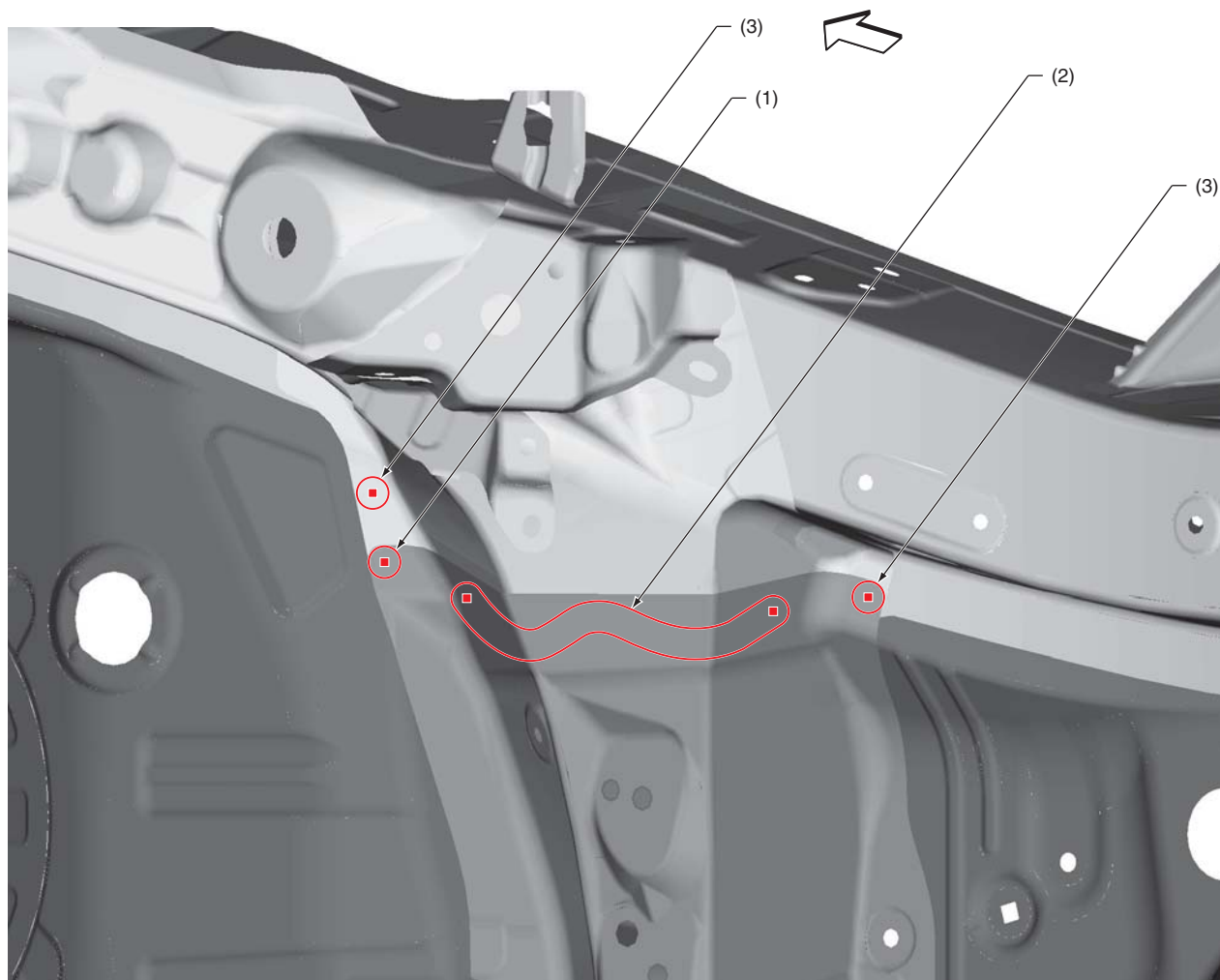
BS-08479

(1) 2 points (service · matching)

(2) 5 points (service)

Panel Replacement

• Views C



C

BS-09037

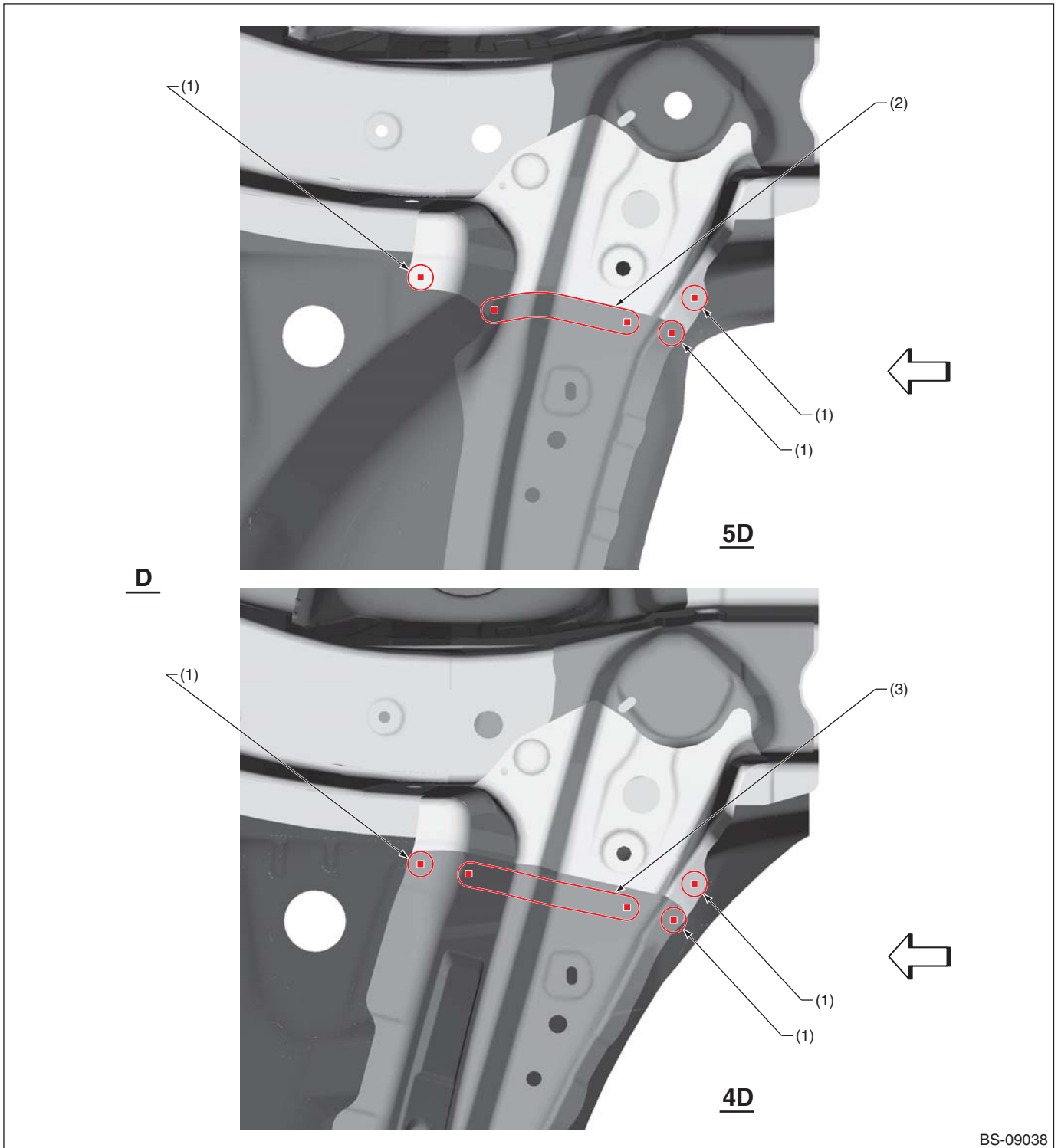
(1) 1 point (service · matching)

(2) 7 points

(3) 1 point

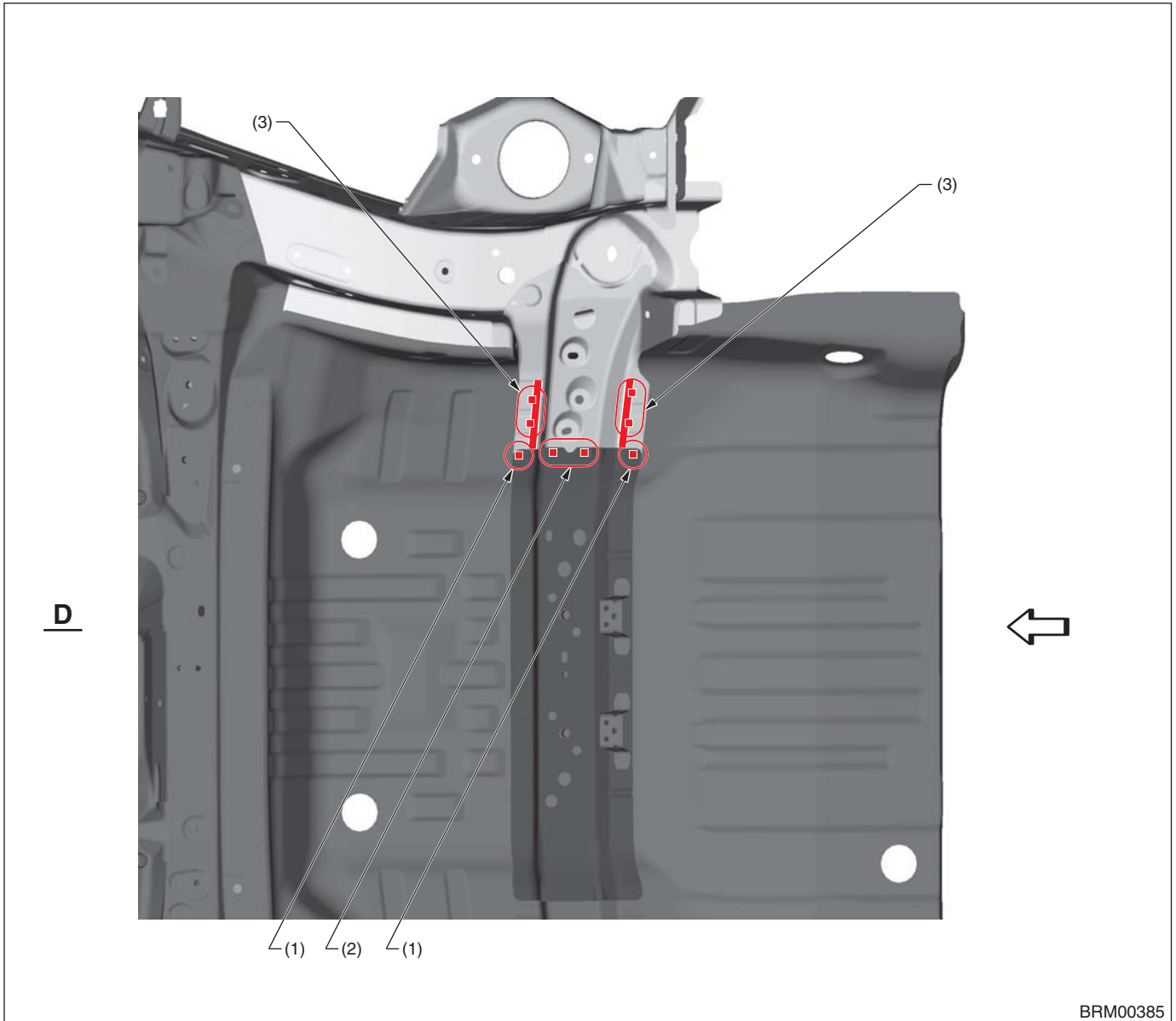
Panel Replacement

• Views D (Gasoline model)



Panel Replacement

• Views D (Hybrid model)



(1) 1 point (service · matching)

(2) 2 points

(3) 2 points (service)

— : Structural adhesive application location

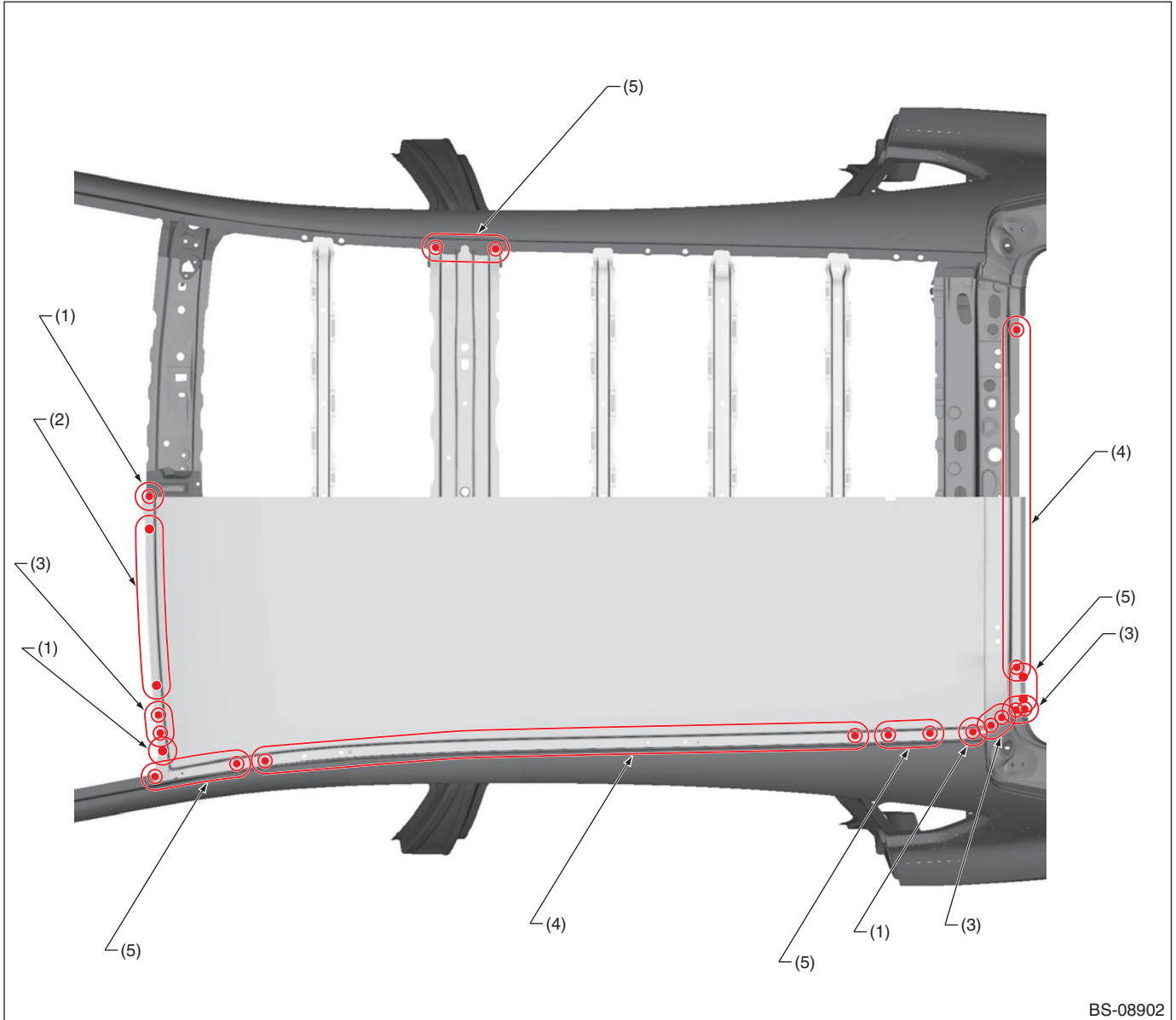
Panel Replacement

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

Model without sunroof

A: REMOVAL

• Overall view



BS-08902

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

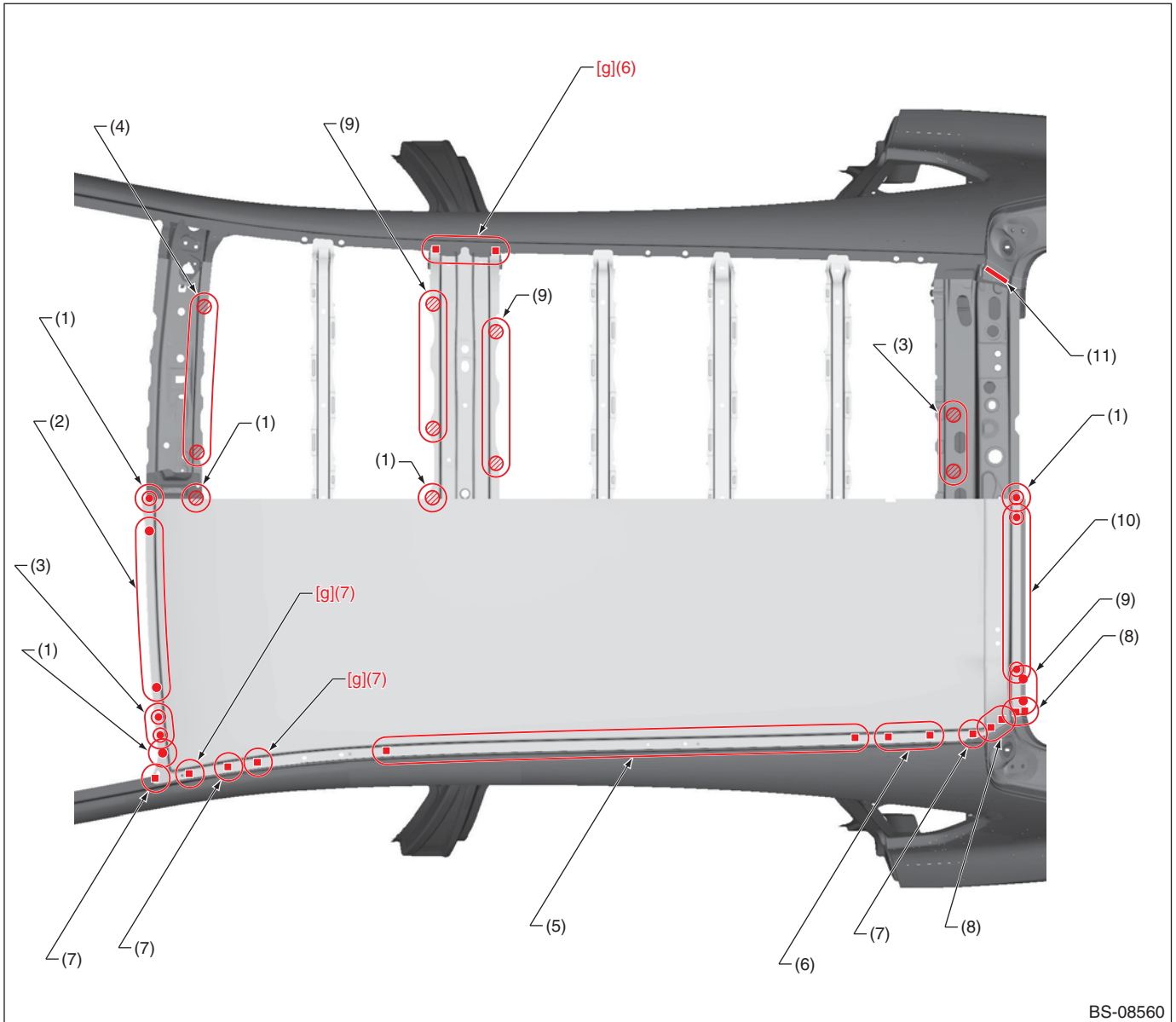
(3) 2 points (top · 1)
(4) 13 points (top · 1)

(5) 3 points (top · 1)


Panel Replacement

B: INSTALLATION

• Overall view



- | | | |
|--------------|-------------------------|--------------------------------|
| (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

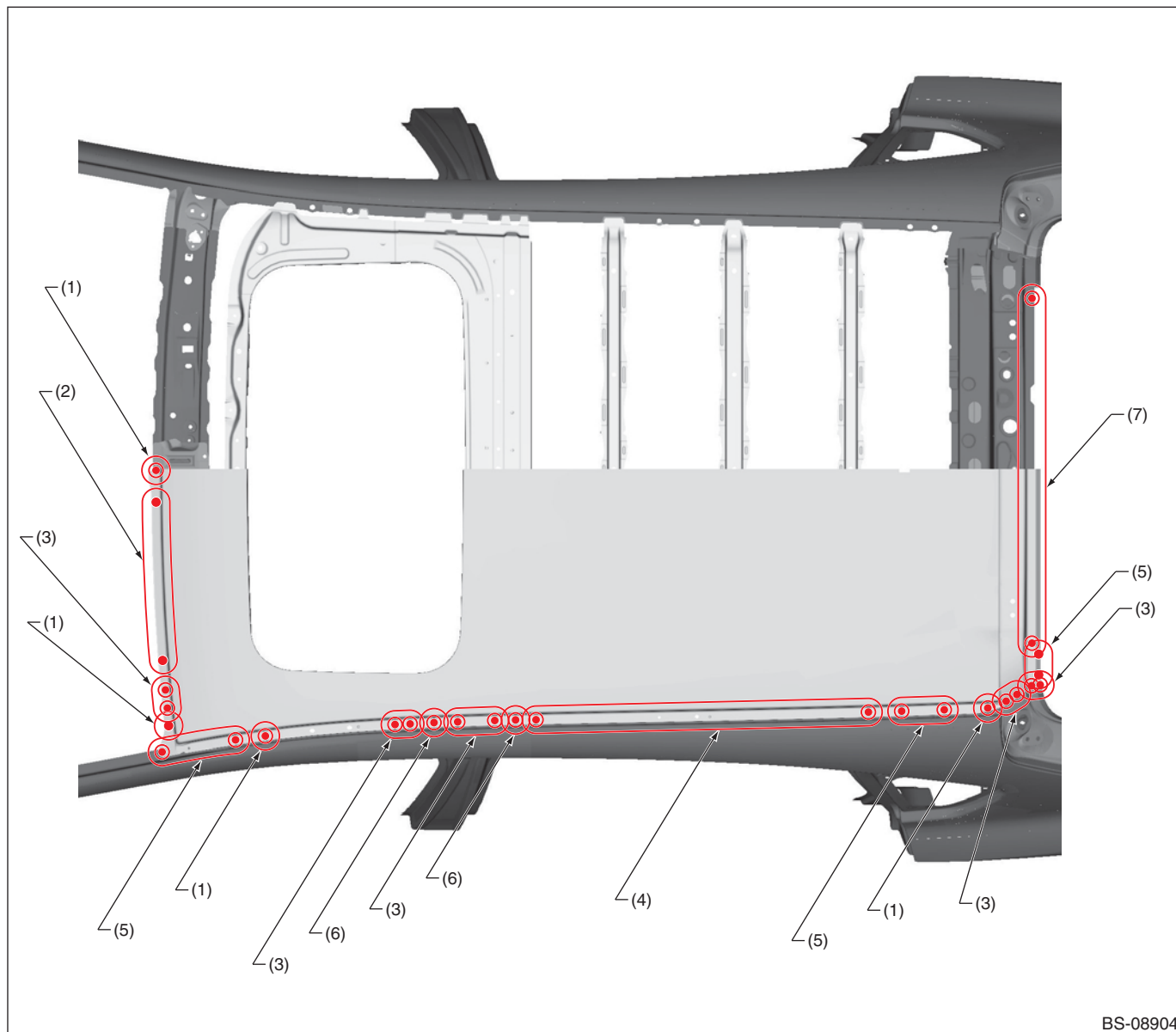
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

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)

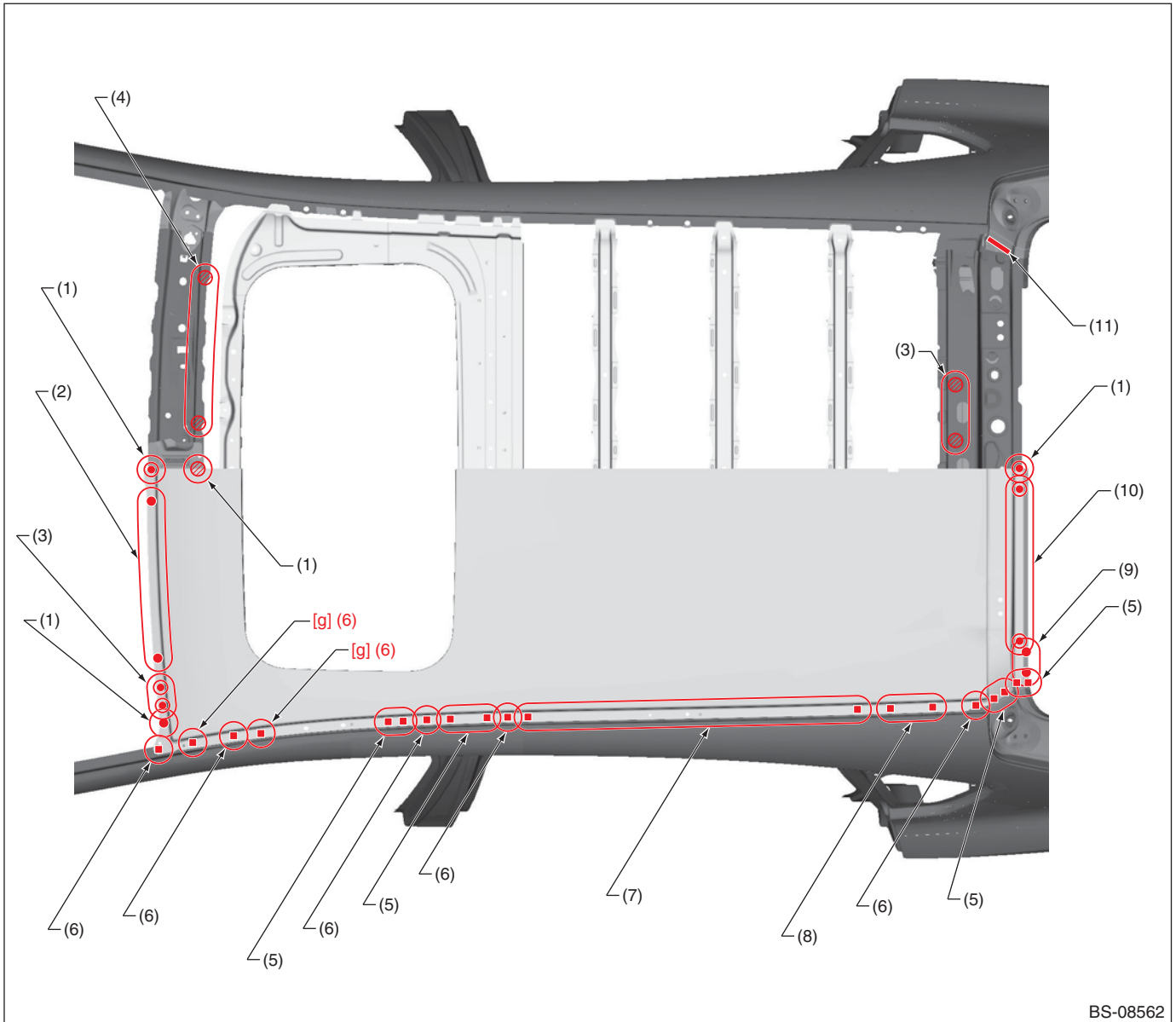
- (4) 8 points (top · 1)
- (5) 3 points (top · 1)

- (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: CO2

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

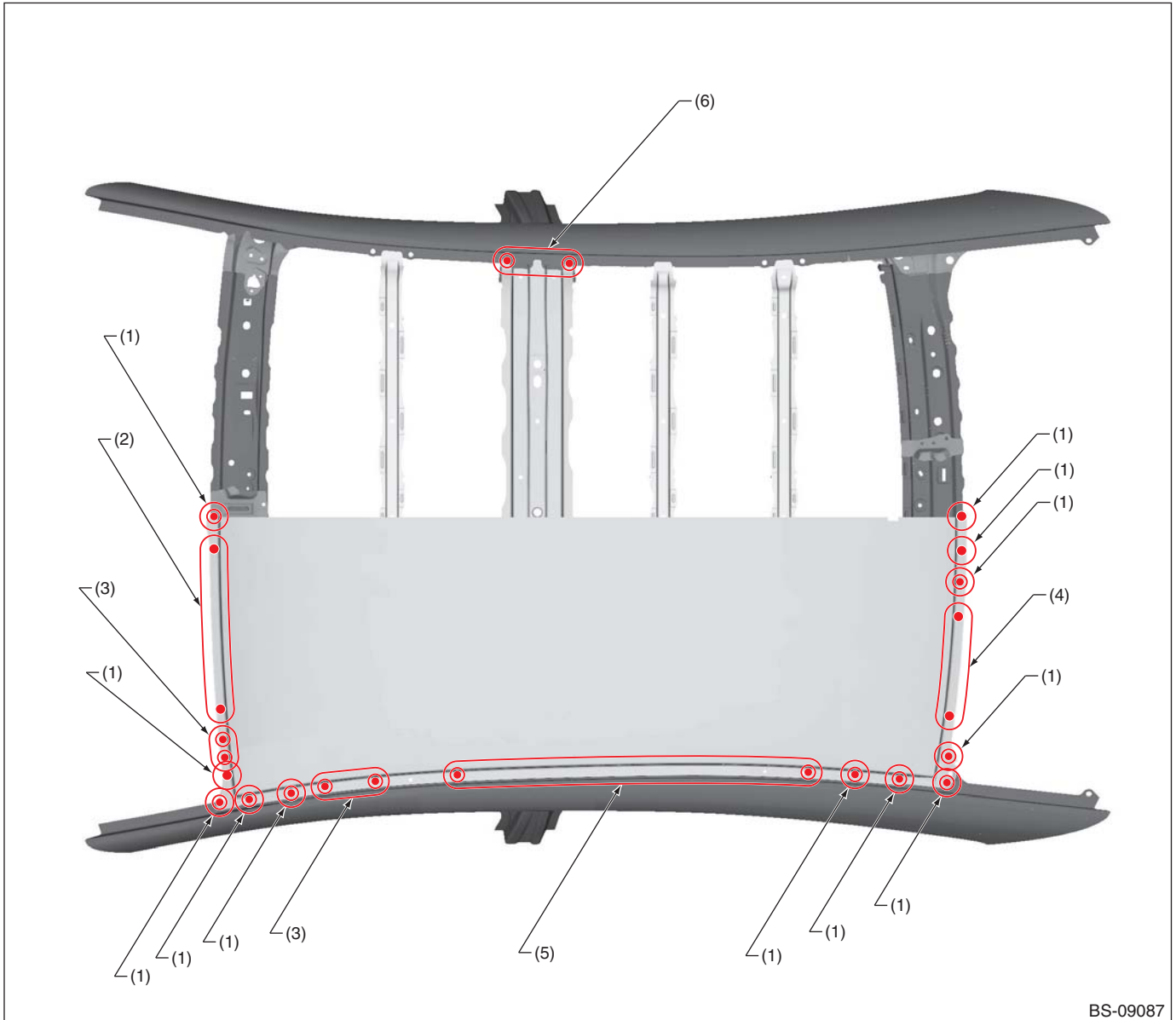
Panel Replacement

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)

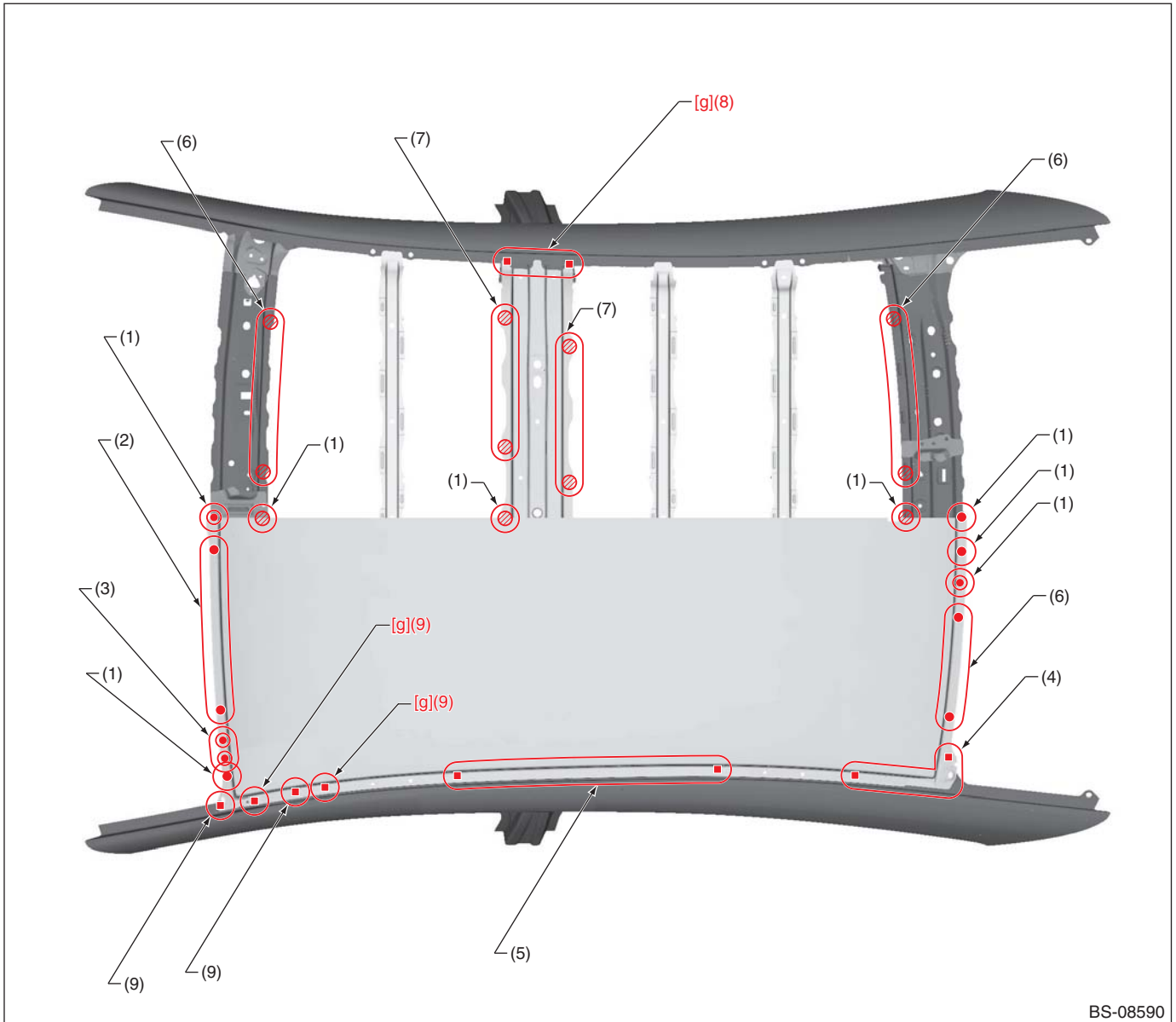
(3) 2 points (top · 1)
(4) 4 points (top · 1)

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

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point

(2) 5 points

(3) 2 points

(4) 4 points (service)

(5) 9 points (service)

(6) 4 points

(7) 3 points

(8) 3 points (service)

(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

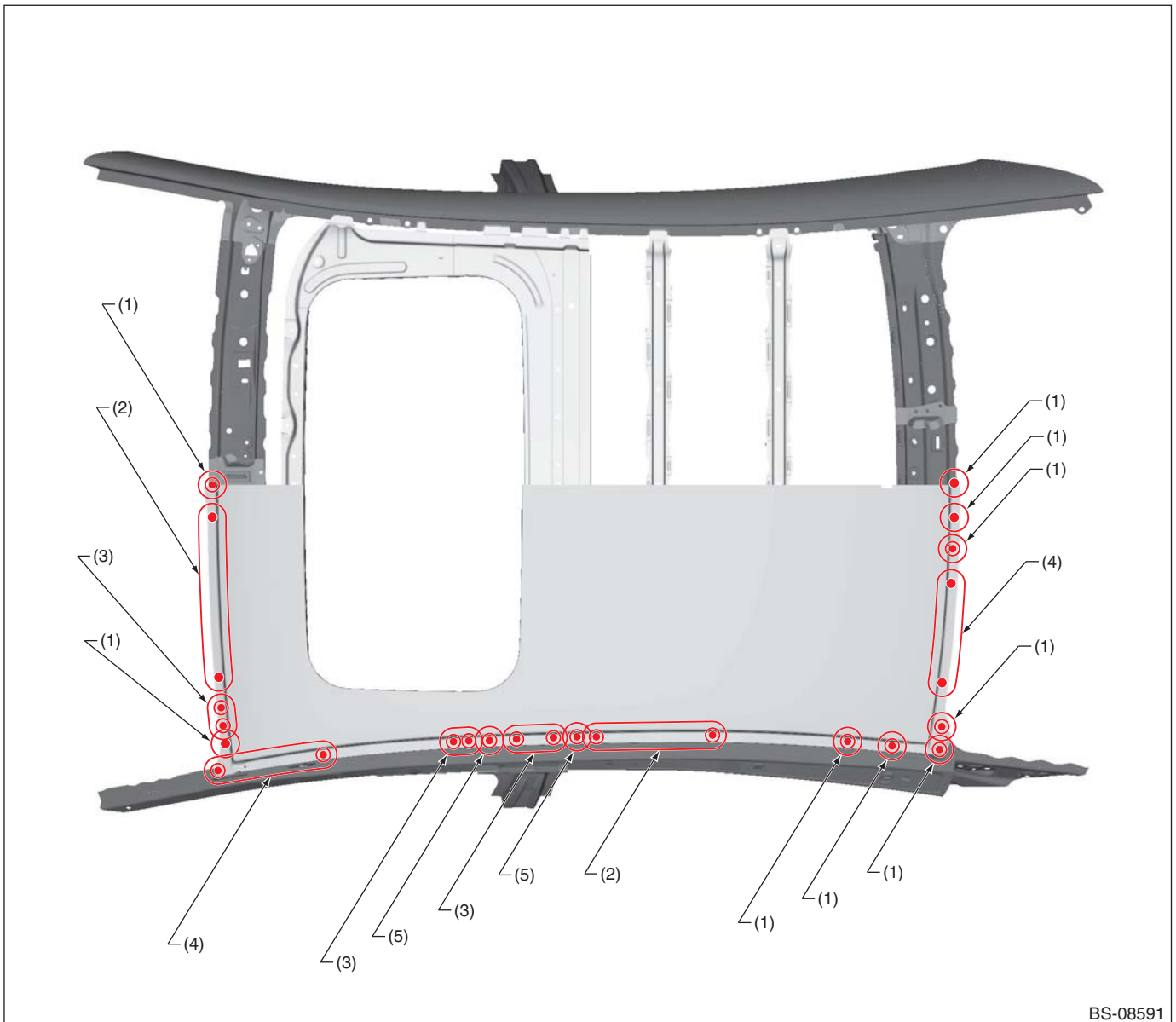
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

Model with sunroof

A: REMOVAL

• Overall view



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

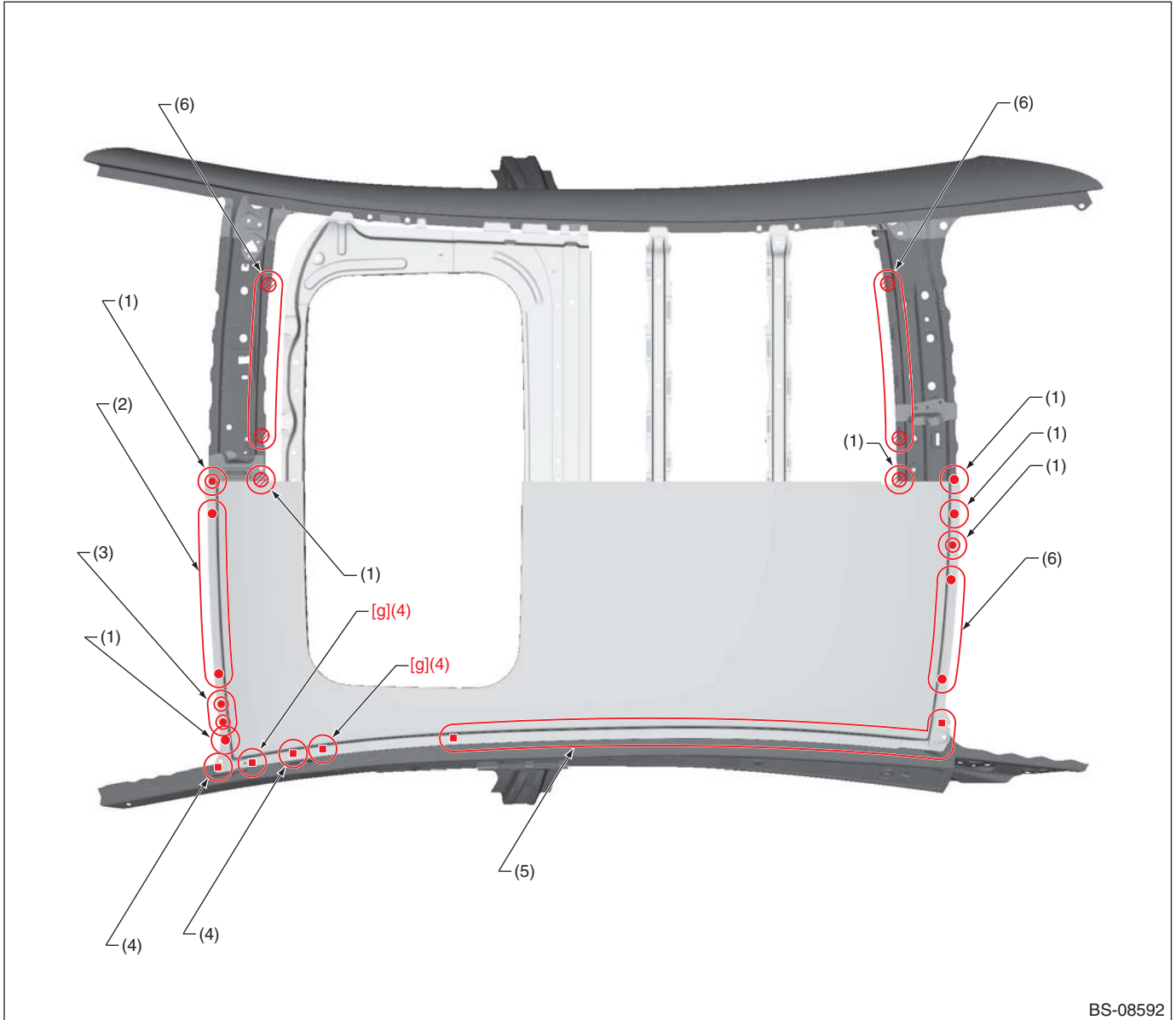
(3) 2 points (top · 1)
(4) 4 points (top · 1)

(5) 1 point (top · 2)

Panel Replacement

B: INSTALLATION

• Overall view



(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

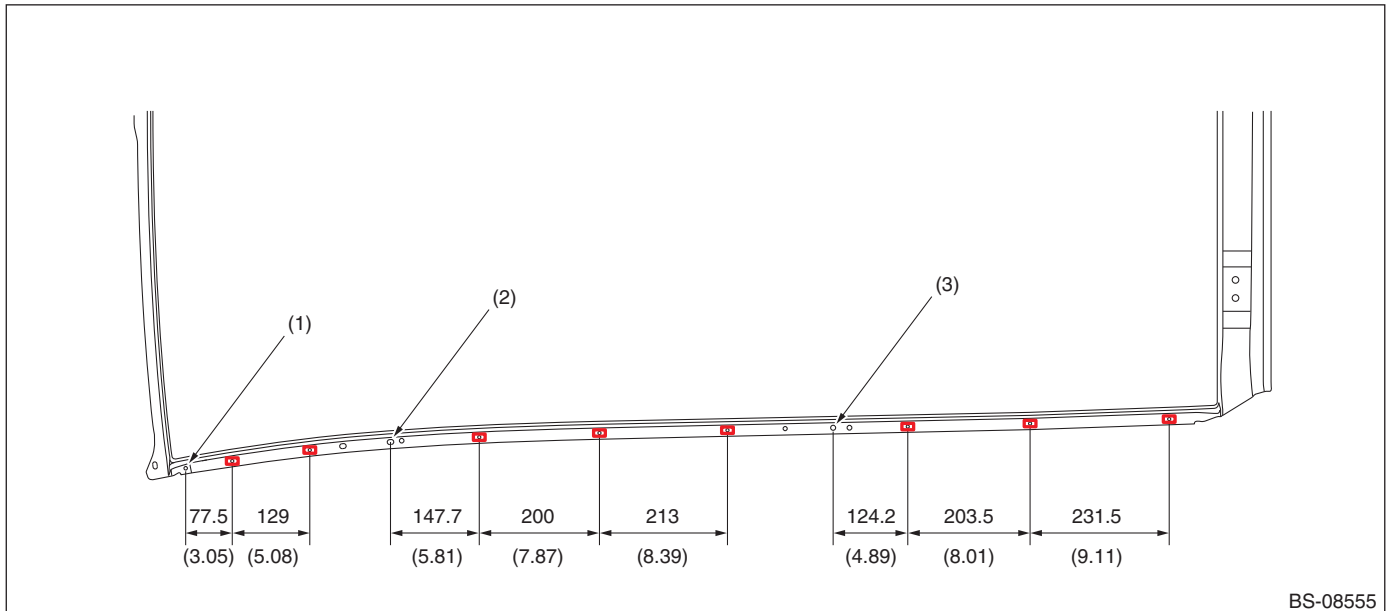
A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

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

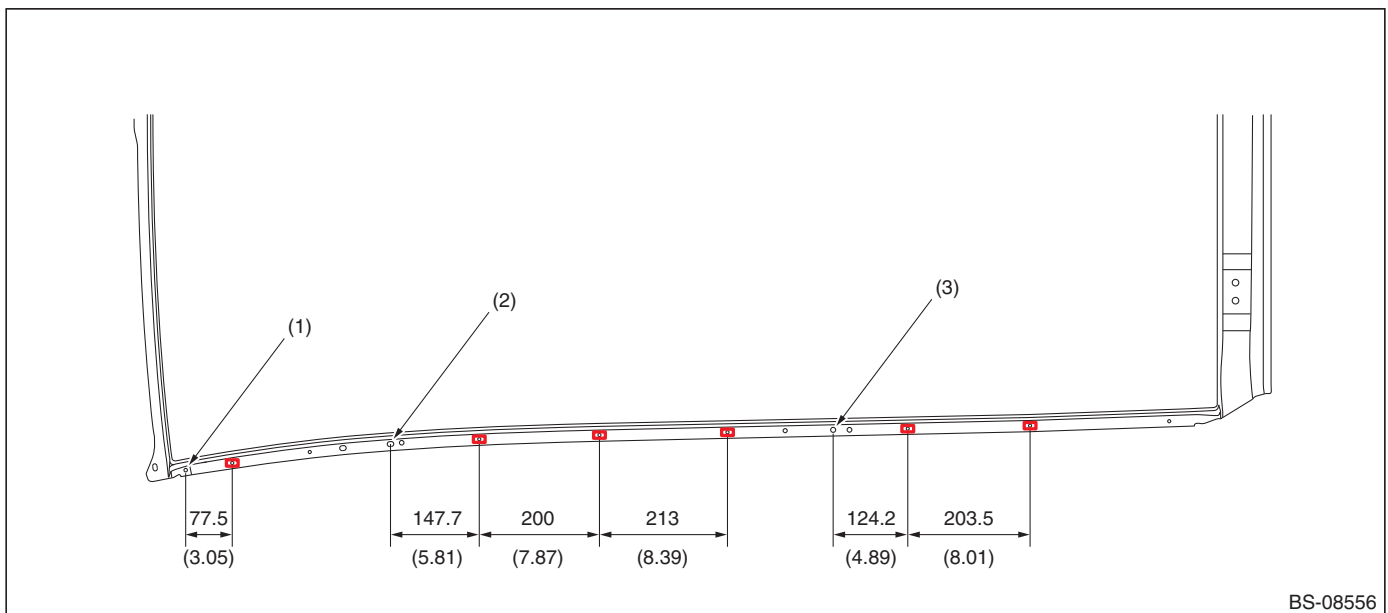
Panel Replacement

8-54. T Stud Installation

• 5 Door (Model without roof rail)

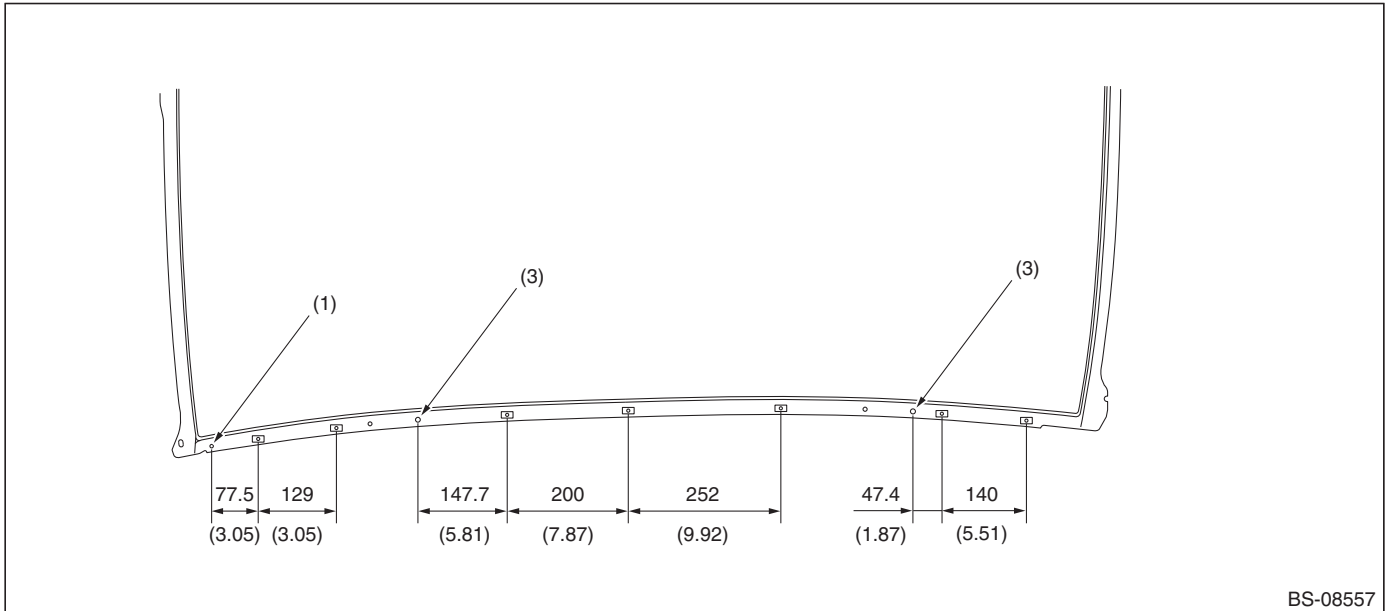


• 5 Door (Model with roof rail)

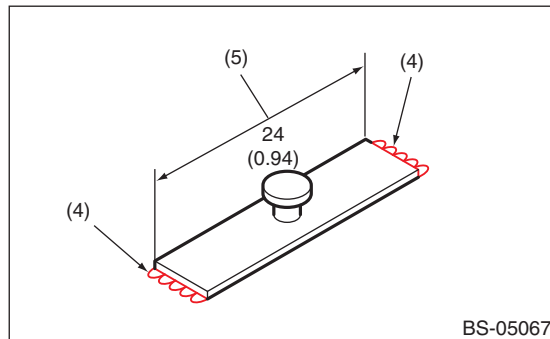


Panel Replacement

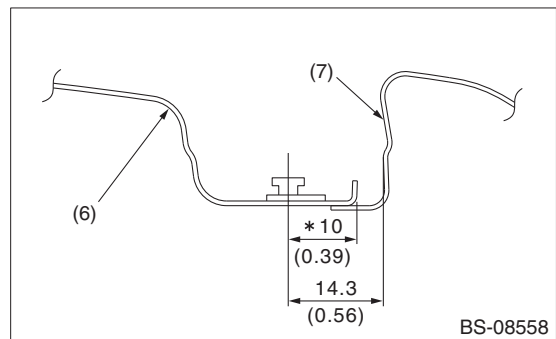
• 4 Door



• T stud welding



• T stud basic cross section



- | | | |
|---|--|----------------------|
| (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.

9. Body Sealing

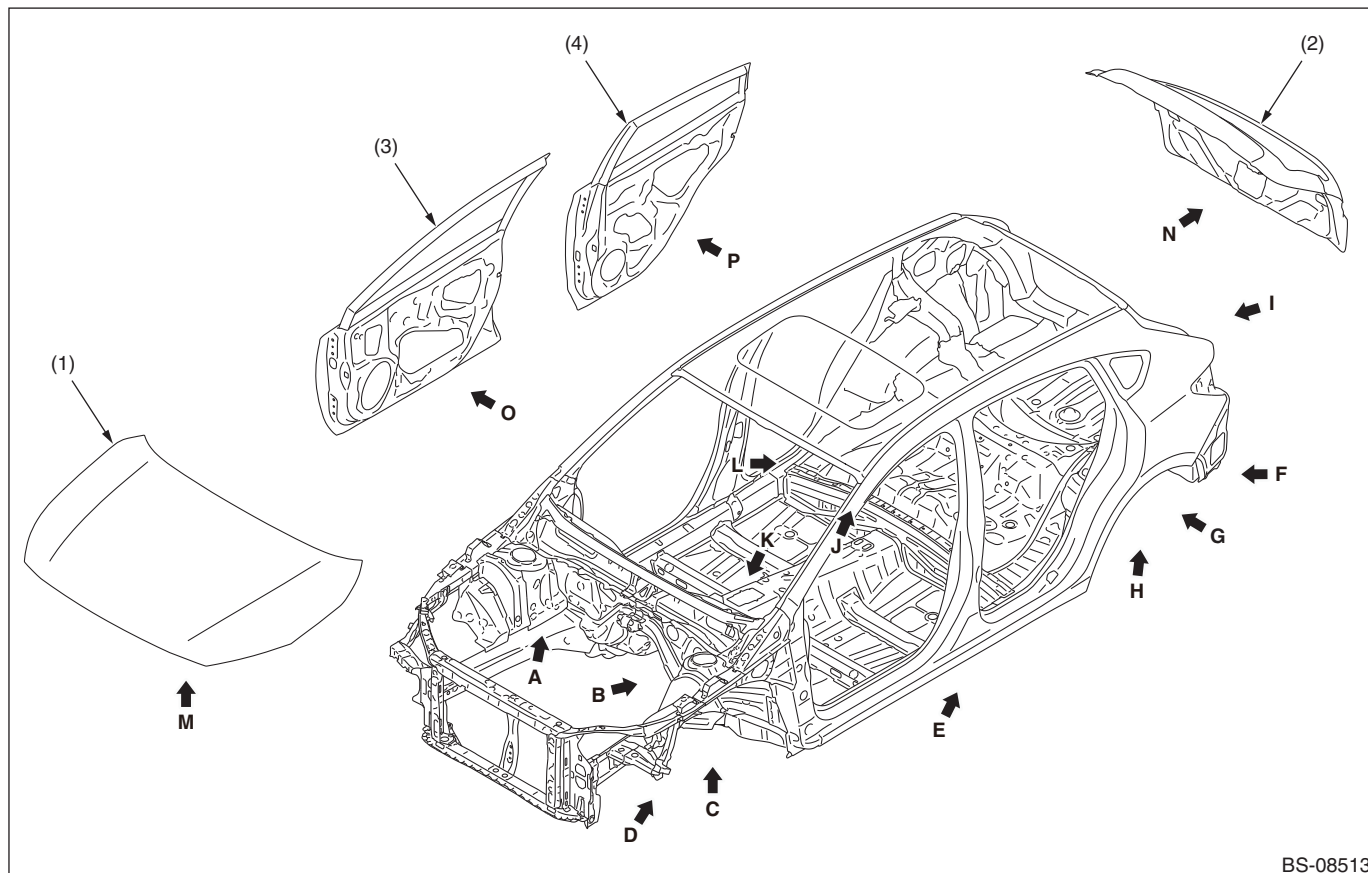
A: SPECIFICATIONS

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

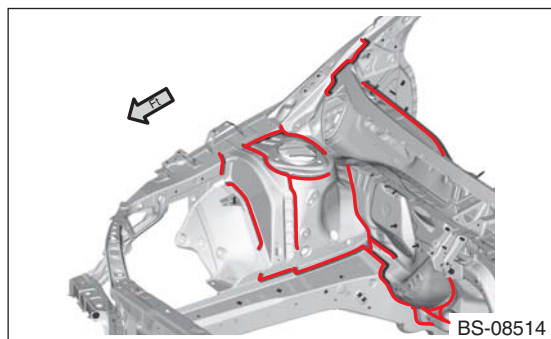
(1) Front hood

(3) Front door

(4) Rear door

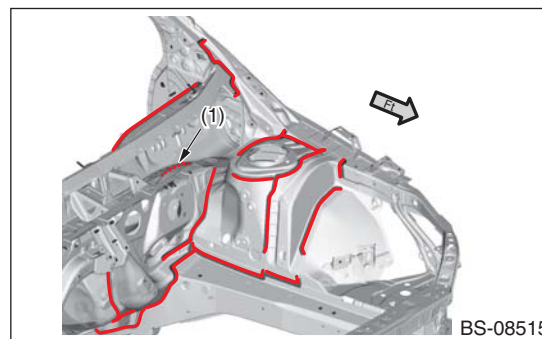
(2) Rear gate

View A



BS-08514

View B

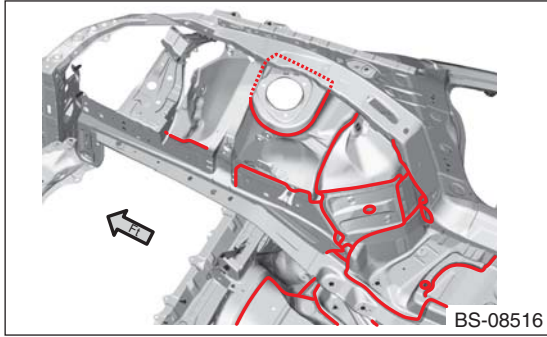


BS-08515

(1) LH only

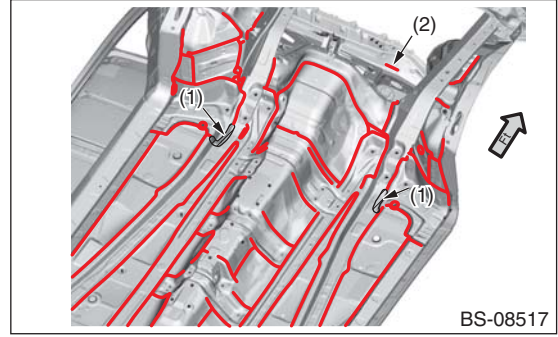
Body Sealing

View C



BS-08516

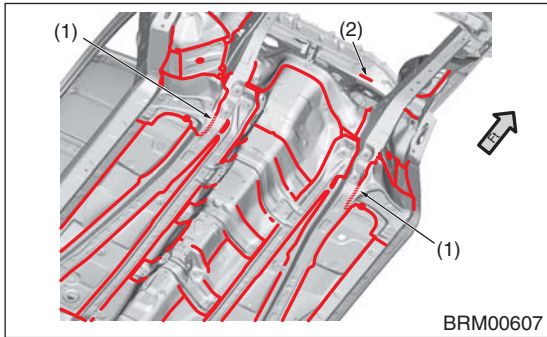
View D (Gasoline model)



BS-08517

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

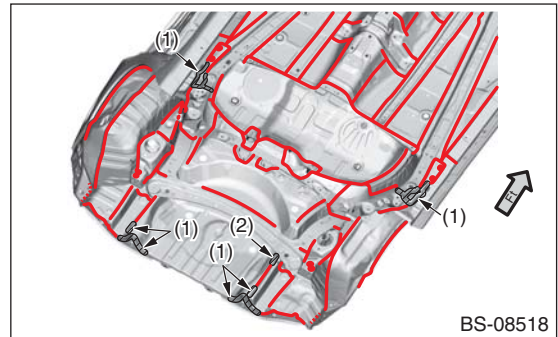
View D (Hybrid model)



BRM00607

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

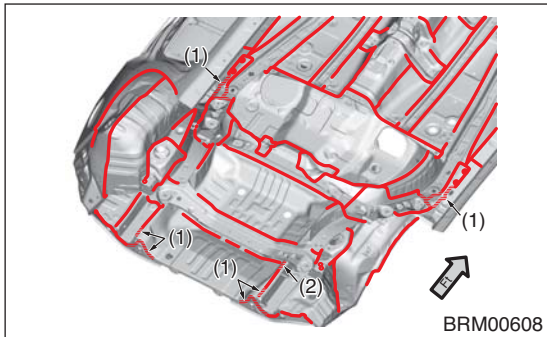
View E (Gasoline model)



BS-08518

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

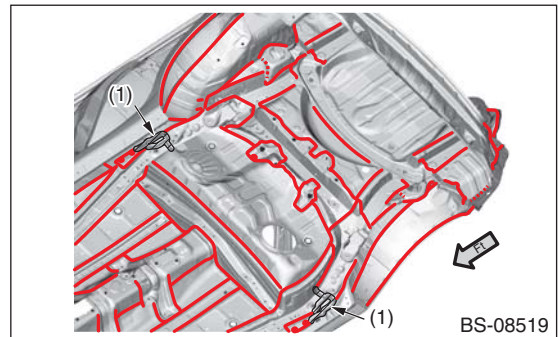
View E (Hybrid model)



BRM00608

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

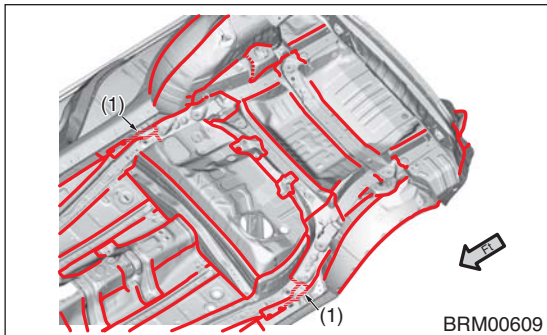
View F (Gasoline model)



BS-08519

- (1) Wax is allowable

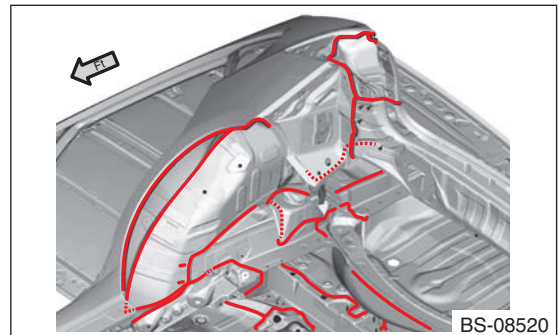
View F (Hybrid model)



BRM00609

- (1) Wax is allowable

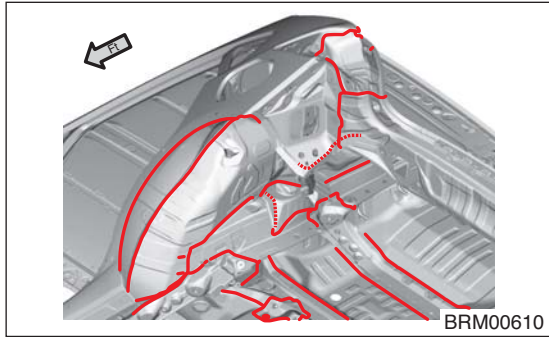
View G (Gasoline model)



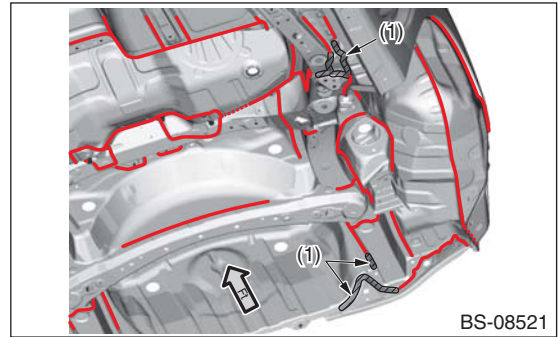
BS-08520

Body Sealing

View G (Hybrid model)

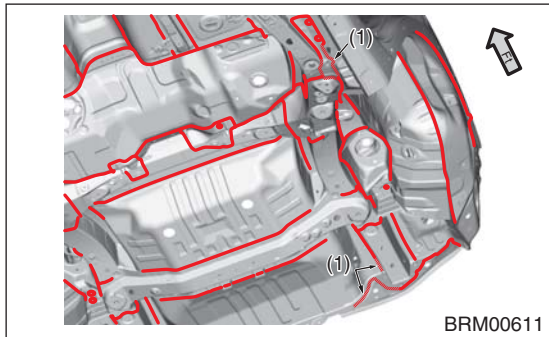


View H (Gasoline model)



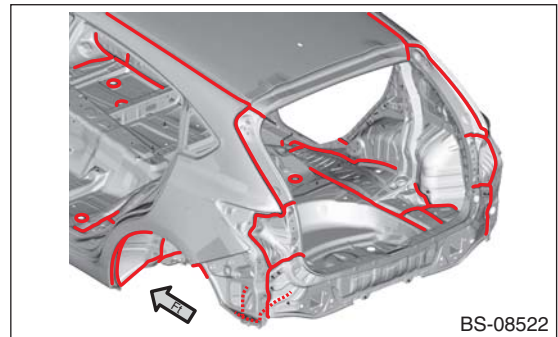
(1) Wax is allowable

View H (Hybrid model)

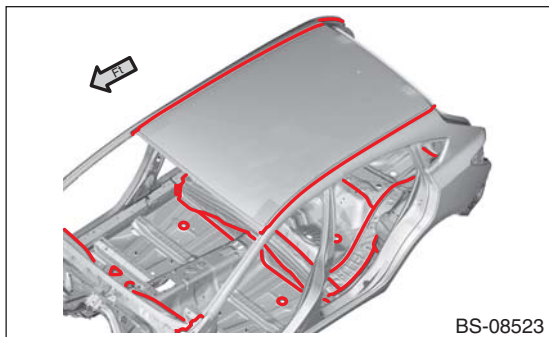


(1) Wax is allowable

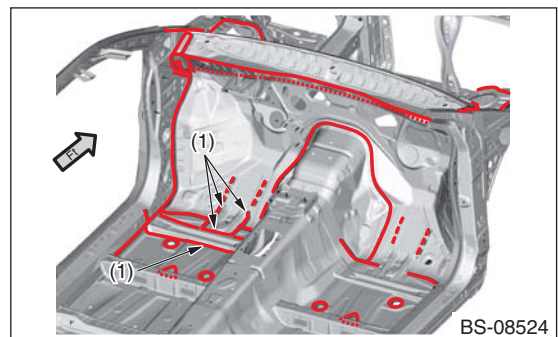
View I



View J

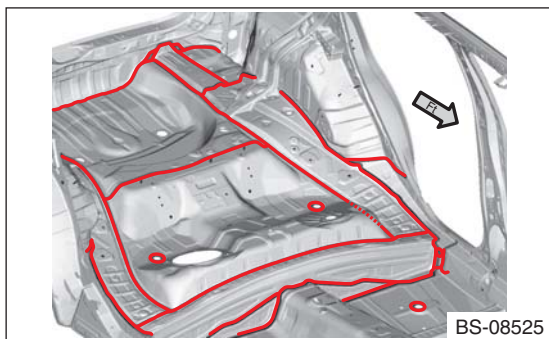


View K

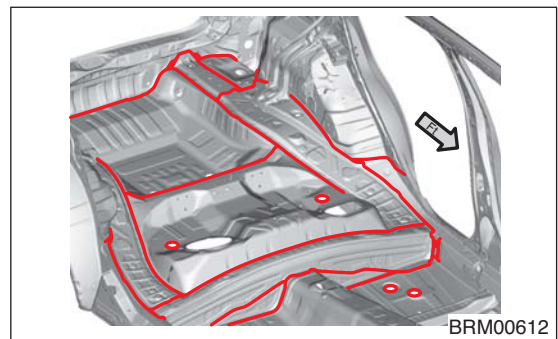


(1) LH only

View L (Gasoline model)

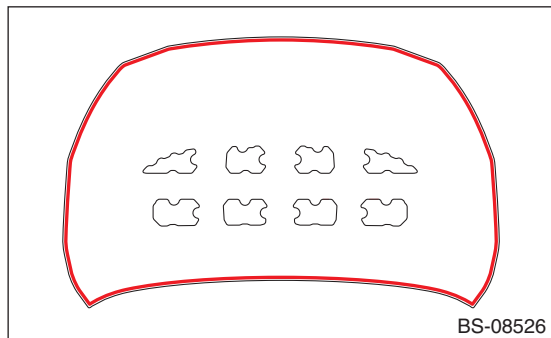


View L (Hybrid model)

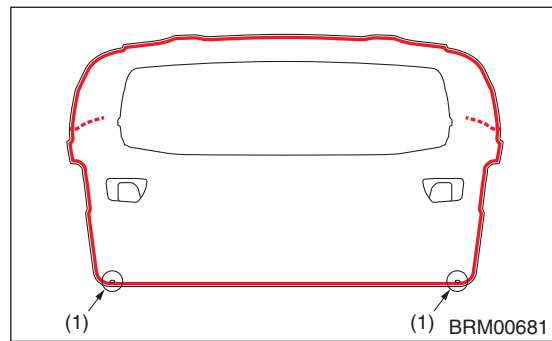


Body Sealing

View M

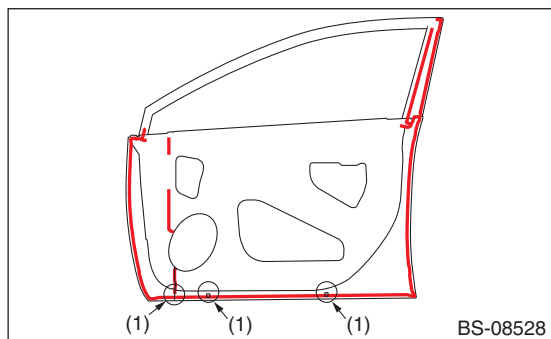


View N



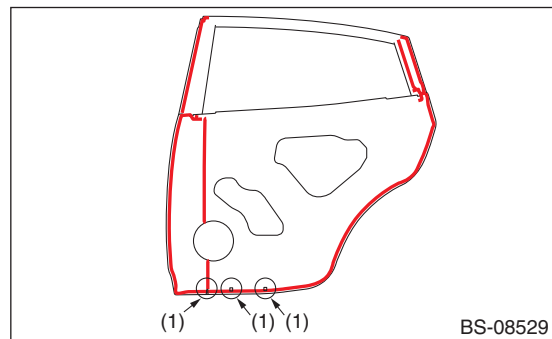
(1) Do not block the water drain holes.

View O



(1) Do not block the water drain holes.

View P



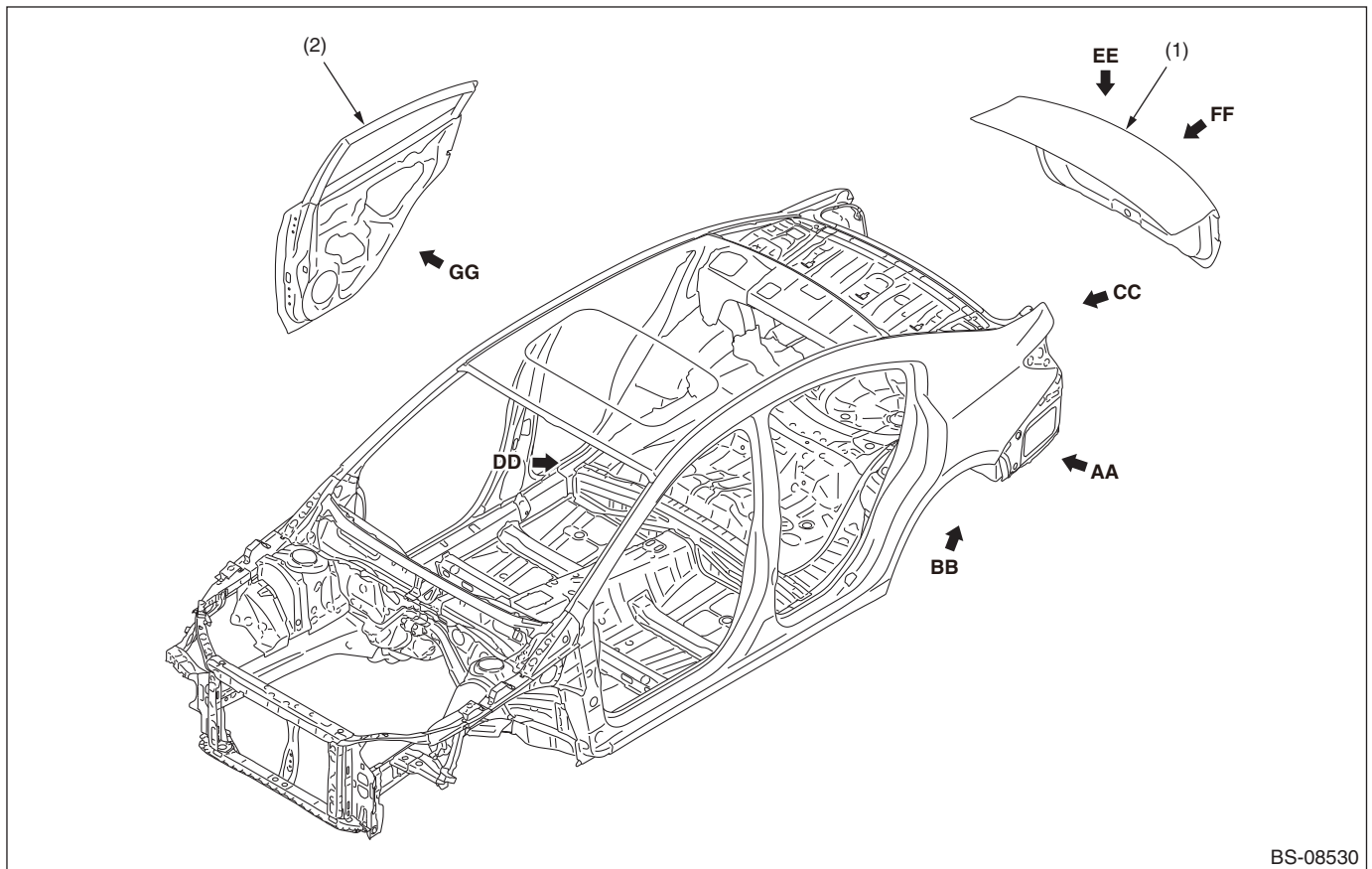
(1) Do not block the water drain holes.

CAUTION:

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

Body Sealing

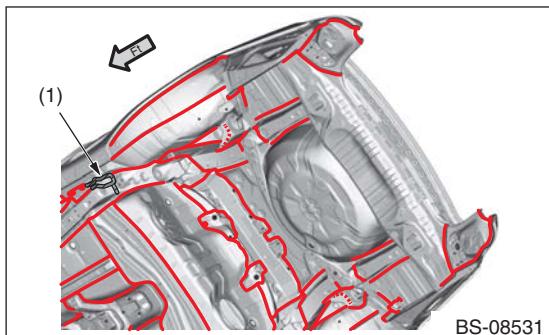
• SPECIAL PARTS FOR 4 DOOR



(1) Trunk

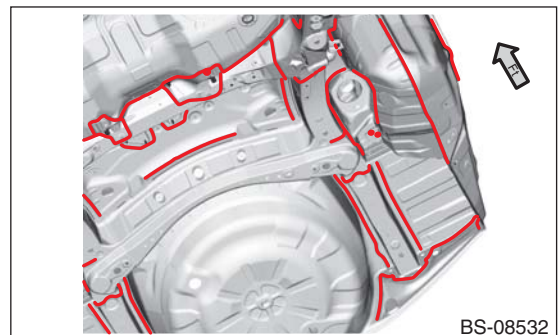
(2) Rear door

View AA



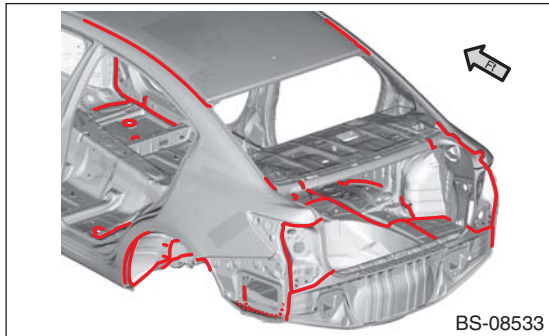
(1) Wax is allowable

View BB

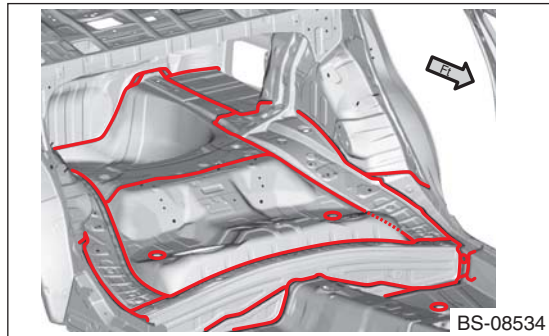


Body Sealing

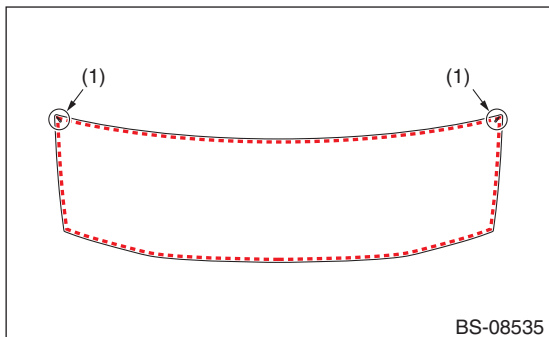
View CC



View DD

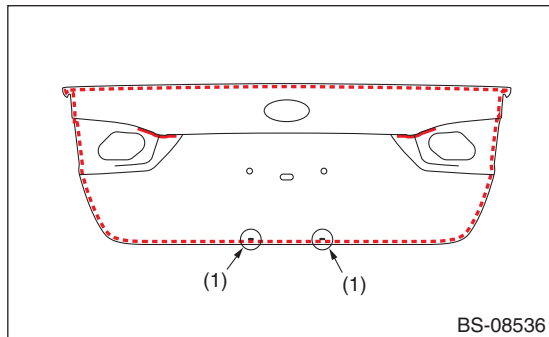


View EE



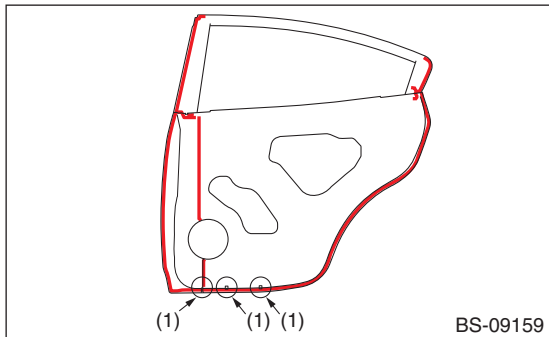
(1) The hole shall be blocked.

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.

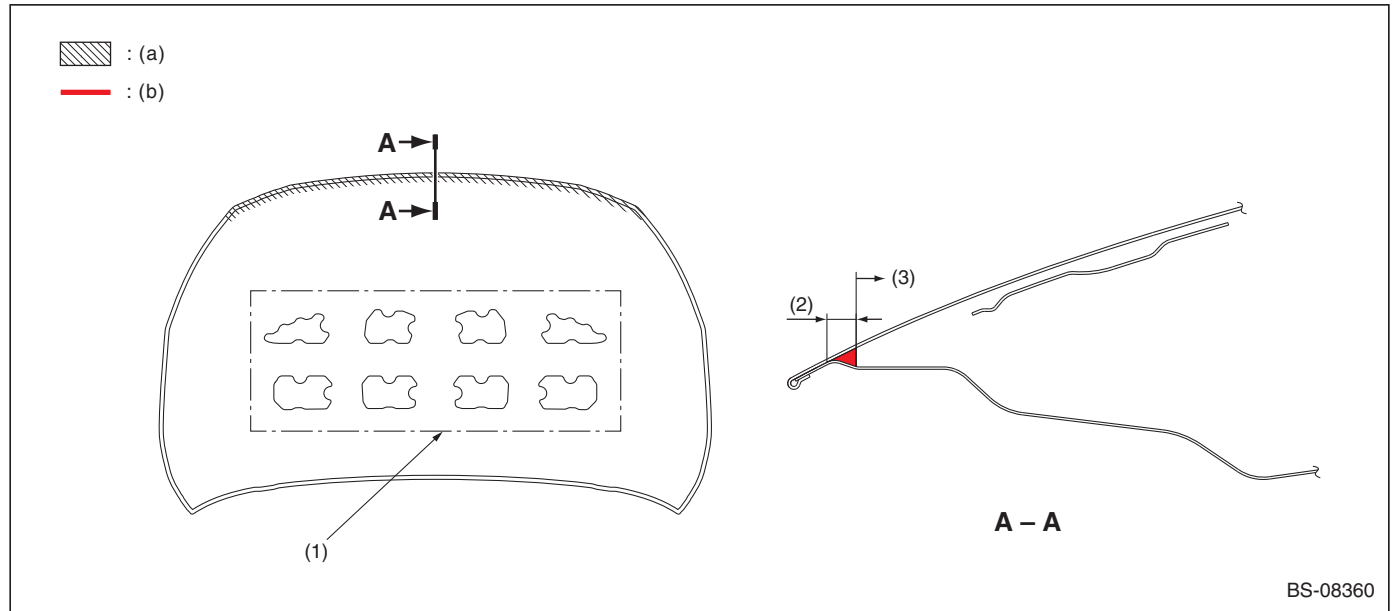
10. Anticorrosion Wax

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

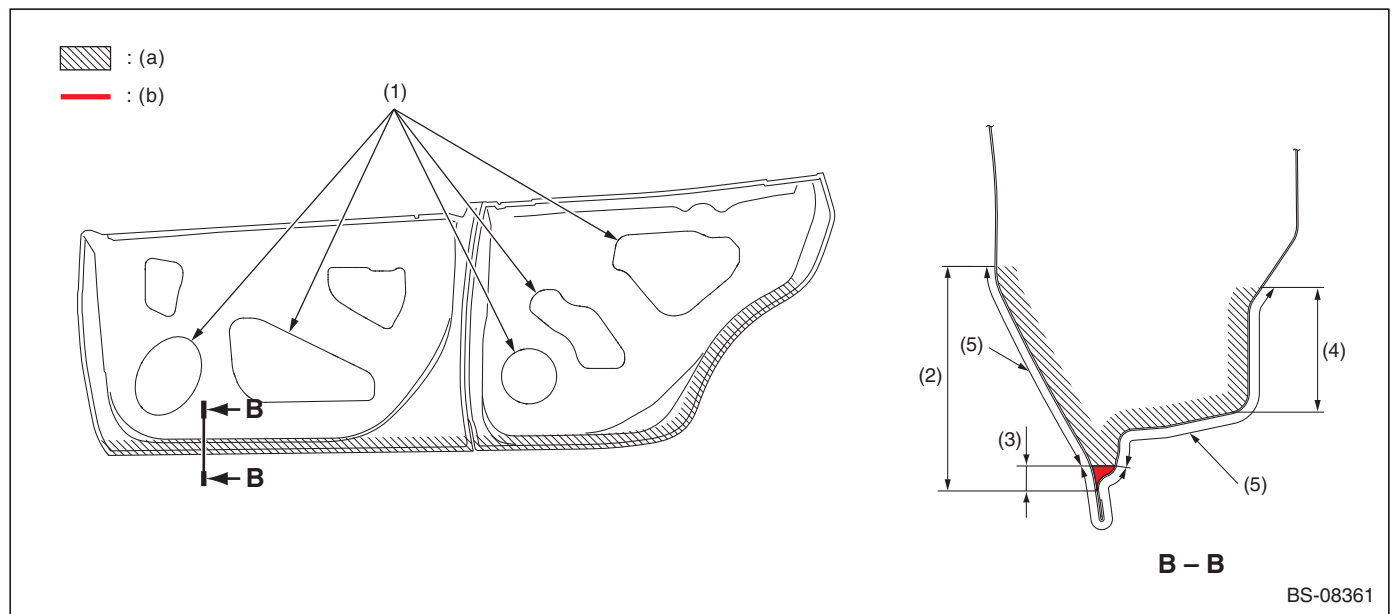
(b) To be filled into the plate joint

(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)

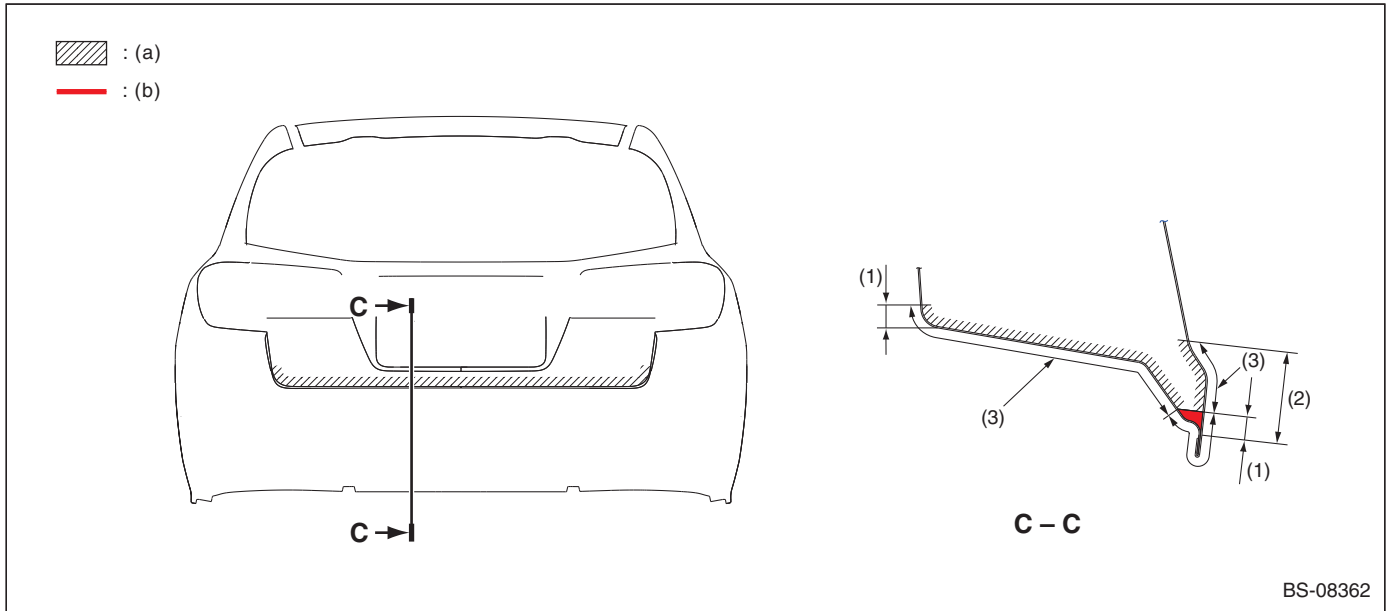
(5) Adherence of mist is allowable

(2) 90 mm (3.54 in)

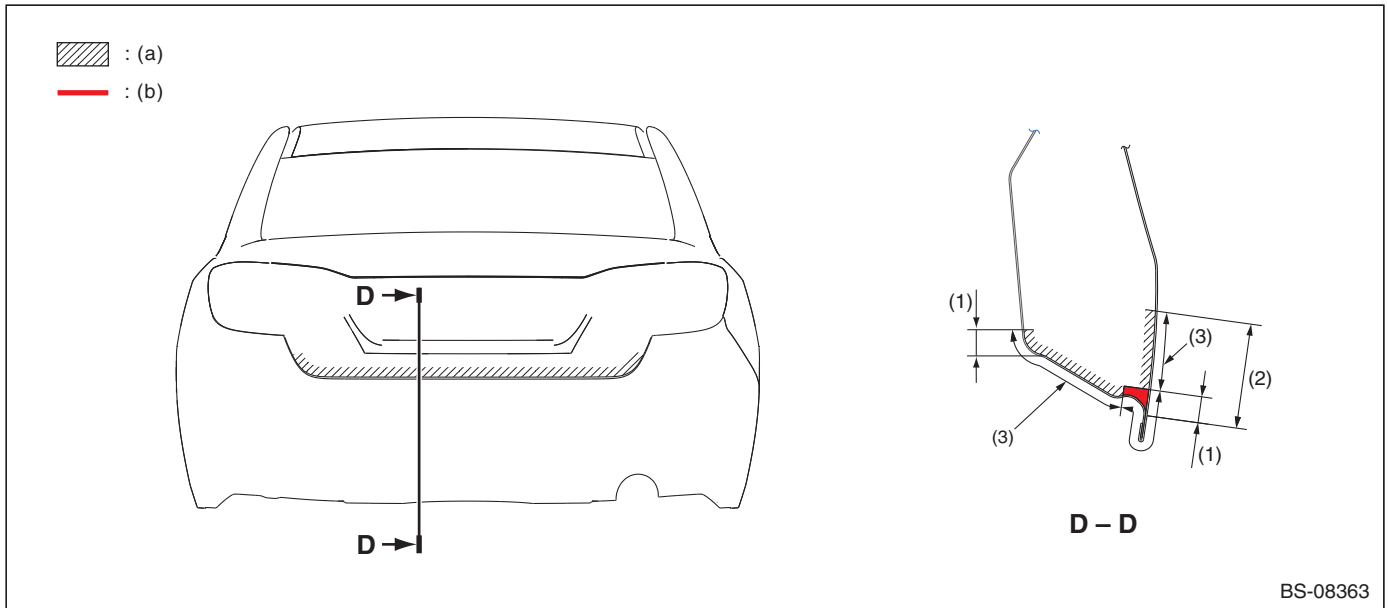
(4) 50 mm (1.97 in)

Anticorrosion Wax

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



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

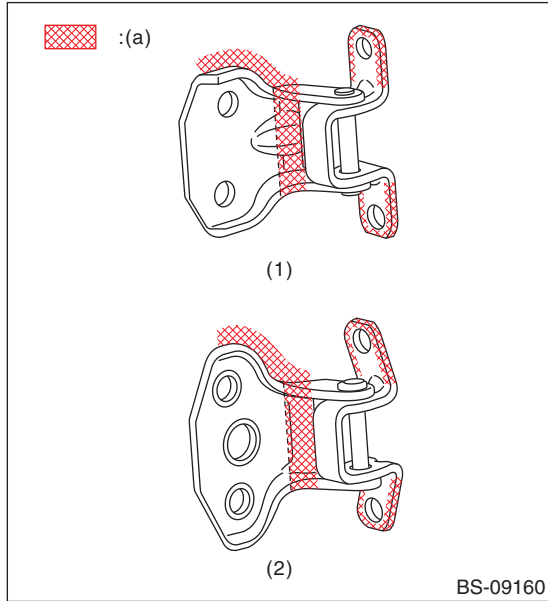


Anticorrosion Wax

- Front door hinge

(Application thickness = 50 µm or more)

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



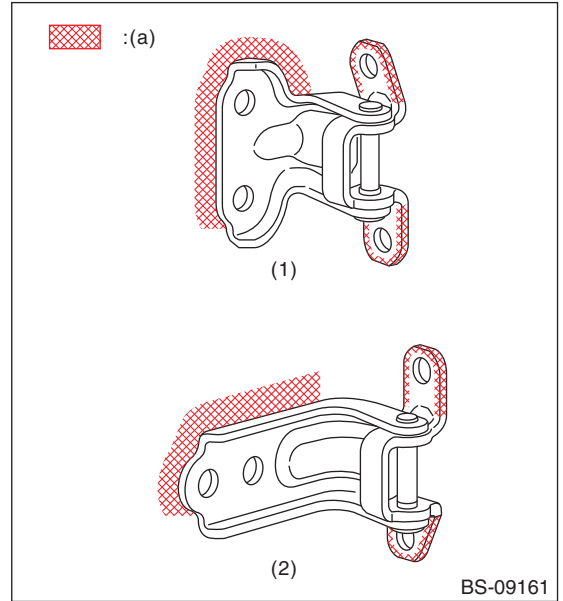
(a) Rust-stop aerosol

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

- Rear door hinge

(Application thickness = 50 µm or more)

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



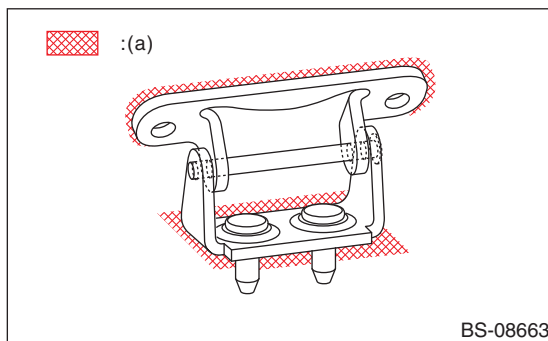
(a) Rust-stop aerosol

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

- Rear gate hinge

(Application thickness = 50 µm or more)

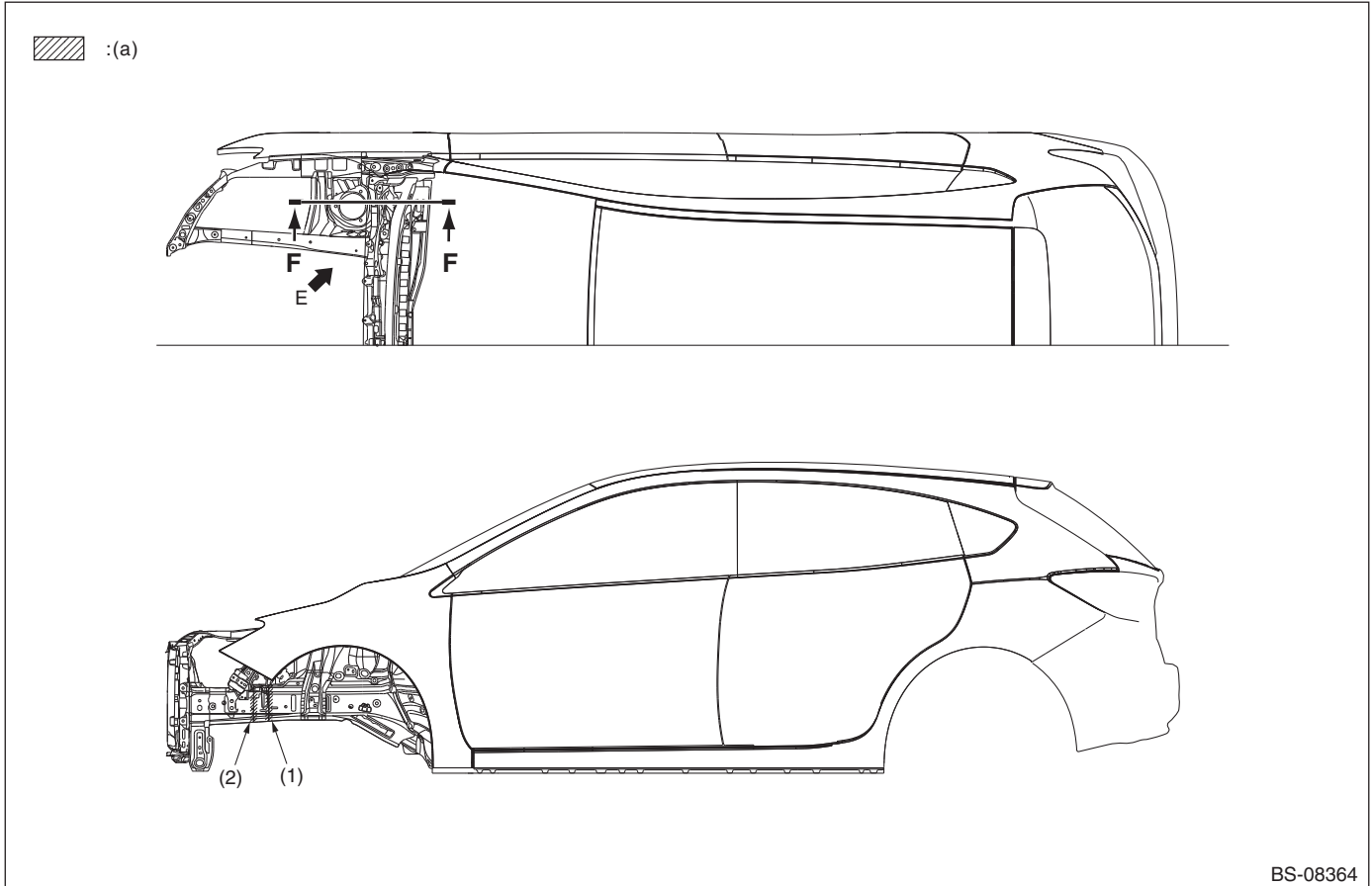
Apply to the contact surface on the body side at two locations on the left and right, and to installation outer circumference (indicated range, plate edges) on the rear gate side and to the head of the bolts.



(a) Rust-stop aerosol

Anticorrosion Wax

- Overall view

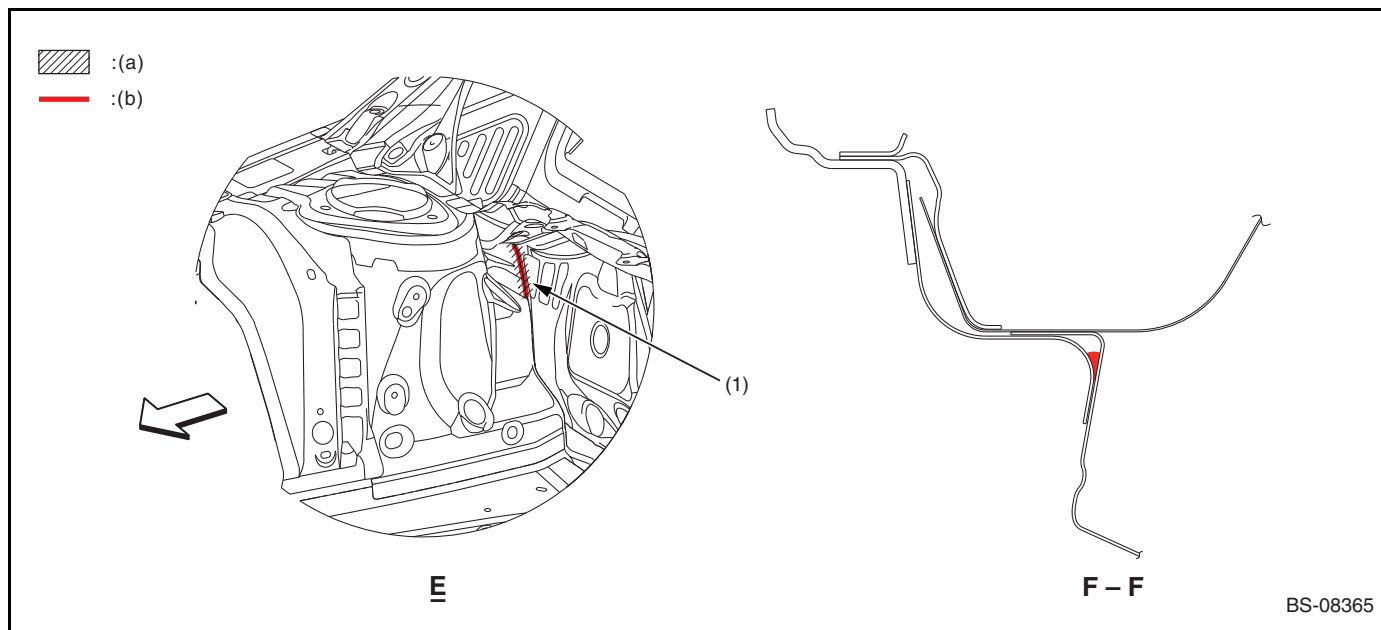


(a) Rust-stop aerosol
(Application thickness = 50 μm or more)

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

Anticorrosion Wax

- View / Cross section



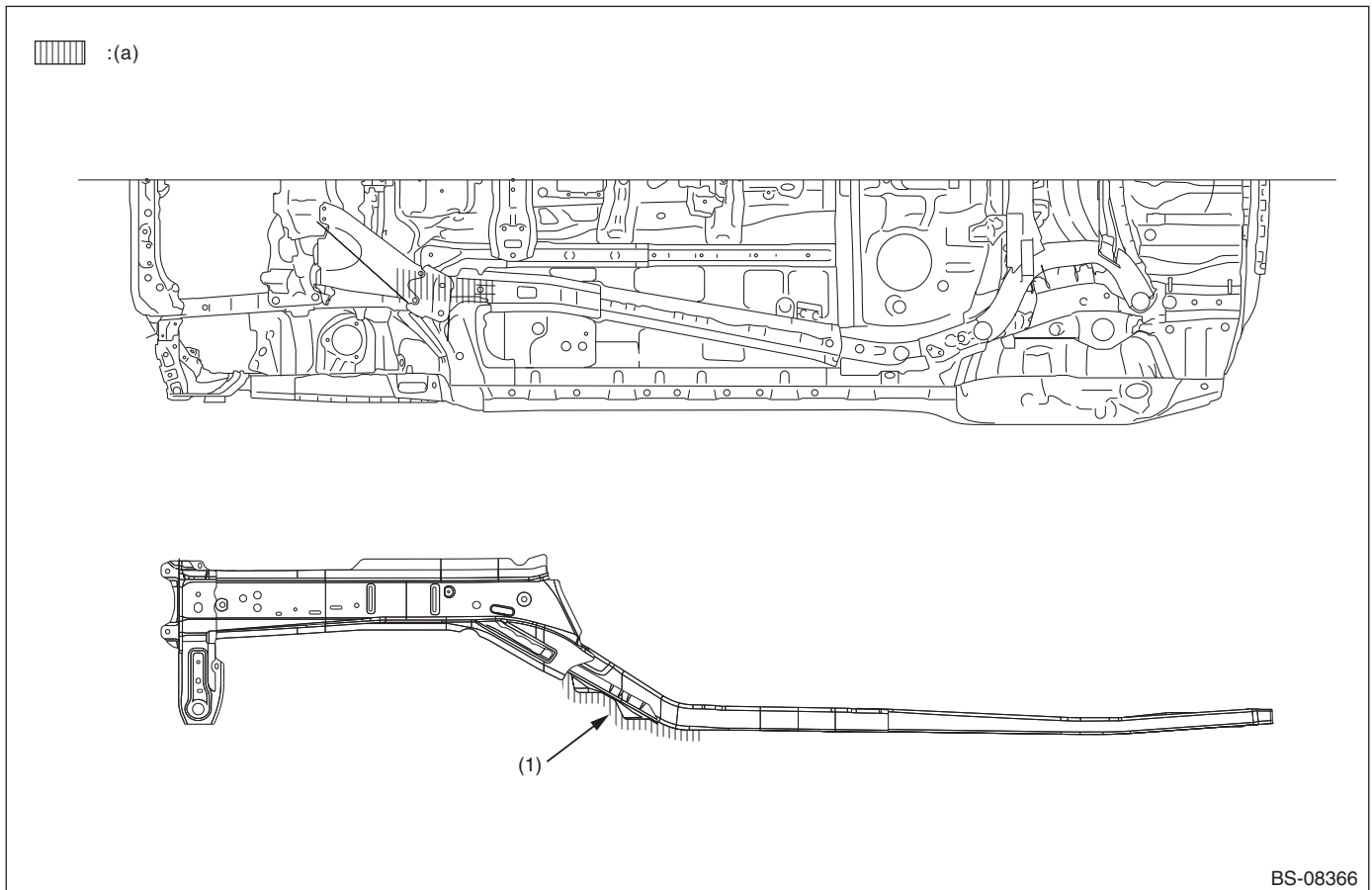
(a) Rust-stop aerosol
(Application thickness = 50 μm or more)

(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



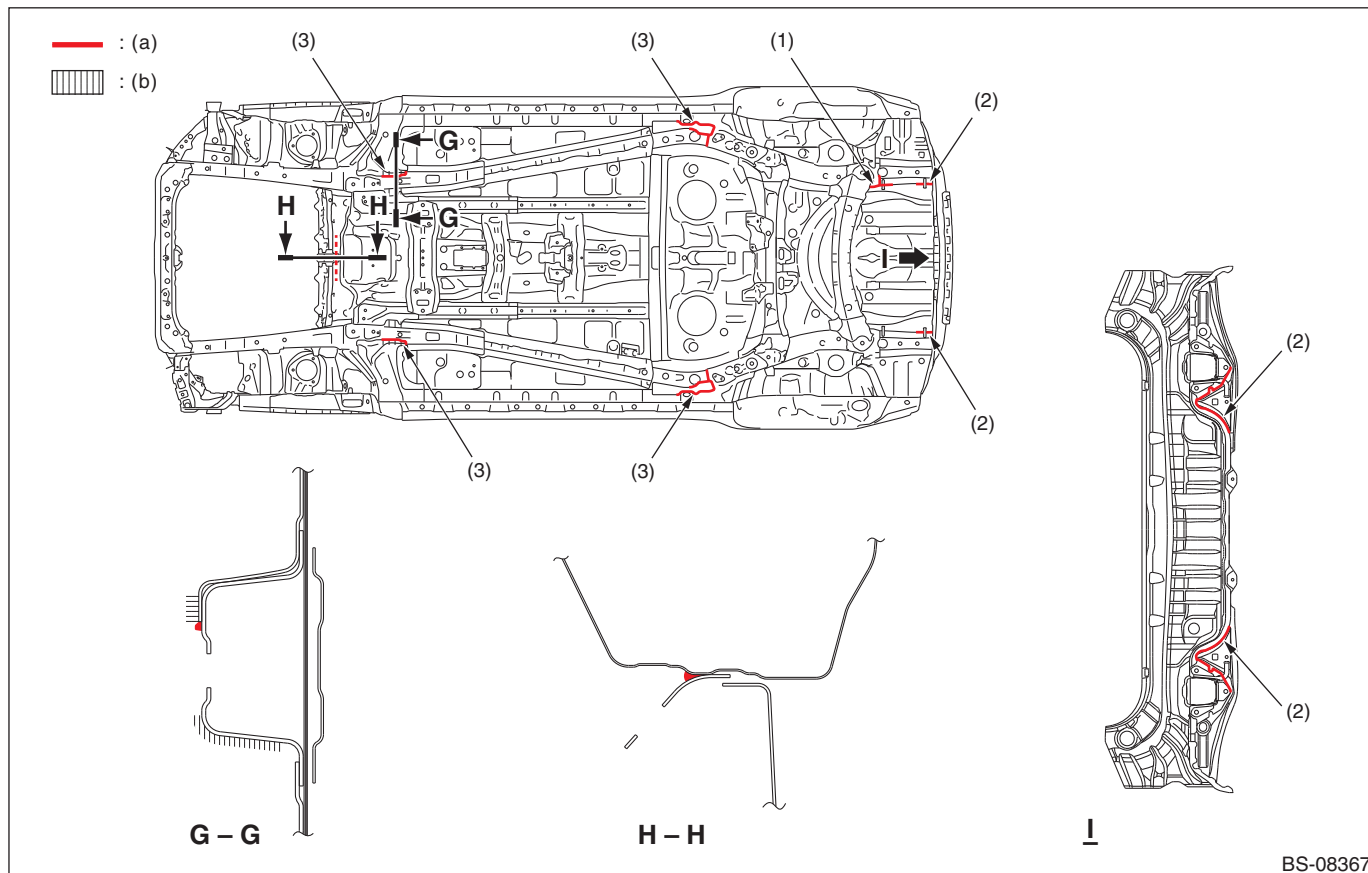
BS-08366

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

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

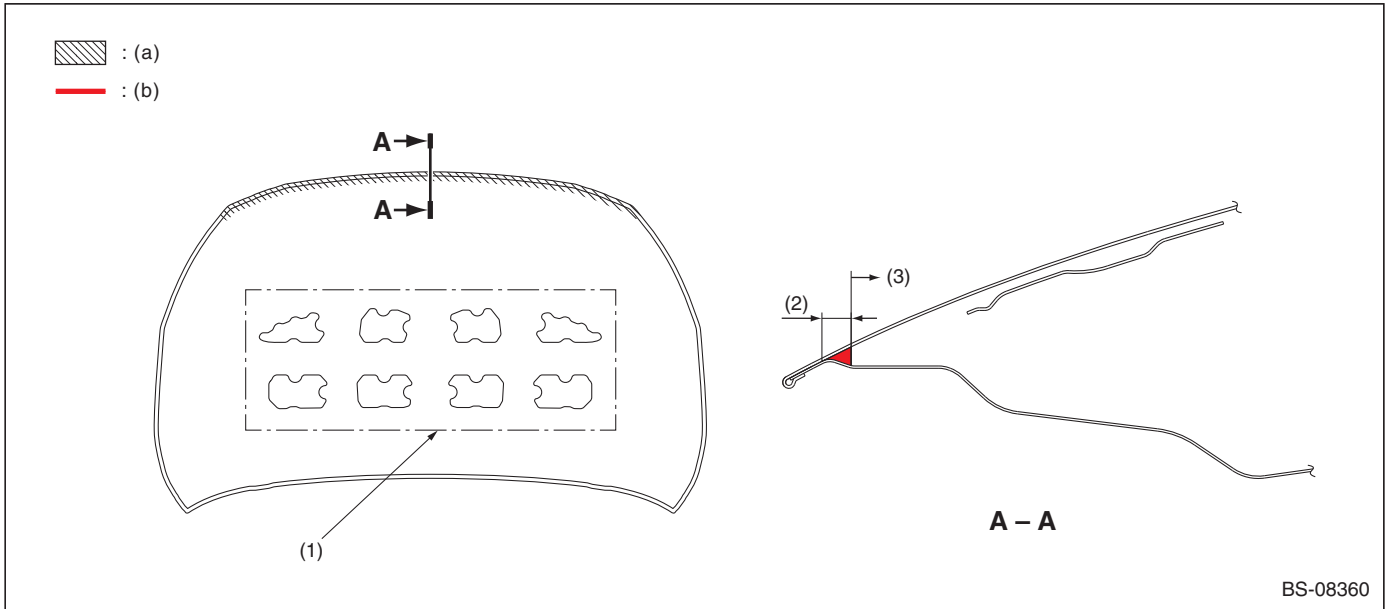
Anticorrosion Wax

B: SPECIFICATIONS (XV / Hybrid model)

Used material: Rust-stop aerosol (K0877YA015)

— and    : Application area

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



(a) Rust-stop aerosol

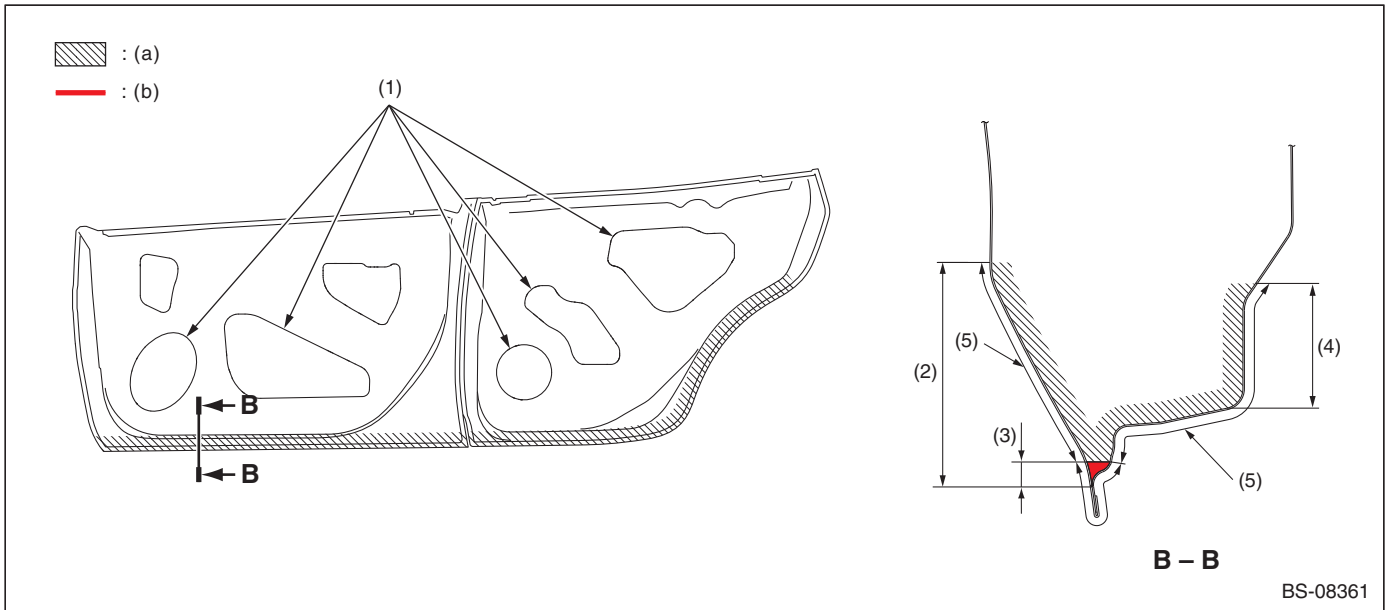
(b) To be filled into the plate joint

(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)

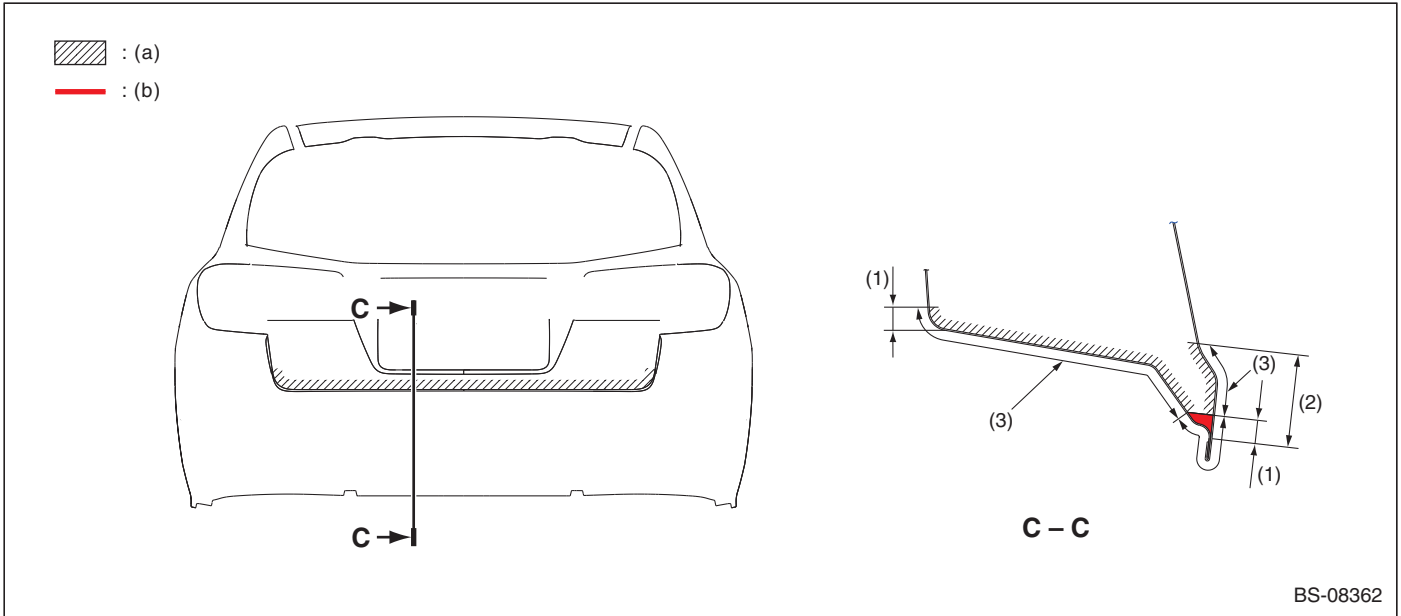
(5) Adherence of mist is allowable

(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)

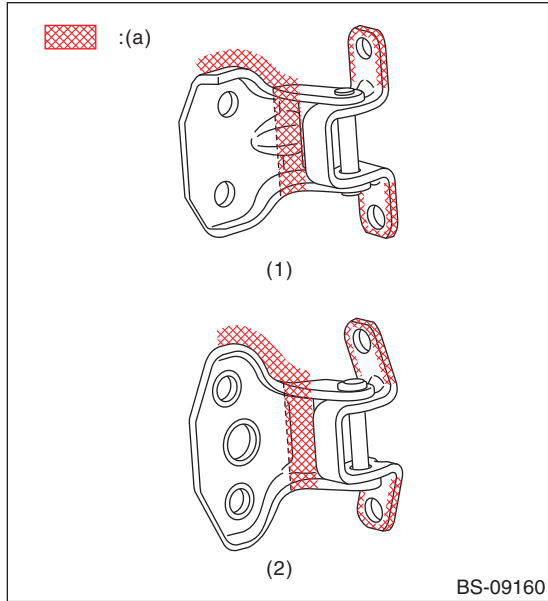
(3) Adherence of mist is allowable

Anticorrosion Wax

- Front door hinge

(Application thickness = 15 μm or more)

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

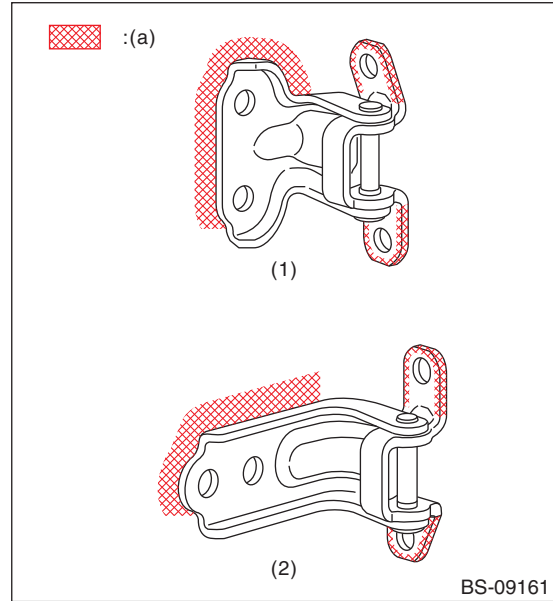


(a) Rust-stop aerosol

- Rear door hinge

(Application thickness = 15 μm or more)

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

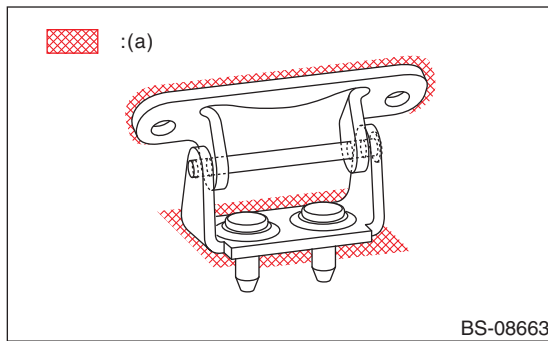


(a) Rust-stop aerosol

- Rear gate hinge

(Application thickness = 15 μm or more)

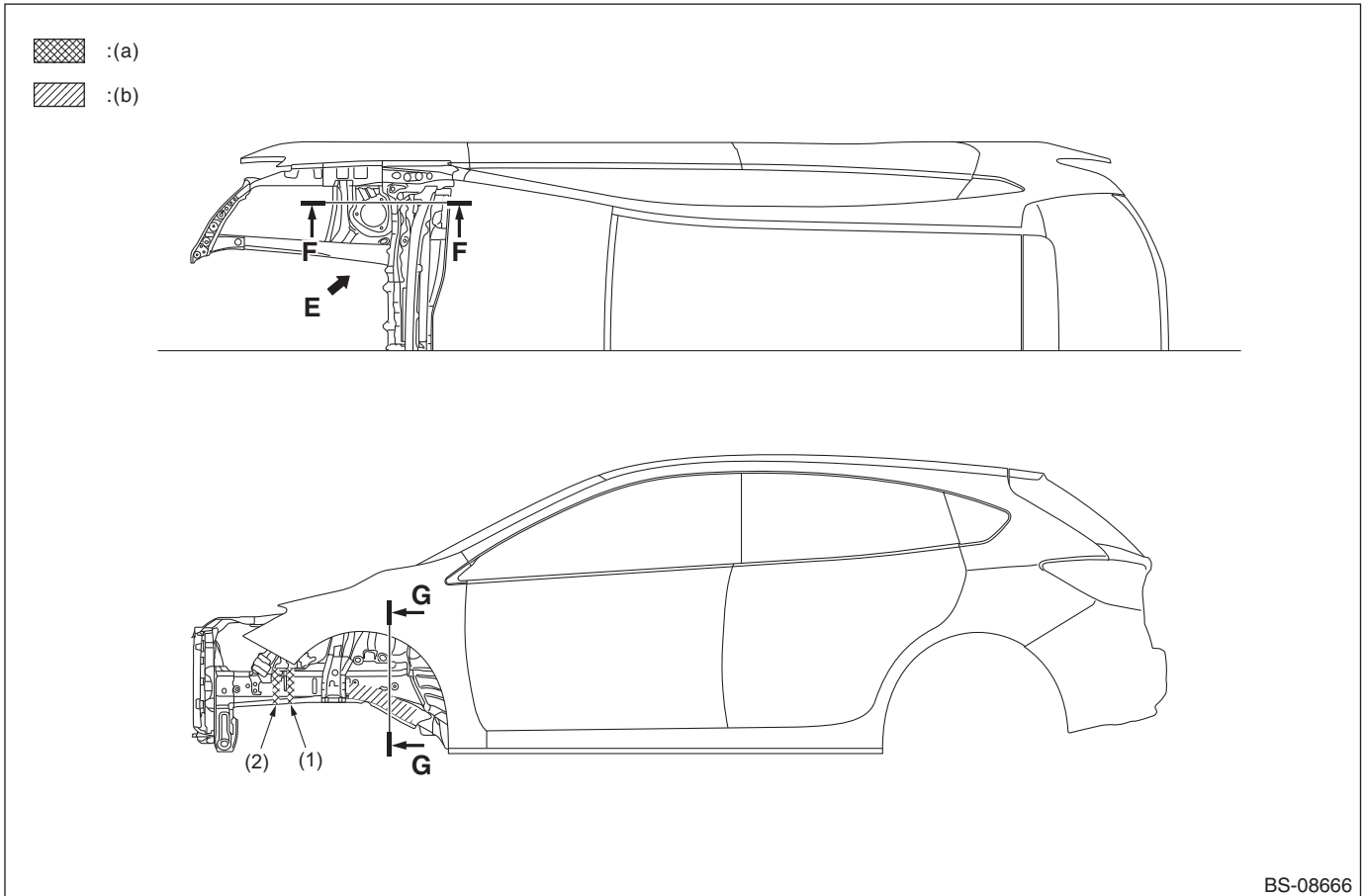
Apply to the contact surface on the body side at two locations on the left and right, and to installation outer circumference (indicated range, plate edges) on the rear gate side and to the head of the bolts.



(a) Rust-stop aerosol

Anticorrosion Wax

- Overall view



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

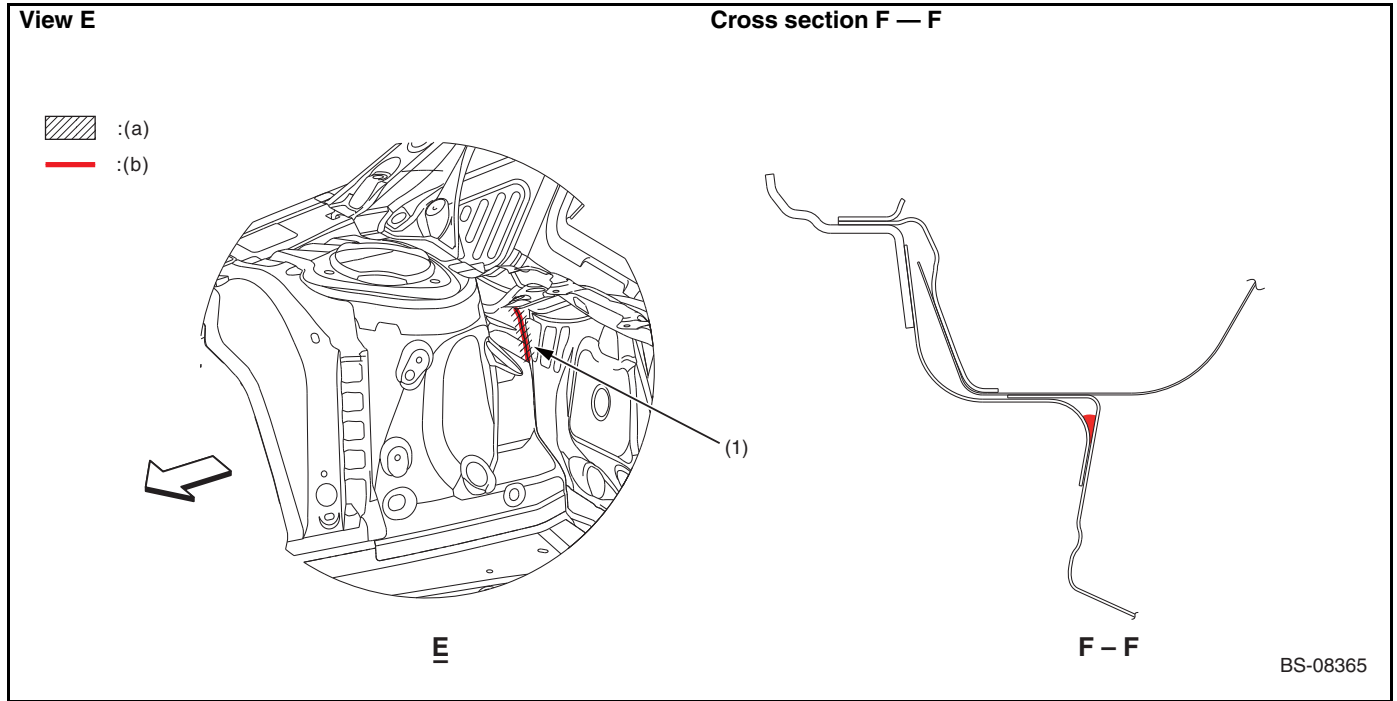
(b) Rust-stop aerosol
(Application thickness = 50 μm or more)

(1) The panel joints shall be covered

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

Anticorrosion Wax

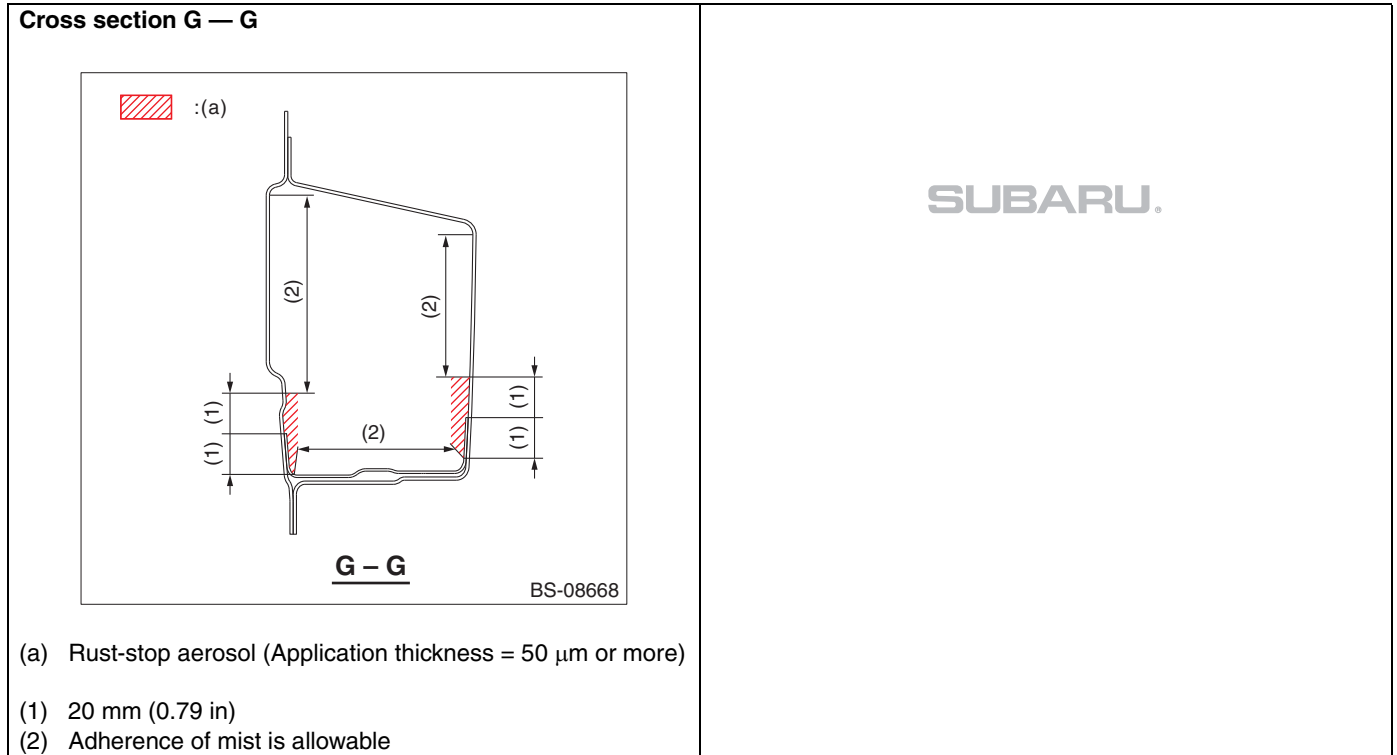
- View / Cross section



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

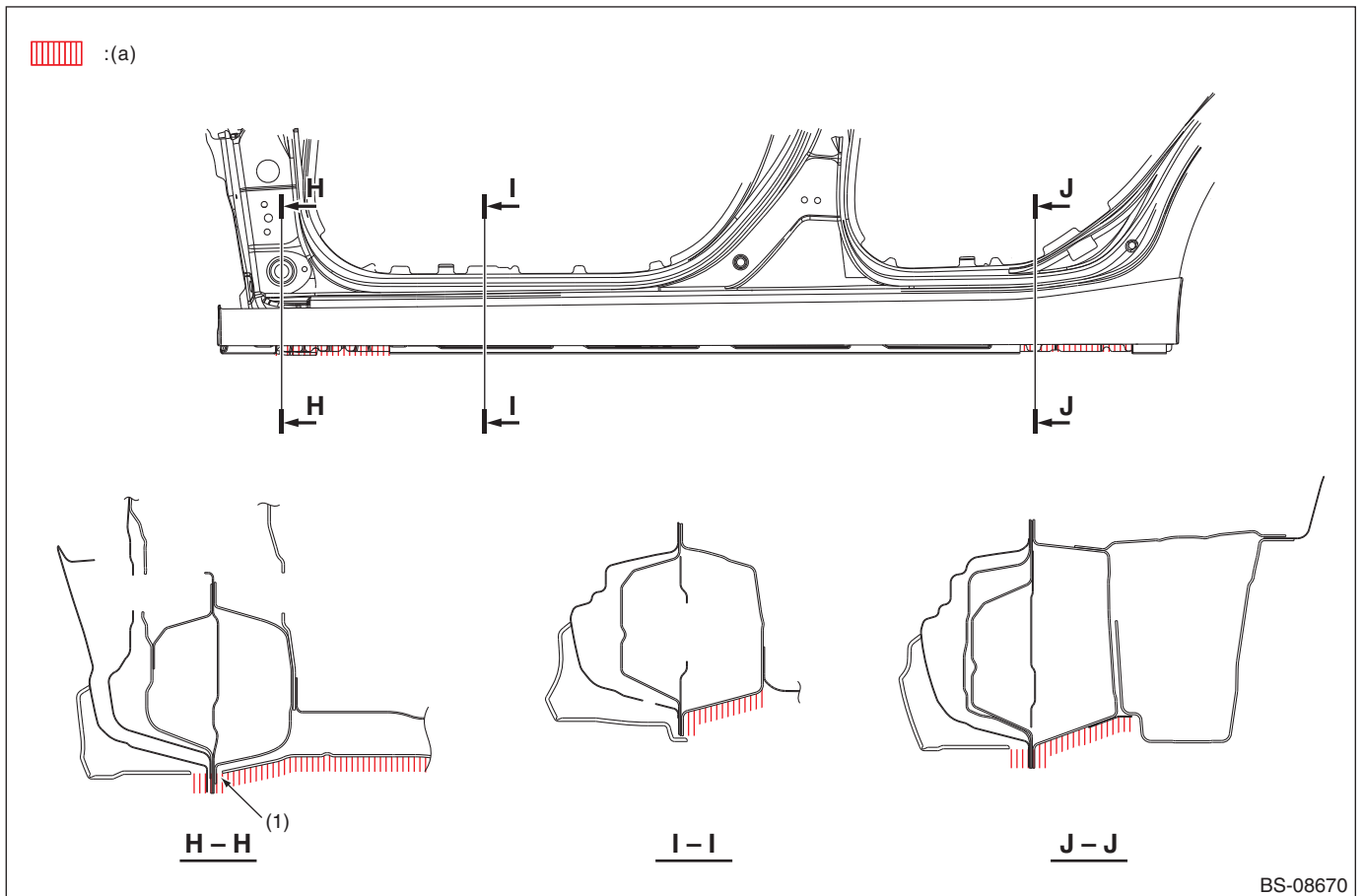
(1) 20 mm (0.79 in)

(2) Adherence of mist is allowable

Anticorrosion Wax

Jack-up point area (Application thickness = 150 μm or more)

Apply as much wax as possible to the side sill flange area from the helical groove of the side sill spoiler.

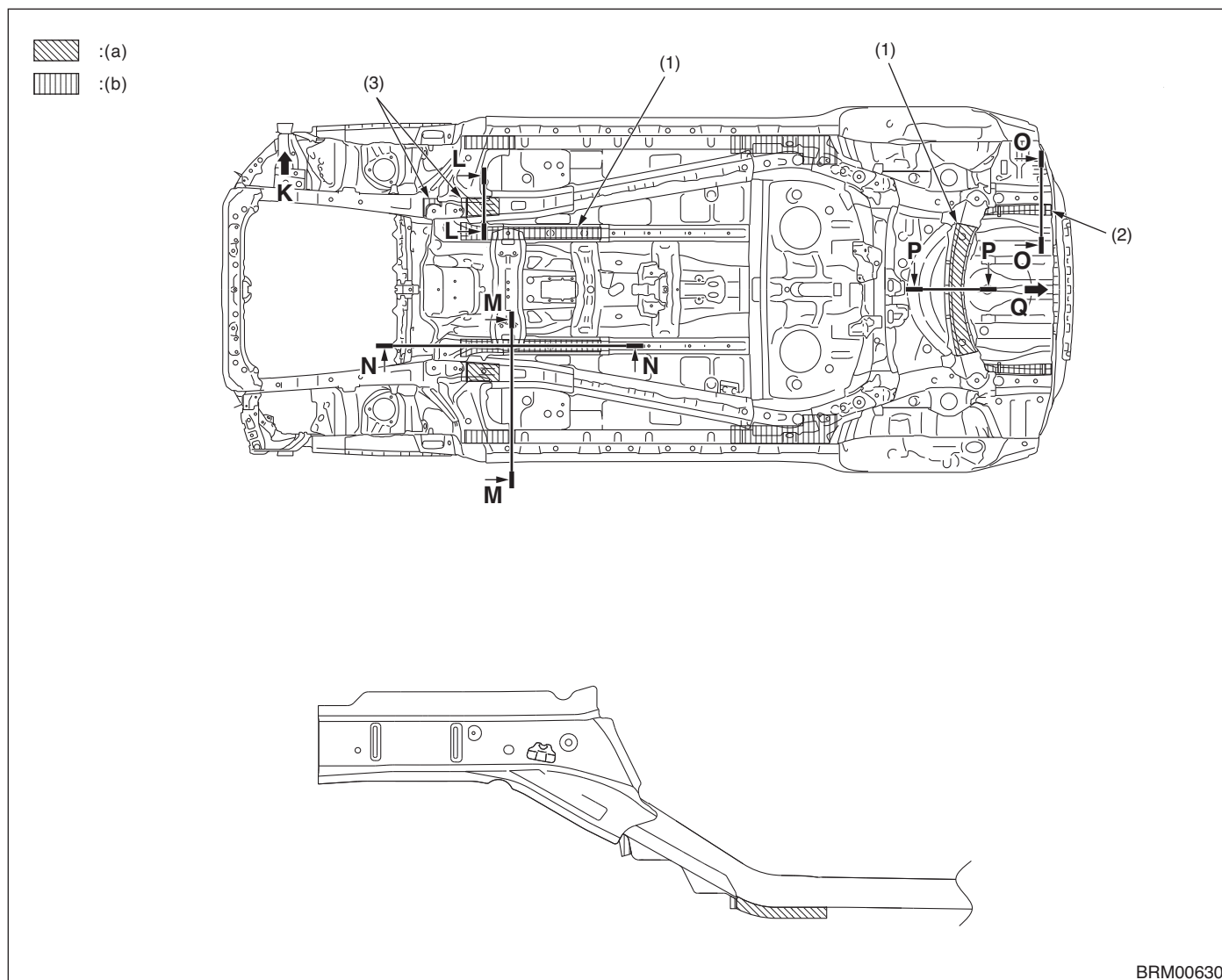


(a) Rust-stop aerosol

(1) Do not close the drain beads (right and left)

Anticorrosion Wax

- Bottom view



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

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

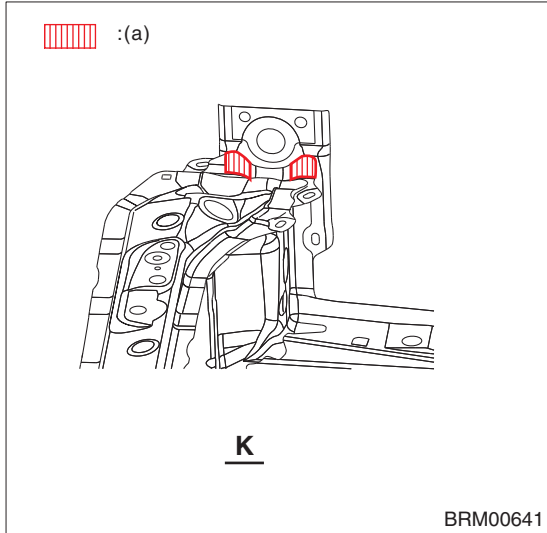
(1) Only XV model

(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.

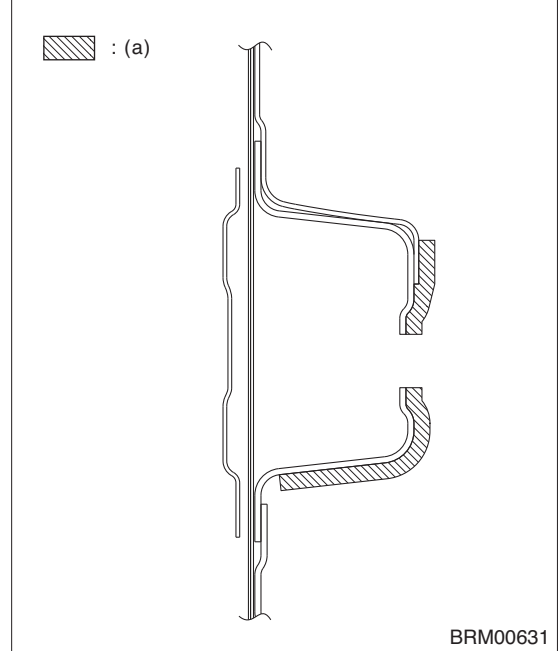
Anticorrosion Wax

View K



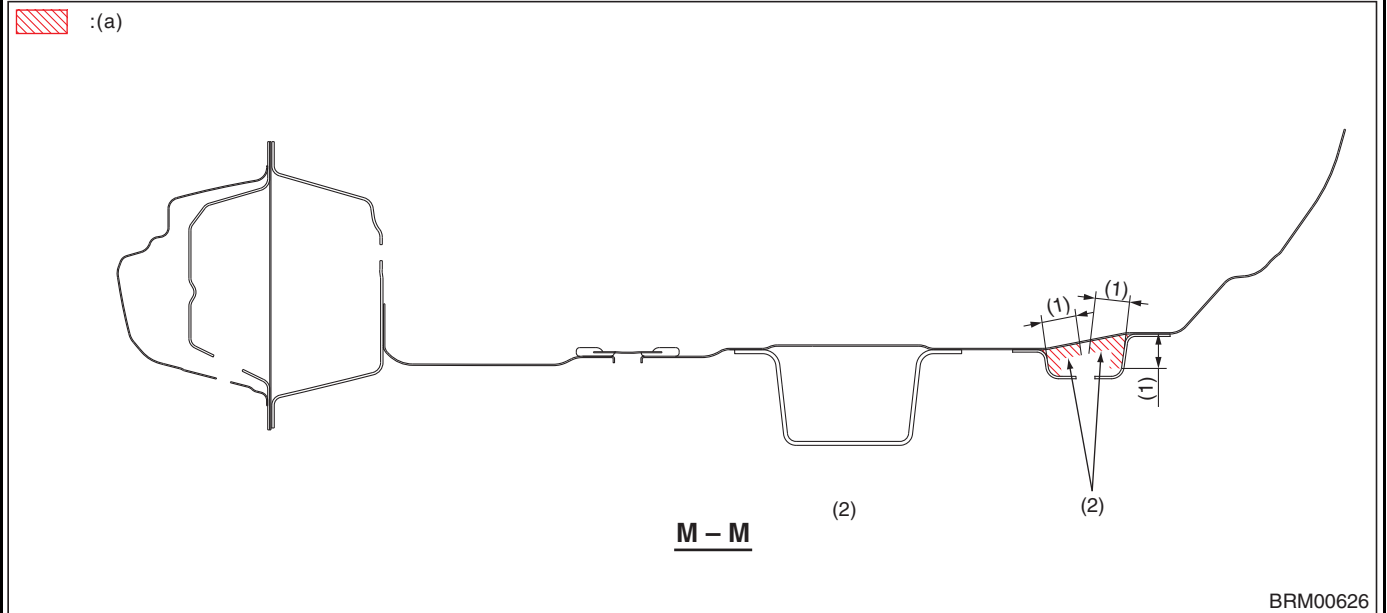
(a) Rust-stop aerosol (Application thickness = 150 μm or more)

Cross section L — L



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

Cross section M — M (Only XV model)



(a) 50 μm or more

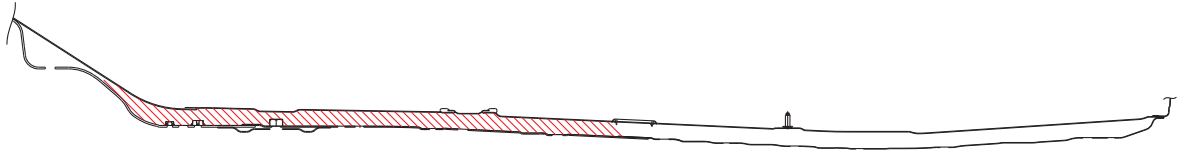
(1) 20 mm (0.79 in)

(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)



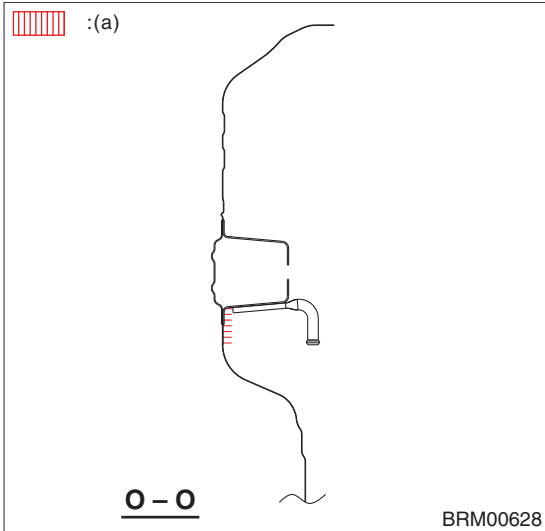
N — N

BRM00627

(a) 50 μm or more

Cross section O — O

 : (a)



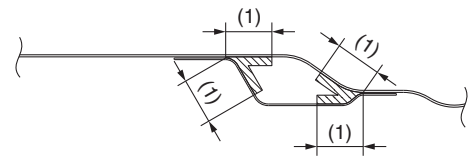
O — O

BRM00628

(a) 150 μm or more

Cross section P — P (Only XV model)

 : (a)



P — P

BRM00632

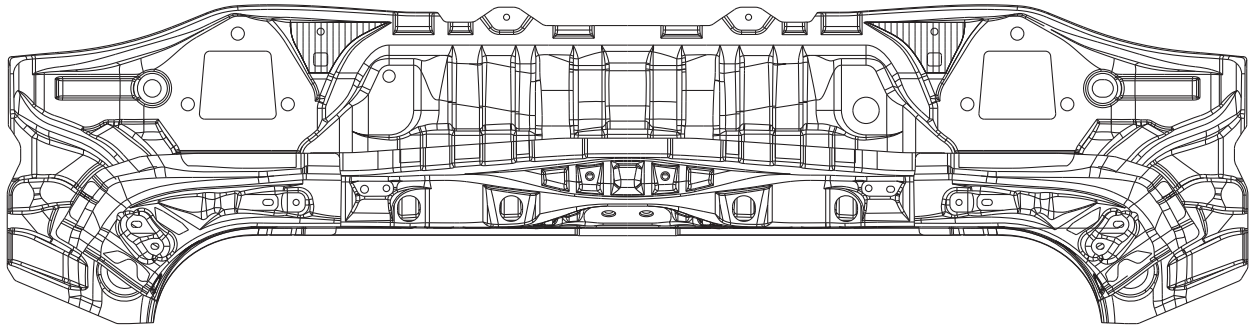
(a) 50 μm or more

(1) 20 mm (0.79 in)

Anticorrosion Wax

View Q

 : (a)



Q

BRM00633

(a) 150 μ m or more

11.Undercoat

A: SPECIFICATIONS (5D/4D model)




Repair material: PVC (NT guardcoat 5900FL)

CAUTION:

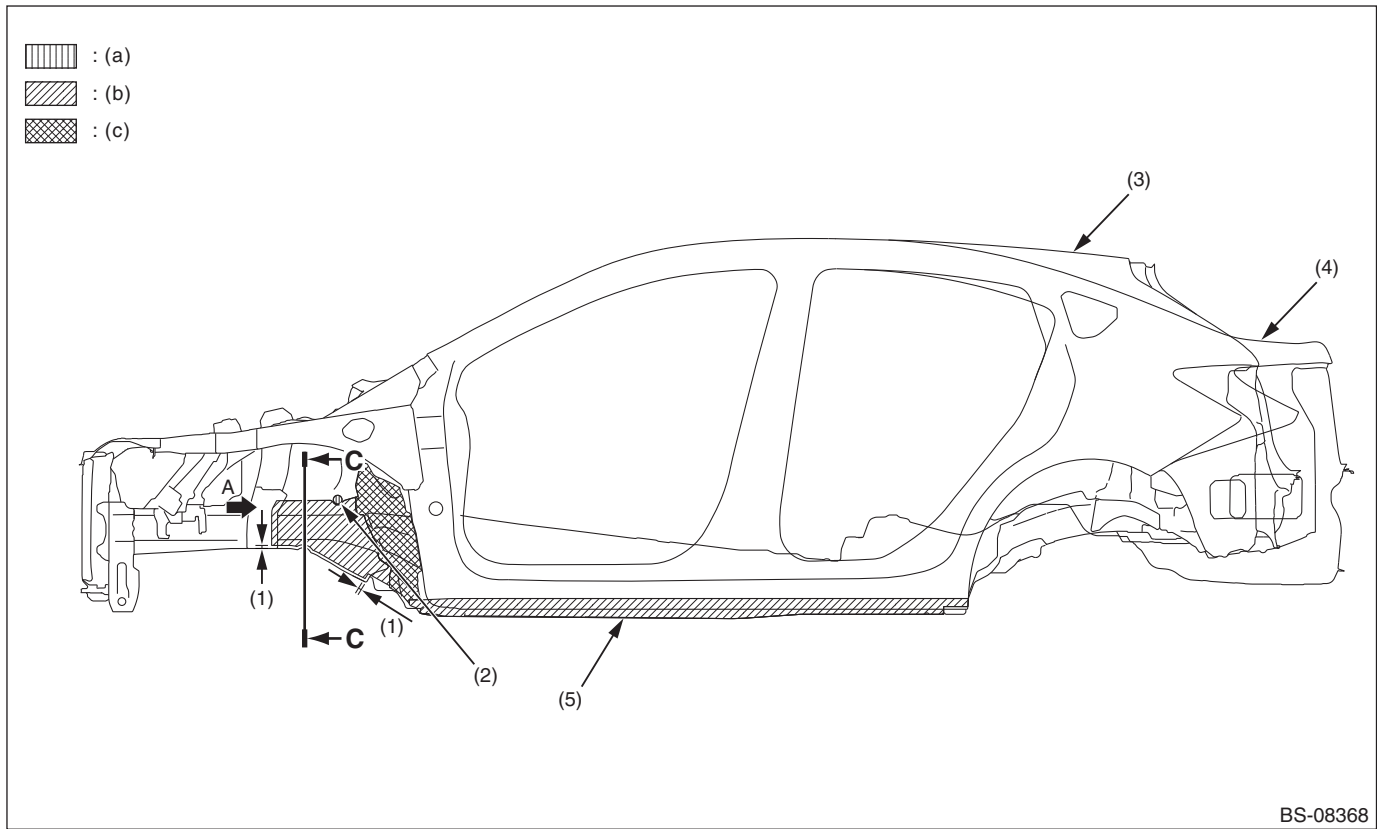
Be careful not to let the undercoating be attached to any parts not indicated below and to the following locations.

- 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



(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

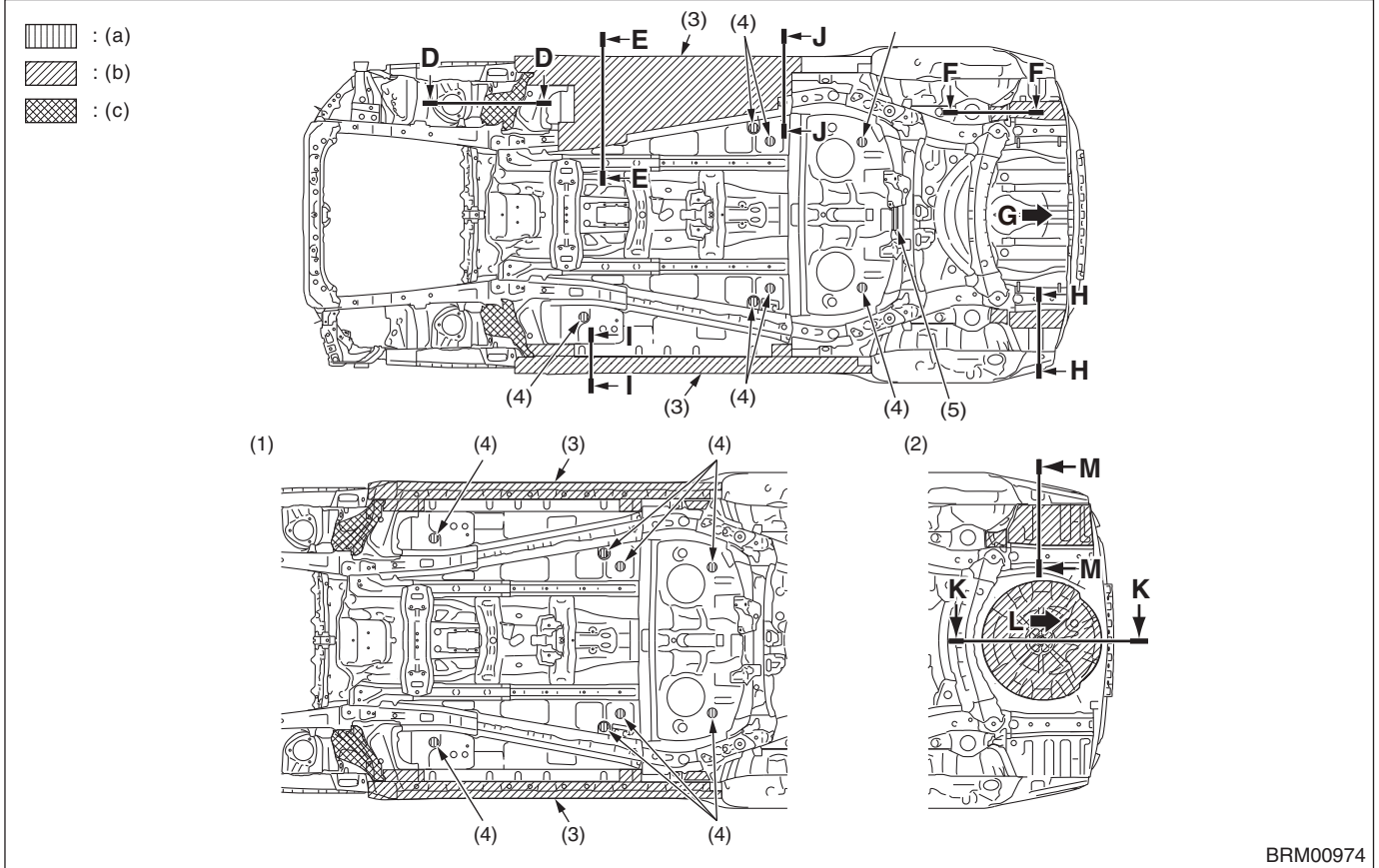
(5) Only for the models without under
cover, and the models with under
cover and without side sill spoiler

(2) Plug must be covered with PVC

(4) 4 Door

Undercoat

• Bottom view



(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

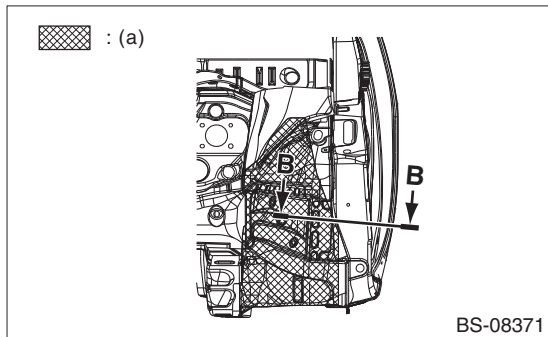
(3) Only for the models without side
sill spoiler

(5) Apply PVC to the air pocket area.

(2) 4 Door

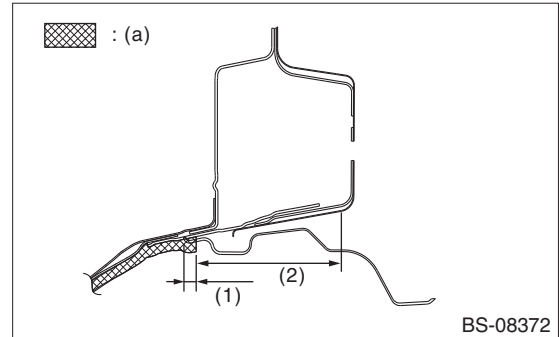
(4) Plug must be covered with
undercoat

View A



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

Cross section B — B



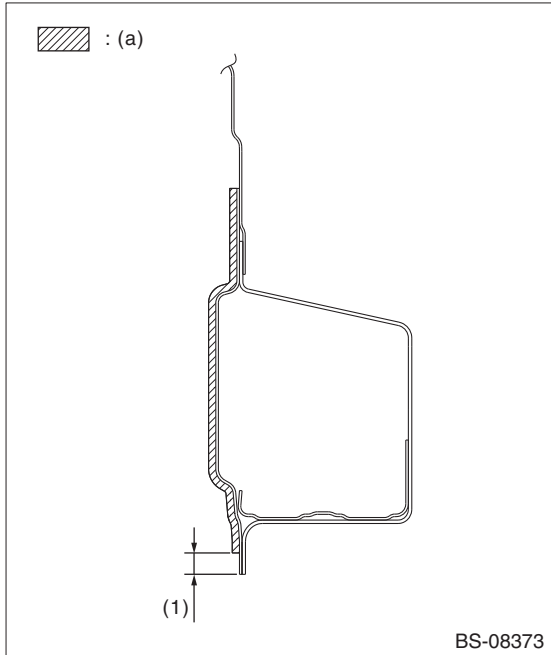
(a) Dry: 780 μm or more, Wet: 630 μm or more

(1) 10 mm (0.39 in)

(2) Adherence of mist is allowable

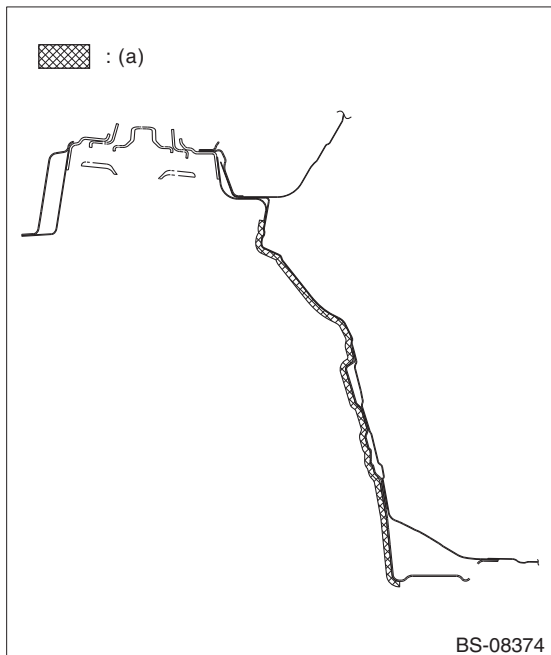
Undercoat

Cross section C — C



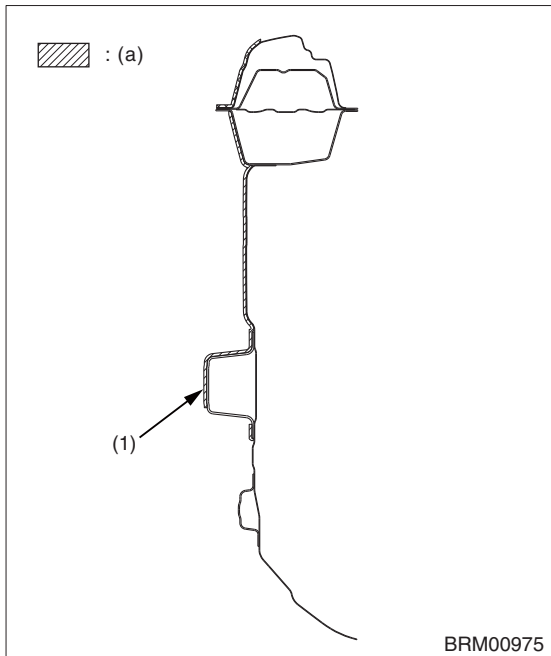
- (a) Dry: 340 μm or more, Wet: 330 μm or more
(1) 10 mm (0.39 in) (Adherence of mist is allowable)

Cross section D — D



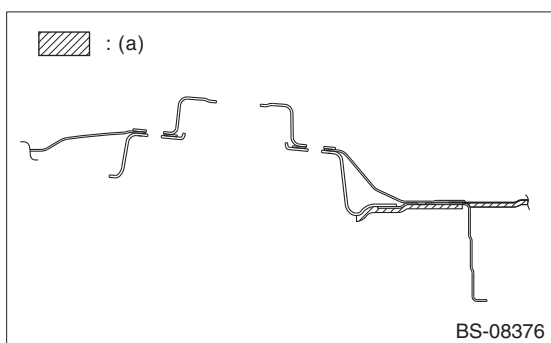
- (a) Dry: 780 μm or more, Wet: 630 μm or more

Cross section E — E



- (a) Dry: 340 μm or more, Wet: 330 μm or more
(1) Model without under cover: LH only

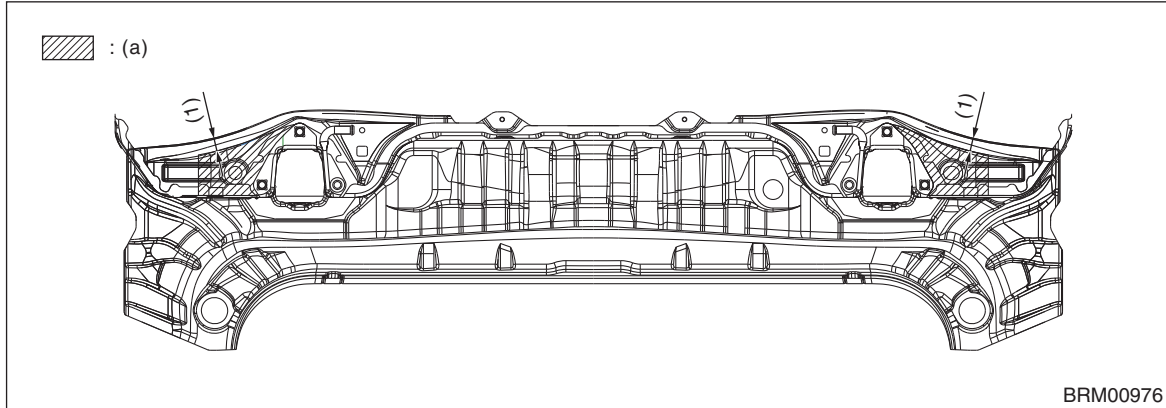
Cross section F — F



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

Undercoat

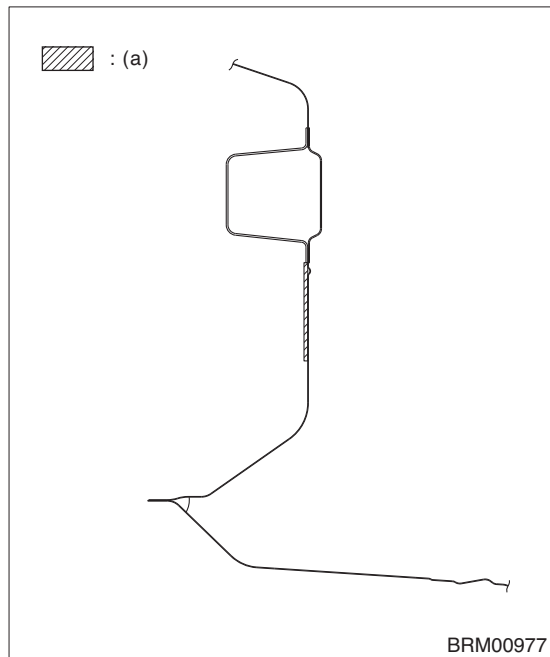
View G



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

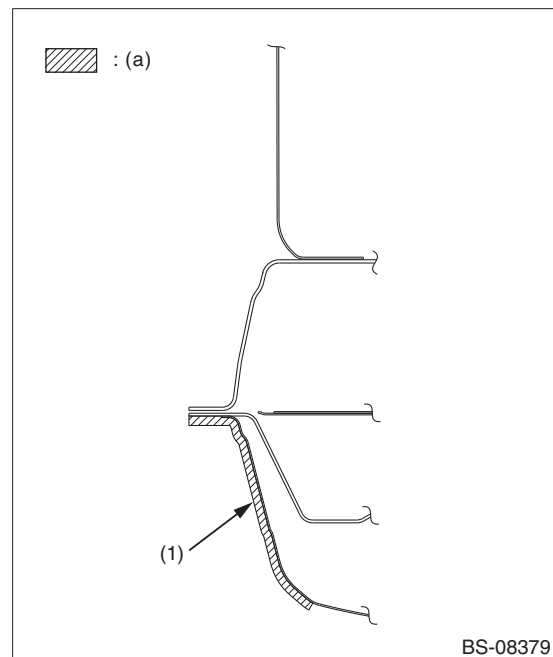
(1) 20 mm (0.79 in)

Cross section H — H



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

Cross section I — I

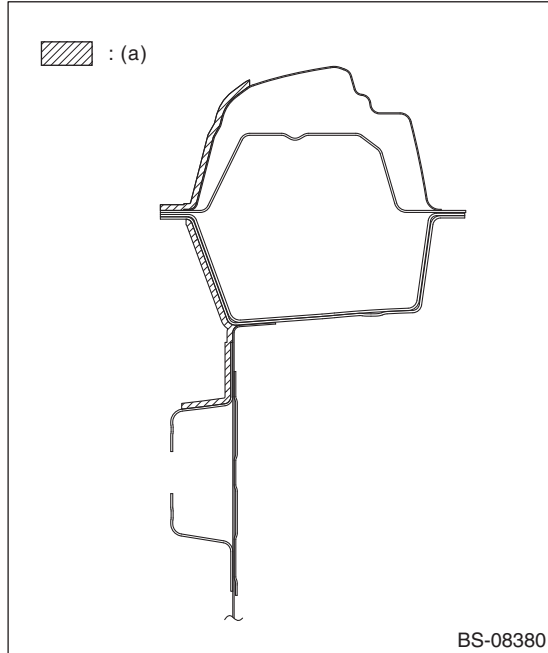


(a) Dry: 340 μm or more, Wet: 330 μm or more

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

Undercoat

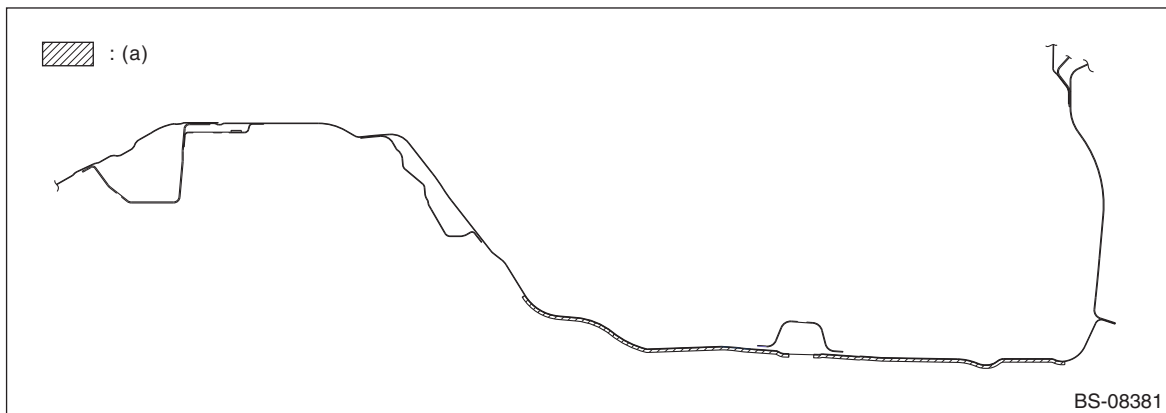
Cross section J — J



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

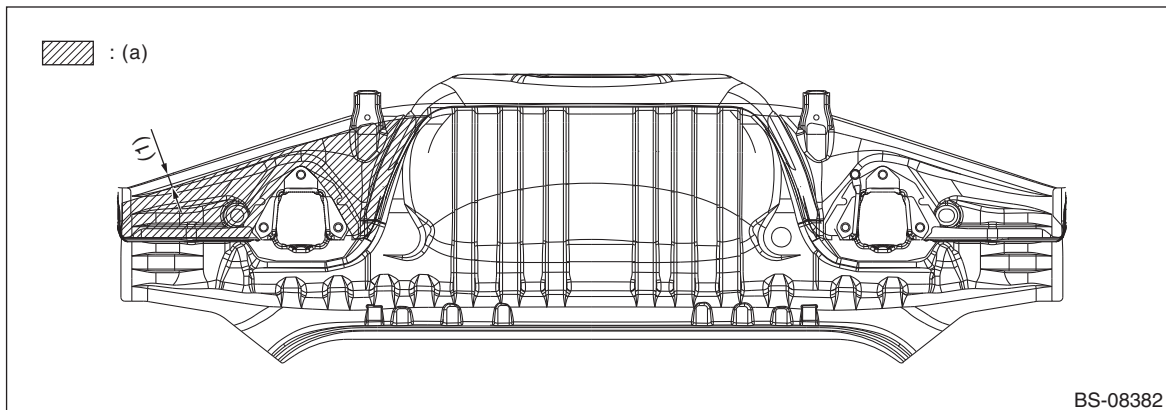
SUBARU.

Cross section K — K



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

View L

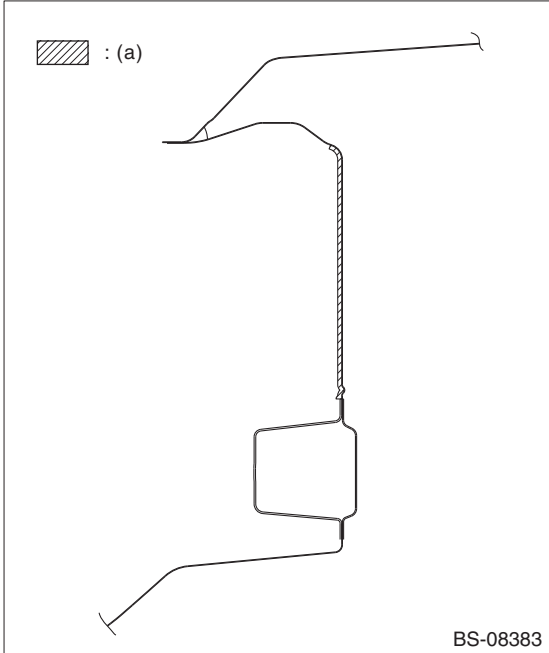


(a) Dry: 340 μm or more, Wet: 330 μm or more

(1) 20 mm (0.79 in)

Undercoat

Cross section M — M



SUBARU.

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

Undercoat

B: SPECIFICATIONS (XV / Hybrid model)




Repair material: PVC (NT guardcoat 5900FL)

CAUTION:

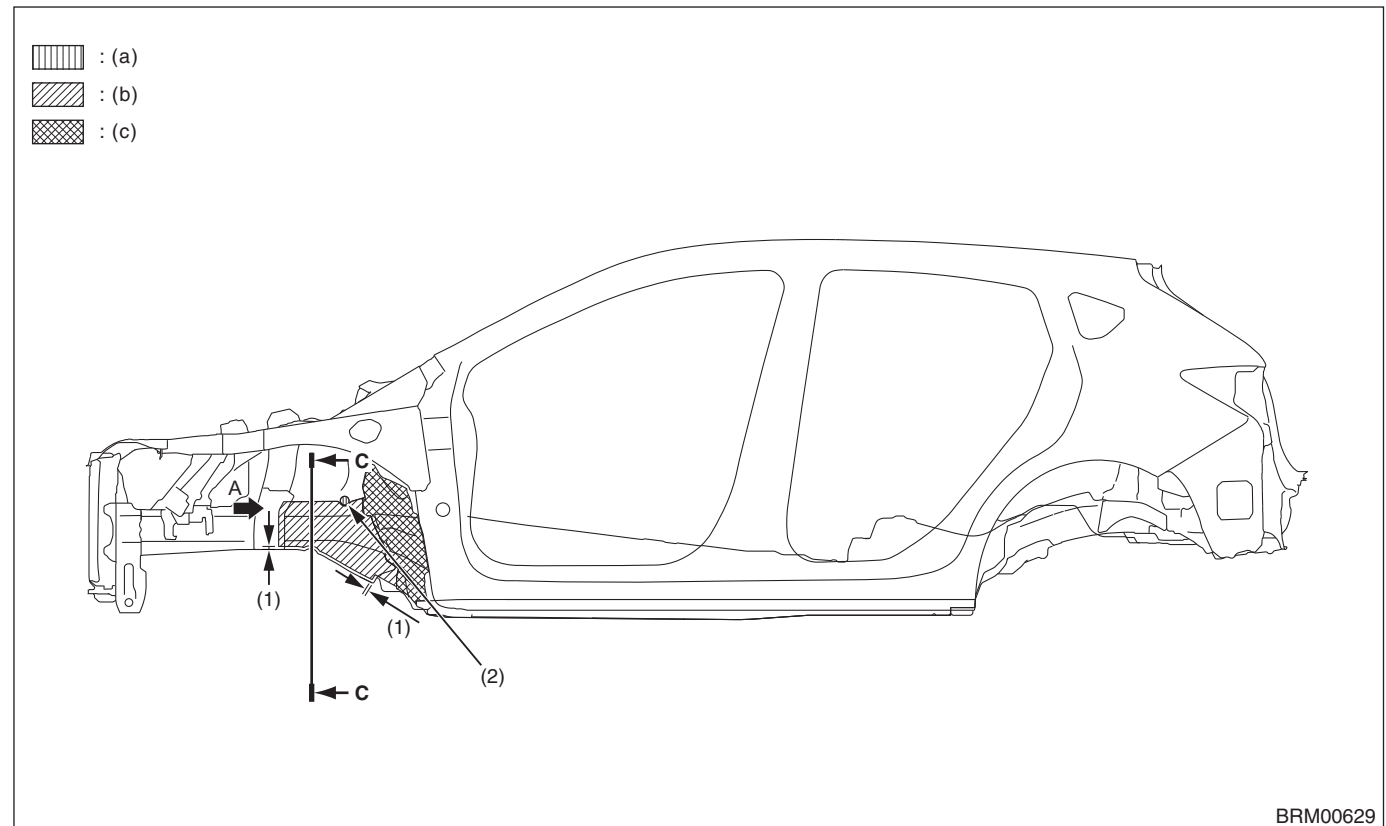
Be careful not to let the undercoating be attached to any parts not indicated below and to the following locations.

- 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

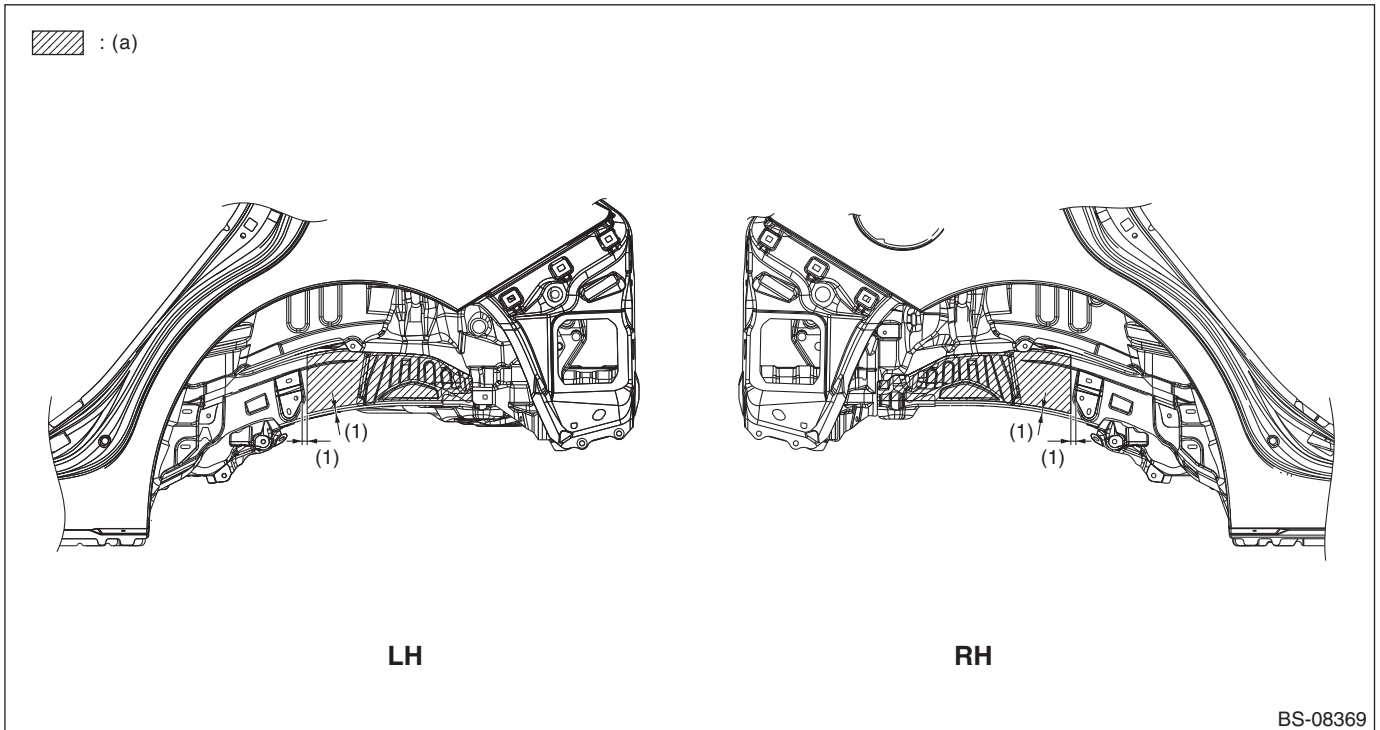
(c) 600 μm — 800 μm

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

(2) Plug must be covered with PVC

Undercoat

- Rear wheel apron side view

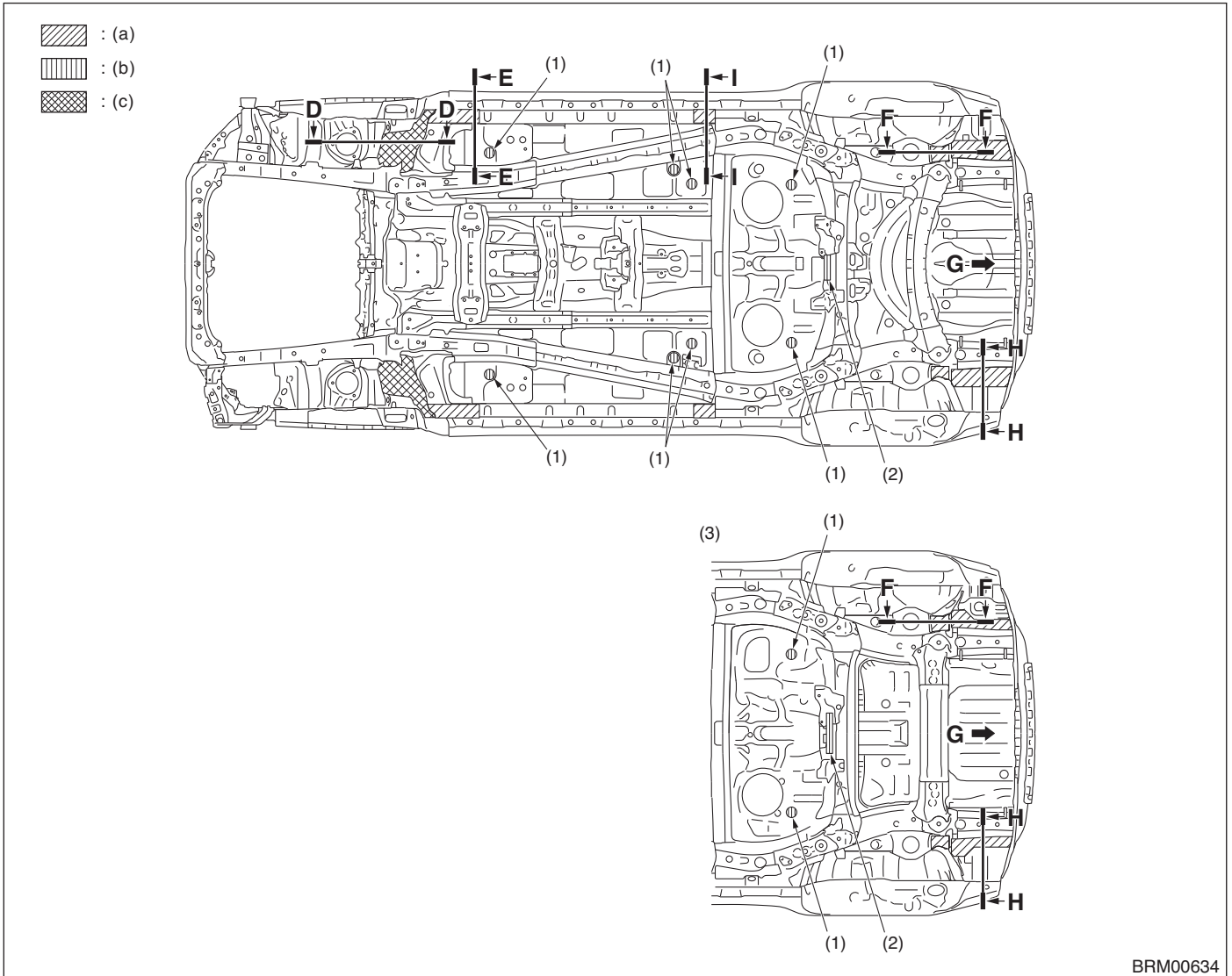


(a) 300 μm — 500 μm

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

Undercoat

- Bottom view



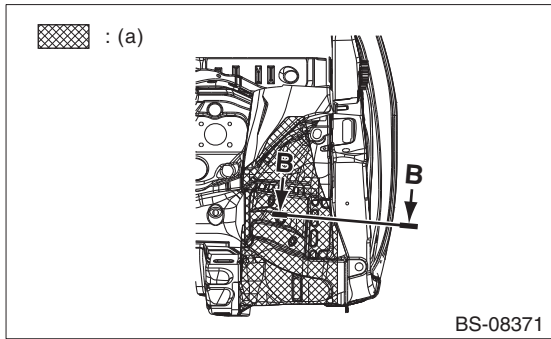
BRM00634

(a) 300 μ m — 500 μ m (b) 200 μ m or more (c) 600 μ m — 800 μ m

(1) Plug must be covered with PVC (2) Apply PVC to the air pocket area. (3) Hybrid model

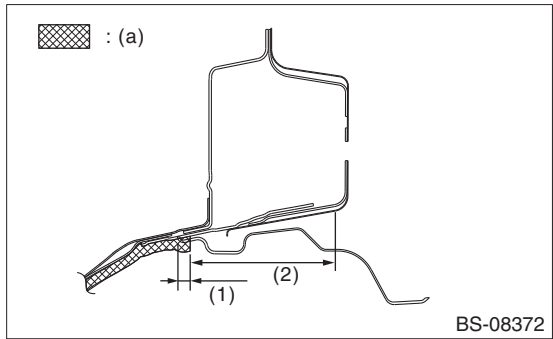
Undercoat

View A



(a) 600 μm — 800 μm

Cross section B — B

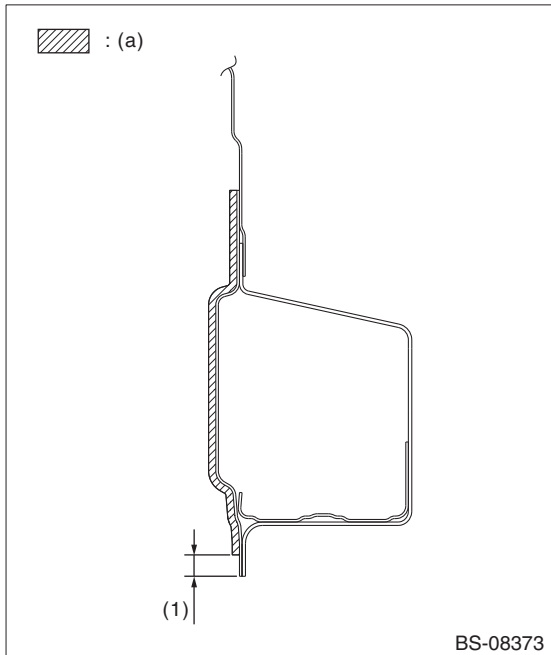


(a) 600 μm — 800 μm

(1) 10 mm (0.39 in)

(2) Adherence of mist is allowable

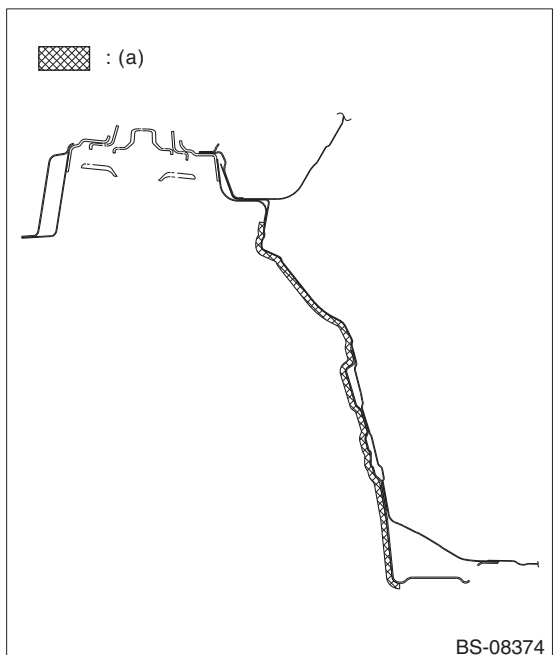
Cross section C — C



(a) 300 μm — 500 μm

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

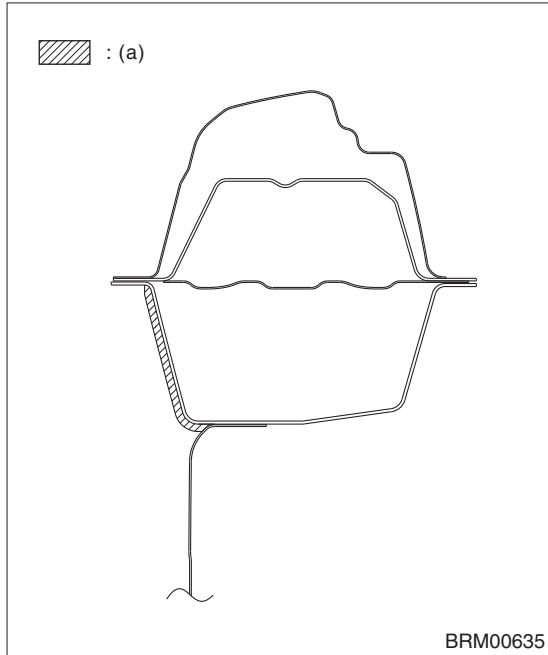
Cross section D — D



(a) 600 μm — 800 μm

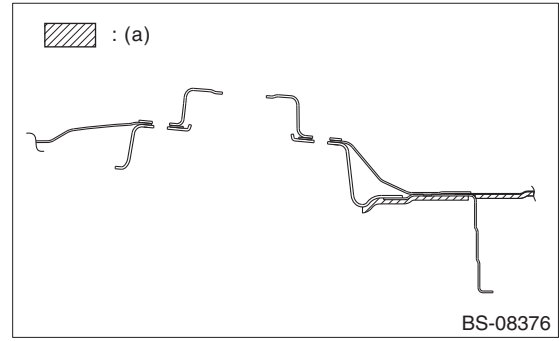
Undercoat

Cross section E — E



(a) 300 μm — 500 μm

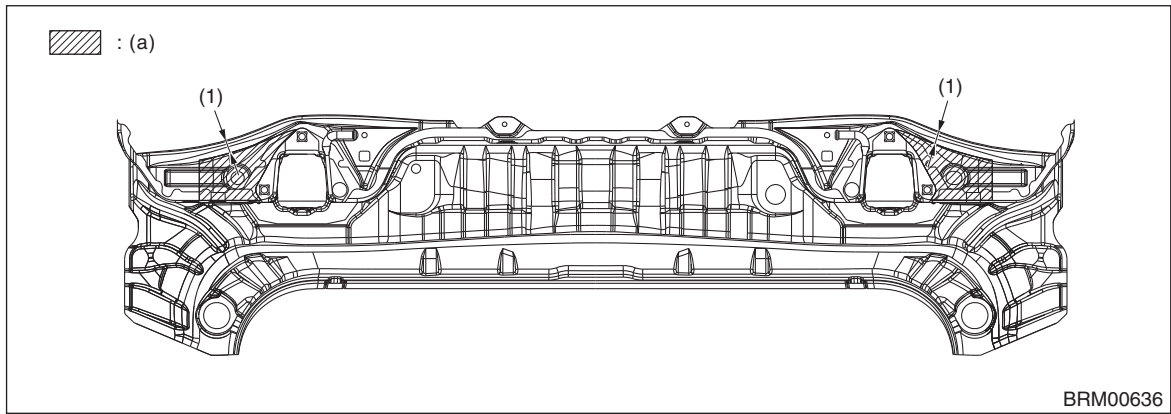
Cross section F — F



(a) 300 μm — 500 μm

SUBARU.

View G

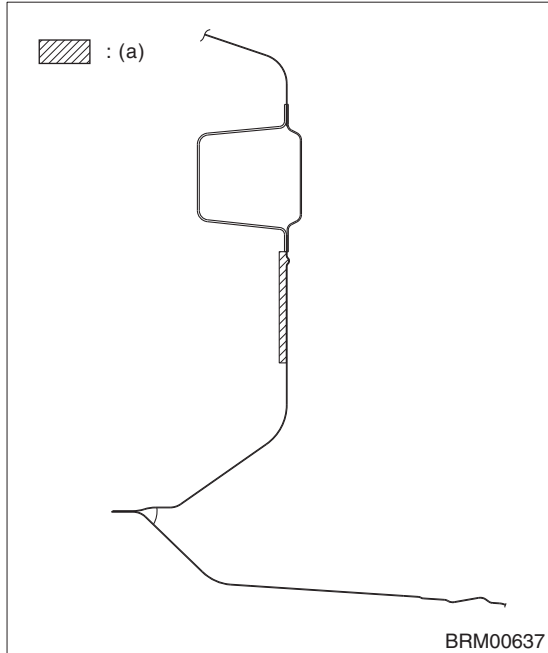


(a) 300 μm — 500 μm

(1) 20 mm (0.79 in)

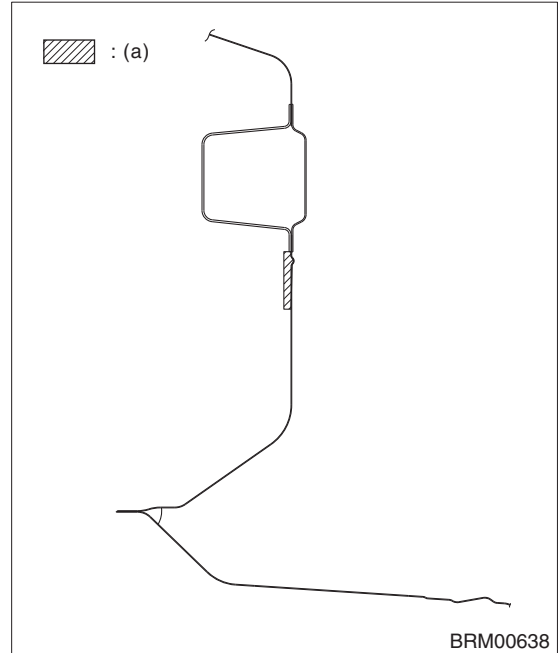
Undercoat

Cross section H — H (XV model)



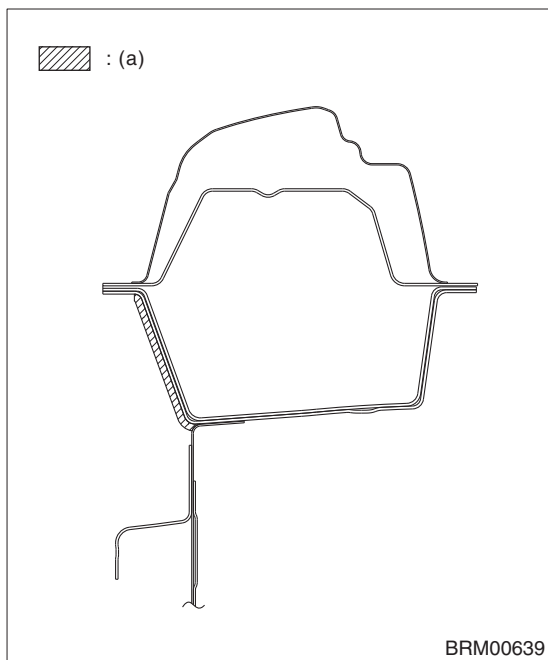
(a) 300 μ m — 500 μ m

Cross section H — H (Hybrid model)



(a) 300 μ m — 500 μ m

Cross section I — I



(a) 300 μ m — 500 μ m

SUBARU.

12.Damping Seat

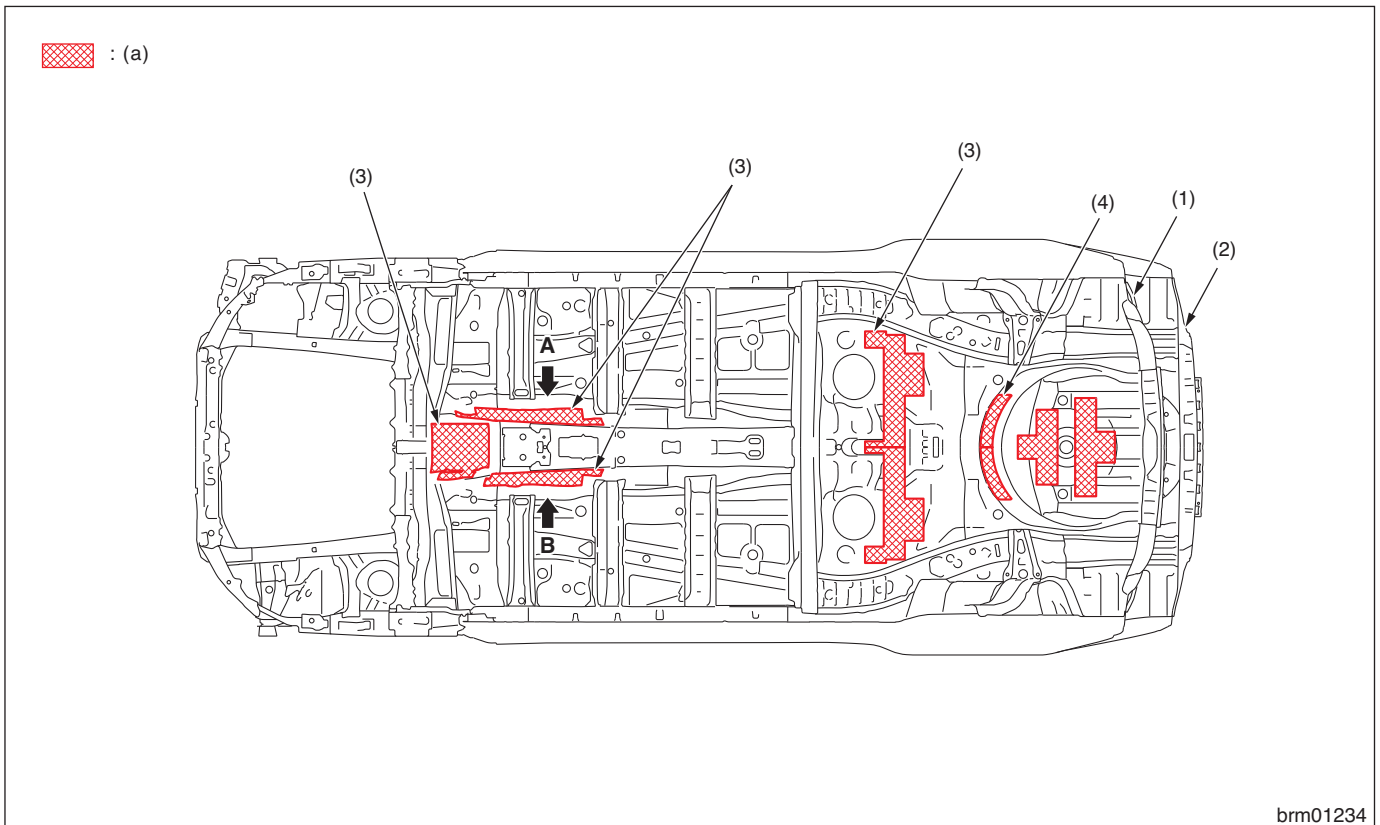
A: SPECIFICATIONS

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

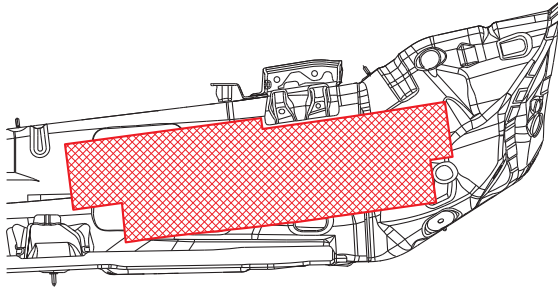
(4) Only for 5 Door models except for
2.0 i

(2) 4 Door

Damping Seat

View A (turned 180°)

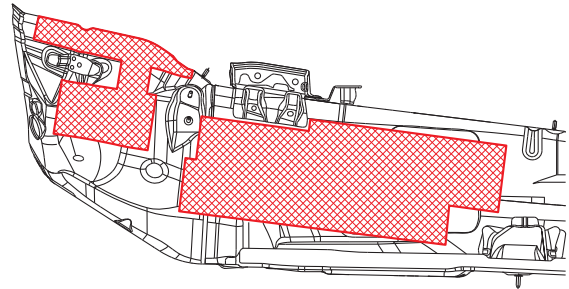
 : (a)



BRM01235

View B

 : (a)



BRM01236

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

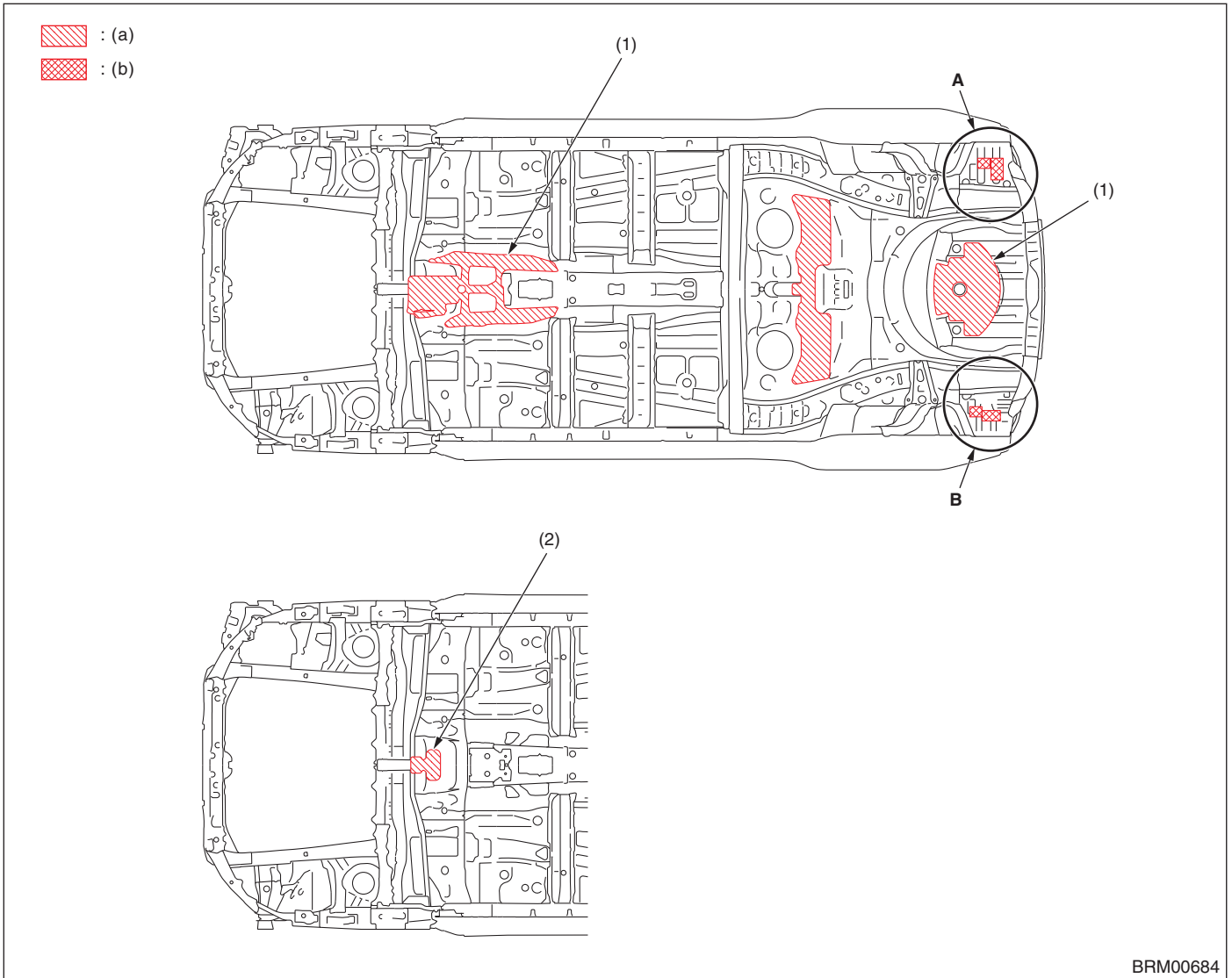
Damping Seat

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

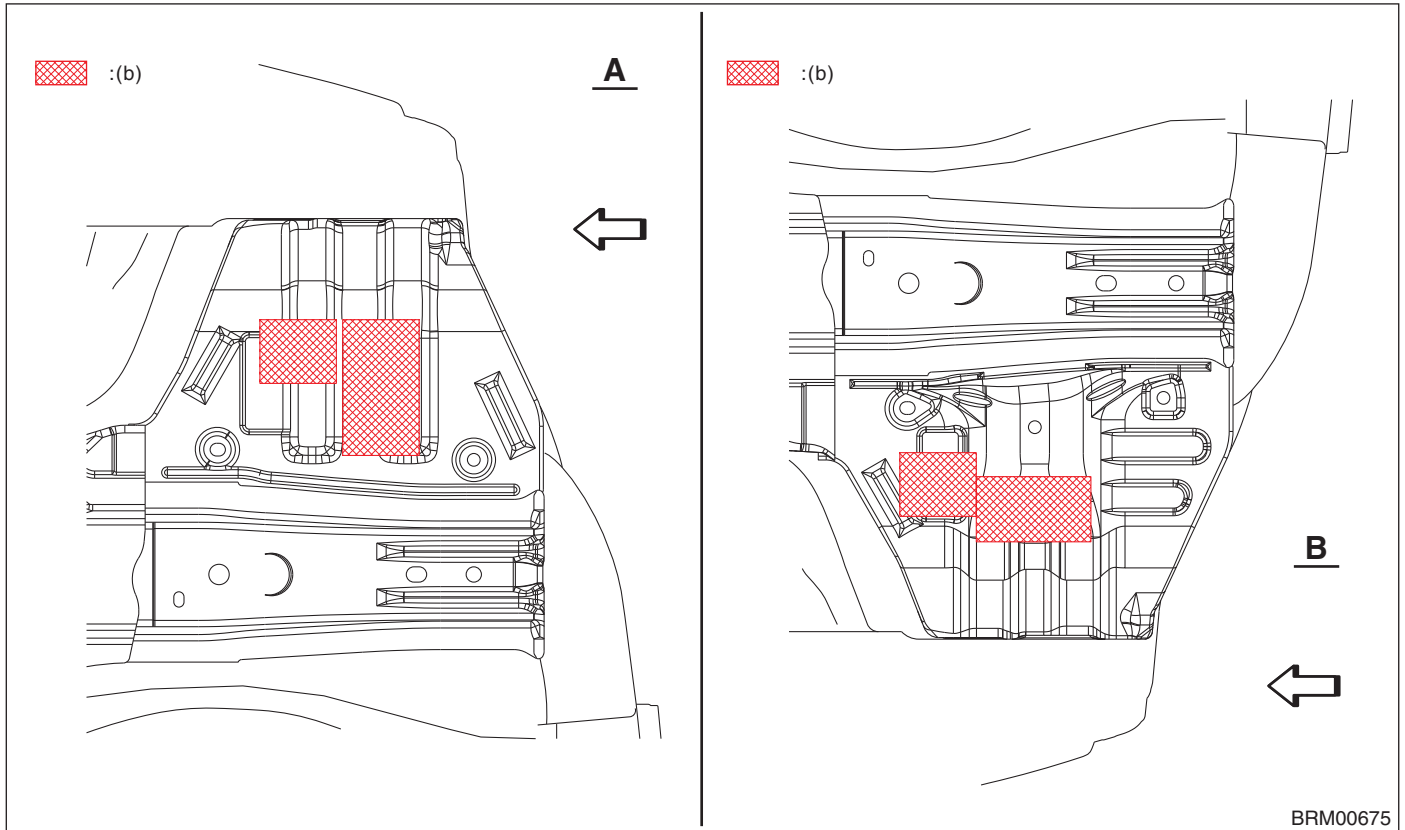
(b) Thickness of the silencer:
5.5 mm (0.22 in)

(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)

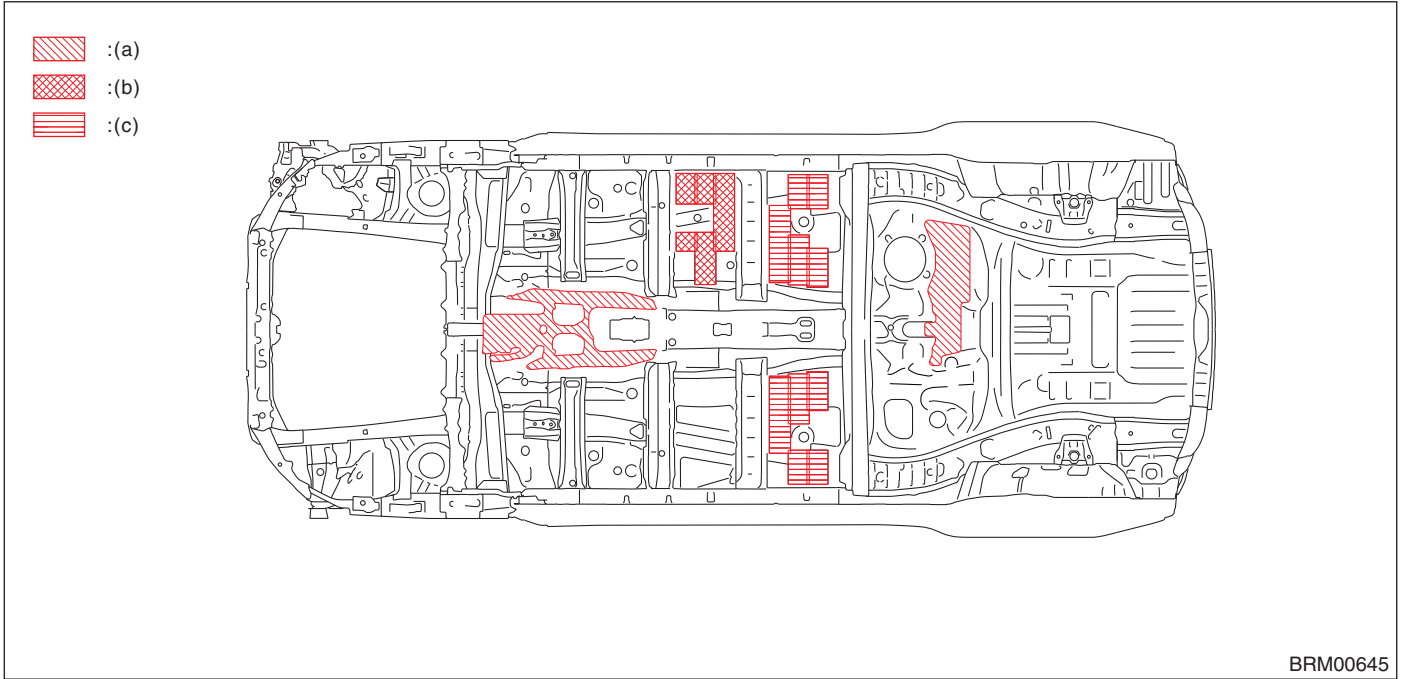
Damping Seat

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



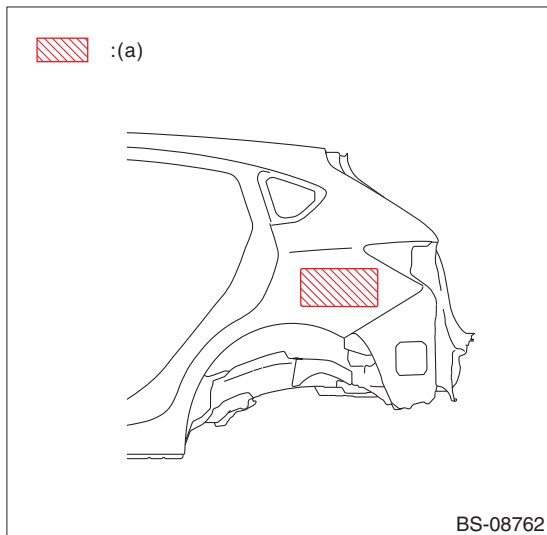
(a) Silencer

(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

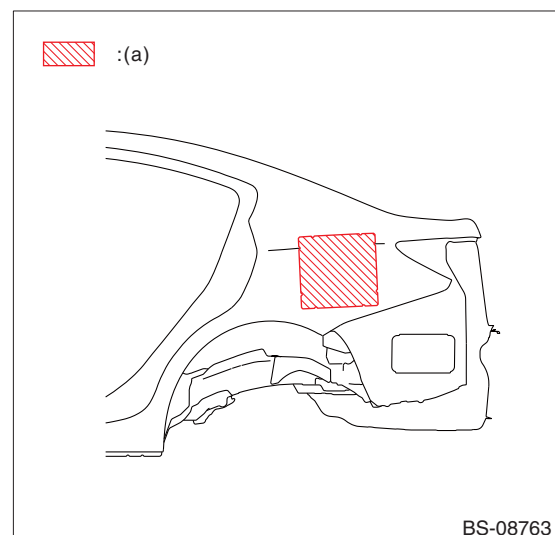
• Side view



(a) Damping Seat

5. SPECIAL PARTS FOR 4 DOOR

• Side view

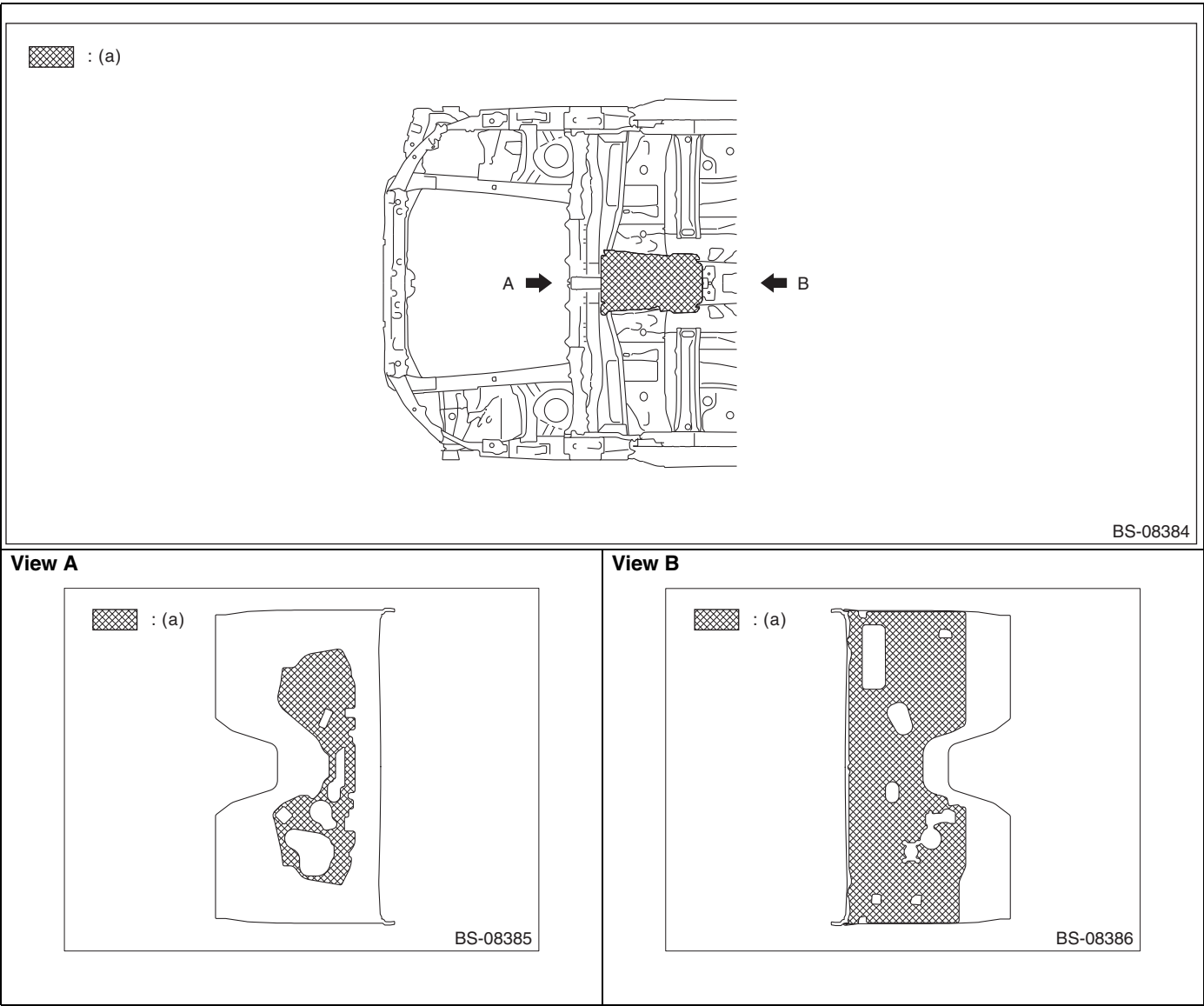


(a) Damping Seat

13.Insulator

A: SPECIFICATIONS

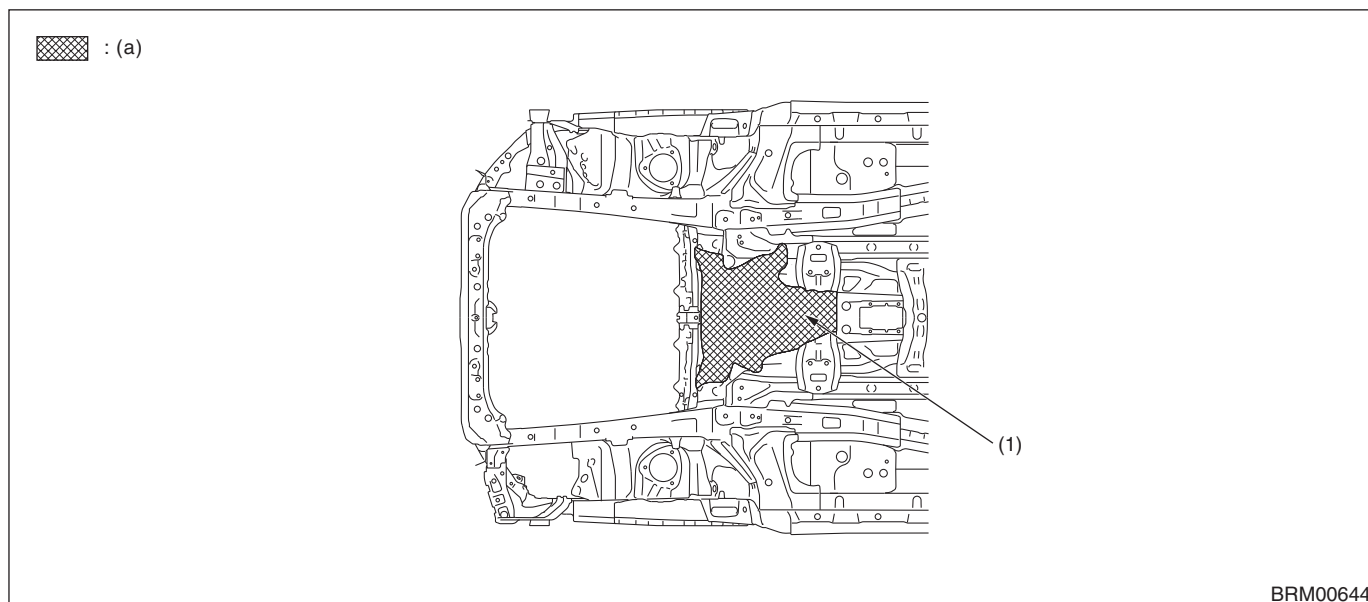
1. UPPER VIEW



(a) Insulator

Insulator

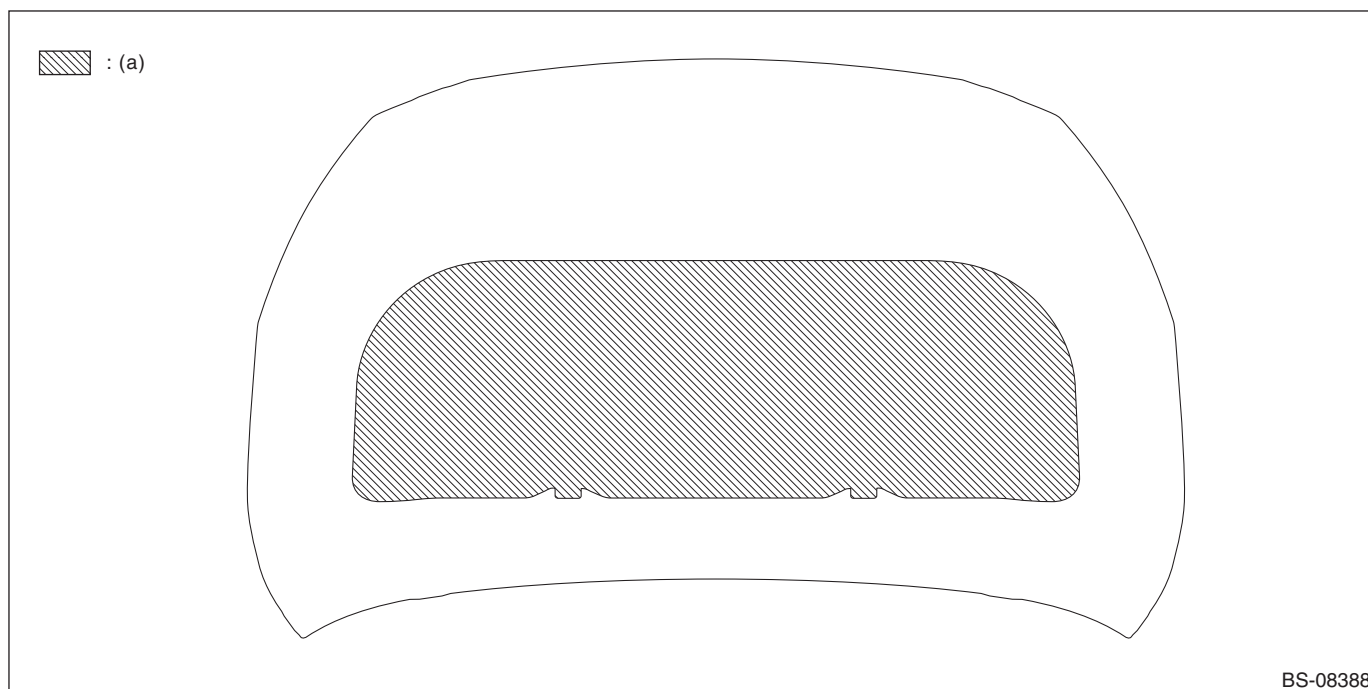
2. BOTTOM VIEW (Except for 2.0 i models)



(a) Insulator

(1) Gasoline model only

3. FRONT HOOD

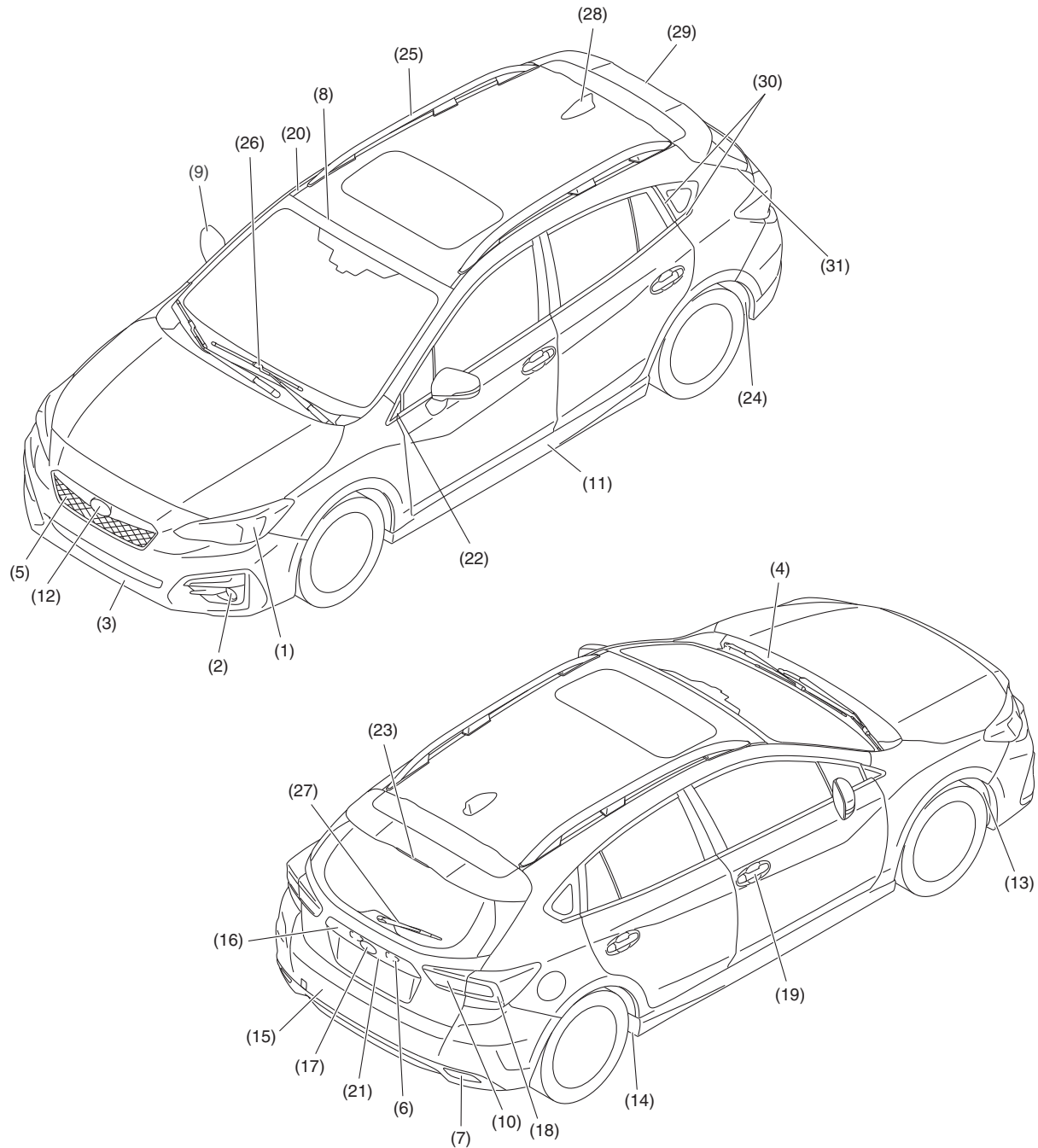


(a) Insulator

14. Plastic Parts and Materials

A: SPECIFICATIONS

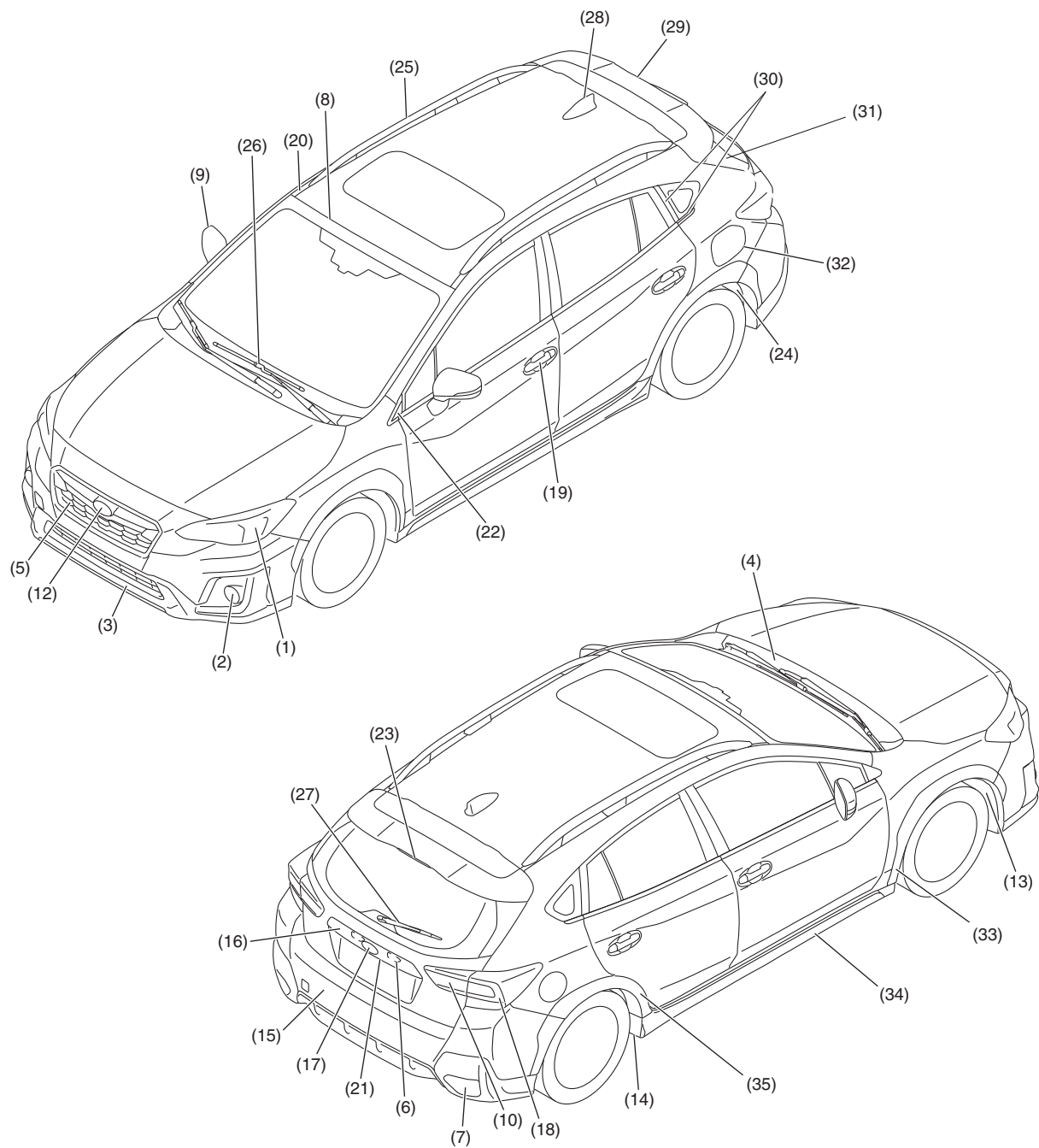
1. SPECIAL 5 DOOR PARTS AND COMMON PARTS FOR 5 DOOR (Gasoline model) & 4 DOOR



BS-09155

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
		Inner lens	PC
		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

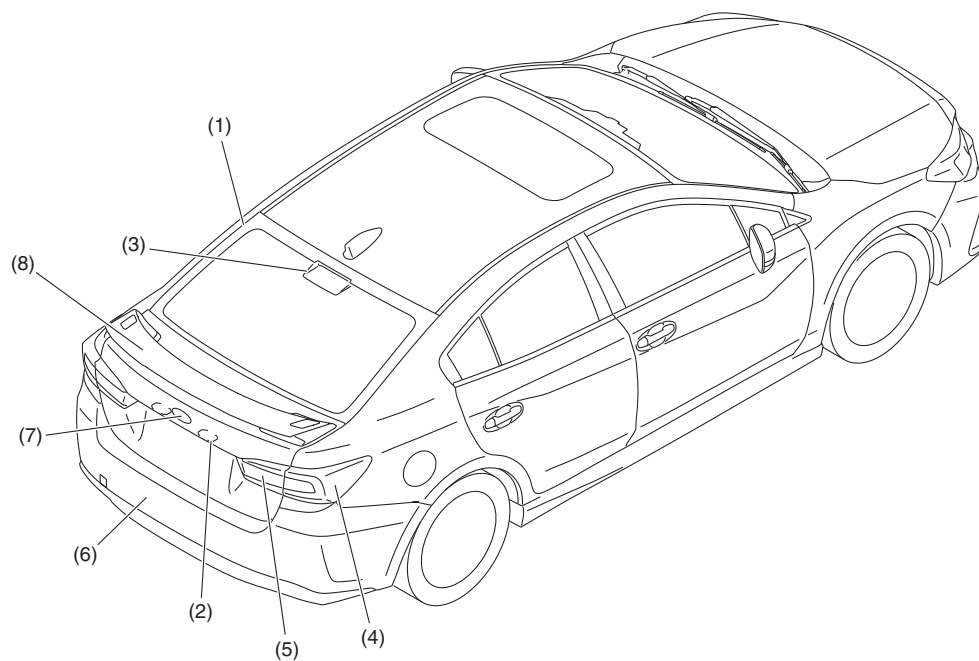
Plastic Parts and Materials

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

3. SPECIAL 4 DOOR PARTS



BS-09162

- | | | |
|--|----------------------------|-------------------|
| (1) Rear window moulding | (4) Rear combination light | (7) Ornament rear |
| (2) License light | (5) Rear finisher light | (8) Spoiler rear |
| (3) High mount stop light
(Indoor type) | (6) Rear bumper | |

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%