

# BODY REPAIR MANUAL

# BS

---

	Page
1. Foreword .....	2
2. Panel Components.....	7
3. Galvanized Sheet Metal .....	17
4. Aluminium Sheet Metal .....	18
5. Body Construction.....	19
6. Gauge Values for Fitting.....	25
7. Plastic Parts and Materials.....	29
8. List of Plastic Material Notations .....	32
9. Body Sealing .....	33
10. Anticorrosion Wax .....	40
11. Undercoat.....	44
12. Body Reference Points.....	47
13. Radiator Panel (total replacement).....	68
14. Radiator Panel (partial replacement) .....	72
15. Front Wheel Apron (total replacement) .....	76
16. Closing Plate (partial replacement).....	82
17. Frame Side Front (partial replacement) .....	84
18. Front Side Frame (partial replacement) .....	88
19. Front Fender Reinforcement (total replacement) .....	90
20. Reinforcement Toe Board (total replacement).....	92
21. Front Pillar (partial replacement) .....	96
22. Center Pillar (partial replacement) .....	102
23. Rear Quarter / Wagon (partial replacement).....	106
24. Rear Quarter / Sedan (partial replacement).....	113
25. Side Sill Outer (partial replacement) .....	119
26. Rear Quarter Upper / Wagon (total replacement) .....	129
27. Rear Quarter Inner Upper / Sedan (total replacement).....	131
28. Rear Quarter Inner Reinforcement / Sedan (total replacement) .....	135
29. Rear Bulkhead / Sedan (total replacement) .....	137
30. Rear Floor Side / Wagon (total replacement).....	141
31. Rear Floor Side / Sedan (total replacement).....	145
32. Rear Skirt / Wagon (partial replacement).....	149
33. Rear Skirt / Sedan (total replacement).....	153
34. Rear Skirt Outer / Wagon (total replacement) .....	157
35. Rear Skirt Inner / Wagon (partial replacement) .....	159
36. Rear Floor Pan (total replacement) .....	163
37. Closing Plate (total replacement) .....	167
38. Rear Frame / Wagon (total replacement) .....	169
39. Rear Side Frame Rear (partial replacement) .....	173
40. Plate Tractive (total replacement).....	177
41. Rear Panel / Sedan (total replacement) .....	179
42. Roof Panel / Wagon (total replacement) .....	183
43. Roof Panel / Sedan (total replacement) .....	188

# Foreword

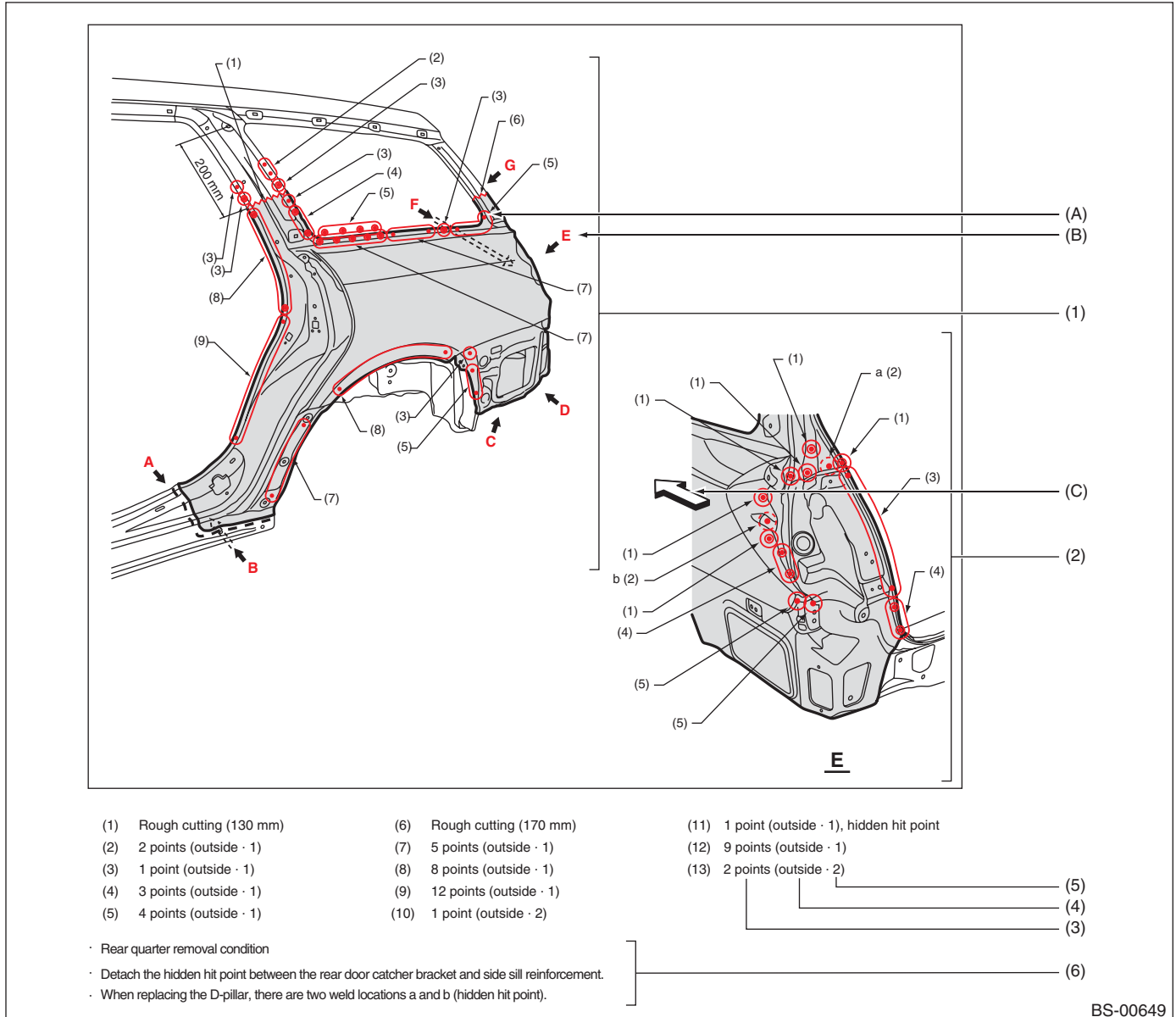
## 1. Foreword

### A: USE OF THIS MANUAL

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

#### 1. ILLUSTRATION EXAMPLE

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

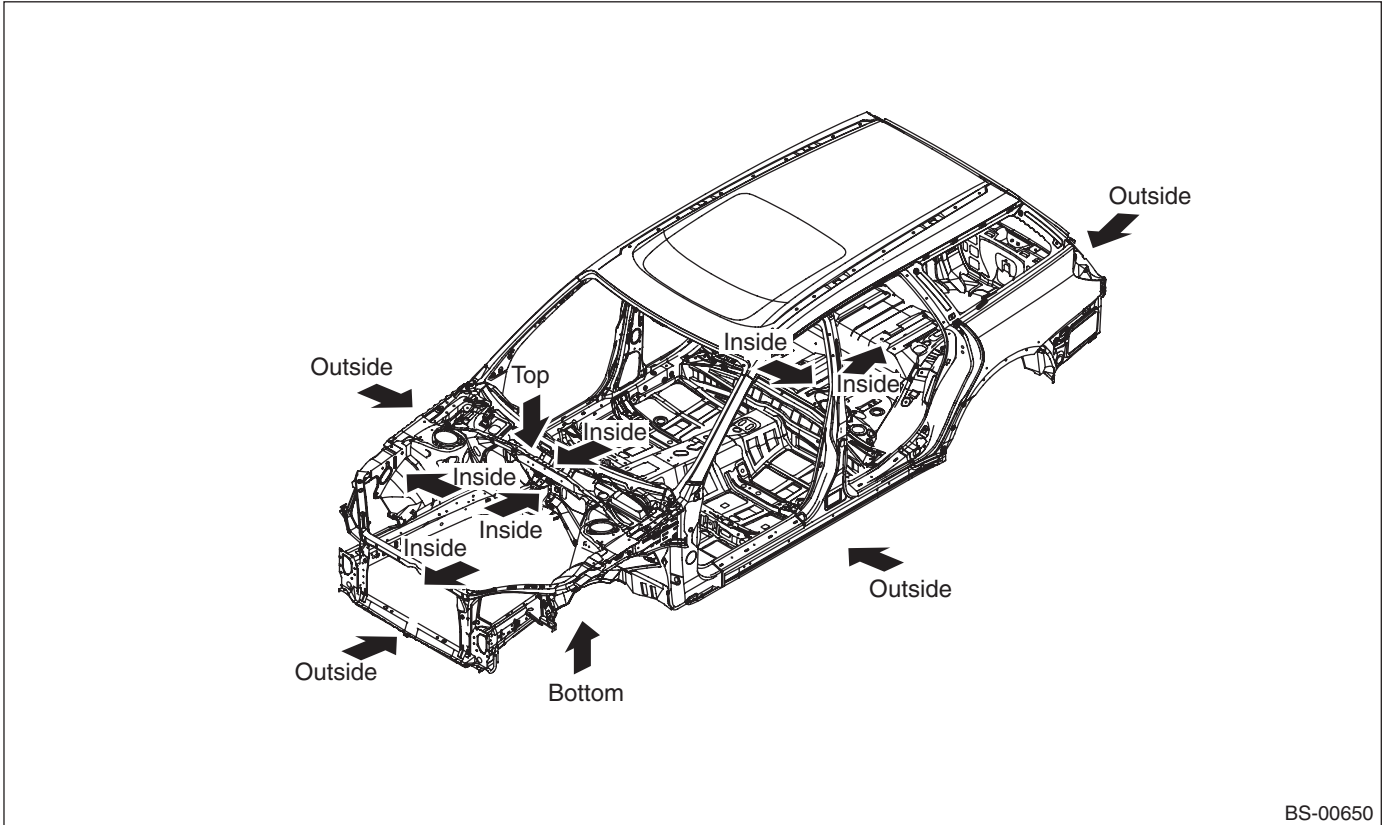


- |                                    |                              |
|------------------------------------|------------------------------|
| (1) Overall view                   | (A) Welding method           |
| (2) Views                          | (B) View direction           |
| (3) Number of welding points etc.  | (C) Towards front of vehicle |
| (4) Removal direction              |                              |
| (5) Number of panels to be drilled |                              |
| (6) Cautions when working, etc.    |                              |

# Foreword

## 2. REMOVAL DIRECTION

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



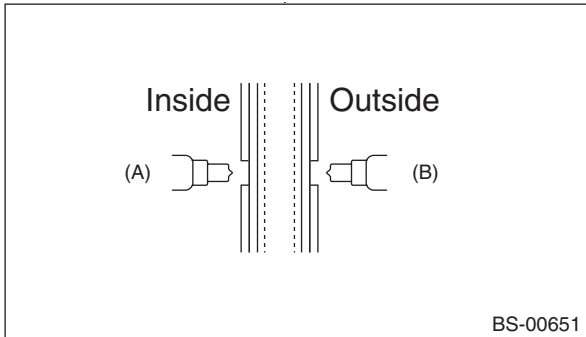
BS-00650

# Foreword

## 3. NUMBER OF PANELS TO BE DRILLED

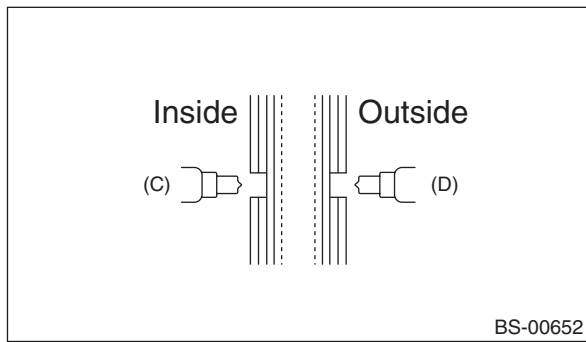
Depending on the number of panels, drilling is performed through one or two panels, and this is listed together with the removal direction.

### (1) Drilling through one plate



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

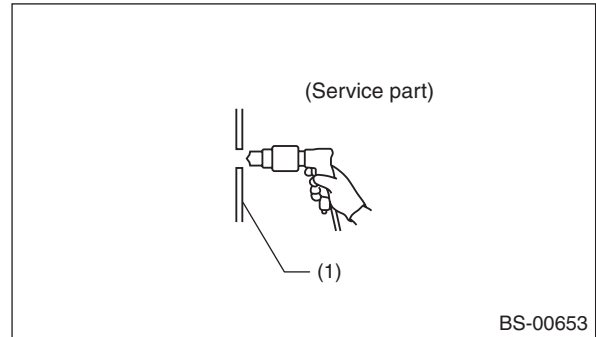
### (2) Drilling through two plate



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

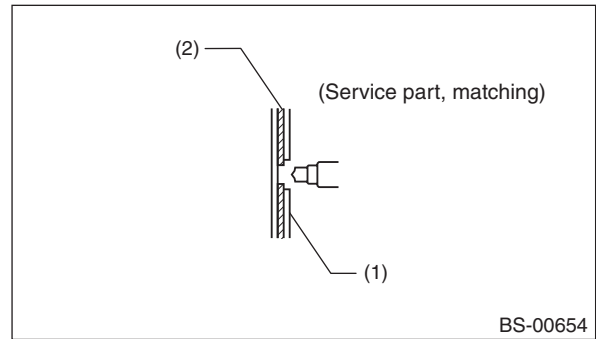
## 4. HOLE DRILLING FOR PLUG WELDING

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



- (A) Service part

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


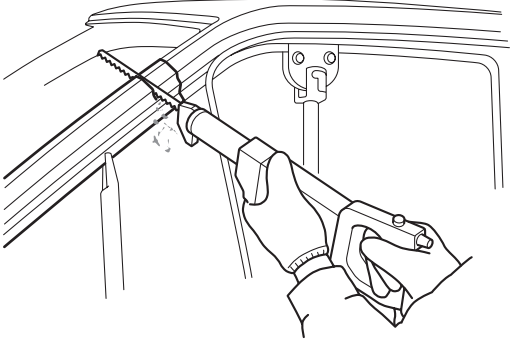


- (1) Service part
- (2) Vehicle side


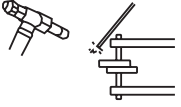
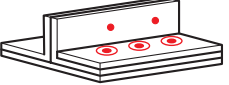
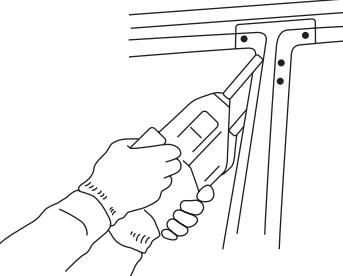


# Foreword

## 5. MEANING OF SYMBOLS



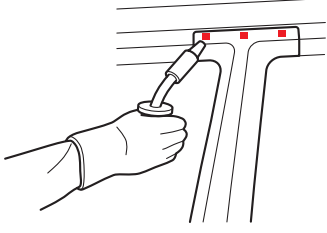


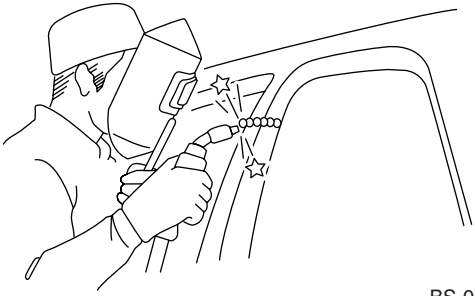
### • Cutting

 <p style="text-align: right;">BS-00352</p>	 <p style="text-align: right;">BS-00267</p>
--	---

### • Spot welding

<p>Two overlapping parts</p>	 <p style="text-align: center;">BS-00655</p>	 <p style="text-align: center;">BS-00656</p>	 <p style="text-align: center;">BS-00657</p>	 <p style="text-align: right;">BS-00658</p>
<p>Three overlapping parts</p>	 <p style="text-align: center;">BS-00659</p>	 <p style="text-align: center;">BS-00660</p>		

### • Carbon dioxide gas arc welding (MIG welding)

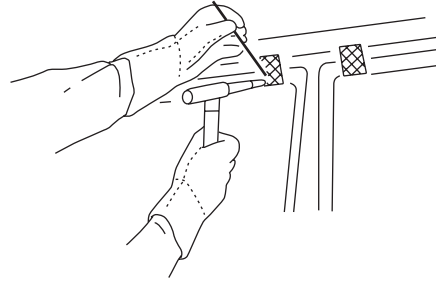
<p>Plug welding</p>	 <p style="text-align: center;">BS-00661</p>	 <p style="text-align: center;">BS-00662</p>	 <p style="text-align: right;">BS-00663</p>
<p>Continuous welding</p>	 <p style="text-align: center;">BS-00664</p>	 <p style="text-align: center;">BS-00665</p>	 <p style="text-align: right;">BS-00666</p>

# Foreword

- **Brazing**



BS-00667



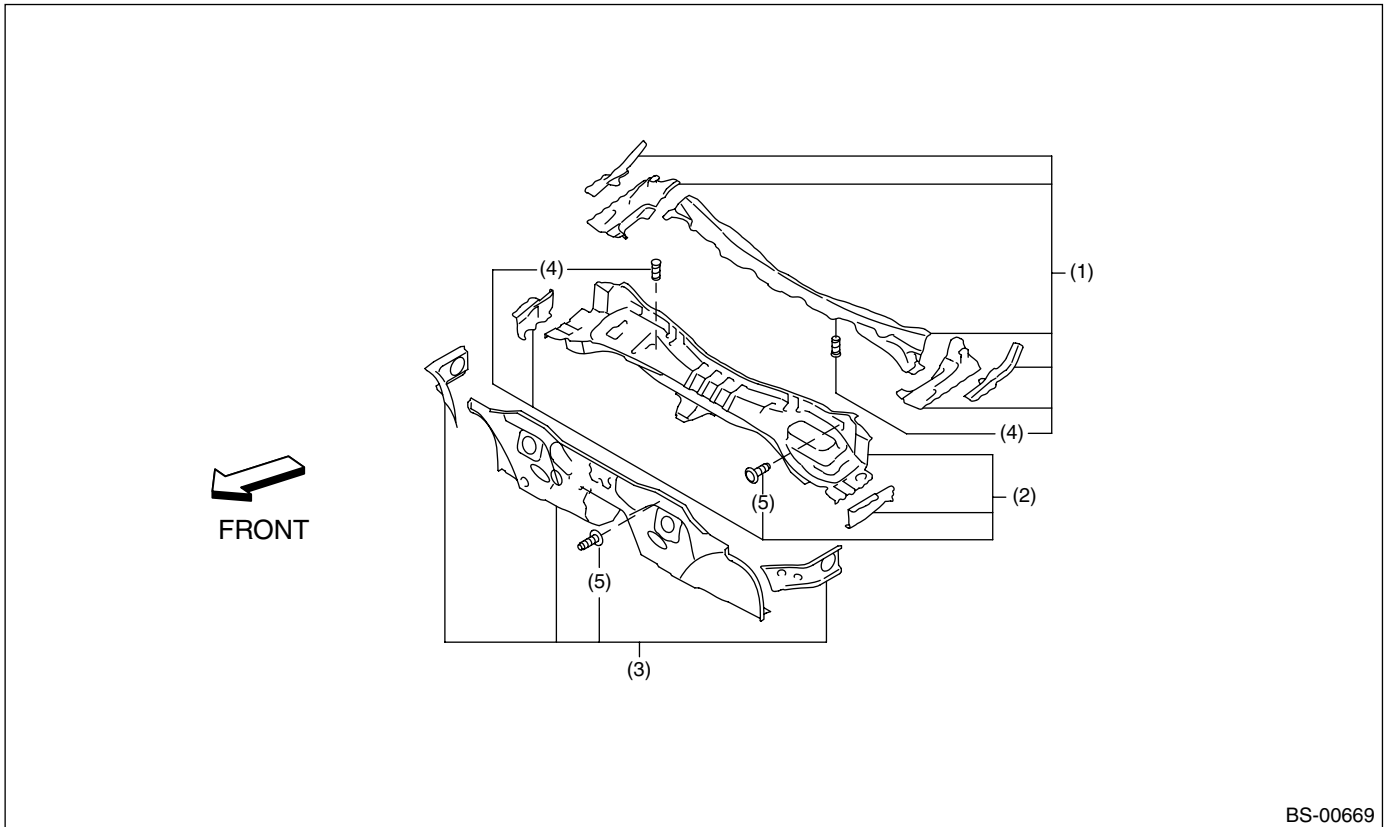
BS-00668

# Panel Components

## 2. Panel Components

### A: COMPONENTS

#### 1. TOE BOARD & FRONT PANEL



BS-00669

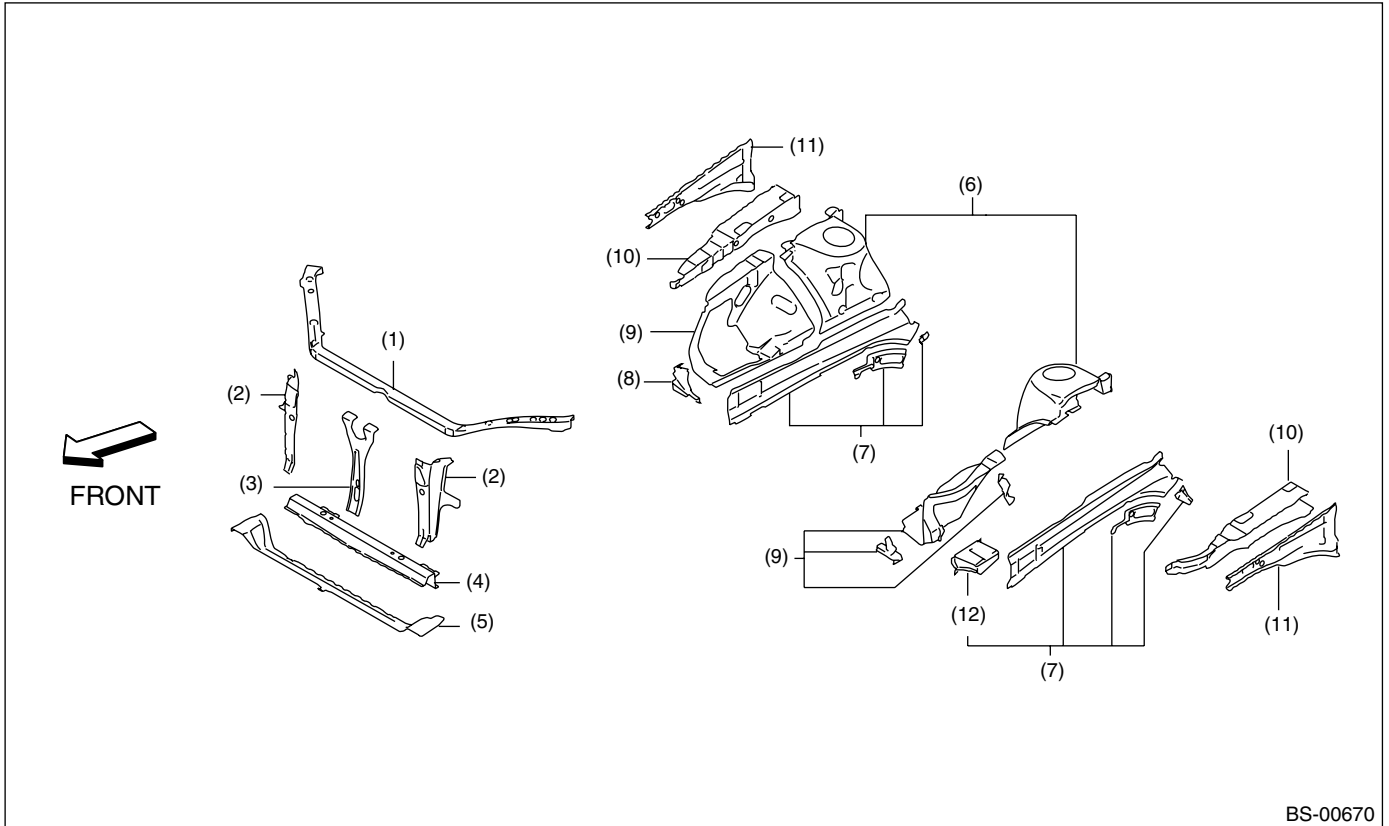
(1) Front panel  
(2) Duct

(3) Toe board  
(4) Stud bolt

(5) Stud bolt

# Panel Components

## 2. RADIATOR PANEL & FRONT WHEEL APRON



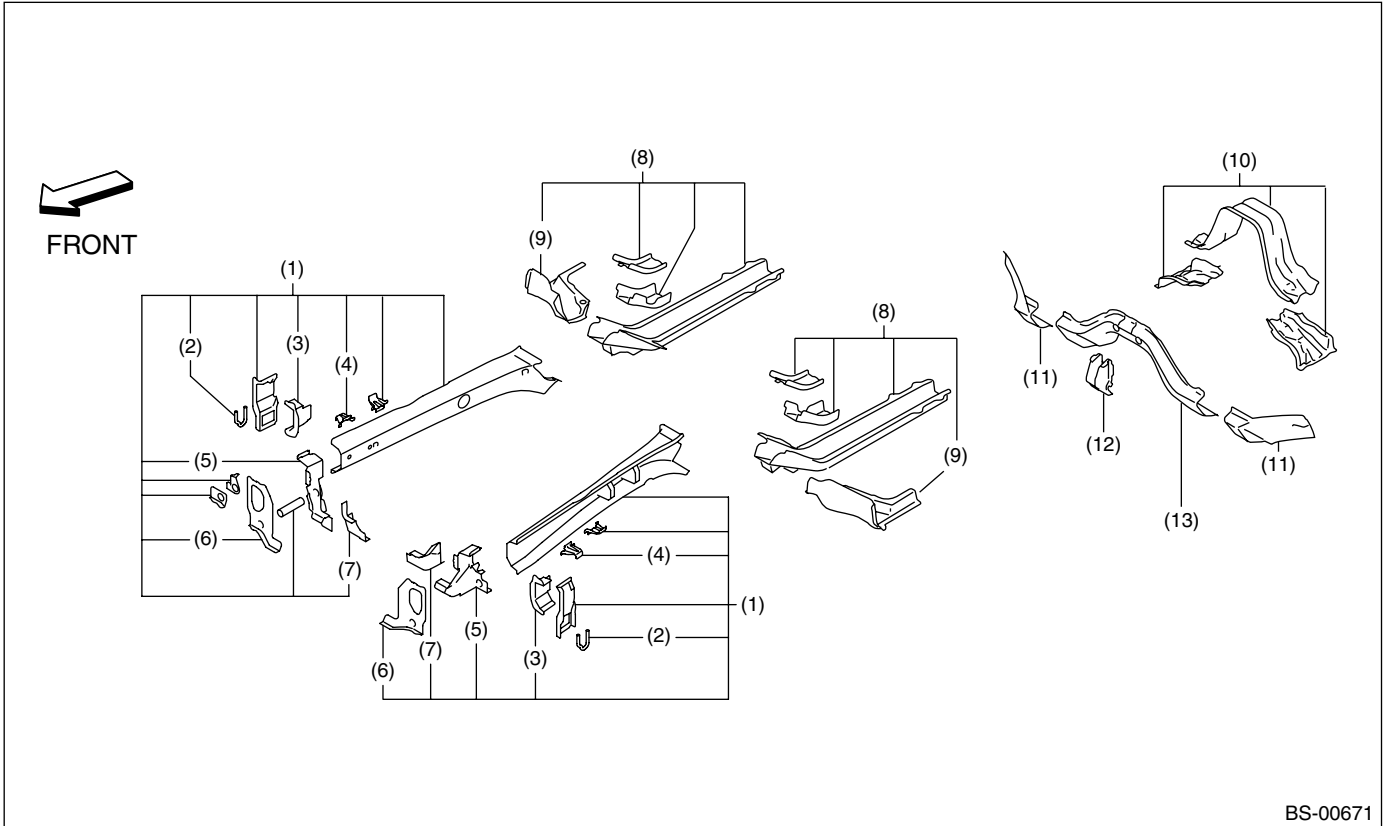
BS-00670

- |                         |                              |                              |
|-------------------------|------------------------------|------------------------------|
| (1) Upper frame         | (5) Lower frame B            | (9) Front wheel apron        |
| (2) Radiator side panel | (6) Front suspension bracket | (10) Front wheel apron upper |
| (3) Hood lock stay      | (7) Closing plate            | (11) Side upper frame        |
| (4) Lower frame A       | (8) Fender bracket           | (12) Gusset battery          |



# Panel Components

## 3. FRONT SIDE FRAME

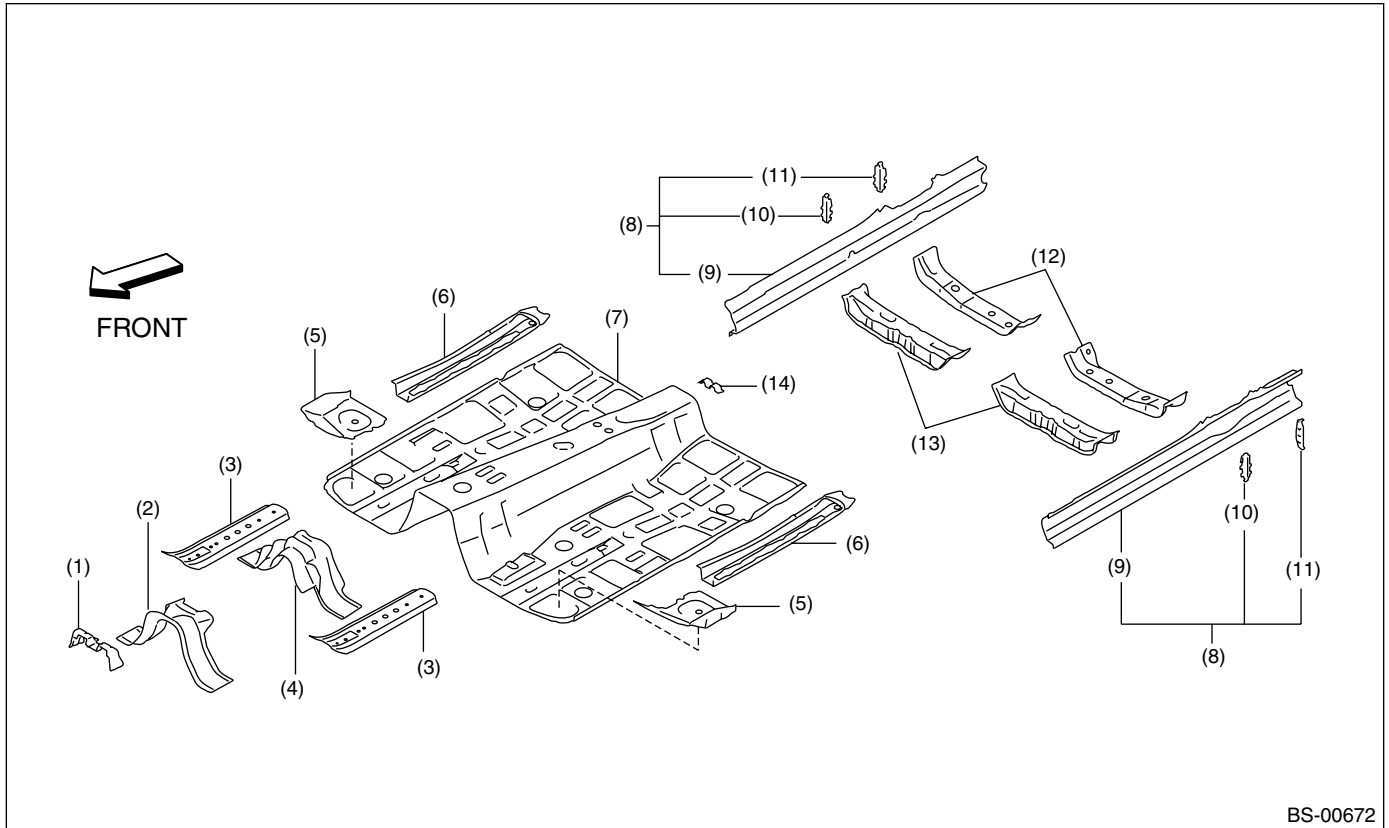


BS-00671

- |                            |                                   |                                   |
|----------------------------|-----------------------------------|-----------------------------------|
| (1) Front side frame front | (6) Front plate                   | (10) Front floor crossmember      |
| (2) Tie-down hook          | (7) Front gusset C                | (11) Toe board crossmember side   |
| (3) Bumper bracket front   | (8) Front side frame rear         | (12) Pitching stopper bracket     |
| (4) Separator B            | (9) Toe board lower reinforcement | (13) Toe board crossmember center |
| (5) Front gusset           |                                   |                                   |

# Panel Components

## 4. FRONT FLOOR PANEL

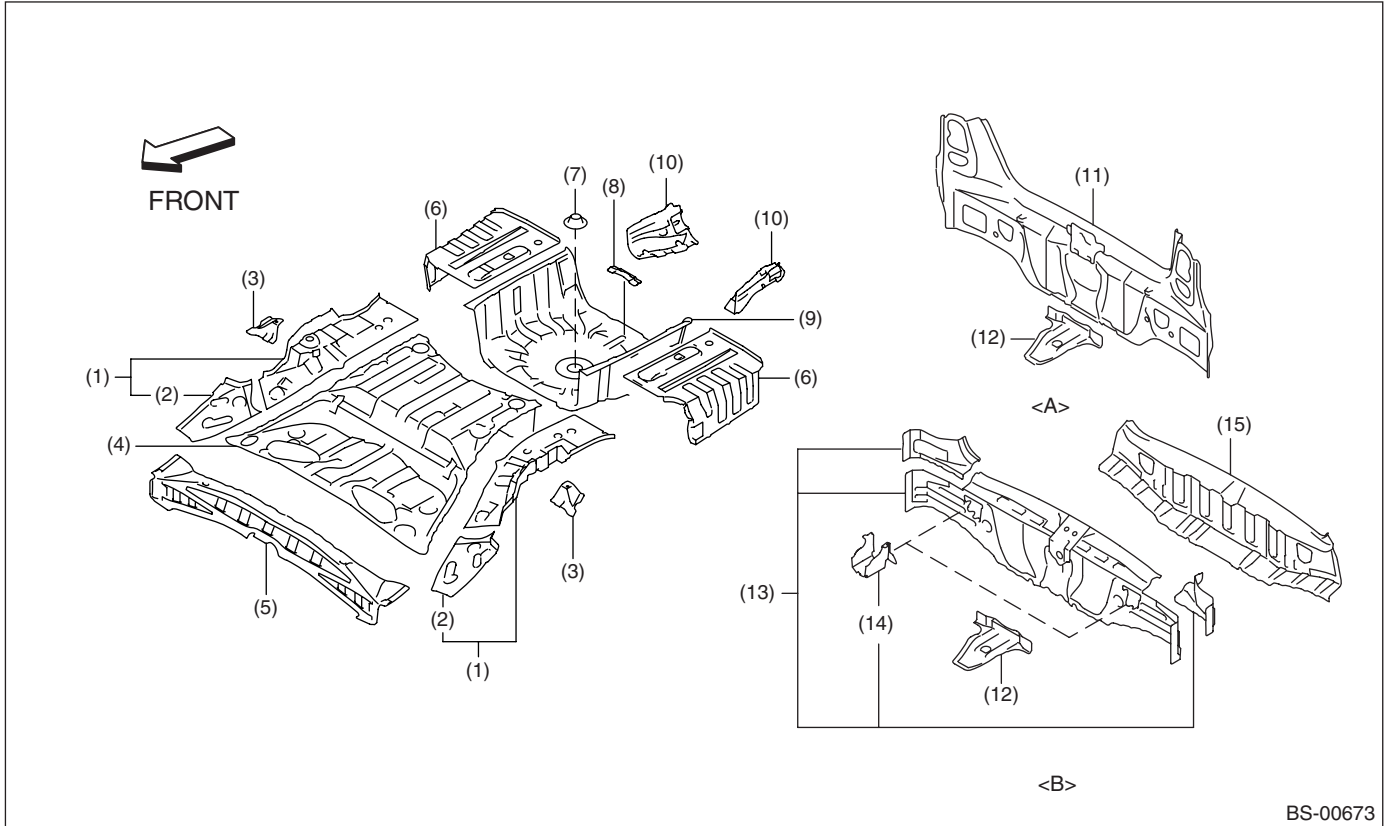


BS-00672

- |                                   |                            |                                   |
|-----------------------------------|----------------------------|-----------------------------------|
| (1) Panel inner bracket           | (6) Front side frame rear  | (11) Side sill separator B        |
| (2) Floor crossmember C           | (7) Front floor pan        | (12) Crossmember front seat rear  |
| (3) Front side frame inner        | (8) Side sill inner        | (13) Crossmember front seat front |
| (4) Floor crossmember rear        | (9) Side sill inner front  | (14) H/B cable bracket            |
| (5) Toe board upper reinforcement | (10) Side sill separator A |                                   |

# Panel Components

## 5. REAR FLOOR PANEL & REAR SKIRT



BS-00673

(A) Sedan

(B) Wagon

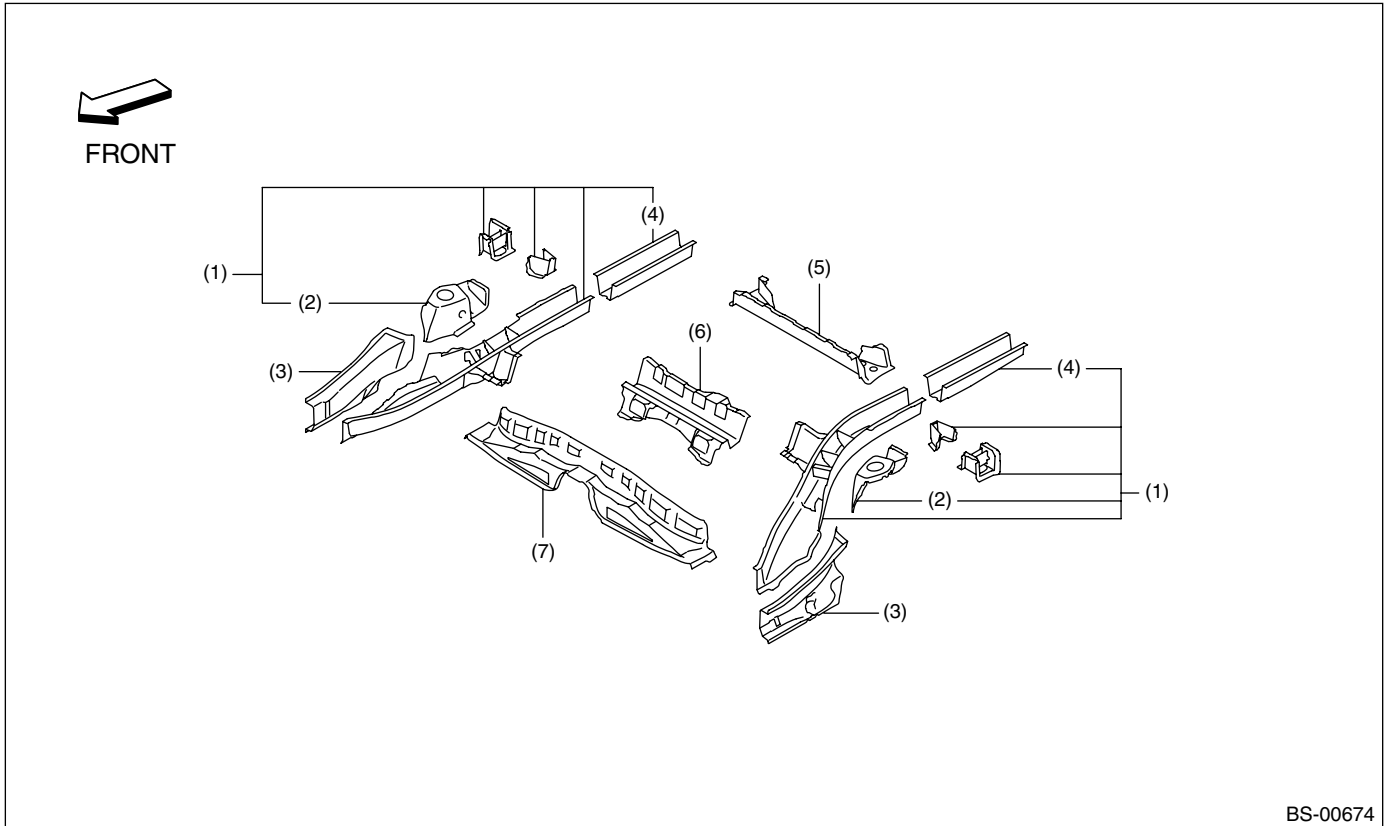
- (1) Closing plate
- (2) Front closing plate
- (3) Rear floor pan doubler front
- (4) NS (Rear floor pan front)
- (5) NS (Crossmember A front)

- (6) Rear floor side
- (7) Spare tire bracket
- (8) Floor patch
- (9) Rear floor pan rear
- (10) Muffler bracket center

- (11) Rear skirt
- (12) Tractive plate
- (13) Rear skirt inner
- (14) Bumper bracket
- (15) Rear skirt outer

# Panel Components

## 6. REAR FLOOR SIDE FRAME



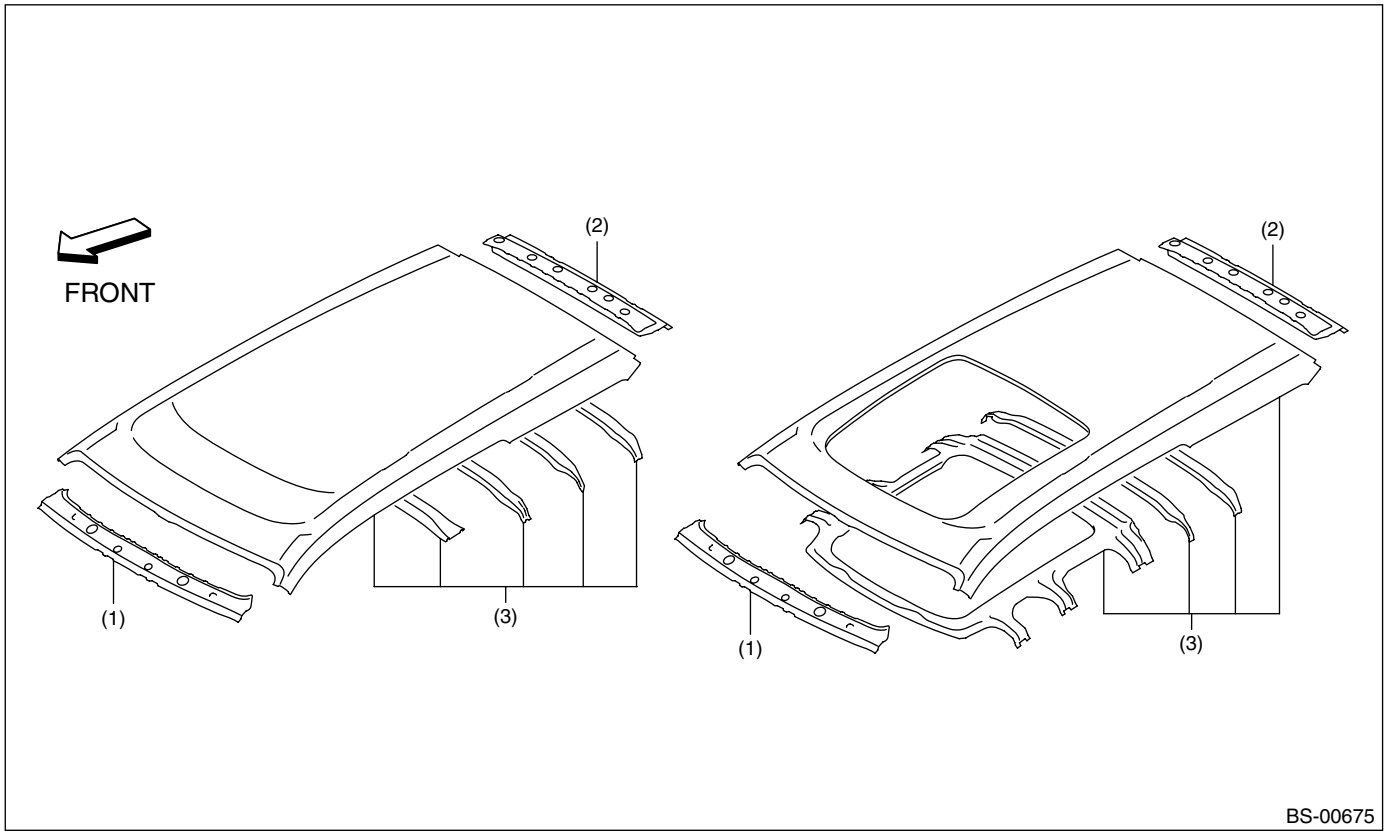
BS-00674

- |                           |                                |                             |
|---------------------------|--------------------------------|-----------------------------|
| (1) Rear floor side frame | (4) Rear floor side frame rear | (6) Crossmember B           |
| (2) Rear damper bracket   | (5) Crossmember C              | (7) NS (Crossmember A rear) |
| (3) Side sill inner rear  |                                |                             |

# Panel Components

## 7. ROOF

- Wagon



BS-00675

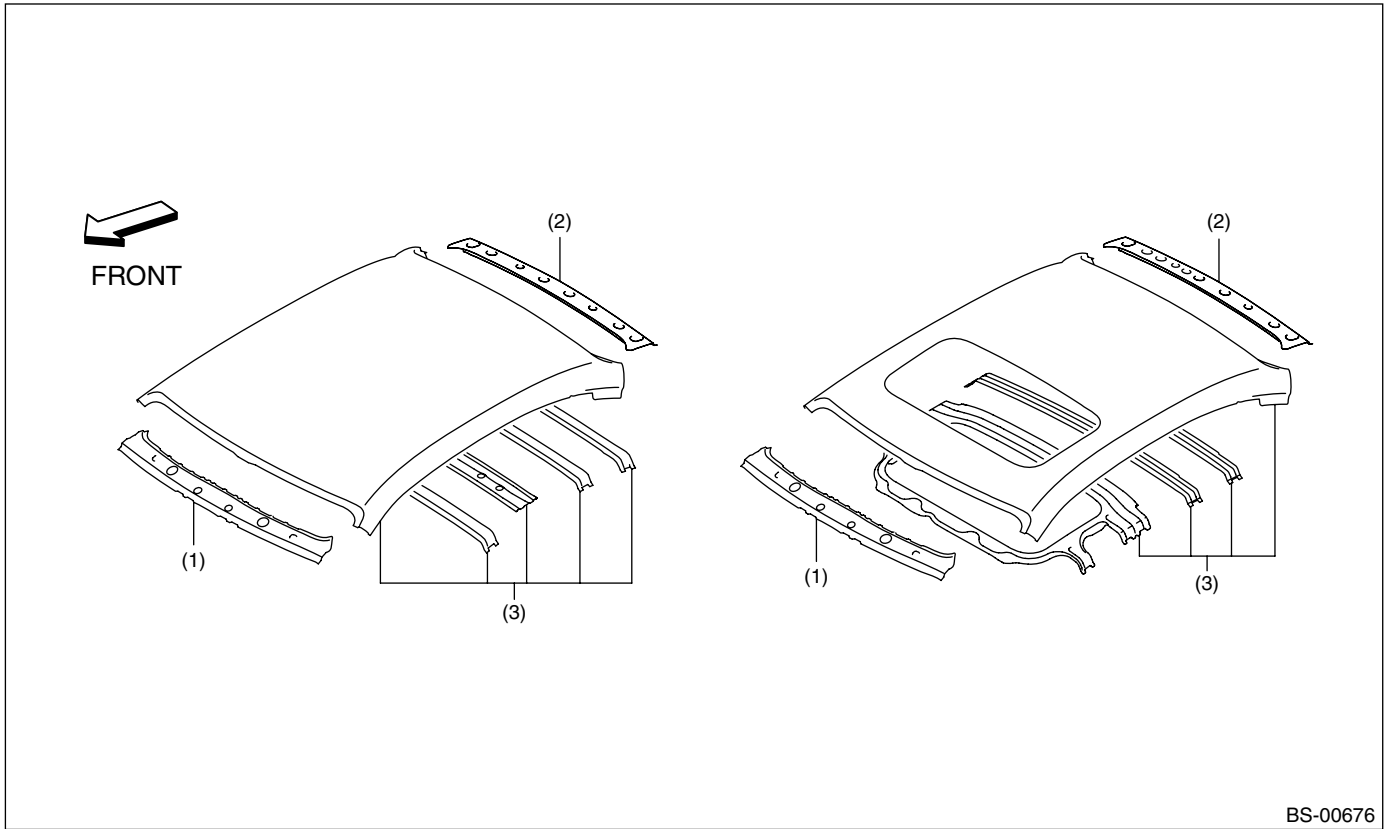
(1) Front roof rail

(2) Rear roof rail

(3) Roof panel

# Panel Components

- Sedan



BS-00676

(1) Front roof rail

(2) Rear roof rail

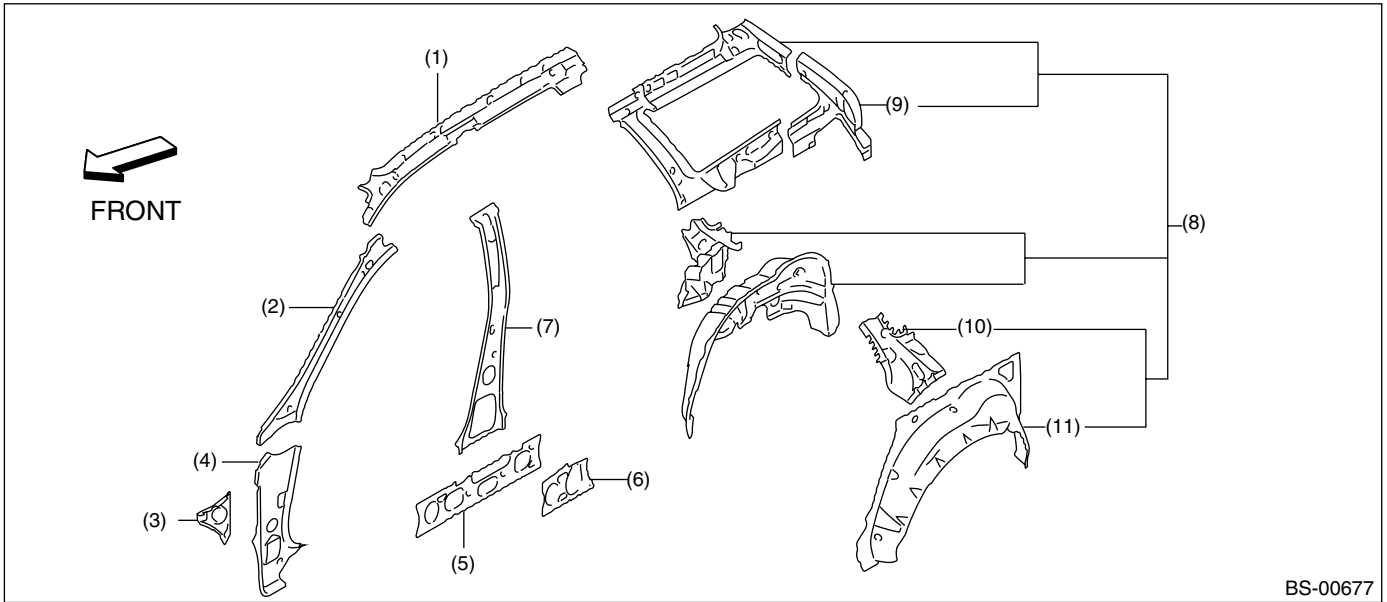
(3) Roof panel

# Panel Components

## 8. SIDE PANEL

### • Wagon

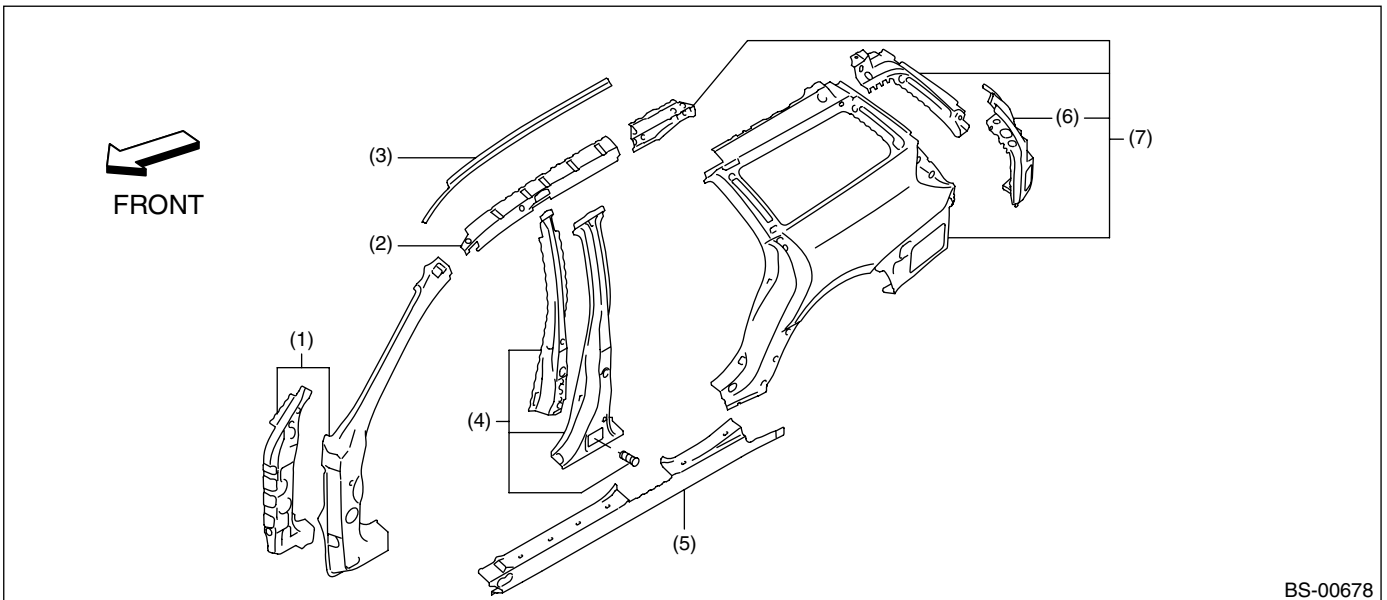
#### 1) Inner panel



BS-00677

- |                              |                                   |                              |
|------------------------------|-----------------------------------|------------------------------|
| (1) Side rail inner          | (5) Side sill reinforcement front | (9) Rear quarter inner lower |
| (2) Front pillar inner upper | (6) Side sill reinforcement rear  | (10) C-pillar reinforcement  |
| (3) Cowl panel side          | (7) Center pillar inner           | (11) Rear arch inner         |
| (4) Front pillar inner lower | (8) Rear quarter inner            |                              |

#### 2) Outer panel



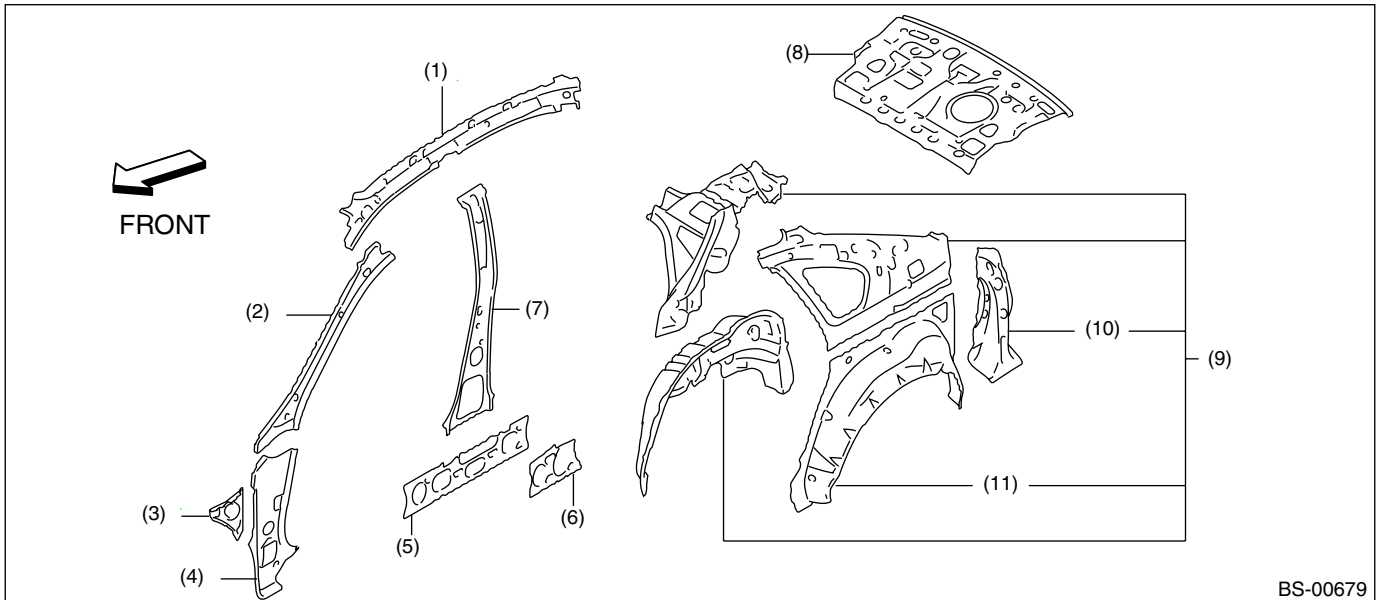
BS-00678

- |                        |                         |                        |
|------------------------|-------------------------|------------------------|
| (1) Front pillar outer | (4) Center pillar outer | (6) Rear quarter end   |
| (2) Side rail outer    | (5) Side sill outer     | (7) Rear quarter outer |
| (3) Drip rail          |                         |                        |

# Panel Components

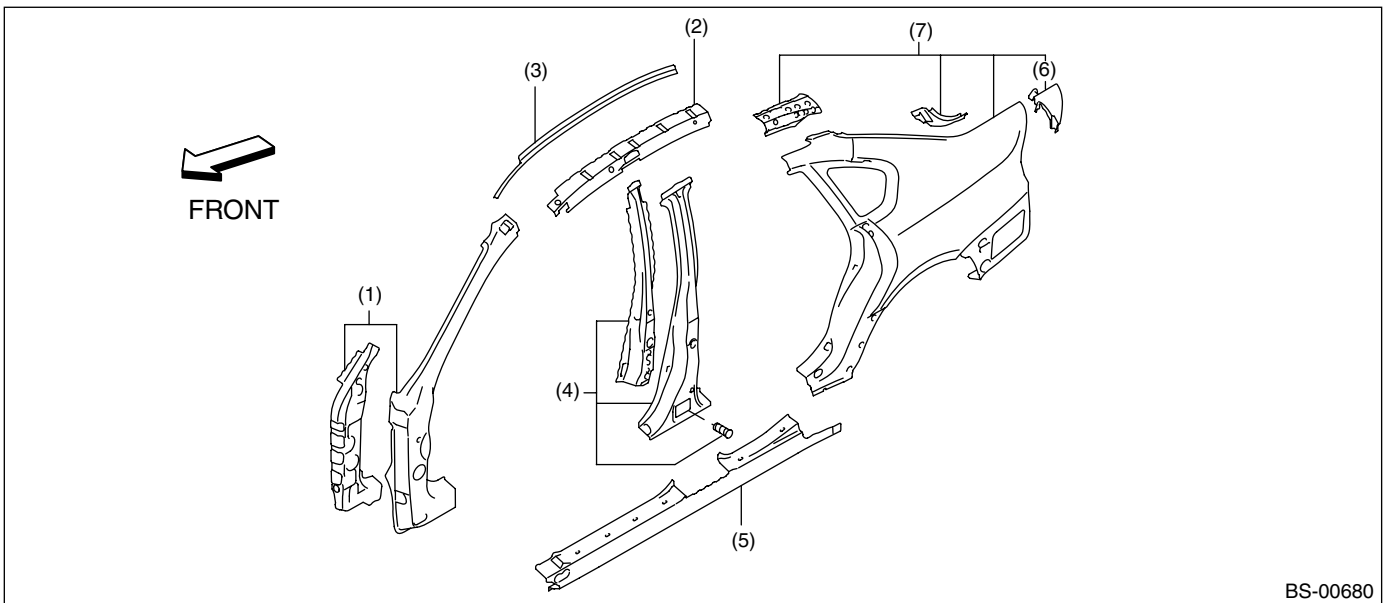
## • Sedan

### 1) Inner panel



- |                              |                                   |                                |
|------------------------------|-----------------------------------|--------------------------------|
| (1) Side rail inner          | (5) Side sill reinforcement front | (9) Rear quarter inner         |
| (2) Front pillar inner upper | (6) Side sill reinforcement rear  | (10) Rear pillar reinforcement |
| (3) Cowl panel side          | (7) Center pillar inner           | (11) Rear arch inner           |
| (4) Front pillar inner lower | (8) Rear panel                    |                                |

### 2) Outer panel

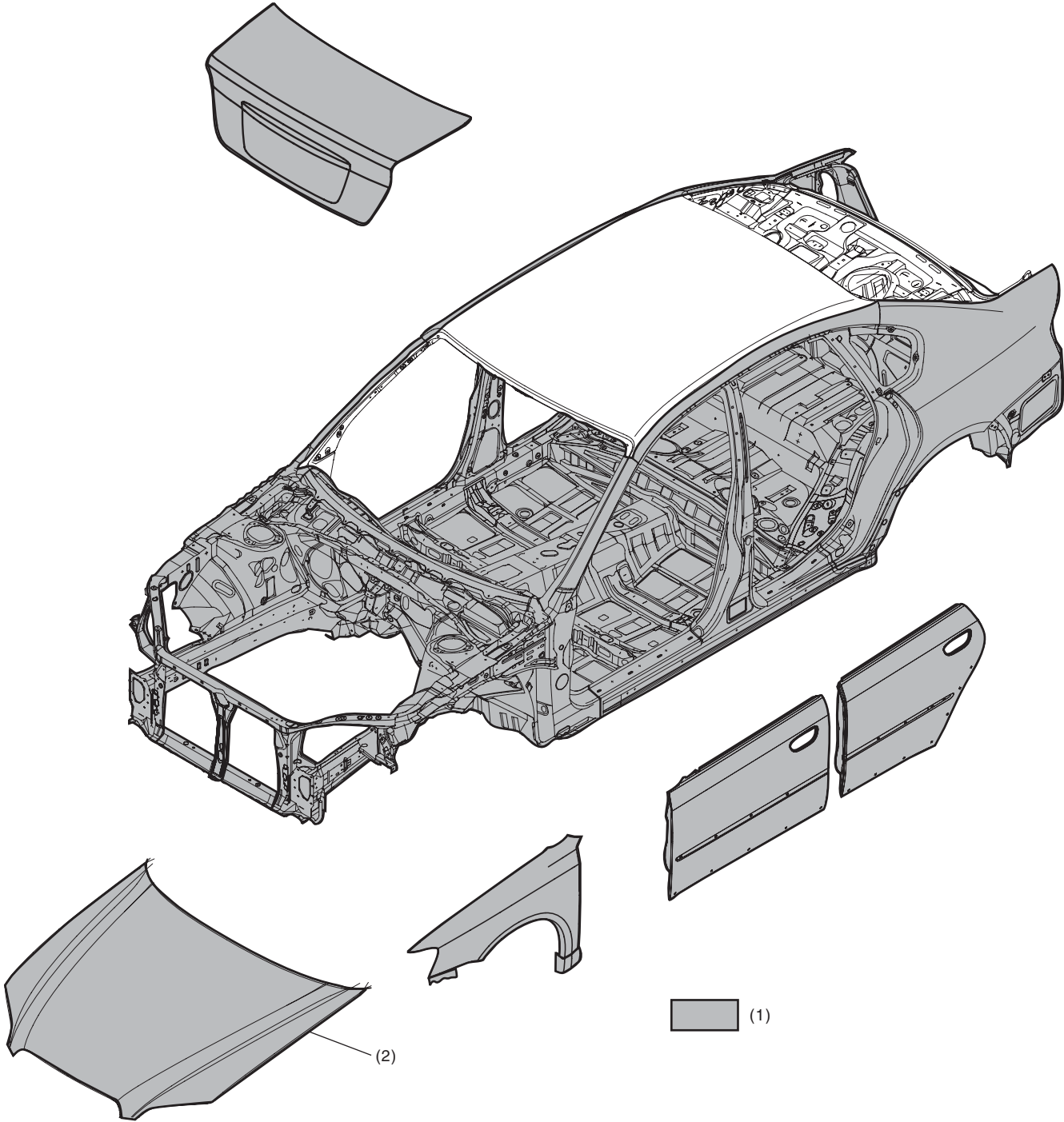


- |                        |                         |                        |
|------------------------|-------------------------|------------------------|
| (1) Front pillar outer | (4) Center pillar outer | (6) Rear quarter end   |
| (2) Side rail outer    | (5) Side sill outer     | (7) Rear quarter outer |
| (3) Drip rail          |                         |                        |



3. Galvanized Sheet Metal

A: SPECIFICATION

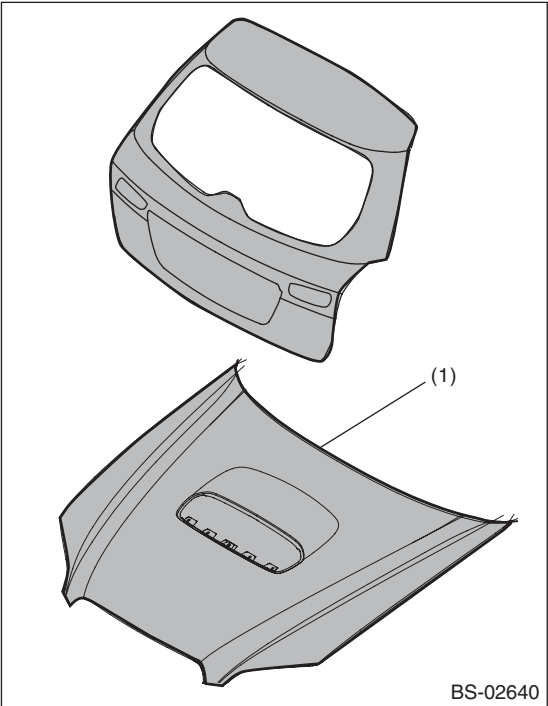


(1) Galvanized on both sides

(2) Only for the OUTBACK hood, steel sheet galvanized on both sides is used

4. Aluminium Sheet Metal

A: SPECIFICATION

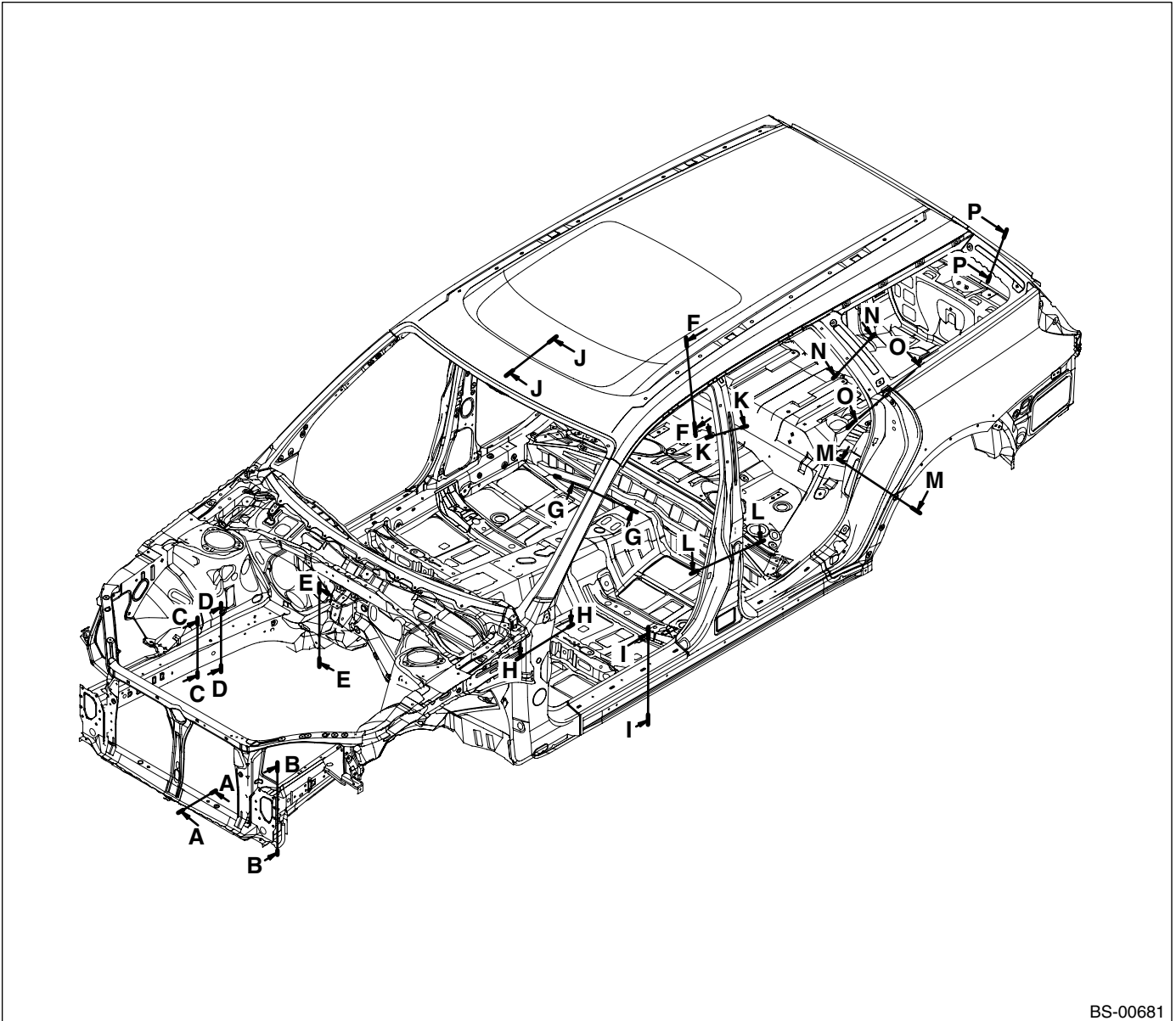


- (1) Hoods for vehicles other than the OUTBACK are aluminum sheet metal

## 5. Body Construction

### A: SPECIFICATION

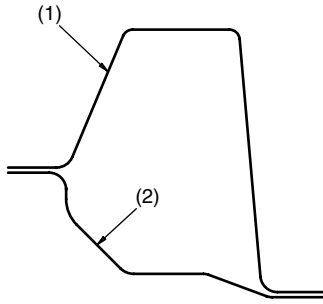
- Wagon / sedan common parts



BS-00681

# Body Construction

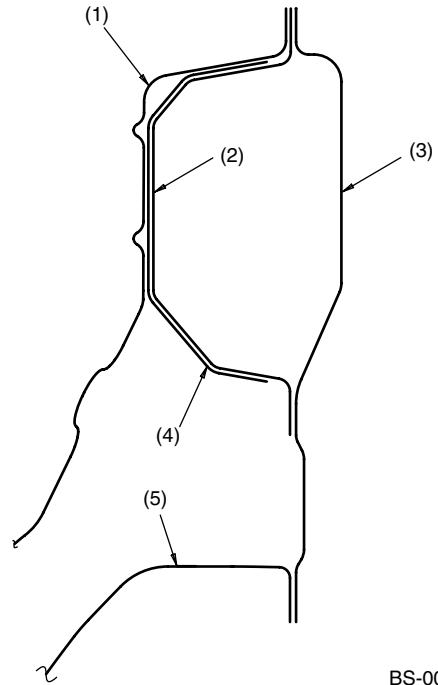
**Cross section A — A**



BS-00682

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

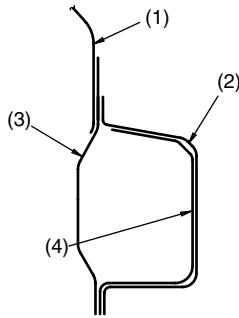
**Cross section B — B**



BS-00683

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

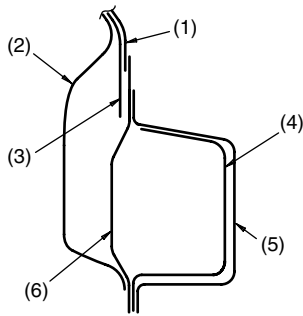
**Cross section C — C**



BS-00684

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

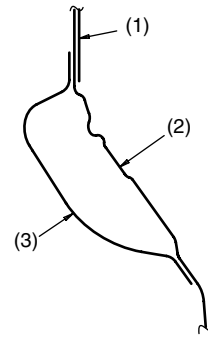
**Cross section D — D**



BS-00685

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

**Cross section E — E**

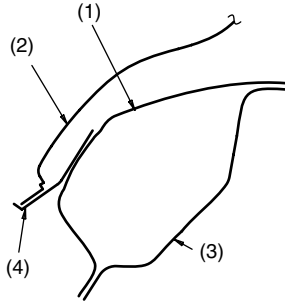


BS-00686

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

# Body Construction

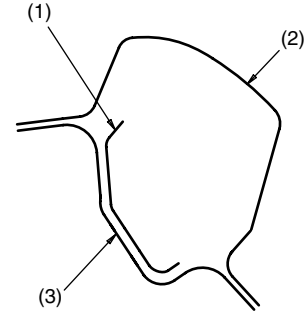
**Cross section F — F**



BS-00687

- (1) Side rail outer
- (2) Roof panel
- (3) Side rail inner
- (4) Drip rail

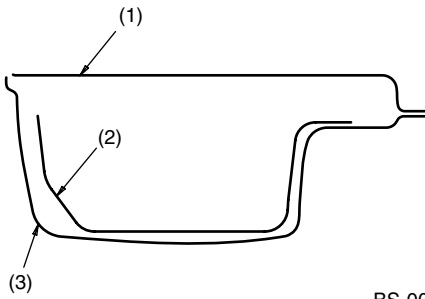
**Cross section G — G**



BS-00688

- (1) Front pillar inner doubler
- (2) Front pillar outer
- (3) Front pillar inner upper

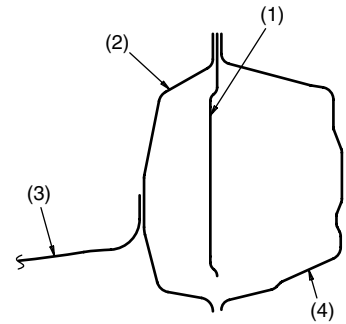
**Cross section H — H**



BS-00689

- (1) Front pillar inner lower
- (2) Front pillar outer reinforcement
- (3) Front pillar outer

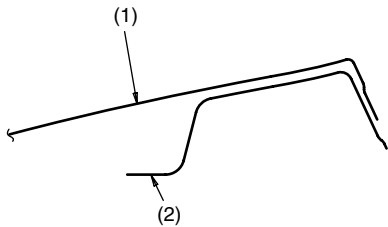
**Cross section I — I**



BS-00690

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

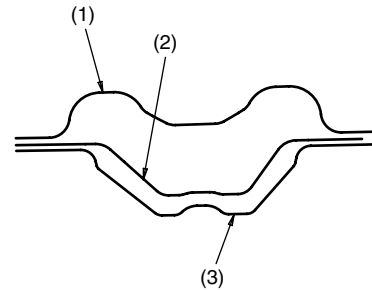
**Cross section J — J**



BS-00691

- (1) Roof panel
- (2) Sunroof frame front

**Cross section K — K**

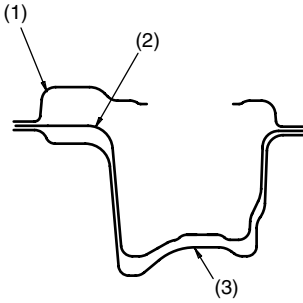


BS-00692

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

# Body Construction

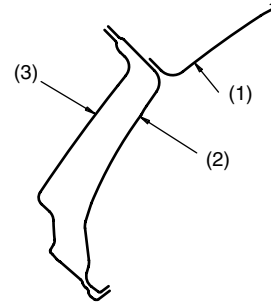
**Cross section L — L**



BS-00693

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

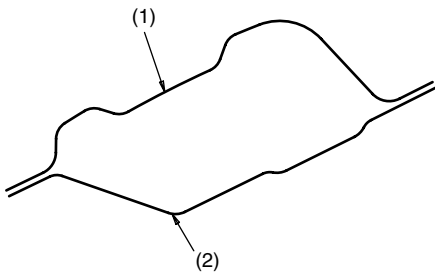
**Cross section M — M**



BS-00694

- (1) Rear wheel apron
- (2) Rear arch inner
- (3) Rear quarter panel outer

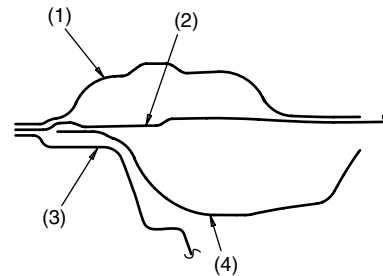
**Cross section N — N**



BS-00695

- (1) Rear quarter panel inner A
- (2) Rear quarter panel outer

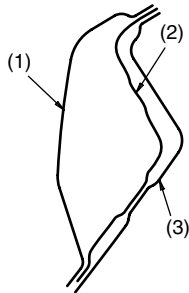
**Cross section O — O**



BS-00696

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

**Cross section P — P**



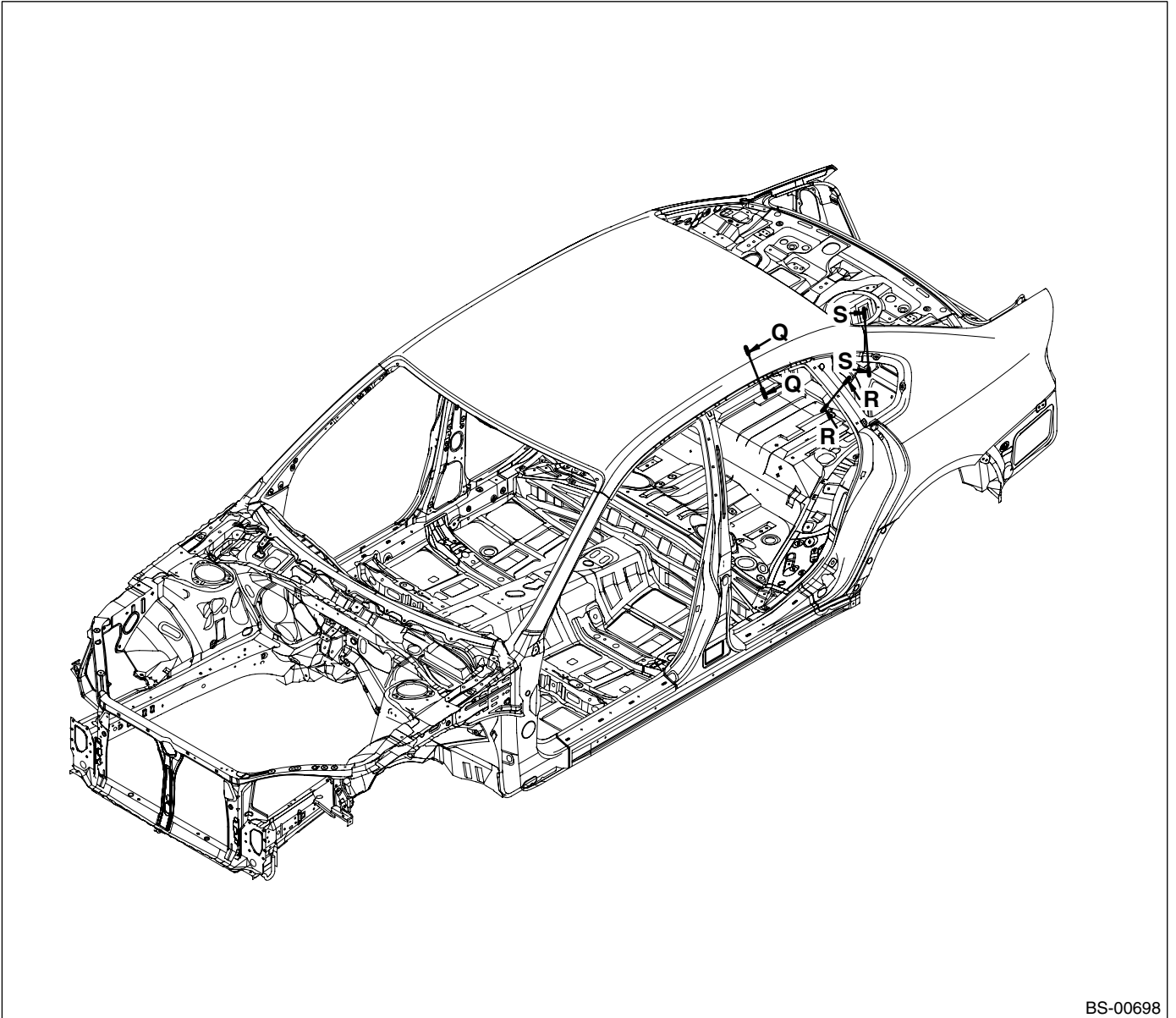
BS-00697

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

**SUBARU.**

# Body Construction

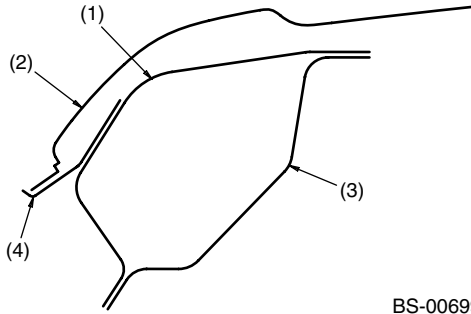
- Sedan-only parts



BS-00698

# Body Construction

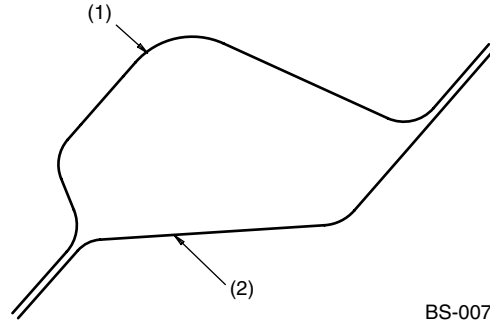
**Cross section Q — Q**



BS-00699

- (1) Side rail outer
- (2) Roof panel
- (3) Side rail inner
- (4) Drip rail

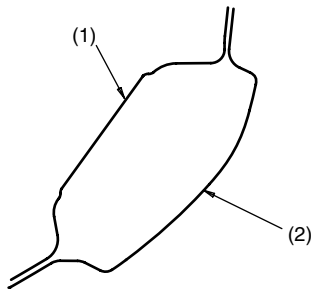
**Cross section R — R**



BS-00700

- (1) Rear pillar inner
- (2) Rear quarter panel outer

**Cross section S — S**



BS-00701

- (1) Rear pillar inner
- (2) Rear quarter panel outer

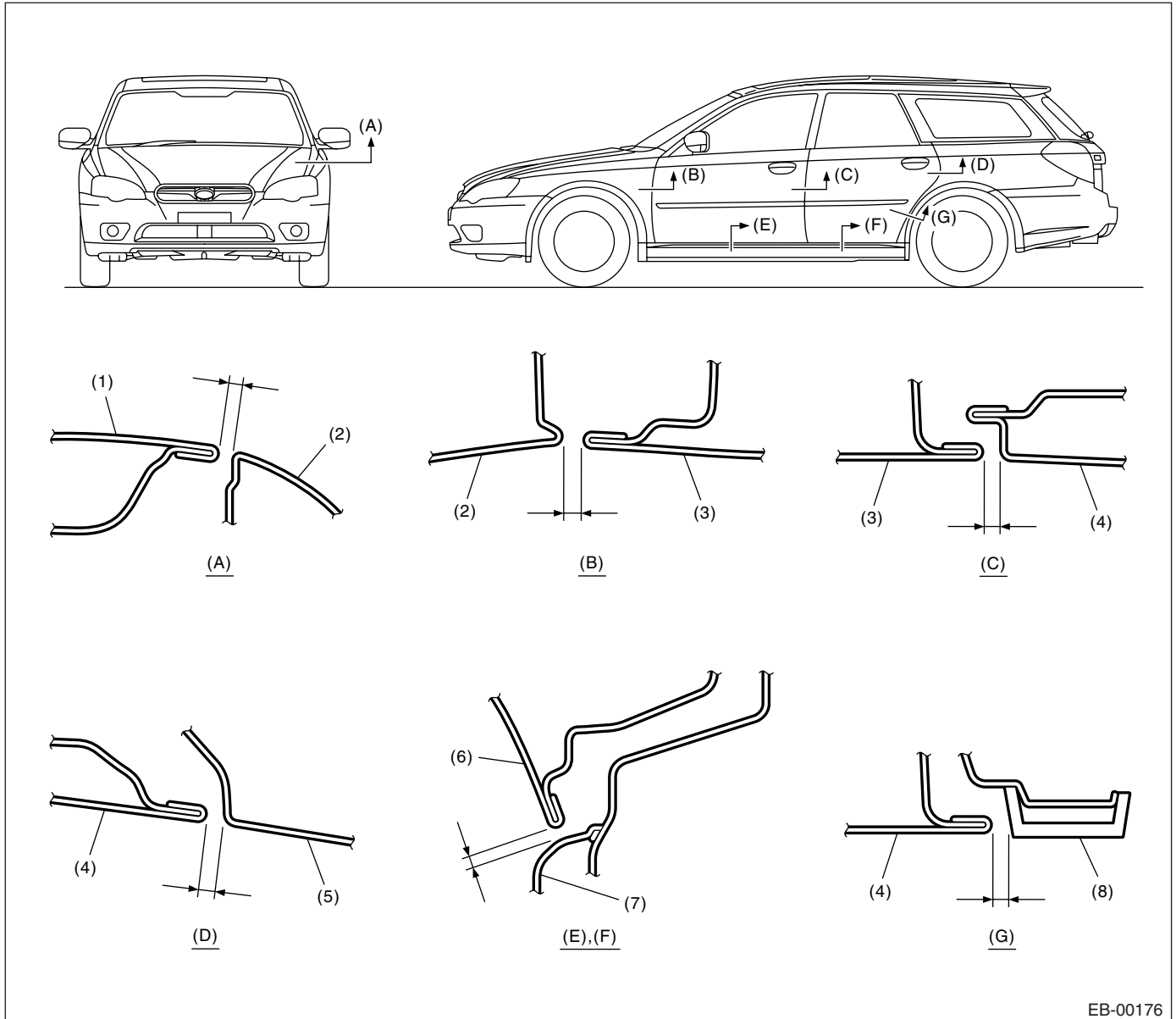
**SUBARU.**



# Gauge Values for Fitting

## 6. Gauge Values for Fitting

### 1. SIDE



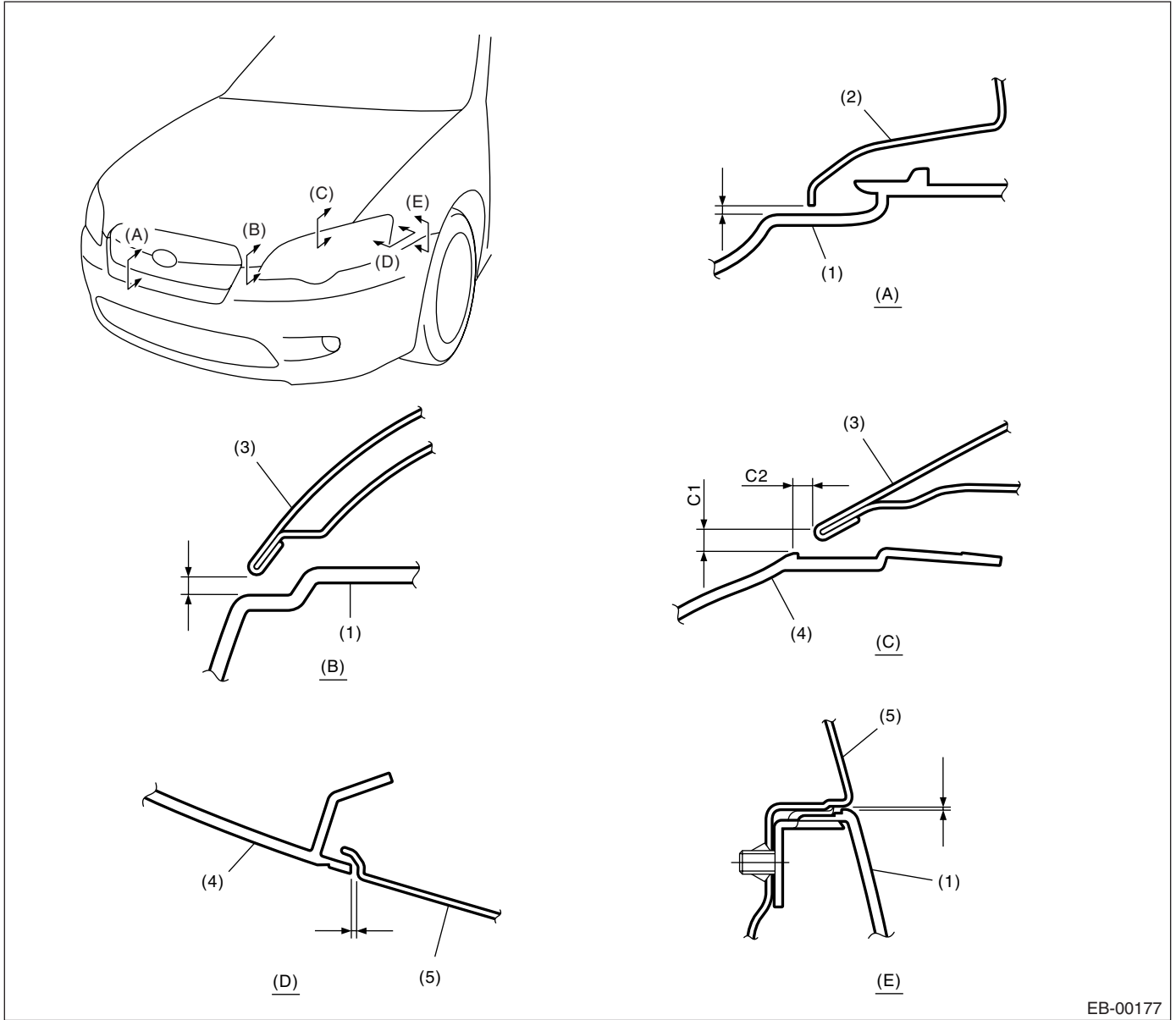
EB-00176

- |                        |                        |                                  |
|------------------------|------------------------|----------------------------------|
| (1) Front hood panel   | (4) Rear door panel    | (7) Side sill                    |
| (2) Front fender panel | (5) Rear quarter panel | (8) Rear quarter lower protector |
| (3) Front door panel   | (6) Door panel         |                                  |

Section	Part	Specification
(A)	Between front hood panel to front fender panel	Except for OUTBACK: 3.5±1.0 mm (0.14±0.04 in) OUTBACK: 3.8±1.0 mm (0.15±0.04 in)
(B)	Between front fender panel to front door panel	4.65±1.0 mm (0.18±0.04 in)
(C)	Between front door panel to rear door panel	5.1±1.0 mm (0.20±0.04 in)
(D)	Between rear door panel to rear quarter panel	4.6±1.0 mm (0.18±0.04 in)
(E), (F)	Between door panel to side sill	6.0±1.0 mm (0.24±0.04 in)
(G)	Between side sill to rear quarter lower protector	5.0±1.0 mm (0.20±0.04 in)

# Gauge Values for Fitting

## 2. FRONT



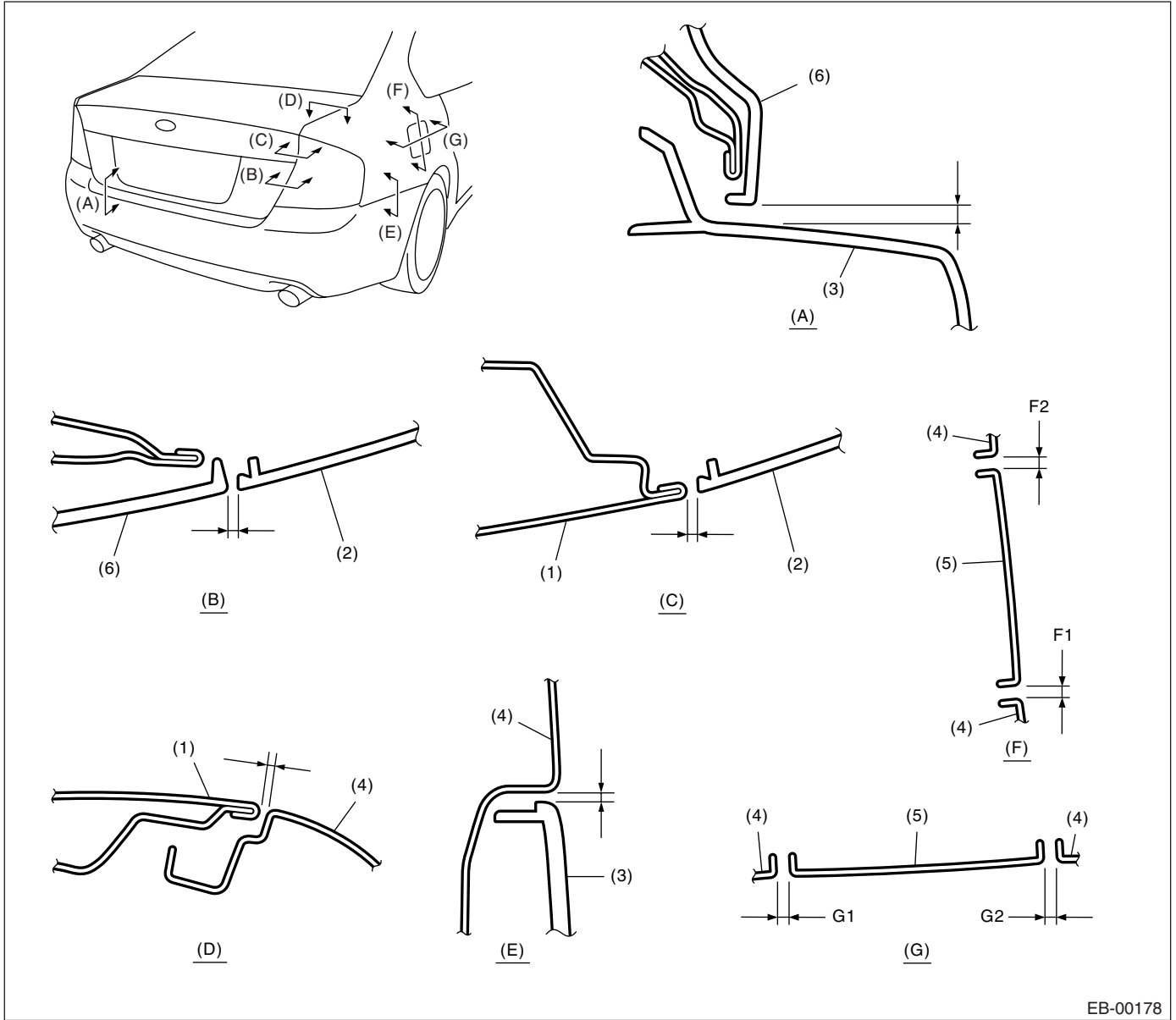
EB-00177

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

Section	Part	Specification
(A)	Between front bumper to front grille	1.0±0.7 mm (0.04±0.03 in)
(B)	Between front hood panel to front bumper	4.0 — 6.0 mm (0.16±0.24 in)
(C)	Between front hood panel to headlight	C1: 5.0±1.0 mm (0.20±0.04 in) C2: 6.0±1.0 mm (0.24±0.04 in)
(D)	Between front fender panel to headlight	2.0±1.0 mm (0.08±0.04 in)
(E)	Between front fender panel to front bumper	1.0±0.7 mm (0.04±0.03 in)

# Gauge Values for Fitting

## 3. REAR (SEDAN MODEL)

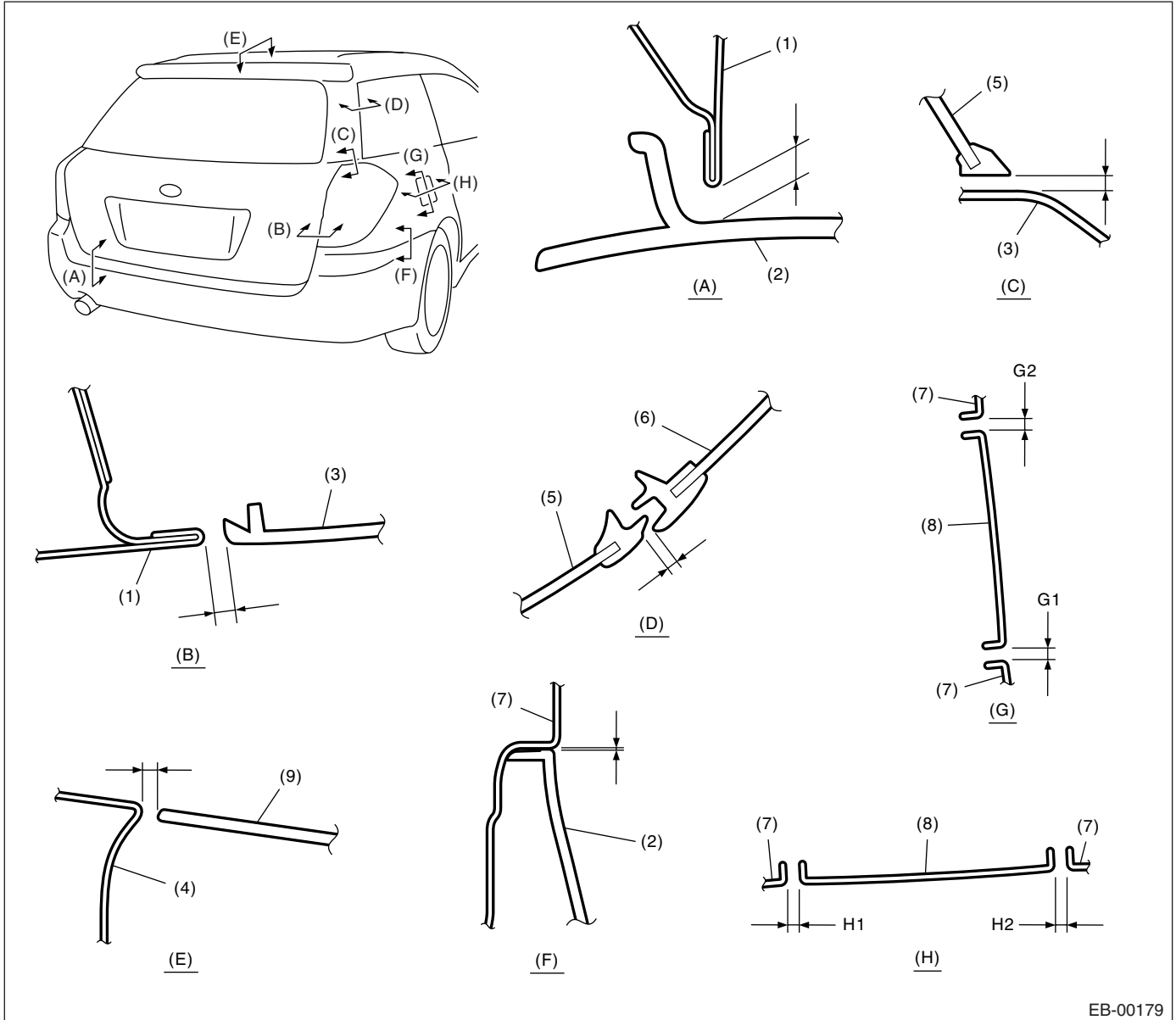


- (1) Trunk lid panel                      (3) Rear bumper                      (5) Fuel filler flap lid  
 (2) Rear combination light              (4) Rear fender panel                  (6) Trunk lid garnish

Section	Part	Specification
(A)	Between trunk lid garnish to rear bumper	7.0±1.0 mm (0.28±0.04 in)
(B)	Between trunk lid garnish to rear combination light	4.0±1.0 mm (0.16±0.04 in)
(C)	Between trunk lid panel to rear combination light	3.5±1.0 mm (0.14±0.04 in)
(D)	Between trunk lid panel to rear fender panel	3.5±1.0 mm (0.14±0.04 in)
(E)	Between rear fender panel to rear bumper	1.0±0.7 mm (0.04±0.03 in)
(F)	Between rear fender panel to fuel filler flap lid (vertical direction)	F1: 3.7±0.5 mm (0.15±0.02 in) F2: 3.4±0.5 mm (0.13±0.02 in)
(G)	Between rear fender panel to fuel filler flap lid (horizontal direction)	G1, G2: 3.5±0.5 mm (0.14±0.02 in)

# Gauge Values for Fitting

## 4. REAR (WAGON MODEL)



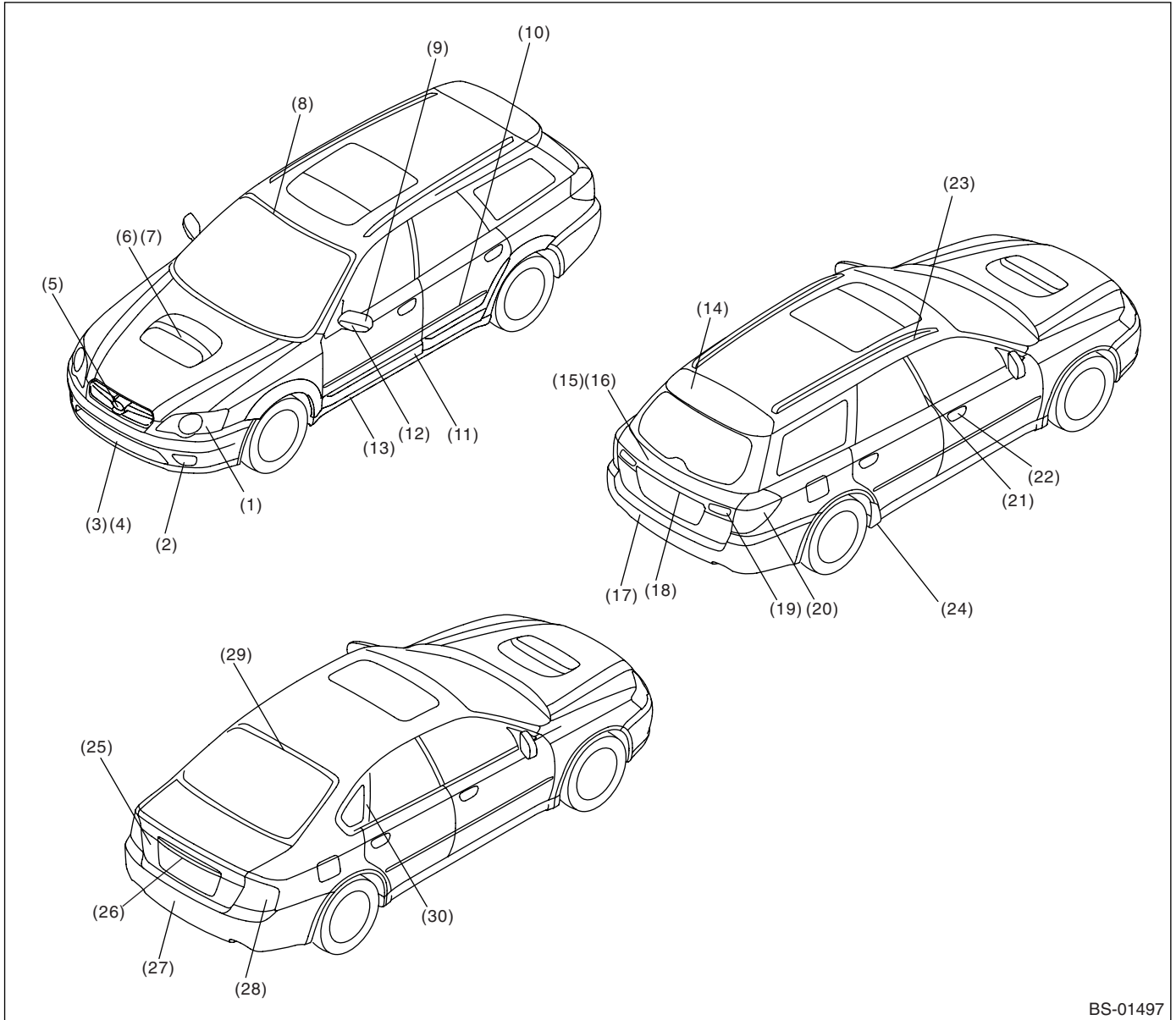
EB-00179

- |                            |                        |                          |
|----------------------------|------------------------|--------------------------|
| (1) Rear gate panel        | (4) Roof panel         | (7) Rear fender panel    |
| (2) Rear bumper            | (5) Rear gate glass    | (8) Fuel filler flap lid |
| (3) Rear combination light | (6) Rear quarter glass | (9) Roof spoiler         |

Section	Part	Specification
(A)	Between rear gate panel to rear bumper	$8.0 \pm 1.5$ mm (0.31 $\pm$ 0.06 in)
(B)	Between rear gate panel to rear combination light	$5.1 \pm 1.0$ mm (0.20 $\pm$ 0.04 in)
(C)	Between rear gate glass to rear combination light	$5.5 \pm 1.0$ mm (0.22 $\pm$ 0.04 in)
(D)	Between rear gate glass to rear quarter glass	$4.0 \pm 1.5$ mm (0.16 $\pm$ 0.06 in)
(E)	Between roof panel to roof spoiler	$5.5 \pm 1.0$ mm (0.22 $\pm$ 0.04 in)
(F)	Between rear fender panel to rear bumper	$1.0 \pm 0.7$ mm (0.04 $\pm$ 0.03 in)
(G)	Between rear fender panel to fuel filler flap lid (vertical direction)	G1: $3.7 \pm 0.5$ mm (0.15 $\pm$ 0.02 in) G2: $3.4 \pm 0.5$ mm (0.13 $\pm$ 0.02 in)
(H)	Between rear fender panel to fuel filler flap lid (horizontal direction)	H1, H2: $3.5 \pm 0.5$ mm (0.14 $\pm$ 0.02 in)

7. Plastic Parts and Materials

A: SPECIFICATION



BS-01497

- |                           |                             |                             |
|---------------------------|-----------------------------|-----------------------------|
| (1) Headlight             | (11) Side garnish           | (21) Center pillar cover    |
| (2) Front fog light       | (12) Side turn light        | (22) Door handle            |
| (3) Front bumper          | (13) Side spoiler           | (23) Roof rail              |
| (4) Air intake cover      | (14) Rear spoiler           | (24) Rear quarter protector |
| (5) Front grille          | (15) Rear garnish           | (25) Trunk garnish          |
| (6) Turbo grille          | (16) License light          | (26) License light          |
| (7) Hood duct inner       | (17) Rear bumper            | (27) Rear bumper            |
| (8) Front window moulding | (18) Rear gate handle       | (28) Rear combination light |
| (9) Door mirror           | (19) Backup light           | (29) Rear window molding    |
| (10) Side protector       | (20) Rear combination light | (30) Six light molding      |

# Plastic Parts and Materials

• Wagon-only parts and common parts for wagon and sedan

No.	Part name		Material
(1)	Headlight	Lens	PC
		Housing	PP
		Extension	PBT + PET
(2)	Front fog light (standard)	Housing	PET
	Front fog light (OUTBACK)	Lens	PC
		Reflector	UP - GF10
		Bracket	PP - GF30
(3)	Front bumper	Face	PP
		EA form	Foamed PP
		Fog light cover	PP
		Hook cover	PP
		Bumper cover (OUTBACK)	PP
(4)	Air intake cover		PP
(5)	Front grille		ABS
(6)	Turbo grille		PA + PPE
(7)	Hood duct inner		PP + EPDM
(8)	Front window moulding		PVC
(9)	Door mirror	Body	ASA
		Inner cover	AES
		Outer cover	ABS
		Mirror holder	PP
(10)	Side protector		PP
(11)	Side garnish	Door body	PC + PET
		Other than door body	PP
		Side sill end cover	PP + EPDM
(12)	Side turn light	Lens	PMMA + PC
		Housing	PC
(13)	Side spoiler		PP
(14)	Rear spoiler	Body	PC + PET
		High mount lens	PMMA
		High mount housing	ABS
(15)	Rear garnish	Body	PC + PET
		Molding	ABS
(16)	License light	Lens	PC
		Housing	PBT + PET
(17)	Rear bumper	Face	PP
		EA form	Foamed PP
(18)	Rear gate handle		PP - GF 20
(19)	Backup light	Lens	PMMA
		Housing	ASA
(20)	Rear combination light	Lens	PMMA
		Inner lens	PC
		Housing	ASA
		Reflex reflector	PMMA
		Cover	ASA
(21)	Center pillar cover		ABS
(22)	Door handle	Handle	PPE + PA
		End cover	PP

## Plastic Parts and Materials

No.	Part name		Material
(23)	Roof rail	Front cover	PC + PET
		Center cover (OUTBACK)	PC + PET
		Rear cover	PC + PET
(24)	Rear quarter protector		PP
	Front mudguard	Body	PE
		Air flap	TPO
	Rear mudguard		PE
	Under cover	Body	PP
		Flap	TPO
	Splashboard		PP
	Cowl panel	Body, side	PP
		Cover	PP
	Rear wiper	Blade	PBT
		Arm	PET
		Arm cover	PBT

• **Sedan-only parts**

No.	Part name		Material
(25)	Trunk garnish		PC + PET
(26)	License light	Lens	PMMA
		Housing	ASA
(27)	Rear bumper	Face	PP
		EA form	Foamed PP
(28)	Rear combination light	Lens	PMMA
		Inner lens	PC
		Housing	ASA
		Reflex reflector	PMMA
		Cover	ASA
(29)	Rear window molding		PVC
(30)	Six light molding		ABS
	High mount stop light	Lens	PC
		Case	PP
		Reflector	PBT + PET

## List of Plastic Material Notations

### 8. List of Plastic Material Notations

#### A: SPECIFICATION

Notation symbol	Material name	Notation symbol	Material name
ABS	ABS resin (acrylonitrile/butadiene/styrene/resin)	PMMA	Polymethyl methacrylate
AES	Acrylonitrile/ethylene/styrene	PP	Polypropylene
ASA	Acrylonitrile/styrene/acrylic resin	PPE	Polyphenylene ether
EPDM	Ethylene/propylene/dien rubber	PP - GF20	Polypropylene (20% glass fiber content)
GF	Glass fiber	PP - GF30	Polypropylene (30% glass fiber content)
PA	Polyamide	PVC	Polyvinyl chloride
PBT	Poly (butylene terephthalate)	SEPM	Styrene/ethylene/propylene rubber
PC	Polycarbonate	TPO	Thermoplastic olefine
PE	Polyethylene	UP	Unsaturated polyester resin
PET	Polyethylene terephthalate	UP - GF10	Unsaturated polyester resin (10% glass fiber content)



# Body Sealing

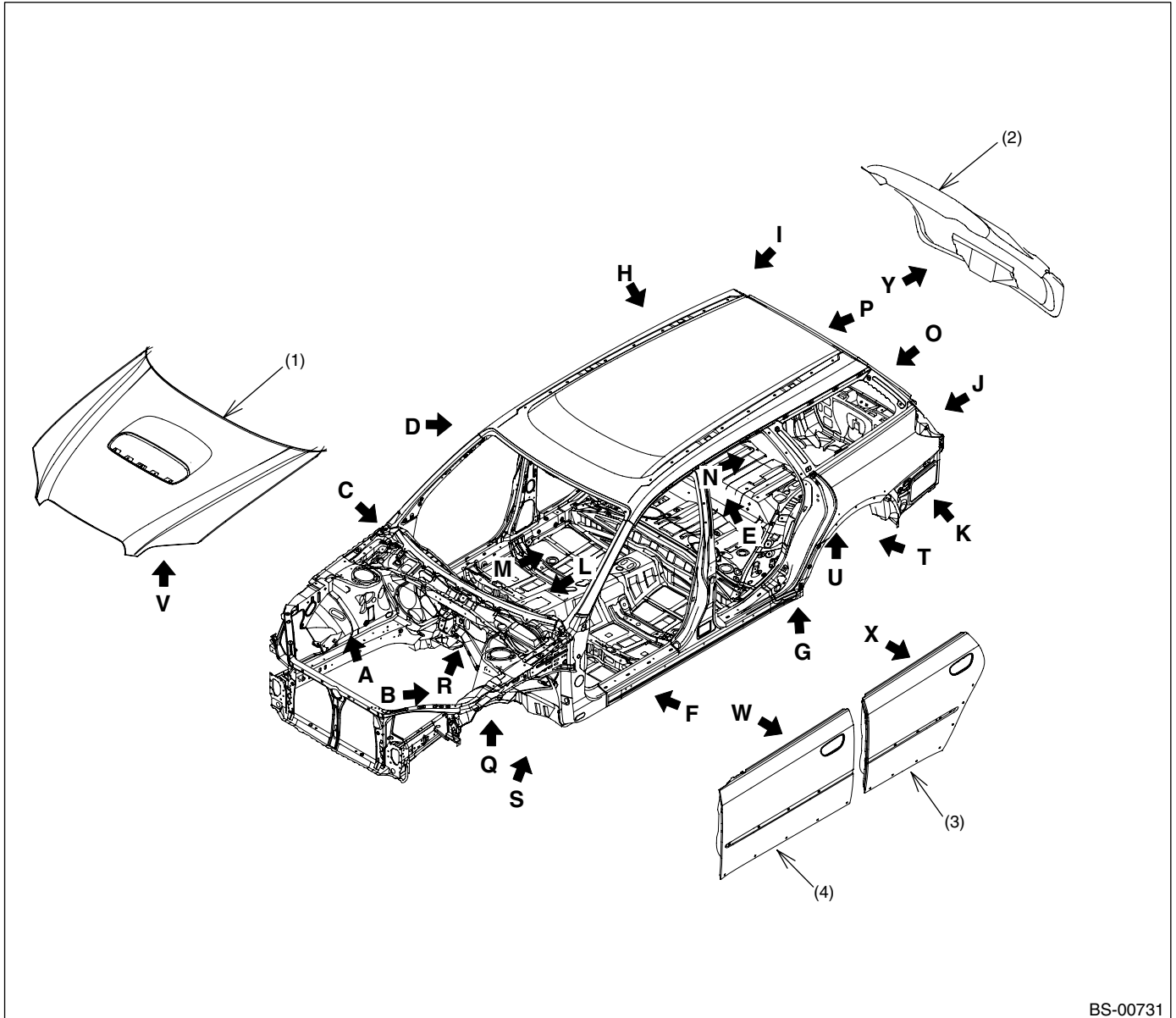
## 9. Body Sealing

### A: SPECIFICATION

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

— : Sealer application location

- Common parts for wagon and sedan



BS-00731

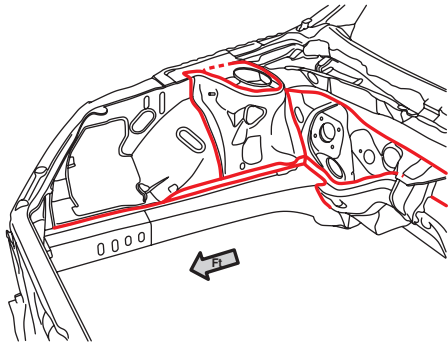
- (1) Front hood  
(2) Rear gate

- (3) Rear door

- (4) Front door

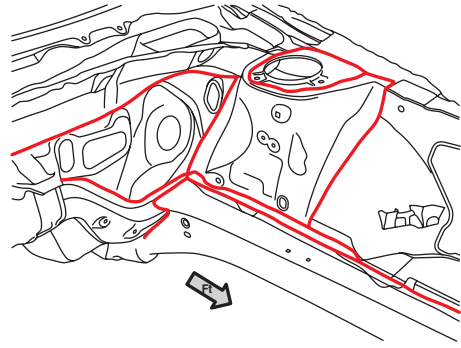
# Body Sealing

View A



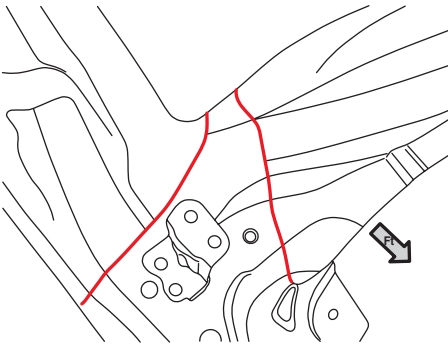
BS-00732

View B



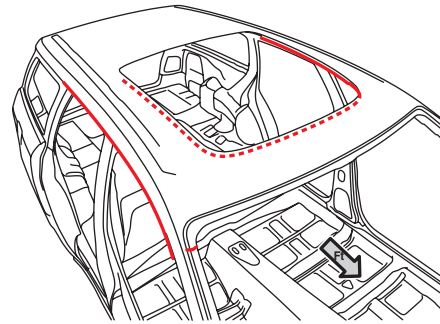
BS-00733

View C



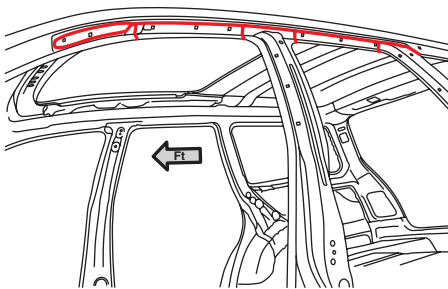
BS-00734

View D



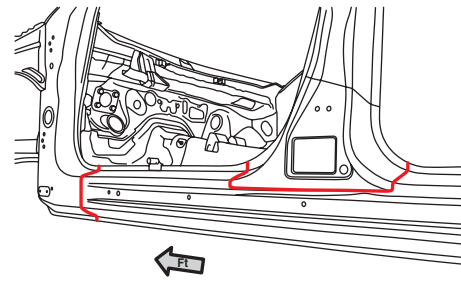
BS-00735

View E



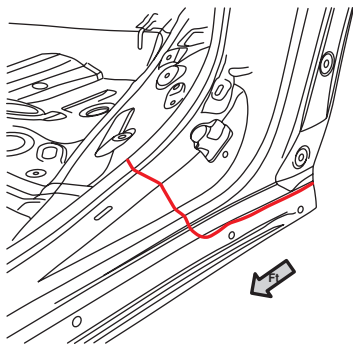
BS-00736

View F



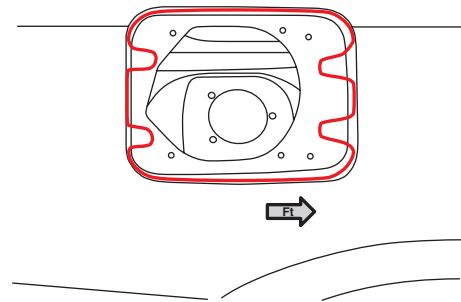
BS-00737

View G



BS-00738

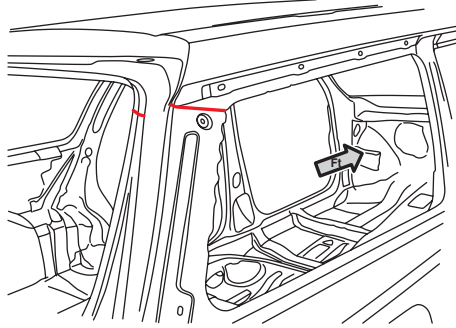
View H



BS-00739

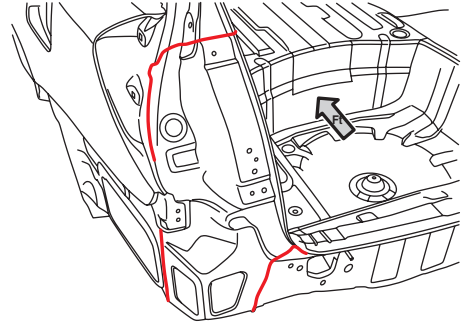
# Body Sealing

View I



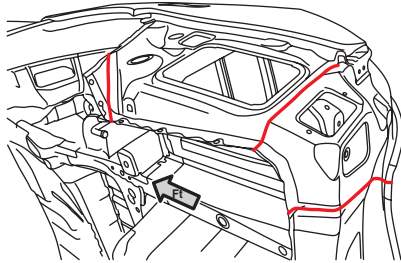
BS-00740

View J



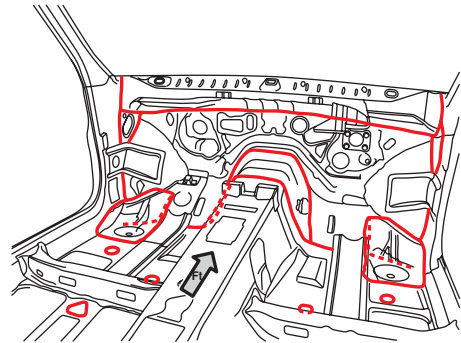
BS-00741

View K



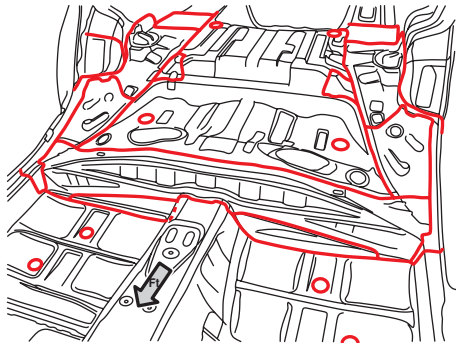
BS-00742

View L



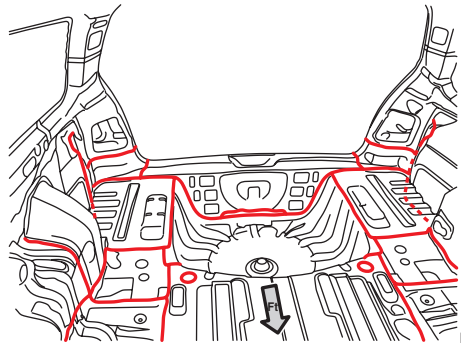
BS-00743

View M



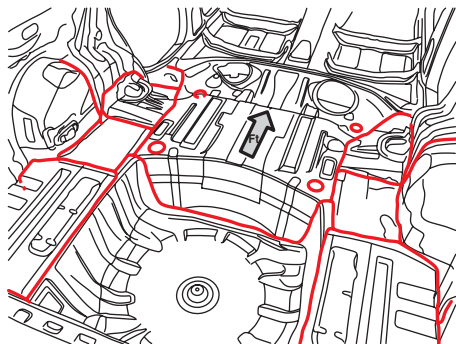
BS-00744

View N



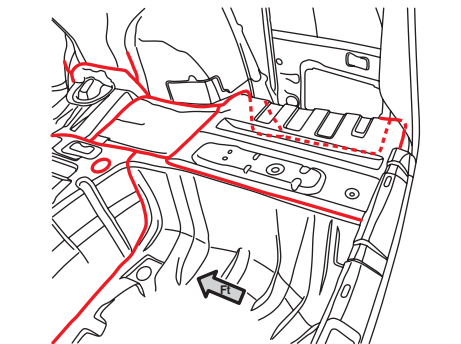
BS-00745

View O



BS-00746

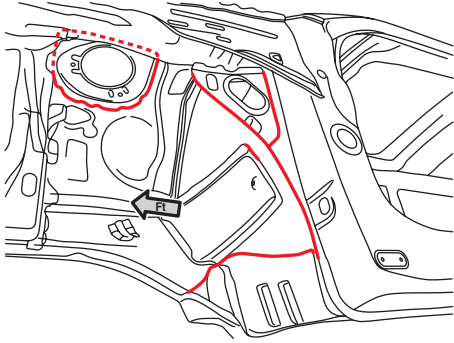
View P



BS-00747

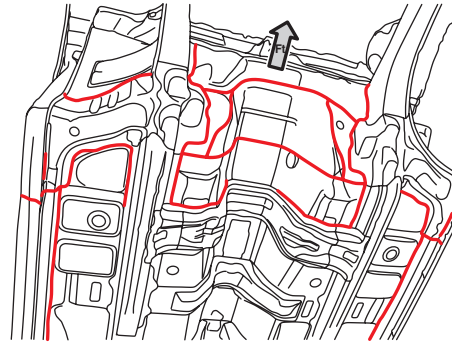
# Body Sealing

View Q



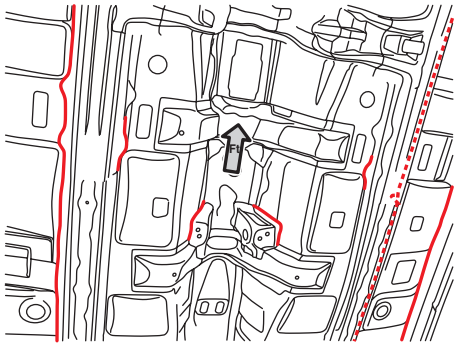
BS-00748

View R



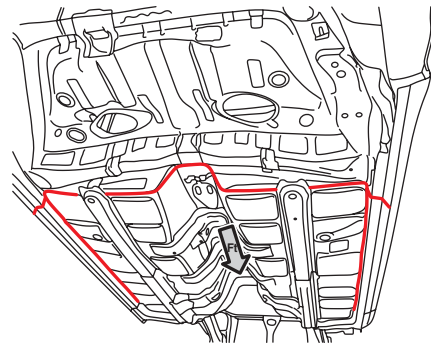
BS-00749

View S



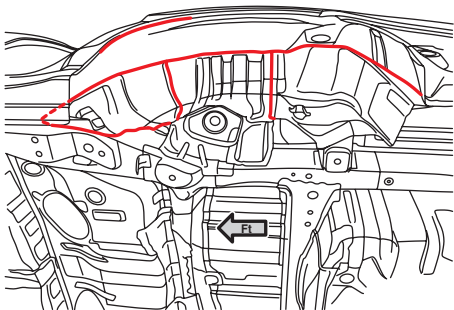
BS-00750

View T



BS-00751

View U

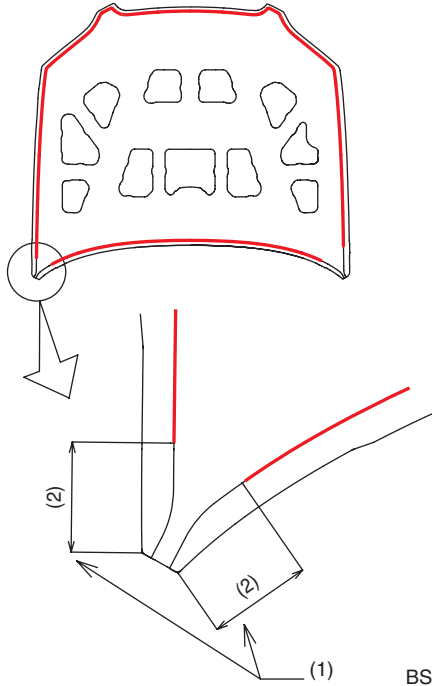


BS-00752

SUBARU.

# Body Sealing

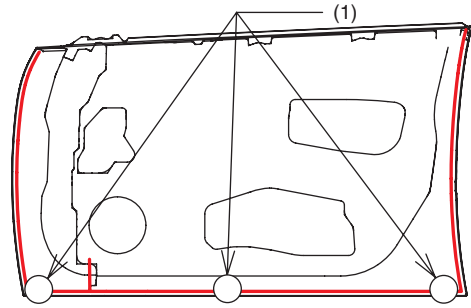
View V



- (1) Application not required.
- (2) 40 mm (1.57 in)

BS-02513

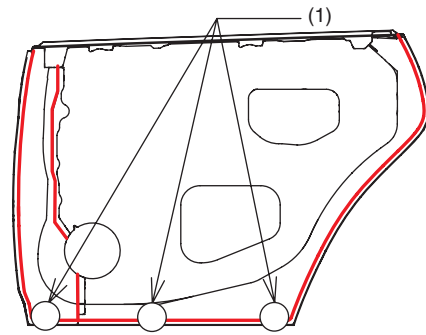
View W



BS-00754

- (1) Do not block the water drain holes.

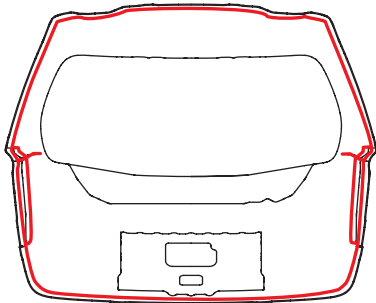
View X



BS-00755

- (1) Do not block the water drain holes.

View Y



BS-00756

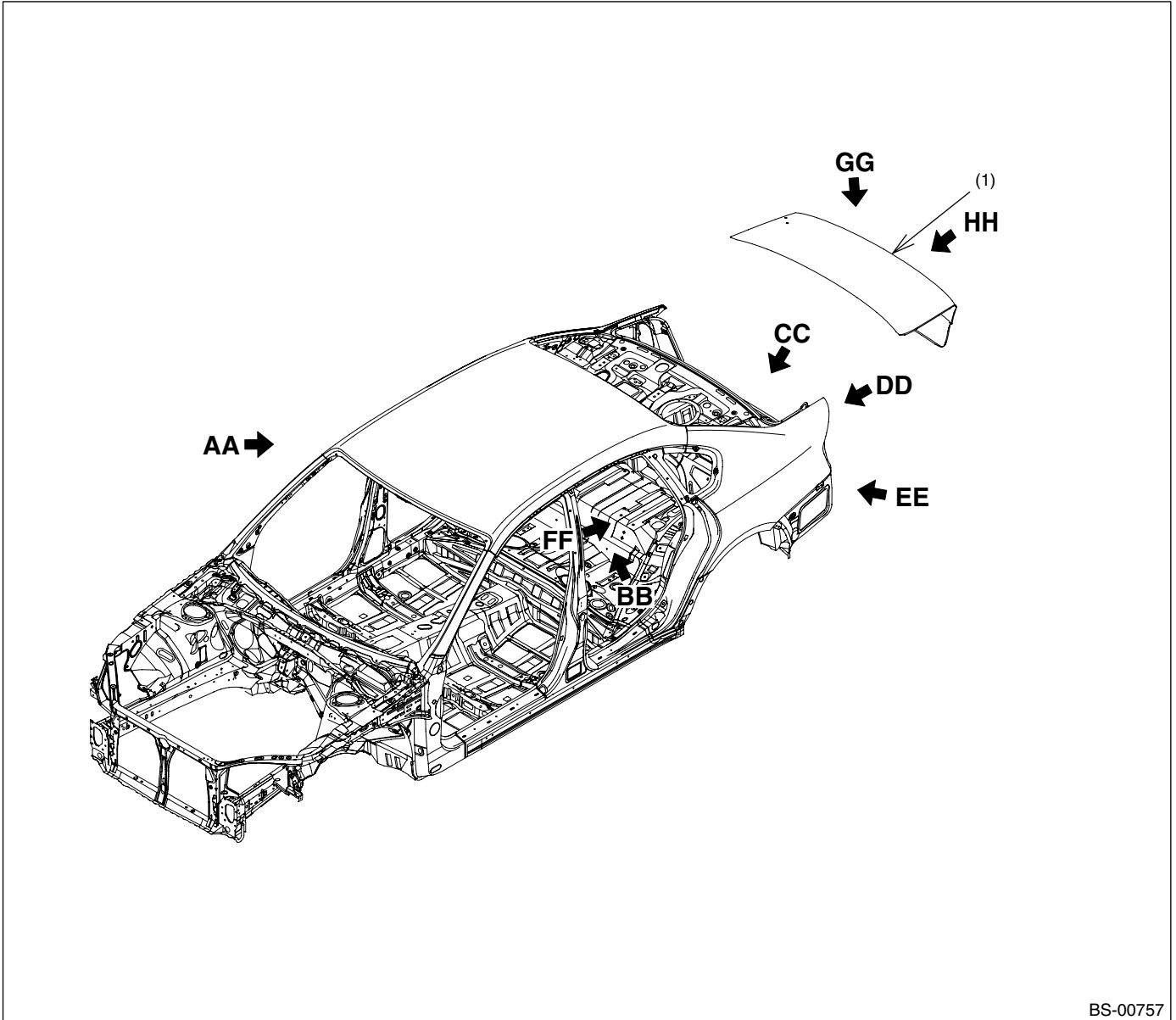
SUBARU.

**CAUTION:**

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

# Body Sealing

- Sedan-only parts

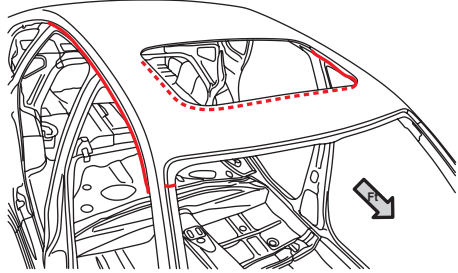


BS-00757

(1) Trunk

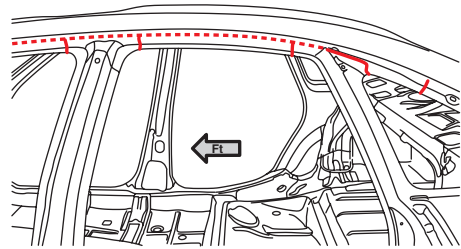
# Body Sealing

View AA



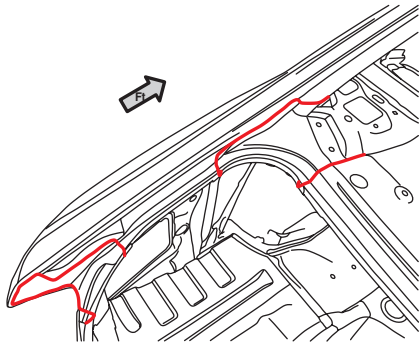
BS-00758

View BB



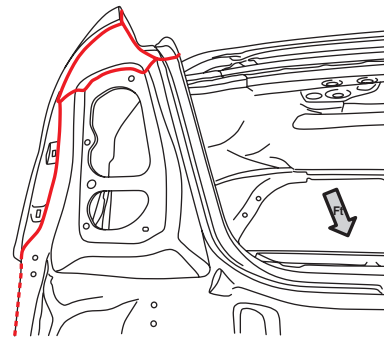
BS-00759

View CC



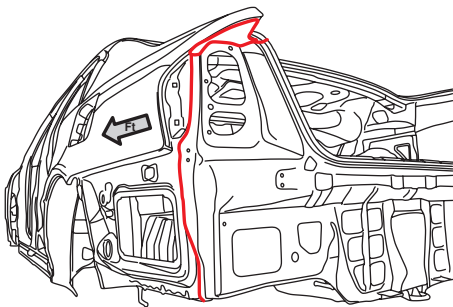
BS-00760

View DD



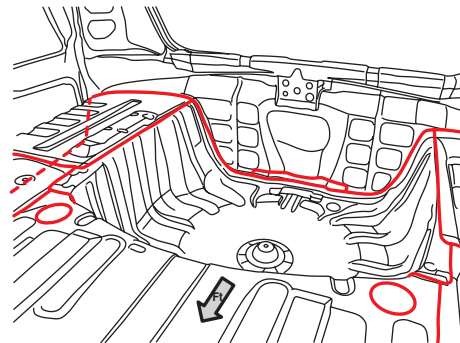
BS-00761

View EE



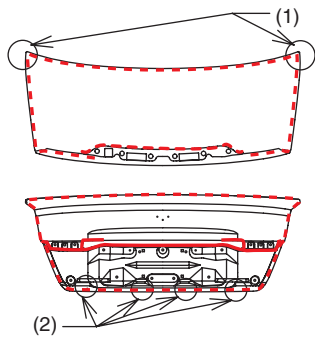
BS-00762

View FF



BS-00763

View GG  
View HH



BS-00764

- (1) Block the holes.
- (2) Do not block the water drain holes.

SUBARU.

**CAUTION:**  
Sealer already has been applied to trunk in replacement condition.

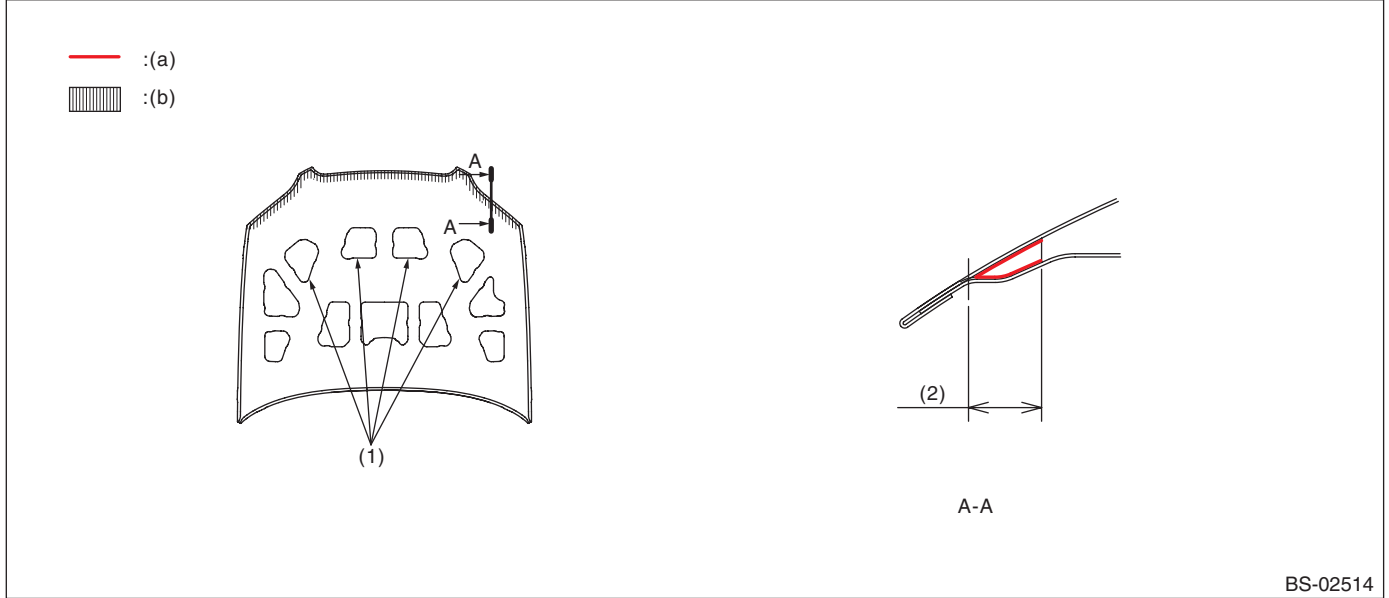
## 10. Anticorrosion Wax

### A: SPECIFICATION

Used material:

**Rust-stop aerosol (K0877YA015)**

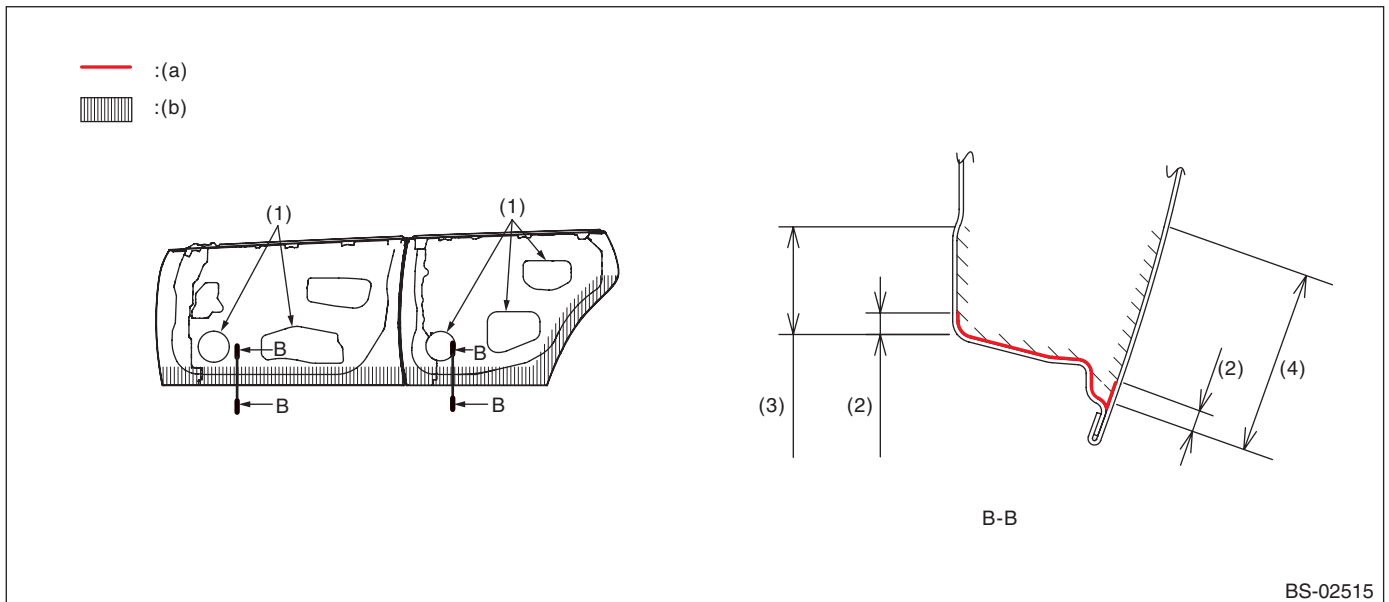
- Front hood



(a) Application thickness: 50 μm or more (b) Application area

(1) Wax application work openings (2) 10 mm (0.39 in)

- Door (Front, rear)



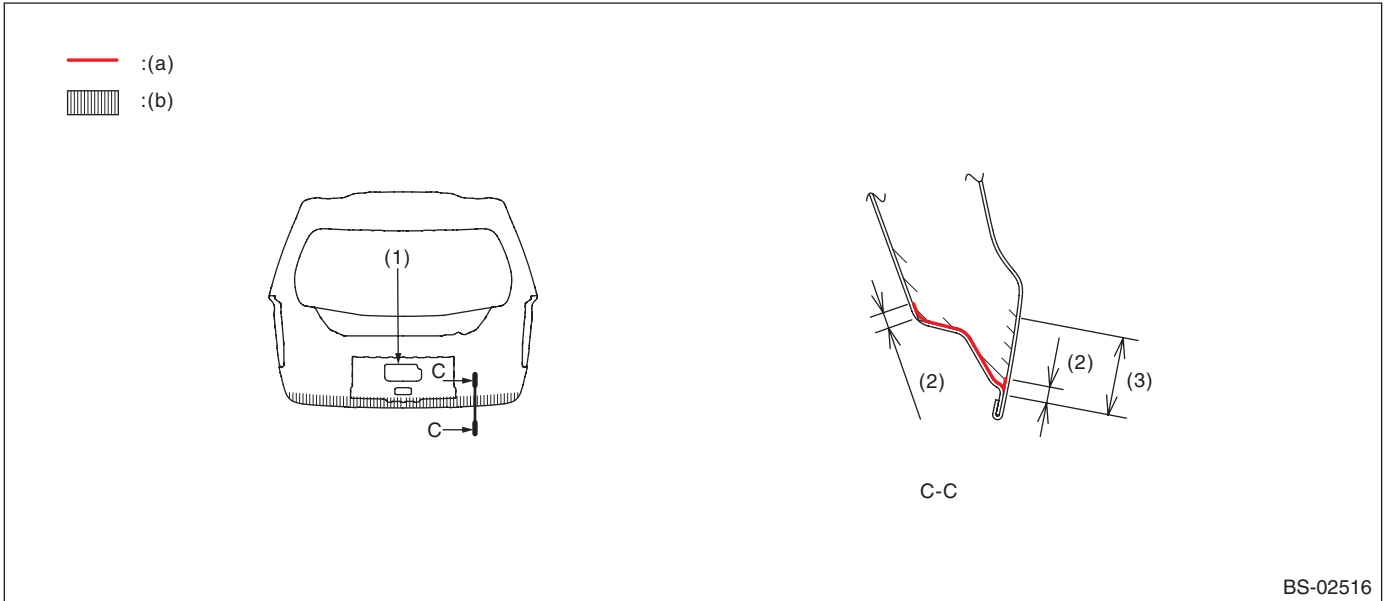
(a) Application thickness: 50 μm or more (b) Application area

(1) Wax application work openings (3) 50 mm (1.97 in) (4) 90 mm (3.54 in)  
 (2) 10 mm (0.39 in)



# Anticorrosion Wax

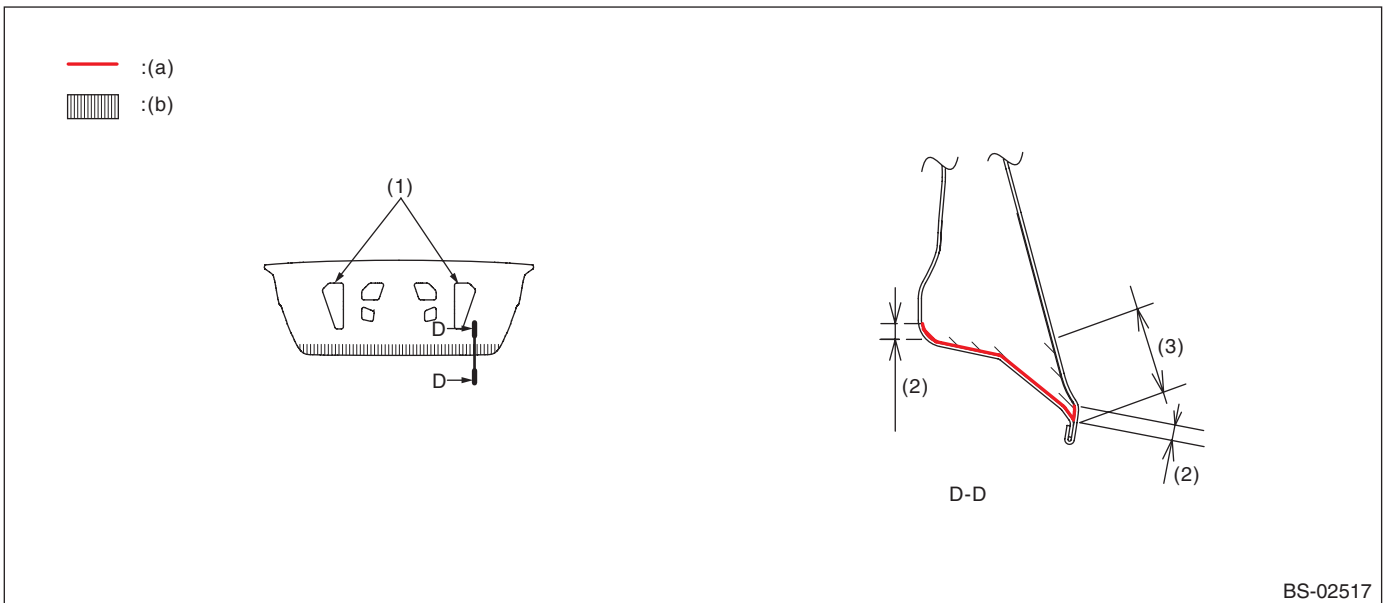
- Rear gate



(a) Application thickness: 50  $\mu\text{m}$  or more (b) Application area

(1) Wax application work openings (2) 10 mm (0.39 in) (3) 40 mm (1.57 in)

- Trunk



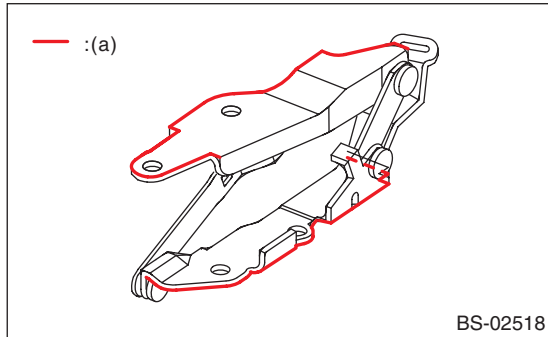
(a) Application thickness: 50  $\mu\text{m}$  or more (b) Application area

(1) Wax application work openings (2) 10 mm (0.39 in) (3) 40 mm (1.57 in)

# Anticorrosion Wax

- Front hood hinge

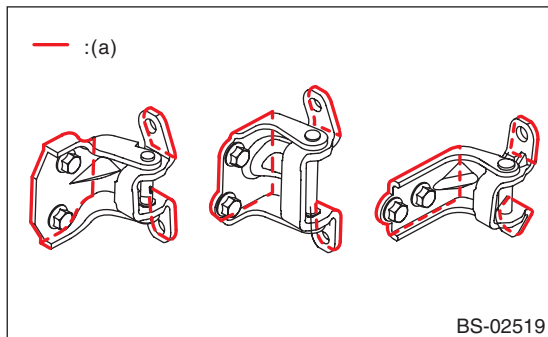
Apply around the installation outer circumference (indicated range) at two locations on the left and right.



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

- Door hinge

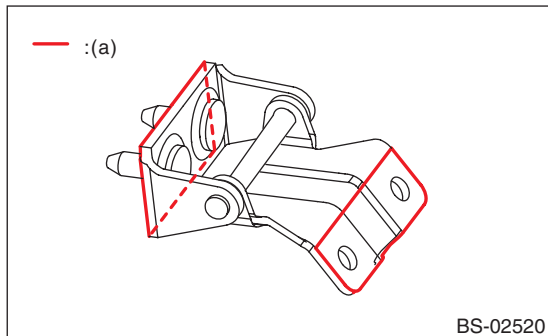
Apply to the installation outer circumference at two locations at the top and bottom (eight locations in all).



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

- Rear gate hinge

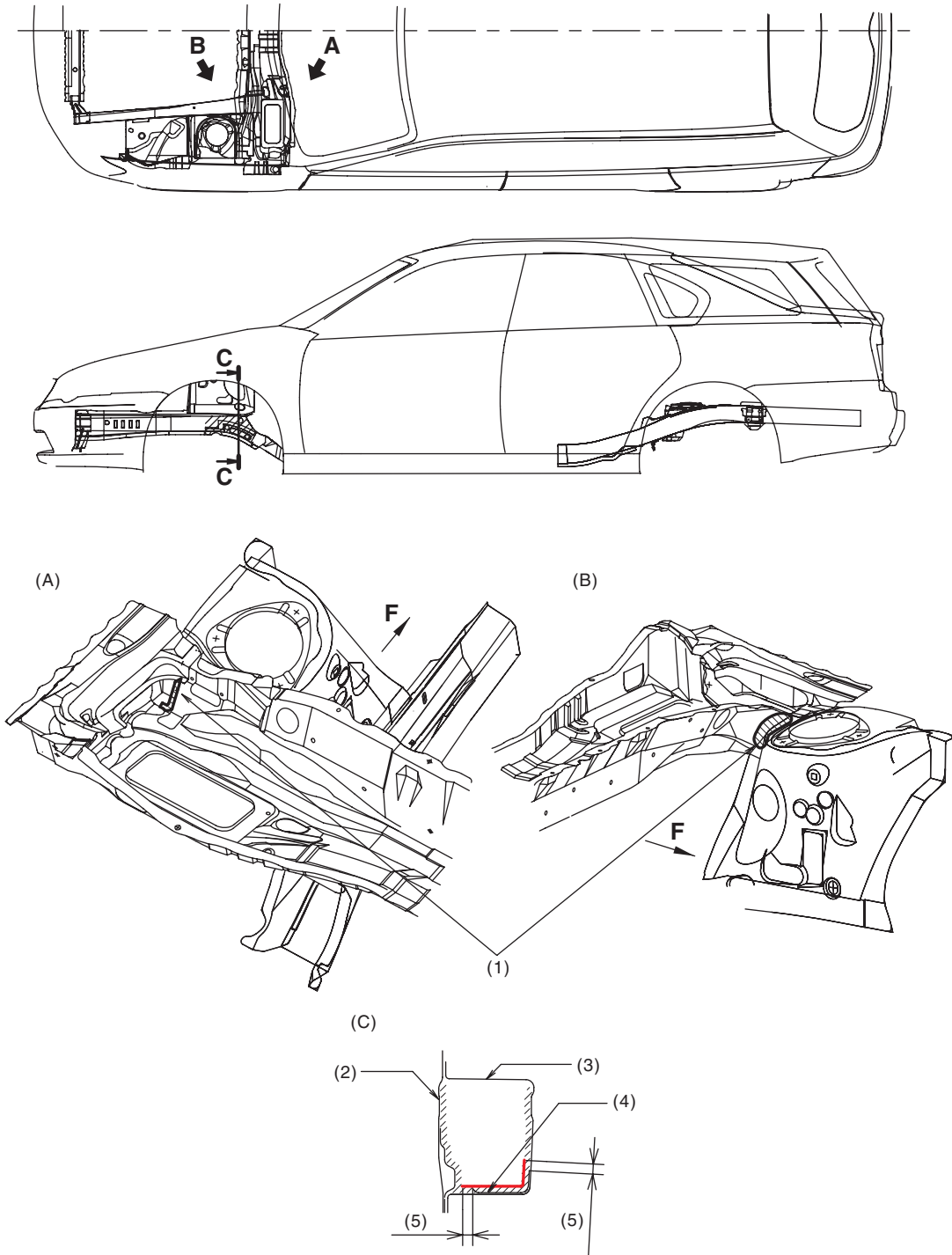
Apply around the installation outer circumference (plate edges) at two locations on the left and right.



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

# Anticorrosion Wax

- Overall view



BS-02521

- |   |                            |                         |
|---|----------------------------|-------------------------|
| (A) View A  | (B) View B                 | (C) Cross section C — C |
| (1) Apply to the mating surface between the front suspension bracket and duct. (15 $\mu$ m or more) | (2) Closing plate          | (4) Reinforcement       |
|   | (3) Front side frame front | (5) 10 mm (0.39 in)     |

# Undercoat

## 11.Undercoat

### A: SPECIFICATION

#### Repair material:

#### **THREE BOND 6115**

1) Application thickness is 0.4 mm or more.

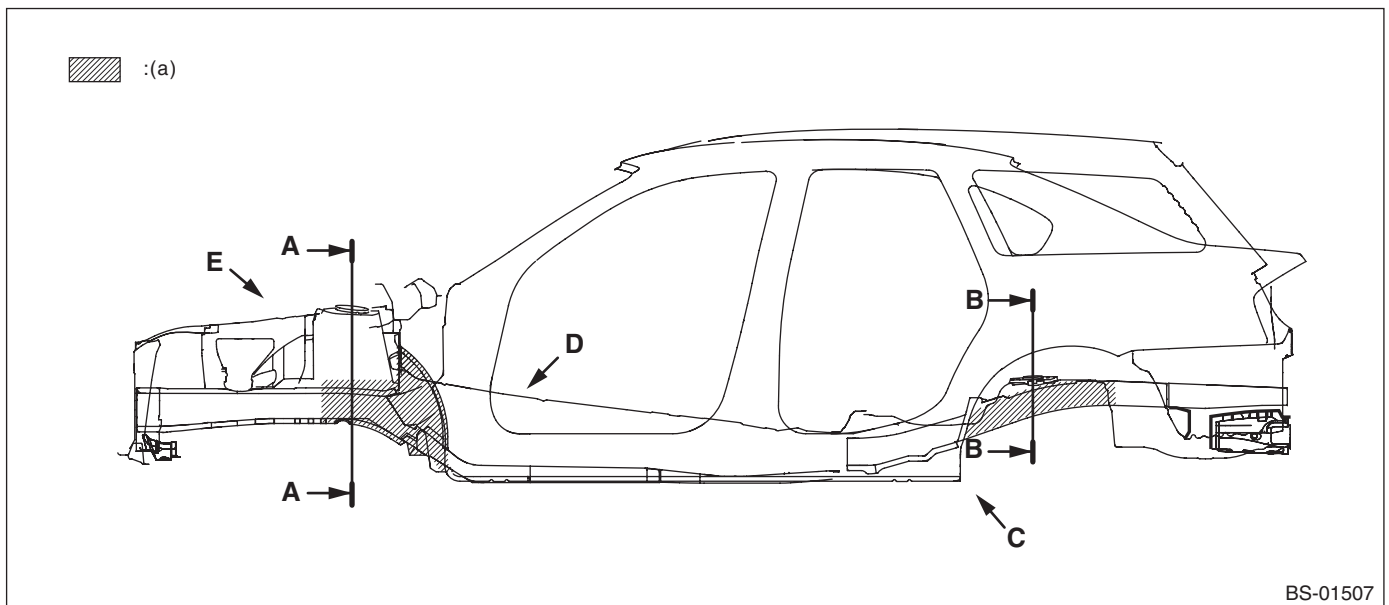
2) Be careful that the undercoat does not become attached to locations other than where indicated in the figure, and on the following locations.

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

3) Application area

▨ and —: Undercoat application location

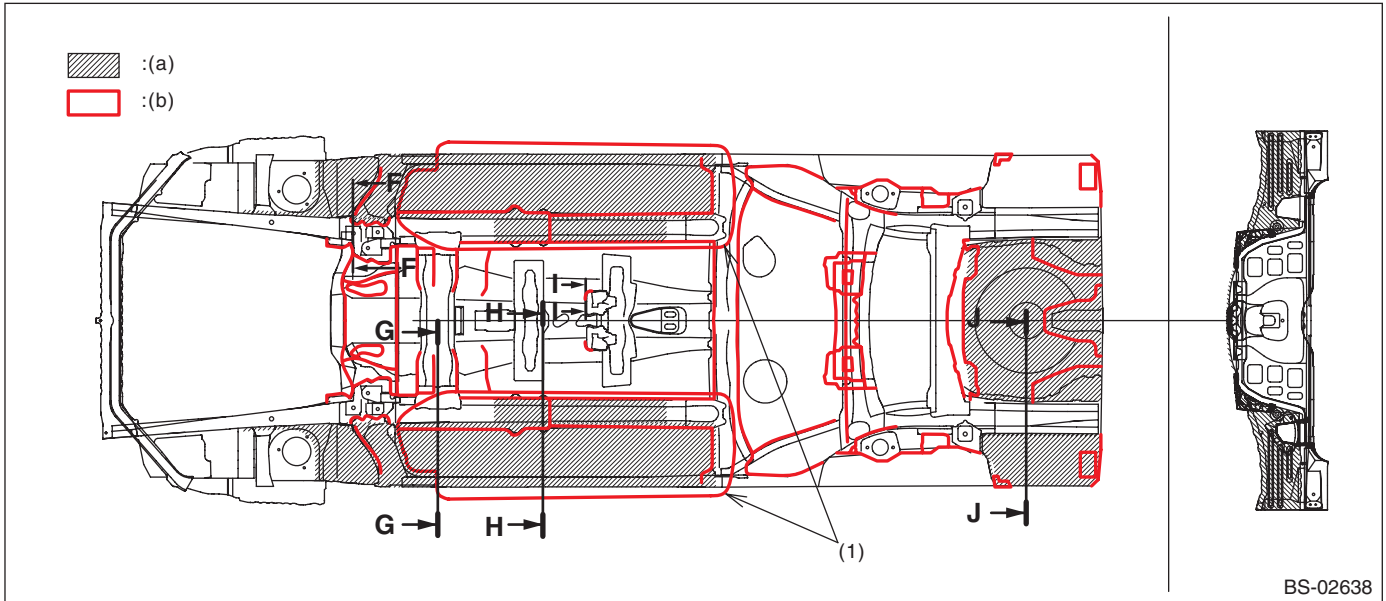
- Side view



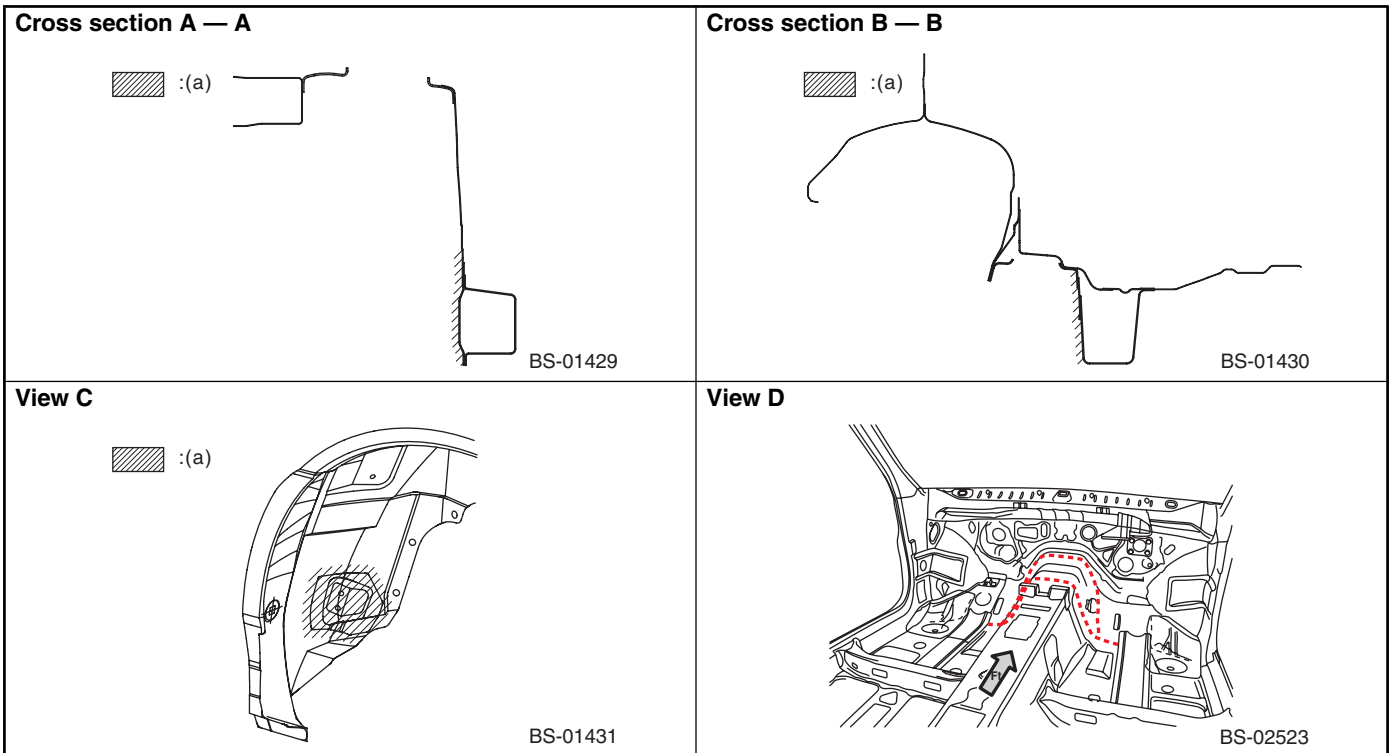
(a) Undercoat application location

# Undercoat

- Bottom view/1

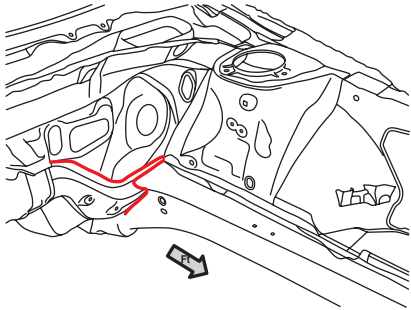


- (1) Undercoat is not required in this area for vehicles equipped with an undercover. (a), (b) Undercoat application location



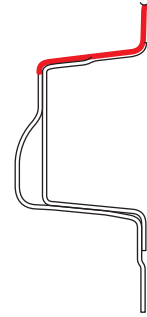
# Undercoat

View E



BS-02524

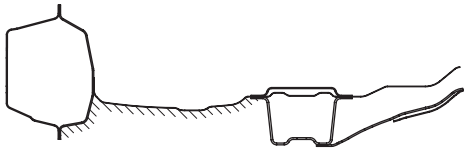
Cross section F — F



BS-02525

Cross section G — G (rotated 90°)

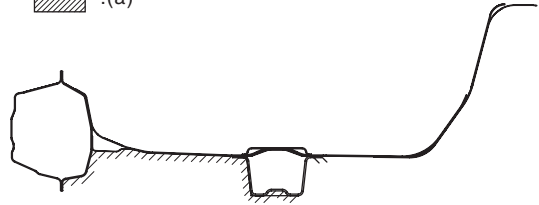
 : (a)



BS-01432

Cross section C — C (rotated 90°)

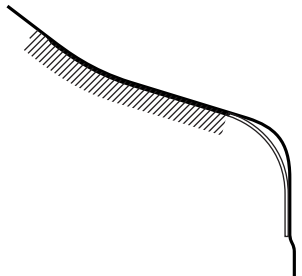
 : (a)



BS-01433

Cross section I — I

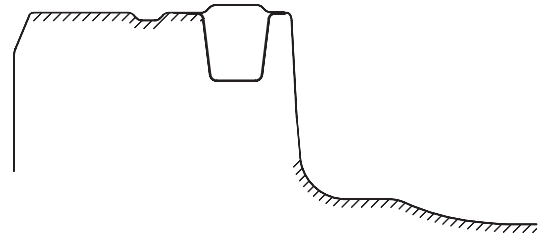
 : (a)



BS-01512

Cross section J — J (rotated 90°)

 : (a)



BS-01434

(a) Undercoat application location

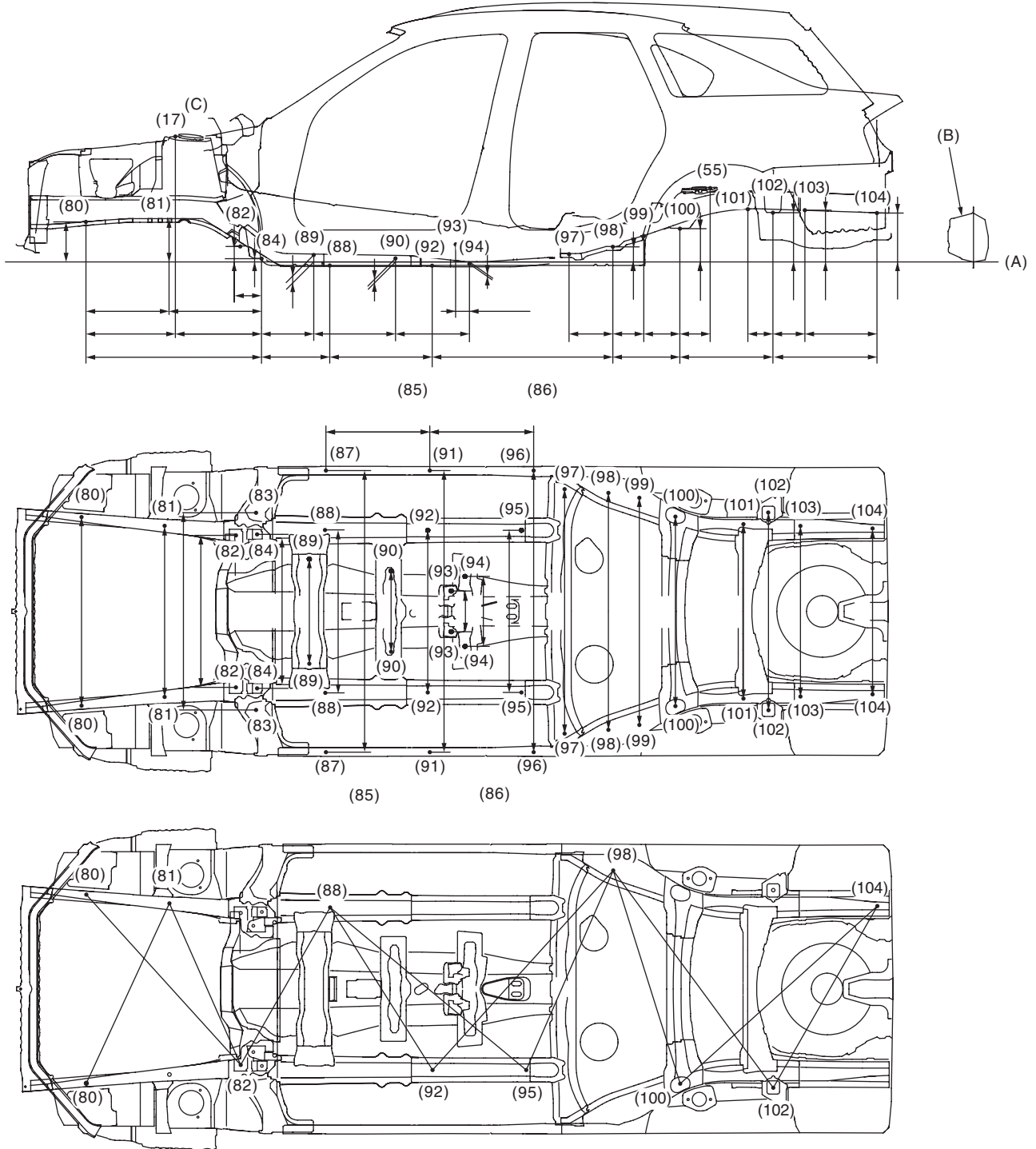
# Body Reference Points

## 12. Body Reference Points

### A: DIMENSIONS

#### 1. BOTTOM

Unit: mm



BS-01530

- Diagonal dimensions are the actual dimensions between reference points. The values in brackets are projected dimensions for reference.

## Body Reference Points

---

### CAUTION:

For reference point 17 strut mount mounting hole (symmetrical), refer to the "Datum dimension". (Refer to the figure "FRONT STRUCTURE, DIMENSIONS, Body Reference Points" on page 51.)

For reference point 55 rear suspension mounting hole (symmetrical), refer to the "Datum dimension". (Refer to the figure "INSIDE, DIMENSIONS, Body Reference Points" on page 54.)

(A) Standard line	(B) Side sill	(C) Upper face
(80) Gauge hole (symmetrical)	(89) Transmission crossmember mounting hole (symmetrical)	(97) Fuel protector mounting hole (symmetrical)
(81) Front crossmember mounting hole (symmetrical), lower face rear	(90) Gauge hole (symmetrical)	(98) Trailing arm mounting hole (symmetrical)
(82) Strut mount mounting hole (symmetrical)	(91) Under cover mounting hole (symmetrical)	(99) Trailing arm mounting hole (symmetrical)
(83) Strut mount mounting hole (symmetrical)	(92) Under cover mounting hole (symmetrical)	(100) Rear suspension crossmember mounting hole (symmetrical)
(84) Strut mount mounting hole (symmetrical)	(93) Center bearing mounting hole (symmetrical)	(101) Canister hose mounting hole (symmetrical)
(85) Transmission crossmember mounting hole (symmetrical)	(94) Exhaust cover mounting hole (symmetrical)	(102) Rear suspension crossmember mounting hole (symmetrical)
(86) Drain hose mounting hole (symmetrical)	(95) Weight reduction hole (symmetrical)	(103) Gauge hole (symmetrical)
(87) Under cover mounting hole (symmetrical)	(96) Under cover mounting hole (symmetrical)	(104) Weight reduction hole (symmetrical)
(88) Under cover mounting hole (symmetrical)		



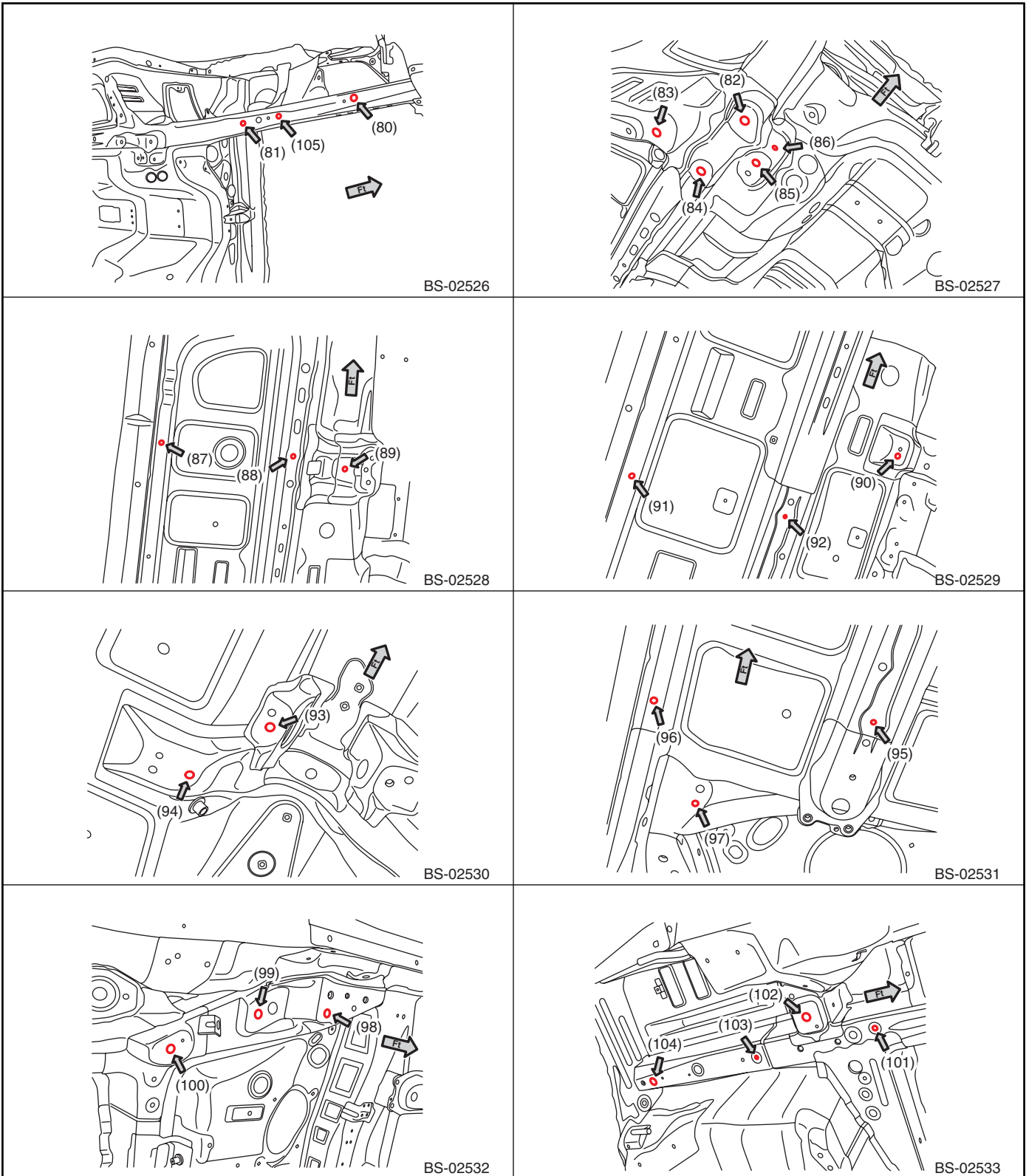
## Body Reference Points

Measurement point	Datum dimension mm (in)
Datum line — (80)	198 (7.80)
Datum line — (81)	212 (8.35)
Datum line — (82)	77 (3.03)
Datum line — (84)	17(0.07)
Datum line — (89)	(4AT, MT) 35 (1.38) (5AT) 56 (2.20)
Datum line — (90)	18 (0.71)
Datum line — (94)	-9 (-0.35)
Datum line — (98)	75 (2.95)
Datum line — (100)	164 (6.46)
Datum line — (102)	243 (9.57)
Datum line — (103)	255 (10.04)
Datum line — (104)	241 (9.49)
(17) — (80)	439 (17.28)
(17) — (84)	423 (16.65)
(80) — (81)	408 (16.06)
(80) — (84)	862 (33.94)
(81) — (84)	454 (17.87)
(82) — (84)	104 (4.09)
(84) — (88)	335 (13.19)
(84) — (89)	(4AT, MT) 257 (10.12) (5AT) 357 (14.06)
(88) — (92)	503 (19.80)
(89) — (90)	302 (11.89)
(90) — (94)	363 (14.29)
(92) — (98)	887 (34.92)
(93) — (94)	68 (2.68)
(97) — (98)	215 (8.46)
(98) — (99)	152 (5.98)
(98) — (100)	329 (12.95)
(99) — (100)	177 (6.97)
(100) — (55)	149 (5.87)
(100) — (102)	457 (17.99)
(101) — (102)	123 (4.84)
(102) — (103)	157 (6.18)
(102) — (104)	511 (20.12)
(103) — (104)	354 (13.94)
(80) RH — (80) LH	926 (36.46)
(81) RH — (81) LH	840 (33.07)
(82) RH — (82) LH	746 (29.37)
(83) RH — (83) LH	968 (38.11)
(84) RH — (84) LH	756 (29.76)
(87) RH — (87) LH	1,382 (54.41)
(87) — (91)	510 (20.08)
(88) RH — (88) LH	800 (31.50)
(89) RH — (89) LH	(4AT, MT) 529 (20.83) (5AT) 433 (17.05)
(90) RH — (90) LH	396 (15.59)
(91) RH — (91) LH	1,382 (54.41)
(91) — (96)	510 (20.08)
(92) RH — (92) LH	796 (31.34)
(93) RH — (93) LH	200 (7.87)

Measurement point	Datum dimension mm (in)
(94) RH — (94) LH	343 (13.50)
(95) RH — (95) LH	796 (31.34)
(96) RH — (96) LH	1,382 (54.51)
(97) RH — (97) LH	1,200 (47.24)
(98) RH — (98) LH	1,163 (45.49)
(99) RH — (99) LH	1,115 (43.90)
(100) RH — (100) LH	930 (36.61)
(101) RH — (101) LH	856 (33.70)
(102) RH — (102) LH	970 (38.19)
(103) RH — (103) LH	836 (32.91)
(104) RH — (104) LH	814 (32.05)
(85)	Height 86 (3.39), Width 620 (24.41)
(86)	Height 117 (4.61), Width 600 (23.62)

Measurement point	Datum dimension/projected reference dimensions mm (in)
(80) RH — (82) LH	1,135 (44.68)/1,128 (44.41)
(80) LH — (81) RH	973 (38.31)/973 (38.31)
(81) RH — (82) LH	877 (34.53)/867 (34.13)
(82) LH — (88) LH	894 (35.20)/889 (35.00)
(88) RH — (92) LH	943 (37.13)/943 (37.13)
(88) RH — (95) LH	1,251 (49.25)/1,251 (49.25)
(92) LH — (98) RH	1,325 (52.17)/1,321 (52.01)
(95) LH — (98) RH	1,072 (42.20)/1,069 (42.09)
(98) RH — (100) LH	1,101 (43.35)/1,097 (43.19)
(98) RH — (102) LH	1,335 (52.56)/1,325 (52.17)
(100) LH — (104) RH	1,305 (51.38)/1,303 (51.30)
(102) LH — (104) RH	1,028 (40.47)/1,028 (40.47)

# Body Reference Points



## CAUTION:

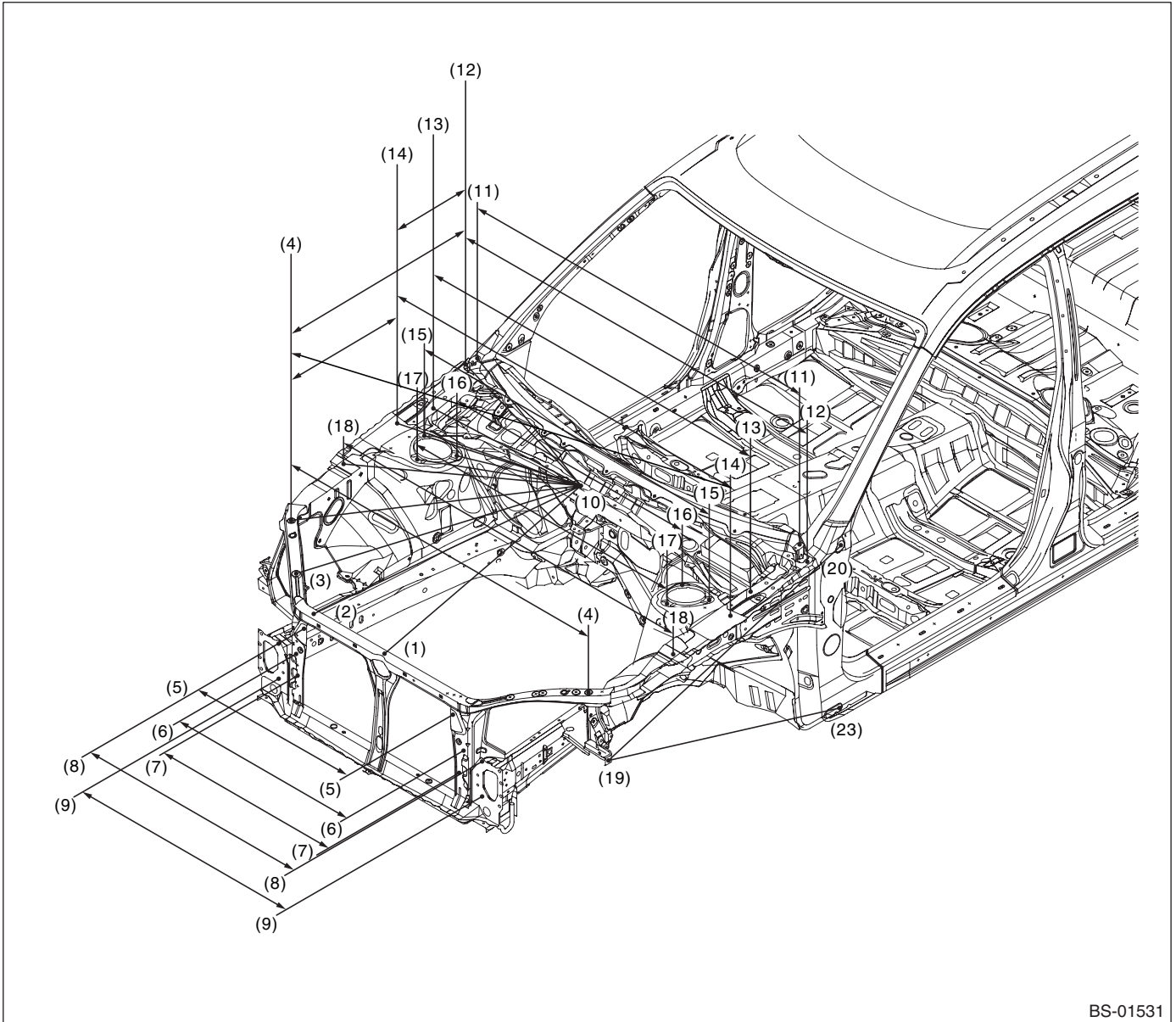
For reference point (17) strut mount mounting hole (symmetrical), refer to the "Body Reference Points". (Refer to the figure "FRONT STRUCTURE, DIMENSIONS, Body Reference Points" on page 51.)

For reference point (55) rear suspension mounting hole (symmetrical), refer to the "Body Reference Points". (Refer to the figure "INSIDE, DIMENSIONS, Body Reference Points" on page 54.)

# Body Reference Points

## 2. FRONT STRUCTURE

- Common for wagon, sedan



BS-01531

- |   |  |   |
|---|--|---|
| (1) Repair locator hole (body center)                 | (9) Bumper beam mounting hole (symmetrical), lower         | (16) Strut mount mounting hole (symmetrical), rear inside |
| (2) Radiator mounting hole                            | (10) Cowl panel mounting hole (body center)                | (17) Strut mount mounting hole (symmetrical), front       |
| (3) Headlight mounting hole (symmetrical)             | (11) Fender mounting hole (symmetrical)                    | (18) Fender mounting hole (symmetrical)                   |
| (4) Reinforcement fender mounting hole (symmetrical)  | (12) Locator hole (symmetrical)                            | (19) Fender mounting hole (symmetrical)                   |
| (5) A/C condenser mounting hole (symmetrical)         | (13) Hood hinge mounting hole (symmetrical), front         | (20) Fender mounting hole (symmetrical)                   |
| (6) Beam corner side mounting hole (symmetrical)      | (14) Fender extension mounting hole (symmetrical)          | (23) Fender mounting hole (symmetrical)                   |
| (7) Heat insulation cover mounting hole (symmetrical) | (15) Strut mount mounting hole (symmetrical), rear outside |   |
| (8) Bumper beam mounting hole (symmetrical), upper    |  |   |

## Body Reference Points

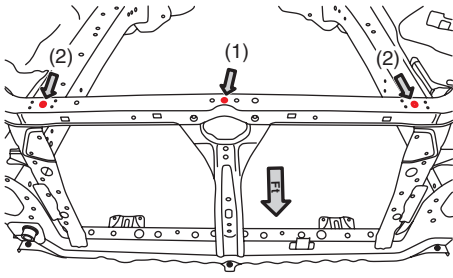
---

Measurement point	Datum dimension mm (in)
(1) — (10)	893 (35.16)
(2) — (10)	948 (37.32)
(3) — (10)	934 (36.77)
(4) — (10)	918 (36.14)
(4) — (4)	1,314 (51.73)
(4) — (12)	882 (34.72)
(4) — (14)	557 (21.93)
(4) RH — (14) LH	1,498 (58.98)
(4) LH — (14) RH	1,498 (58.98)
(5) — (5)	658 (25.91)
(6) — (6)	740 (29.13)
(7) — (7)	700 (27.56)
(8) — (8)	900 (35.43)
(9) — (9)	900 (35.43)
(10) — (11)	755 (29.72)
(10) — (12)	794 (31.26)
(10) — (13)	707 (27.83)
(10) — (14)	745 (29.33)
(10) — (15)	639 (25.16)
(10) — (16)	512 (20.16)
(10) — (17)	585 (23.03)
(10) — (18)	804 (31.65)
(11) — (11)	1,422 (55.98)
(12) — (12)	1,508 (59.37)
(12) — (14)	326 (12.83)
(13) — (13)	1,402 (55.20)
(14) — (14)	1,472 (57.95)
(15) — (15)	1,258 (49.53)
(16) — (16)	995 (39.17)
(17) — (17)	1,104 (43.46)
(18) — (18)	1,456 (57.32)
(19) — (20)	1,064 (41.89)
(19) — (23)	1,035 (40.75)

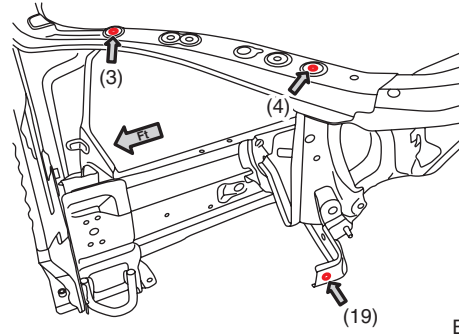
**NOTE:**

- The reference points (1) and (10) are at the body center, while the other points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

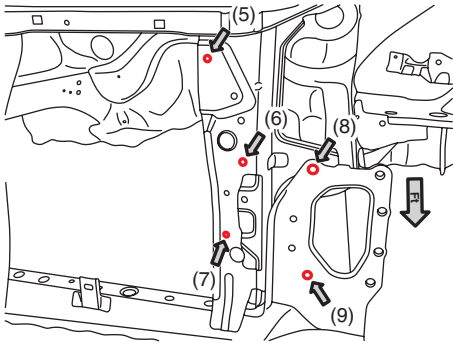
# Body Reference Points



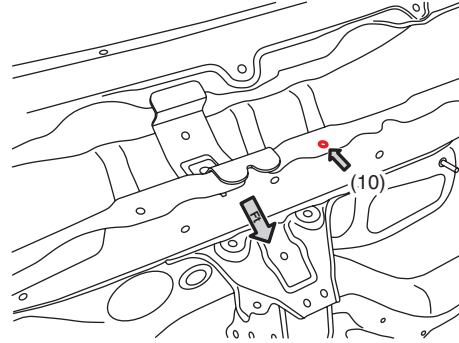
BS-02534



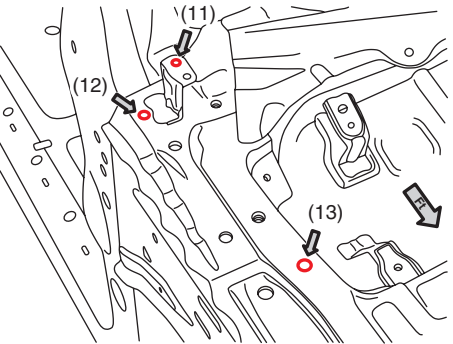
BS-02535



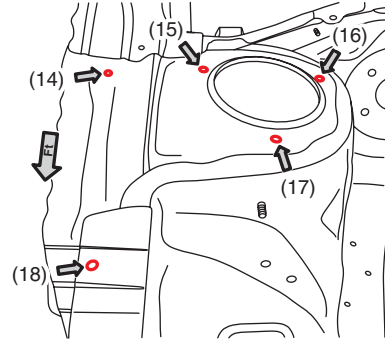
BS-02536



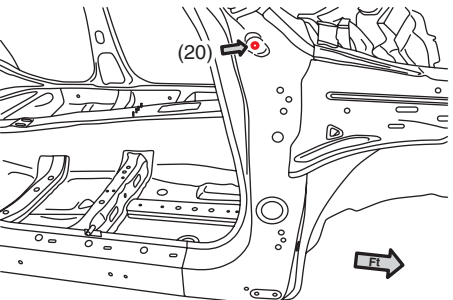
BS-02537



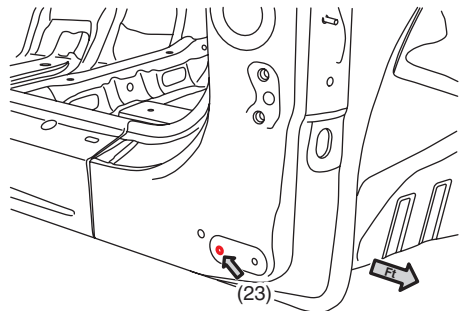
BS-02538



BS-02539



BS-02540

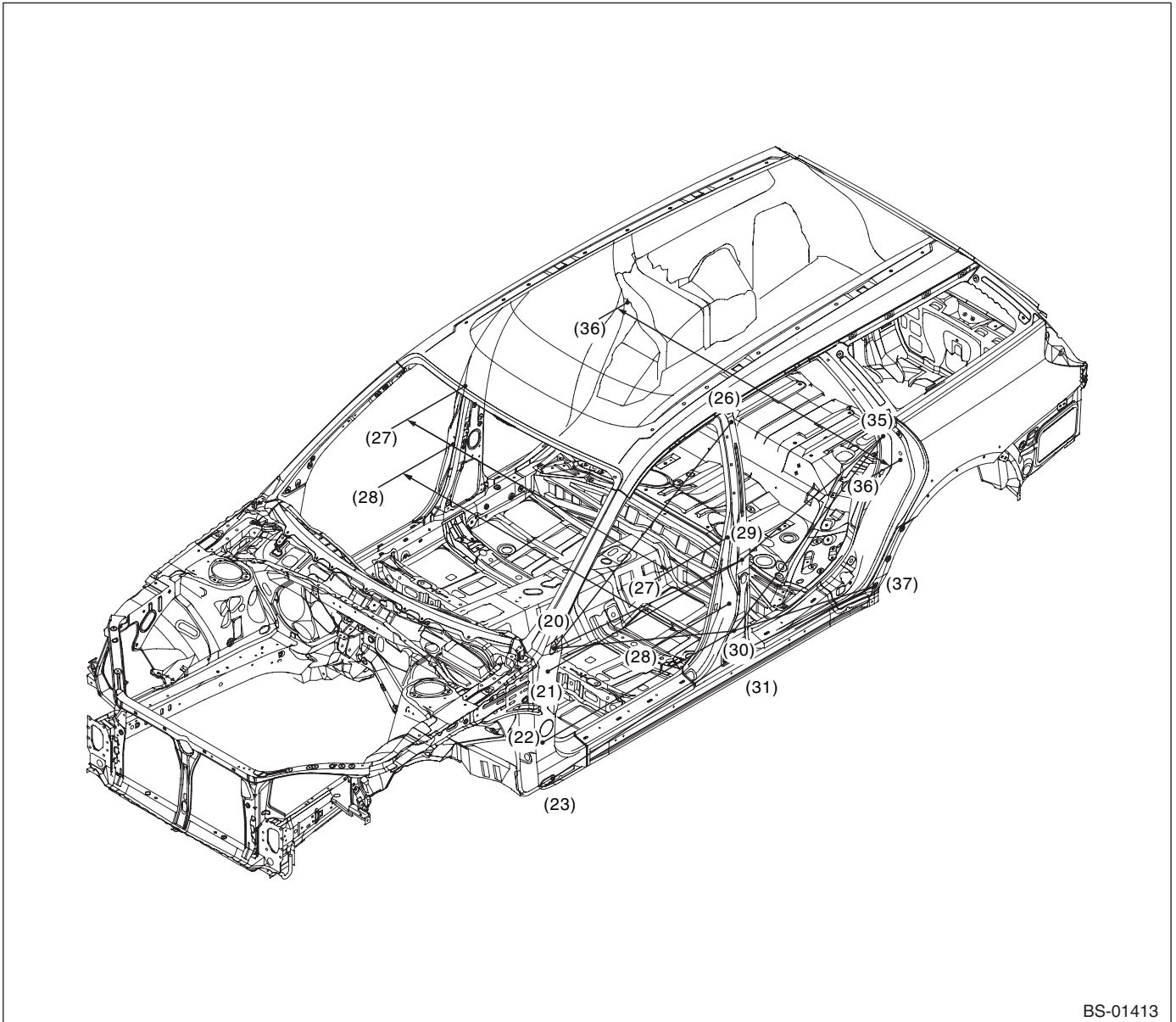


BS-02541

# Body Reference Points

## 3. INSIDE

- Common for wagon and sedan, 1



BS-01413

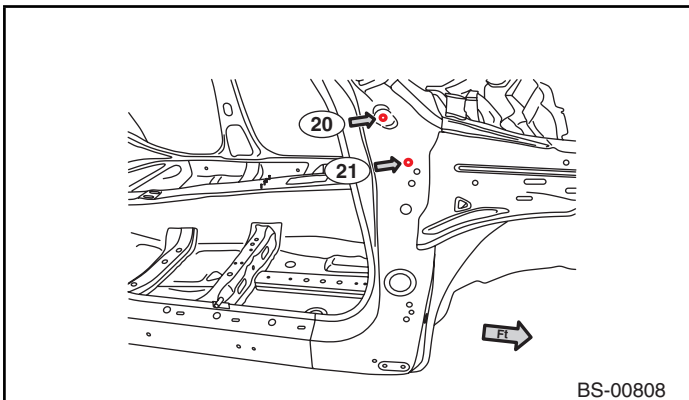
- |   |  |  |
|---|--|--|
| (20) Fender mounting hole (symmetrical)                             | (27) Weatherstrip mounting hole (symmetrical)          | (31) Gauge hole (symmetrical)                      |
| (21) Front door hinge upper mounting hole (symmetrical), upper side | (28) Front door striker mounting hole (symmetrical)    | (35) Weatherstrip mounting hole (symmetrical)      |
| (22) Front door hinge lower mounting hole (symmetrical), upper side | (29) Rear door hinge upper mounting hole (symmetrical) | (36) Rear door striker mounting hole (symmetrical) |
| (23) Fender mounting hole (symmetrical)                             | (30) Rear door hinge lower mounting hole (symmetrical) | (37) Protector mounting hole (symmetrical)         |
| (26) Gauge hole (symmetrical)                                       |  |  |

# Body Reference Points

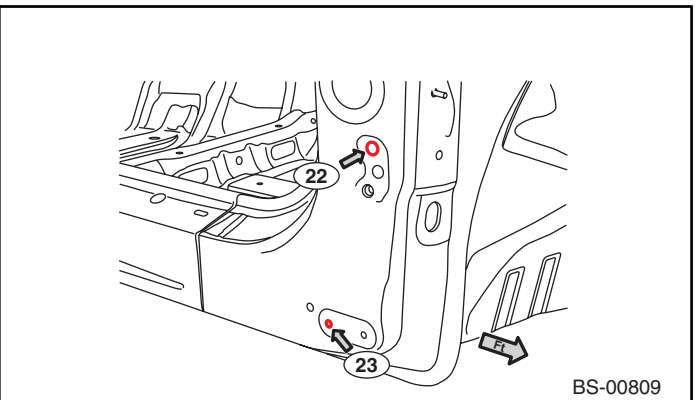
Measurement point	Datum dimension mm (in)
(20) — (26)	1,232 (48.50)
(20) — (29)	1,034 (40.71)
(20) — (30)	1,066 (41.97)
(21) — (29)	1,080 (42.52)
(22) — (30)	1,055 (41.54)
(23) — (31)	1,070 (42.13)
(27) — (27)	1,448 (57.01)
(28) — (28)	1,523 (59.96)
(29) — (35)	863 (33.98)
(30) — (35)	1,002 (39.45)
(30) — (37)	753 (29.65)
(31) — (37)	679 (26.73)
(36) — (36)	1,506 (59.29)

**NOTE:**

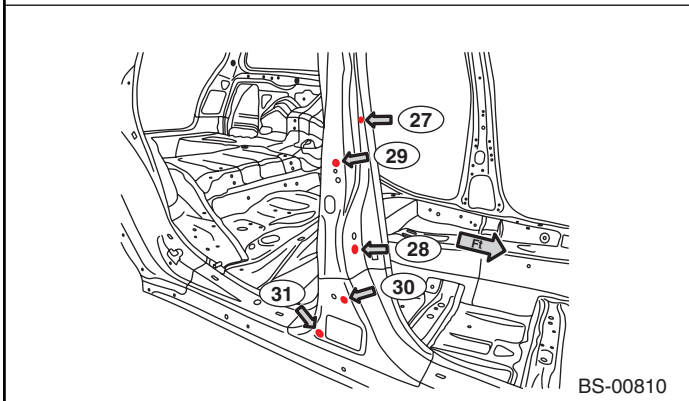
- All reference points are left-right symmetrical.
- The dimensions between the reference points are the actual dimensions.



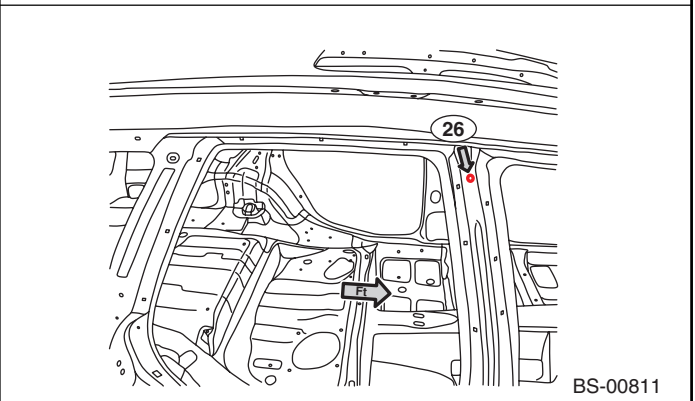
BS-00808



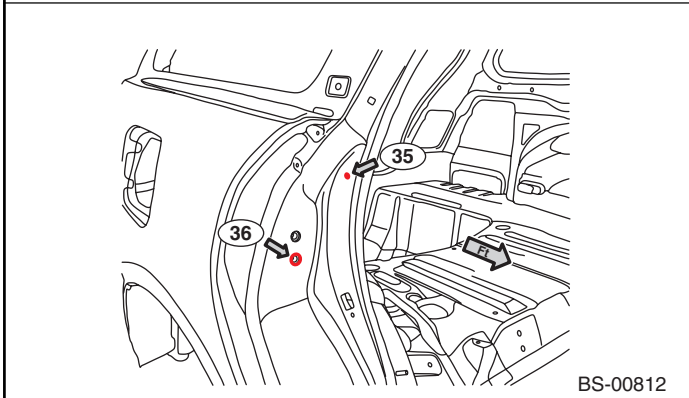
BS-00809



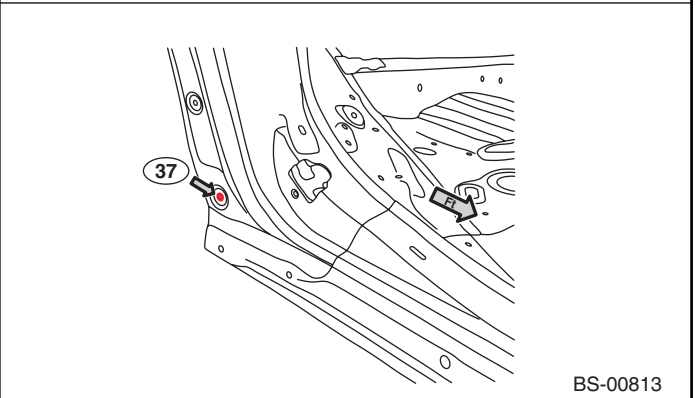
BS-00810



BS-00811



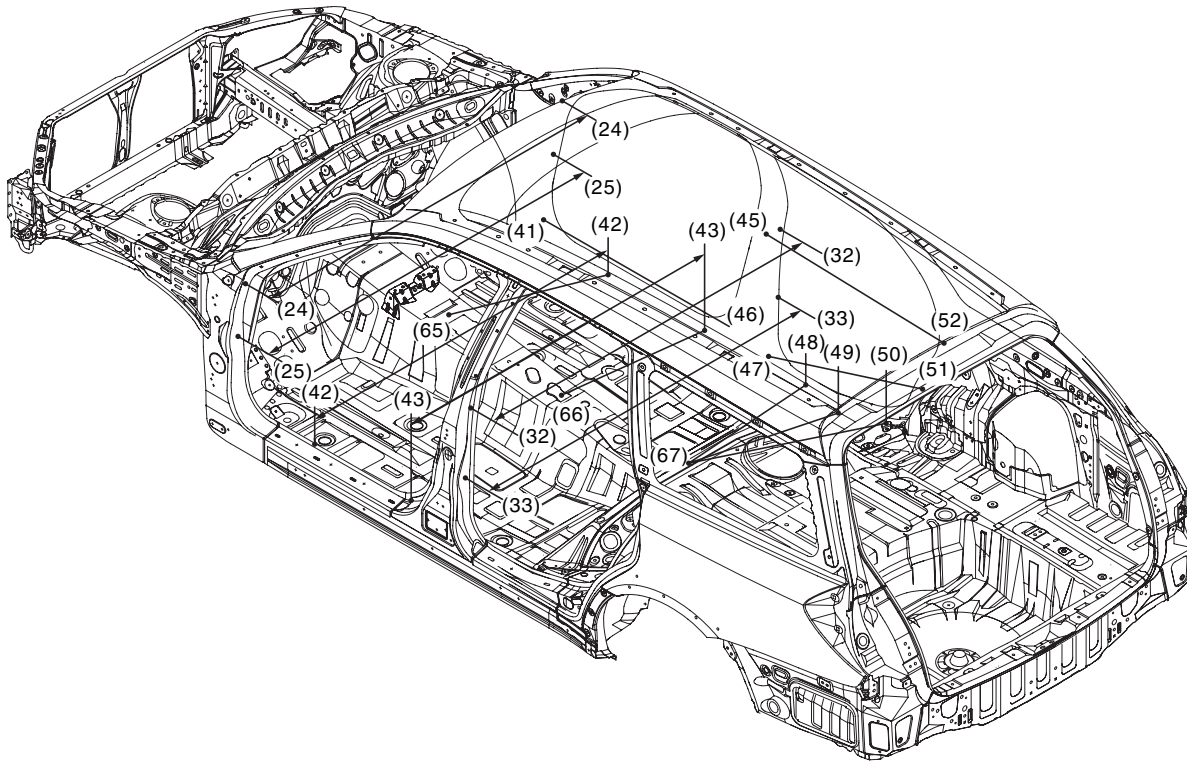
BS-00812



BS-00813

## Body Reference Points

- Common for wagon and sedan, 2



BS-01414

- |   |   |  |
|---|---|--|
| (24) Weatherstrip mounting hole (symmetrical)       | (43) Harness clip mounting hole (symmetrical) | (50) Side sill cover mounting hole (symmetrical)                       |
| (25) Front door checker mounting hole (symmetrical) | (45) Trim clip mounting hole (symmetrical)    | (51) Gauge hole (symmetrical)<br>Trim clip mounting hole (symmetrical) |
| (32) Weatherstrip mounting hole (symmetrical)       | (46) Trim clip mounting hole (symmetrical)    | (52) (symmetrical)   |
| (33) Rear door checker mounting hole (symmetrical)  | (47) Harness clip mounting hole (symmetrical) | (65) Airbag unit mounting hole (body center)                           |
| (41) Side sill cover mounting hole (symmetrical)    | (48) Harness clip mounting hole (symmetrical) | (66) Hand brake mounting hole (body center)                            |
| (42) Harness clip mounting hole (symmetrical)       |   | (67) Floor mat mounting hole (body center)                             |



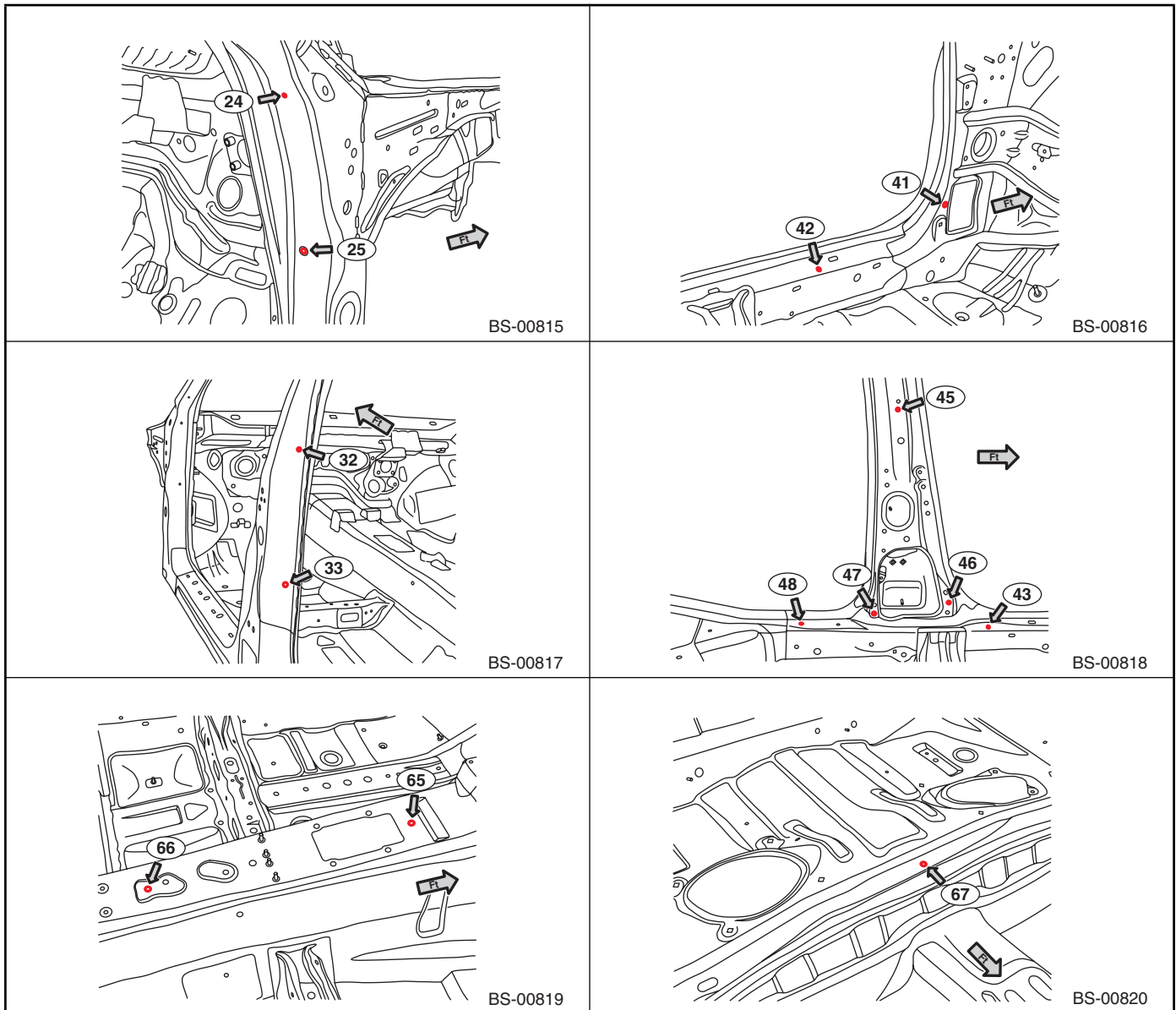
# Body Reference Points

Unit: mm

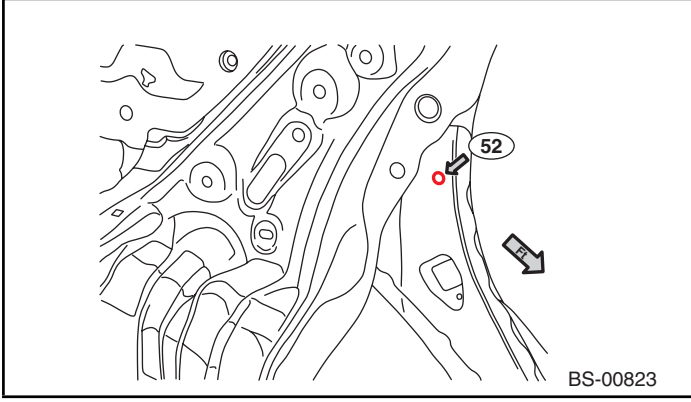
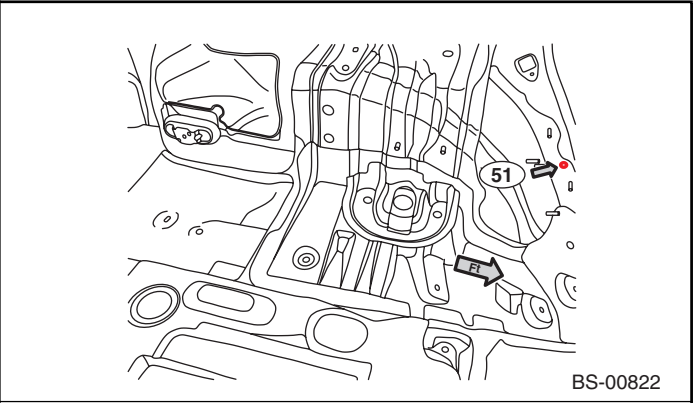
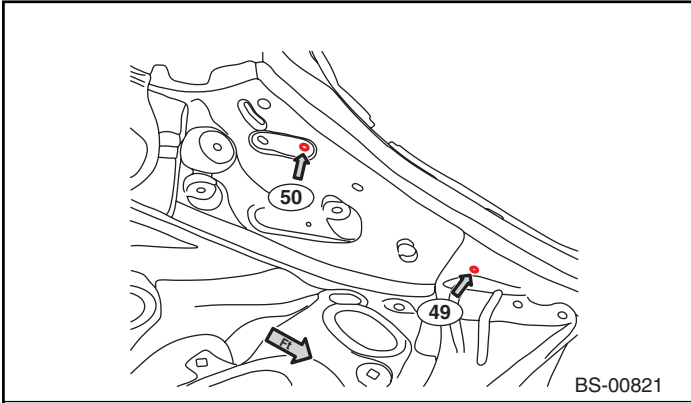
Measurement point	Datum dimension	Measurement point	Datum dimension
24 — 24	1482	43 — 43	1373
25 — 25	1476	43 — 66	693
32 — 32	1448	45 — 52	838
33 — 33	1464	47 — 51	740
41 — 46	863	48 — 67	711
42 — 42	1373	49 — 67	649
42 — 65	706	50 — 67	704

**NOTE:**

- The reference points 65, 66 and 67 are at the body center, while the other points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

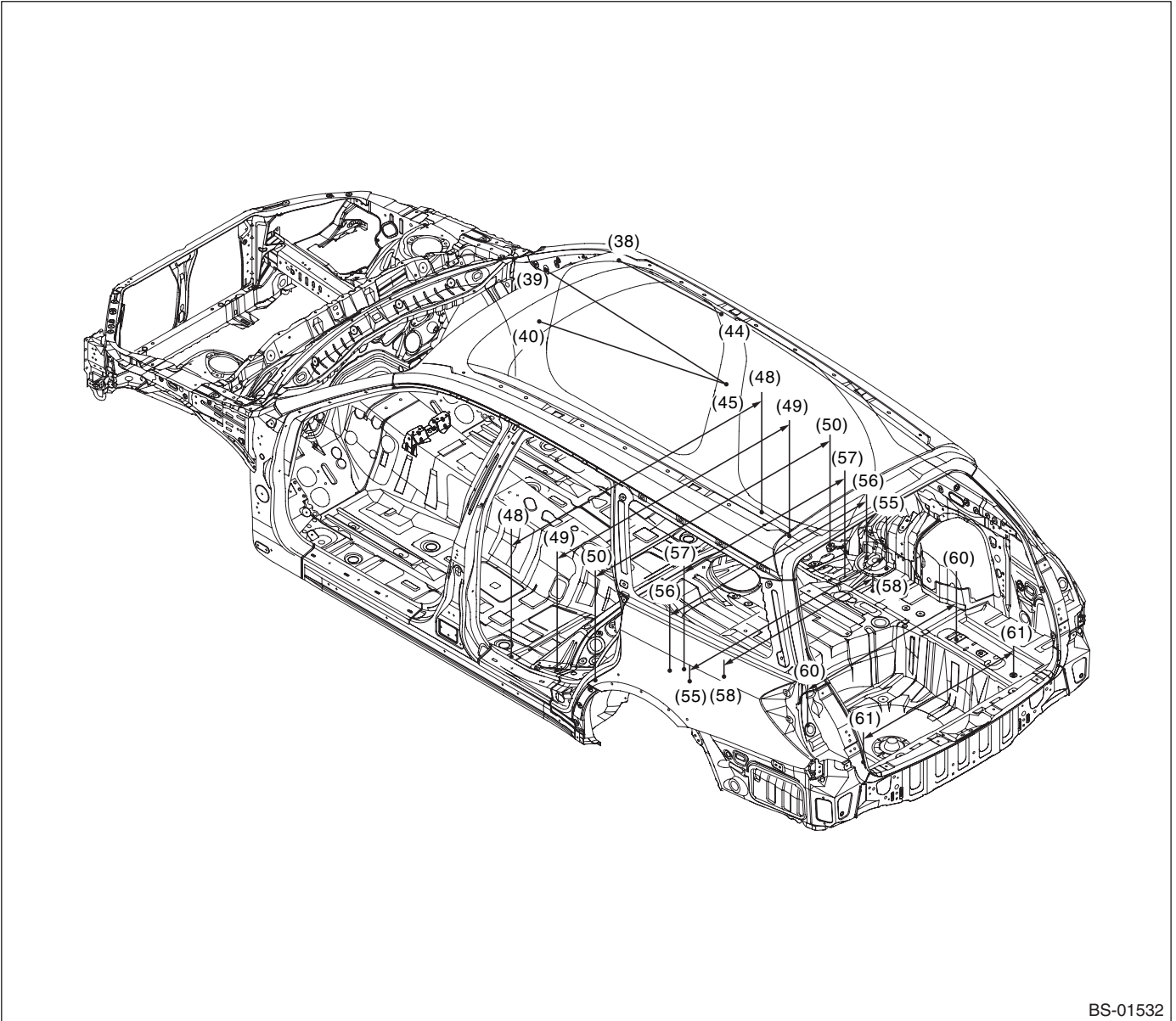


# Body Reference Points



# Body Reference Points

- Common for wagon and sedan, 3



BS-01532

- |   |  |   |
|---|--|---|
| (38) Trim clip mounting hole (symmetrical)        | (48) Harness clip mounting hole (symmetrical)          | (56) Rear suspension mounting hole (symmetrical), front |
| (39) ED hole (symmetrical)                        | (49) Harness clip mounting hole (symmetrical)          | (57) Rear seat hinge mounting hole (symmetrical)        |
| (40) Hood lock lever area stop hole (symmetrical) | (50) Side sill cover mounting hole (symmetrical)       | (58) Gauge hole (symmetrical)                           |
| (44) Trim clip mounting hole (symmetrical)        | (55) Rear suspension mounting hole (symmetrical), rear | (60) Gauge hole (symmetrical)                           |
| (45) Trim clip mounting hole (symmetrical)        |  | (61) Gauge hole (symmetrical)                           |

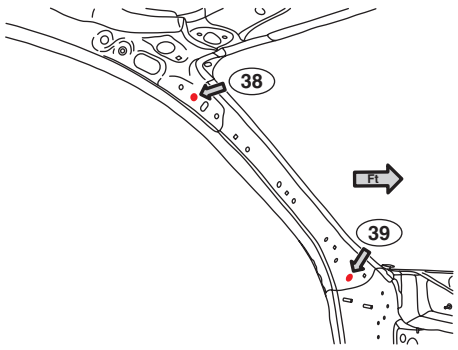
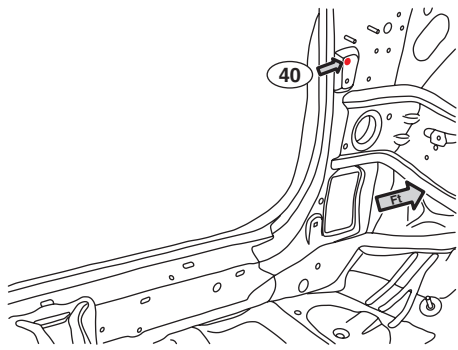
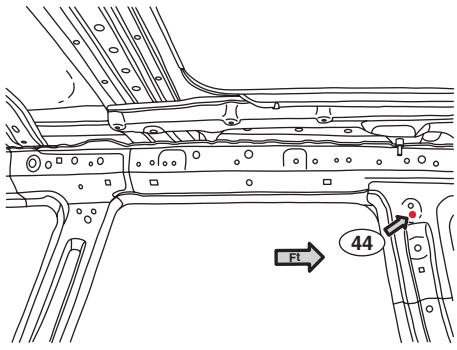
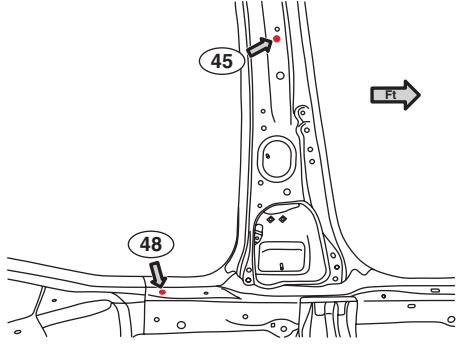
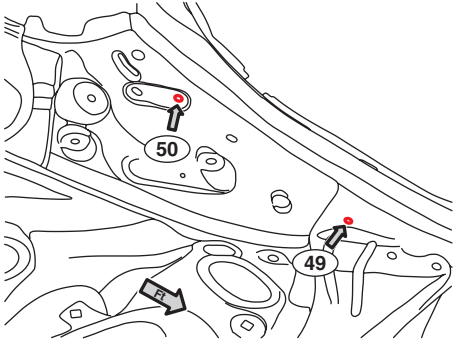
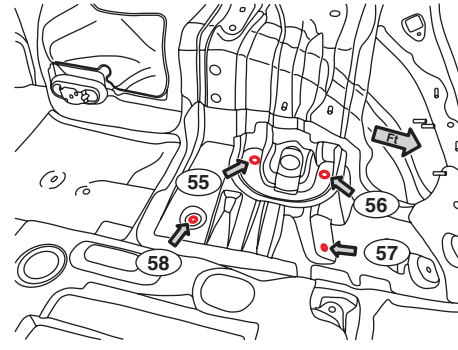
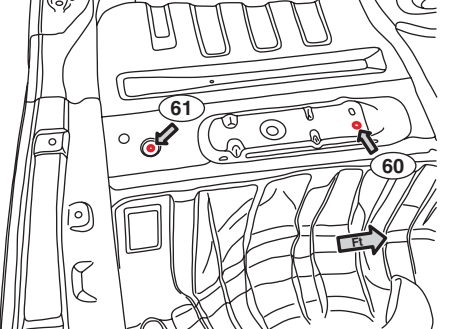
Measurement point	Datum dimension mm (in)
(38) — (44)	586 (23.07)
(39) — (45)	993 (39.09)
(40) — (45)	1,043 (41.06)
(48) — (48)	1,380 (54.33)
(49) — (49)	1,280 (50.39)
(50) — (50)	1,294 (50.94)

Measurement point	Datum dimension mm (in)
(55) — (55)	1,084 (42.68)
(56) — (56)	1,090 (42.91)
(57) — (57)	886 (34.88)
(58) — (58)	820 (32.28)
(60) — (60)	820 (32.28)
(61) — (61)	840 (33.07)

# Body Reference Points

## NOTE:

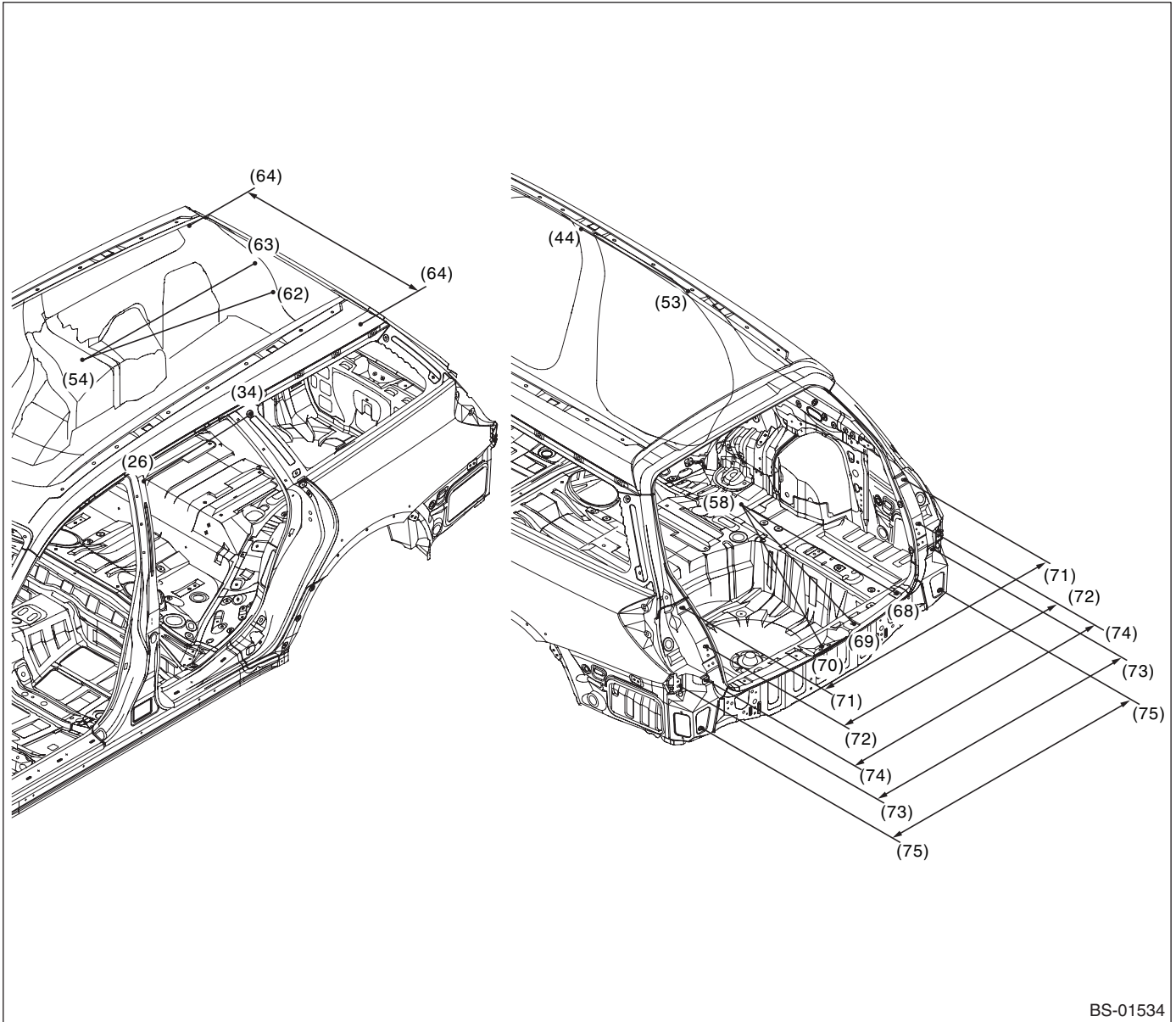
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

 <p>BS-00825</p>	 <p>BS-00826</p>
 <p>BS-00827</p>	 <p>BS-00828</p>
 <p>BS-00829</p>	 <p>BS-01521</p>
 <p>BS-00831</p>	<p style="text-align: center;">SUBARU.</p>

# Body Reference Points

## 4. REAR S906337a1404

- Wagon only



BS-01534

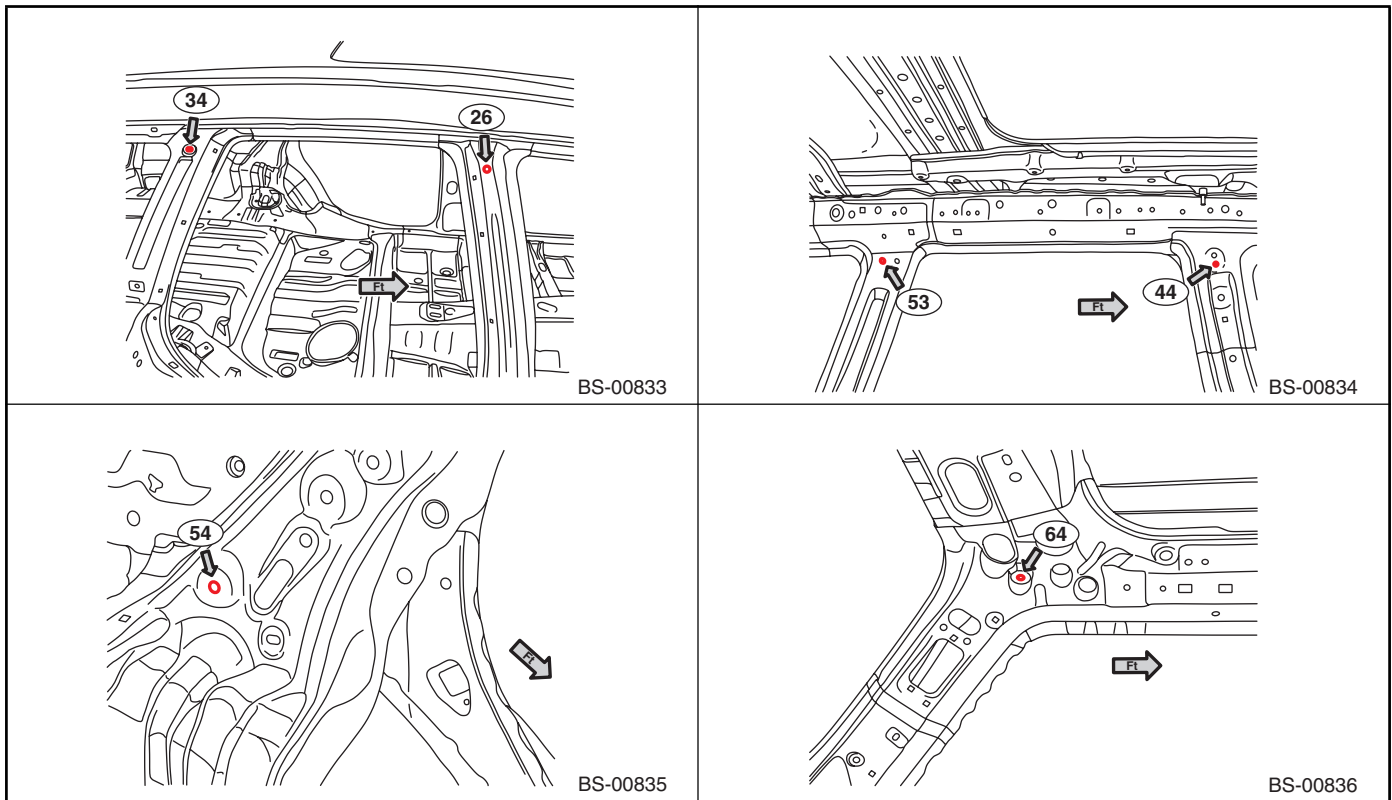
- |   |   |  |
|---|---|--|
| (26) Gauge hole (symmetrical)                       | (63) Trim clip mounting hole (symmetrical)    | (71) Combination light mounting hole (symmetrical) |
| (34) Rear quarter glass mounting hole (symmetrical) | (64) Harness clip mounting hole (symmetrical) | (72) Buffer mounting hole (symmetrical)            |
| (44) Trim clip mounting hole (symmetrical)          | (68) Trim clip mounting hole (symmetrical)    | (73) Bumper mounting hole (symmetrical)            |
| (53) Trim clip mounting hole (symmetrical)          | (69) Trim clip mounting hole (symmetrical)    | (74) Bracket corner mounting hole (symmetrical)    |
| (54) Rear seat striker mounting hole (symmetrical)  | (70) Repair locator hole (body center)        | (75) Gauge hole (symmetrical)                      |
| (58) Gauge hole (symmetrical)                       |   |  |
| (62) Trim clip mounting hole (symmetrical)          |   |  |

# Body Reference Points

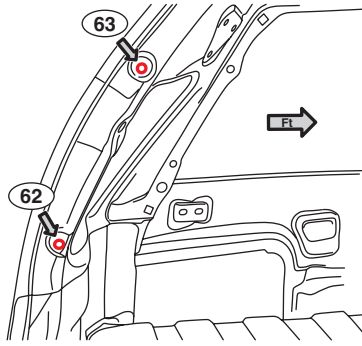
Measurement point	Datum dimension mm (in)
(26) — (34)	613 (24.13)
(44) — (53)	591 (23.27)
(54) — (62)	969 (38.15)
(54) — (63)	884 (34.80)
(58) — (68)	900 (35.43)
(58) — (69)	958 (37.72)
(58) — (70)	990 (38.98)
(64) — (64)	944 (37.17)
(71) — (71)	1,224 (48.19)
(72) — (72)	1,173 (46.18)
(73) — (73)	1,438 (56.61)
(74) — (74)	1,250 (49.21)
(75) — (75)	1,320 (59.97)

**NOTE:**

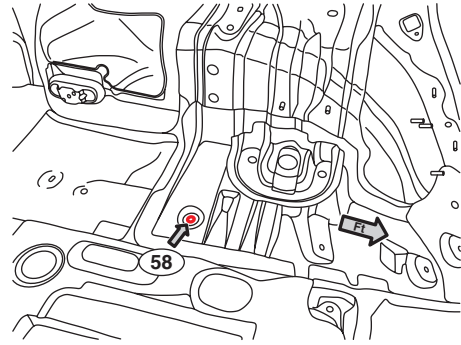
- The reference point (70) is at the body center, while the other points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



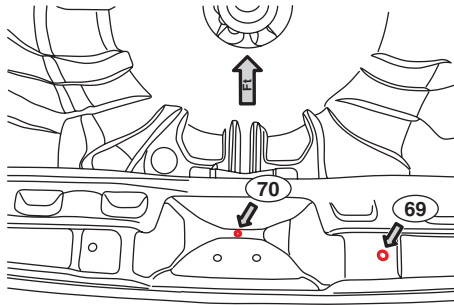
# Body Reference Points



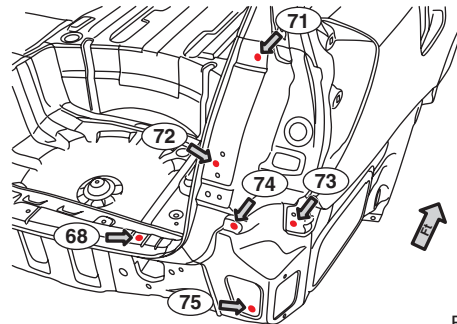
BS-00837



BS-01522



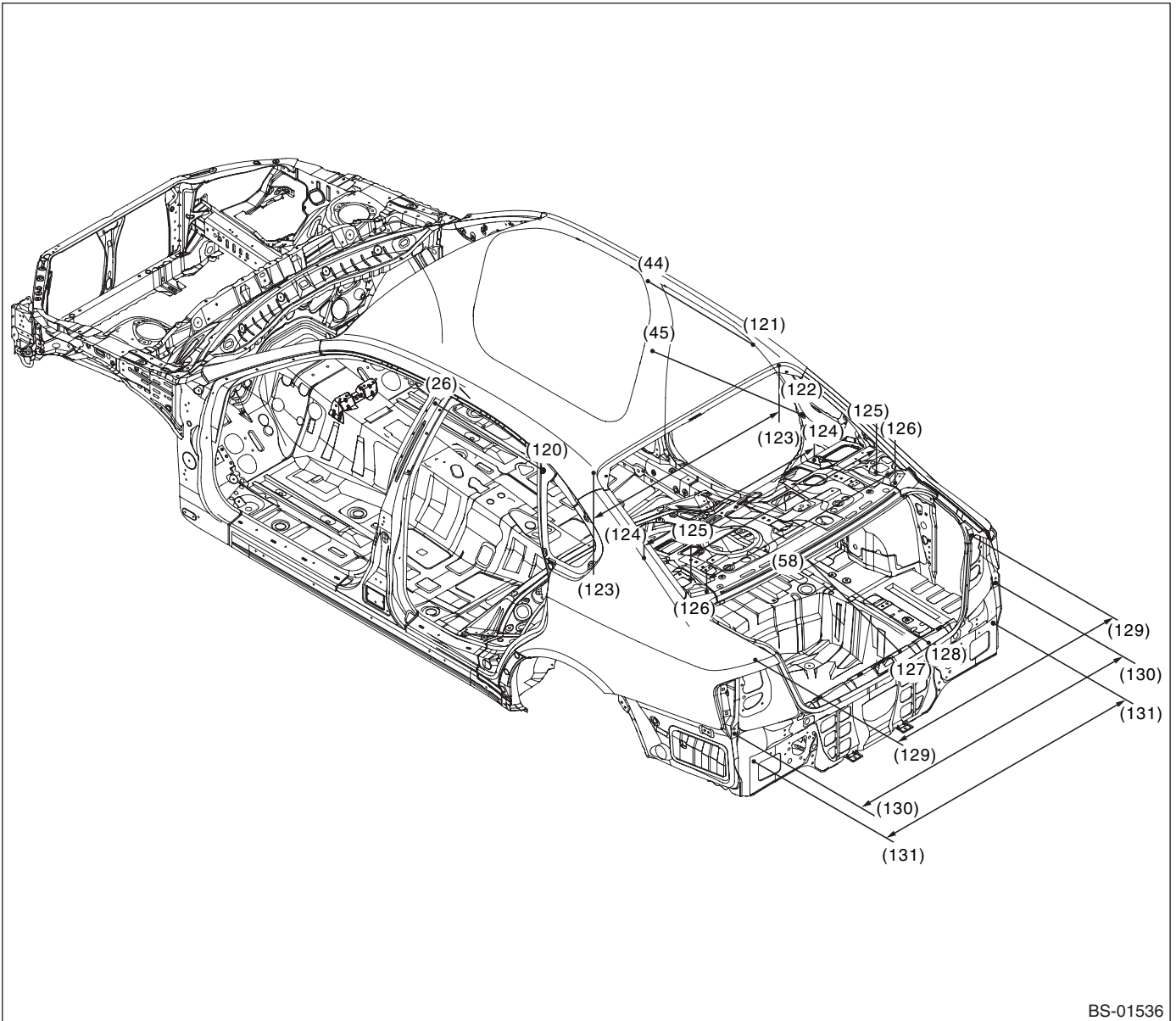
BS-00839



BS-00840

# Body Reference Points

- Sedan only



BS-01536

- |   |   |   |
|---|---|---|
| (26) Gauge hole (symmetrical)                     | (122) Trim clip mounting hole (symmetrical)               | (127) Trim clip mounting hole (symmetrical)         |
| (44) Trim clip mounting hole (symmetrical)        | (123) Sunroof drain hose clip mounting hole (symmetrical) | (128) ED hole (symmetrical)                         |
| (45) Trim clip mounting hole (symmetrical)        | (124) Trim clip mounting hole (symmetrical)               | (129) Combination light mounting hole (symmetrical) |
| (58) Gauge hole (symmetrical)                     | (125) Harness clip mounting hole (symmetrical)            | (130) Bumper bracket mounting hole (symmetrical)    |
| (120) Six light glass mounting hole (symmetrical) | (126) Gauge hole (symmetrical)                            | (131) ED hole (symmetrical)                         |
| (121) Trim clip mounting hole (symmetrical)       |   |   |

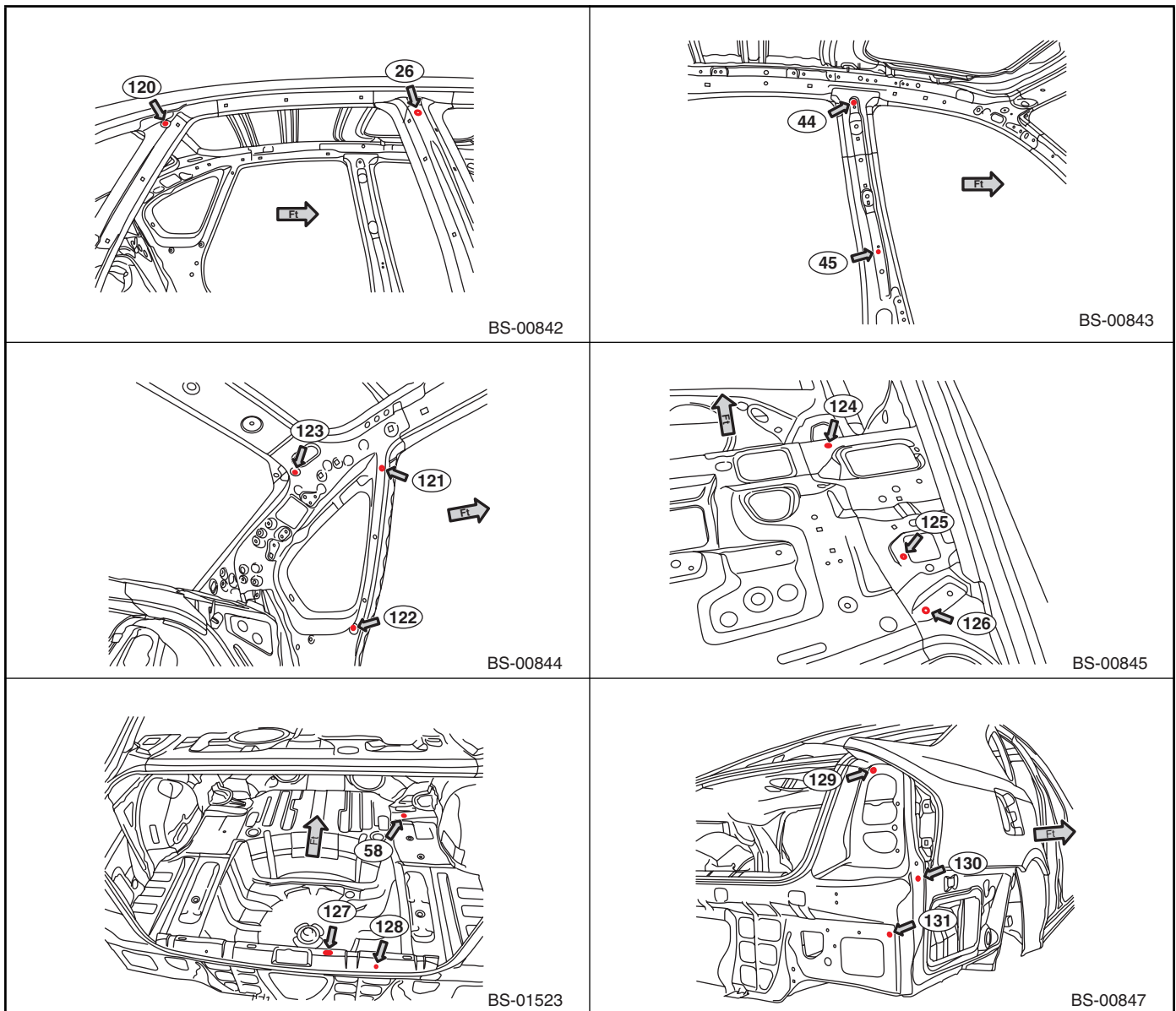


# Body Reference Points

Measurement point	Datum dimension mm (in)
(26) — (120)	598 (23.54)
(44) — (121)	570 (22.44)
(45) — (122)	835 (32.87)
(58) — (127)	904 (35.59)
(58) — (128)	916 (36.06)
(123) — (123)	1,024 (40.31)
(124) — (124)	940 (37.01)
(125) — (125)	1,024 (40.31)
(126) — (126)	1,040 (40.94)
(129) — (129)	1,191 (46.89)
(130) — (130)	1,442 (56.77)
(131) — (131)	1,322 (52.05)

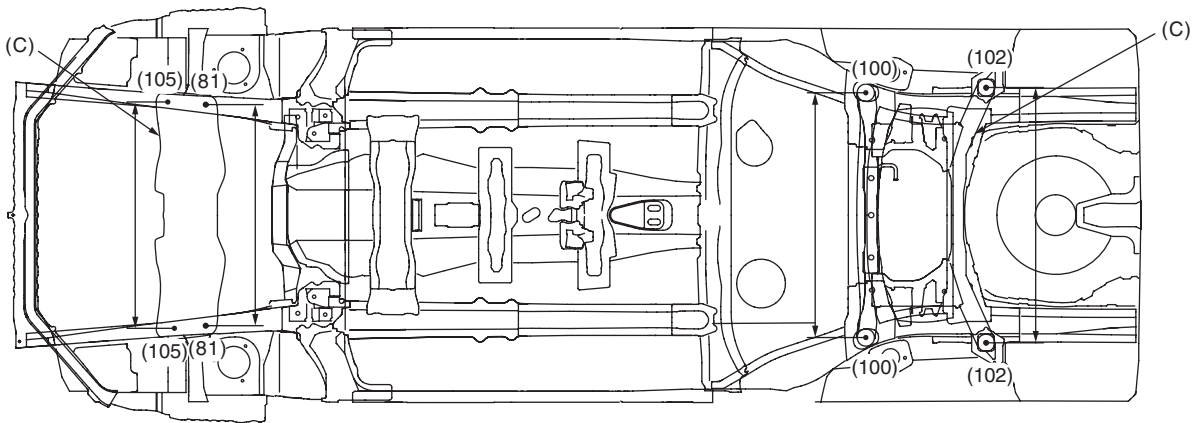
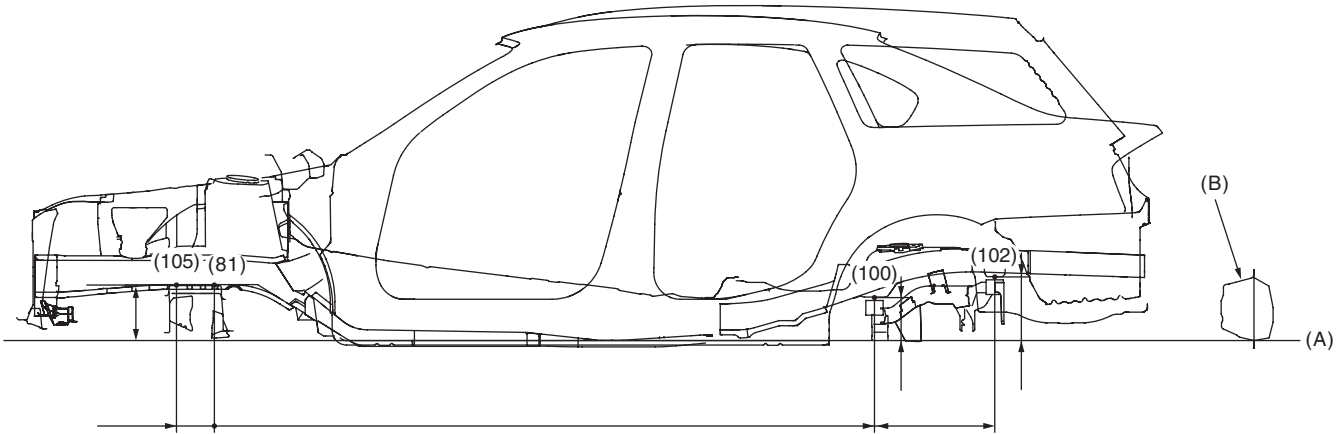
**NOTE:**

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



# Body Reference Points

## 5. SUSPENSION MOUNT



BS-01418

(A) Standard line

(B) Side sill

(C) Crossmember

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

(102) Rear suspension crossmember mounting hole (symmetrical)

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

(100) Rear suspension crossmember mounting hole (symmetrical)

## Body Reference Points

---

Measurement point	Datum dimension mm (in)
(105) — (81)	144 (5.67)
(81) — (100)	2508 (98.74)
(100) — (102)	457 (17.99)
(A) — (105)	212 (8.35)
(A) — (81)	212 (8.35)
(A) — (100)	164 (6.46)
(A) — (102)	243 (9.57)
(105) — (105)	862 (33.94)
(81) — (81)	840 (33.07)
(100) — (100)	930 (33.61)
(102) — (102)	970 (38.19)

**NOTE:**

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

**CAUTION:**

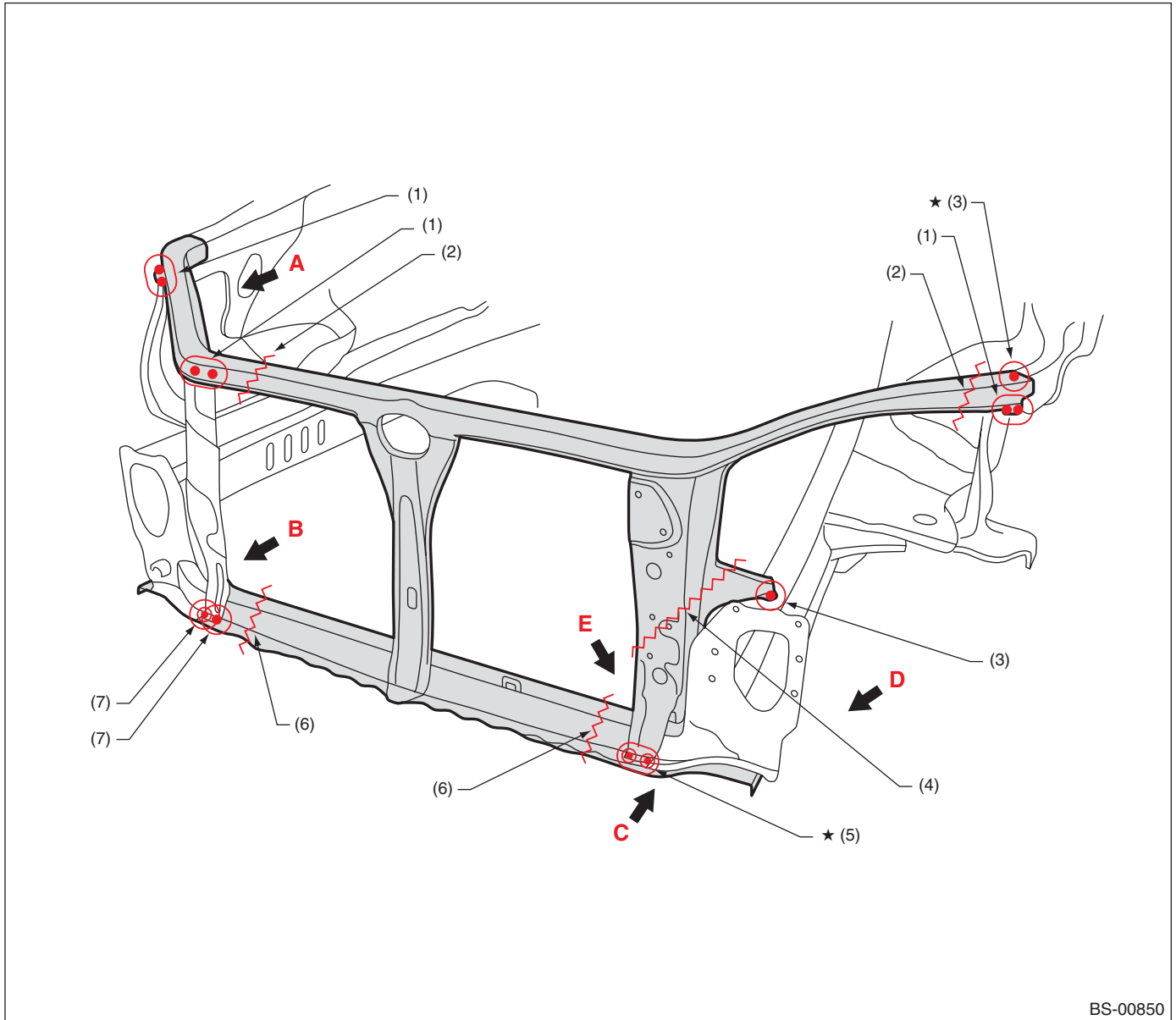
Refer to "Datum dimension" for the reference point position. (Refer to the figure "INSIDE, DIMENSIONS, Body Reference Points" on page 54.)

# Radiator Panel (total replacement)

## 13.Radiator Panel (total replacement)

### A: REMOVAL

#### • Overall view



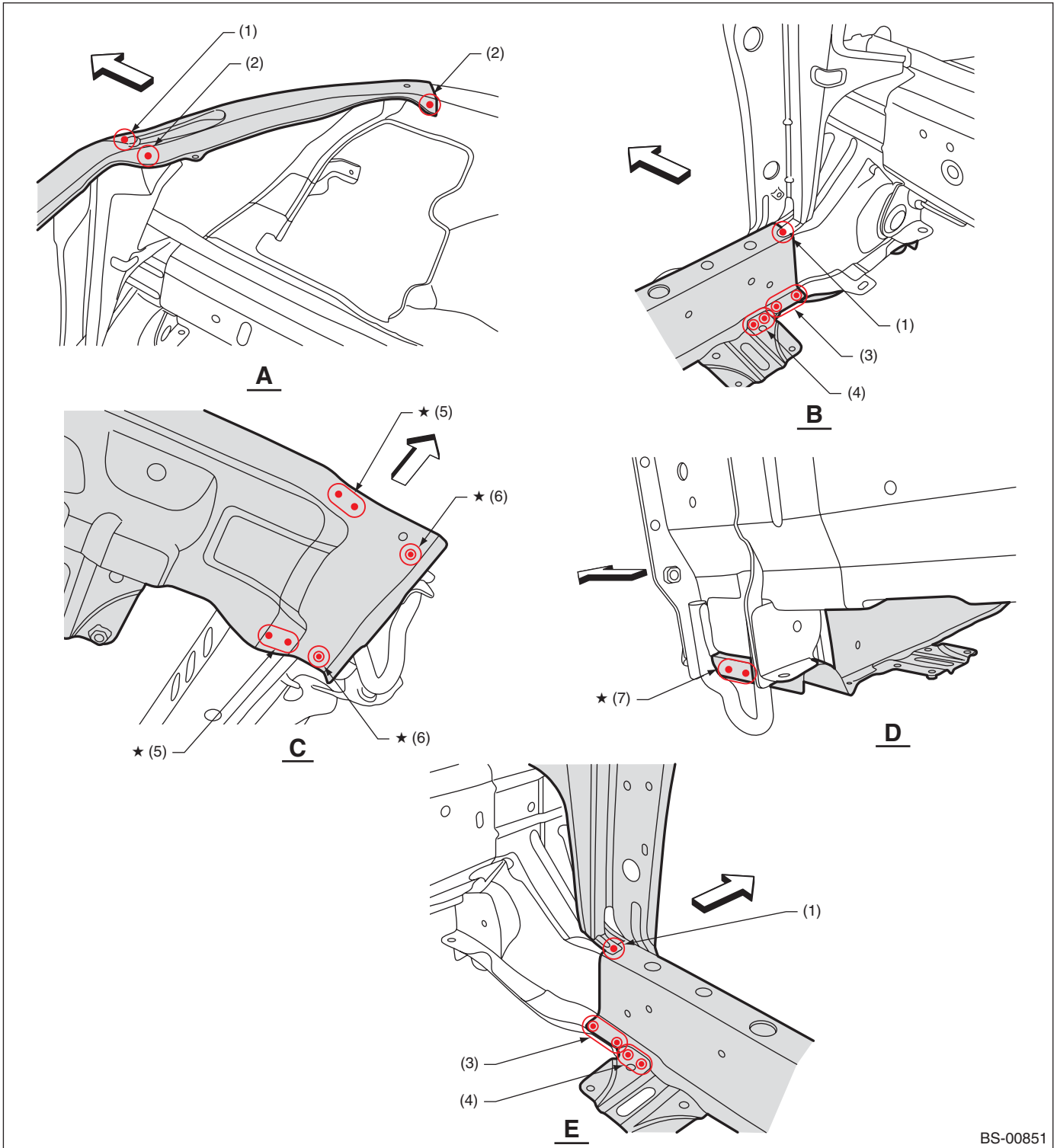
- |  |   |   |
|--|---|---|
| (1) 2 points (outside · 1)                       | (4) Rough cutting (140 mm) to make removal easier | (6) Rough cutting (190 mm) to make removal easier |
| (2) Rough cutting (80 mm) to make removal easier | (5) 2 points (top · 1, bottom · 1)                | (7) 1 point (outside · 1)                         |
| (3) 1 point (top · 1)                            |   |   |

#### NOTE:

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

# Radiator Panel (total replacement)

## • Views



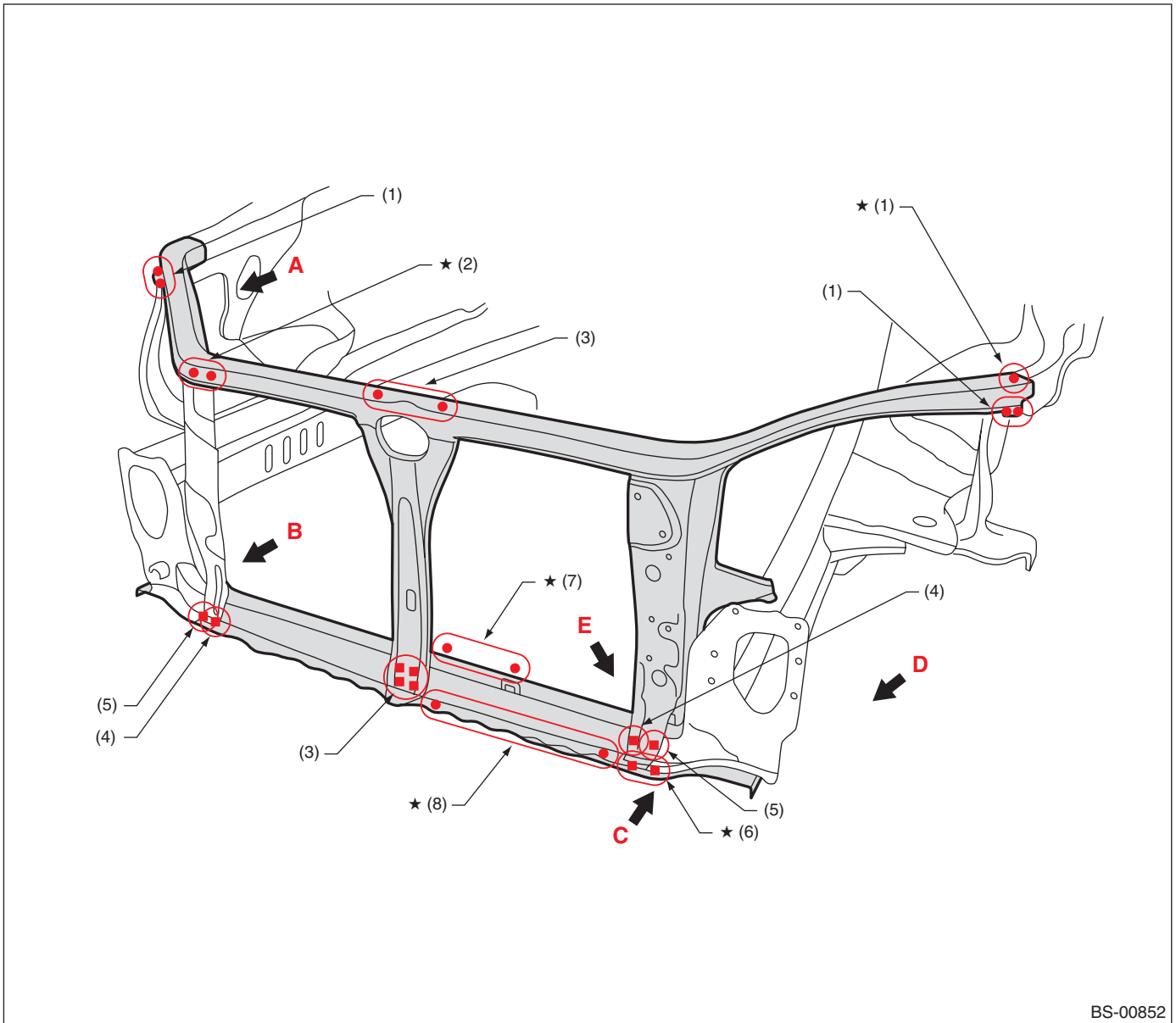
BS-00851

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

# Radiator Panel (total replacement)

## B: INSTALLATION

### • Overall view



BS-00852

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

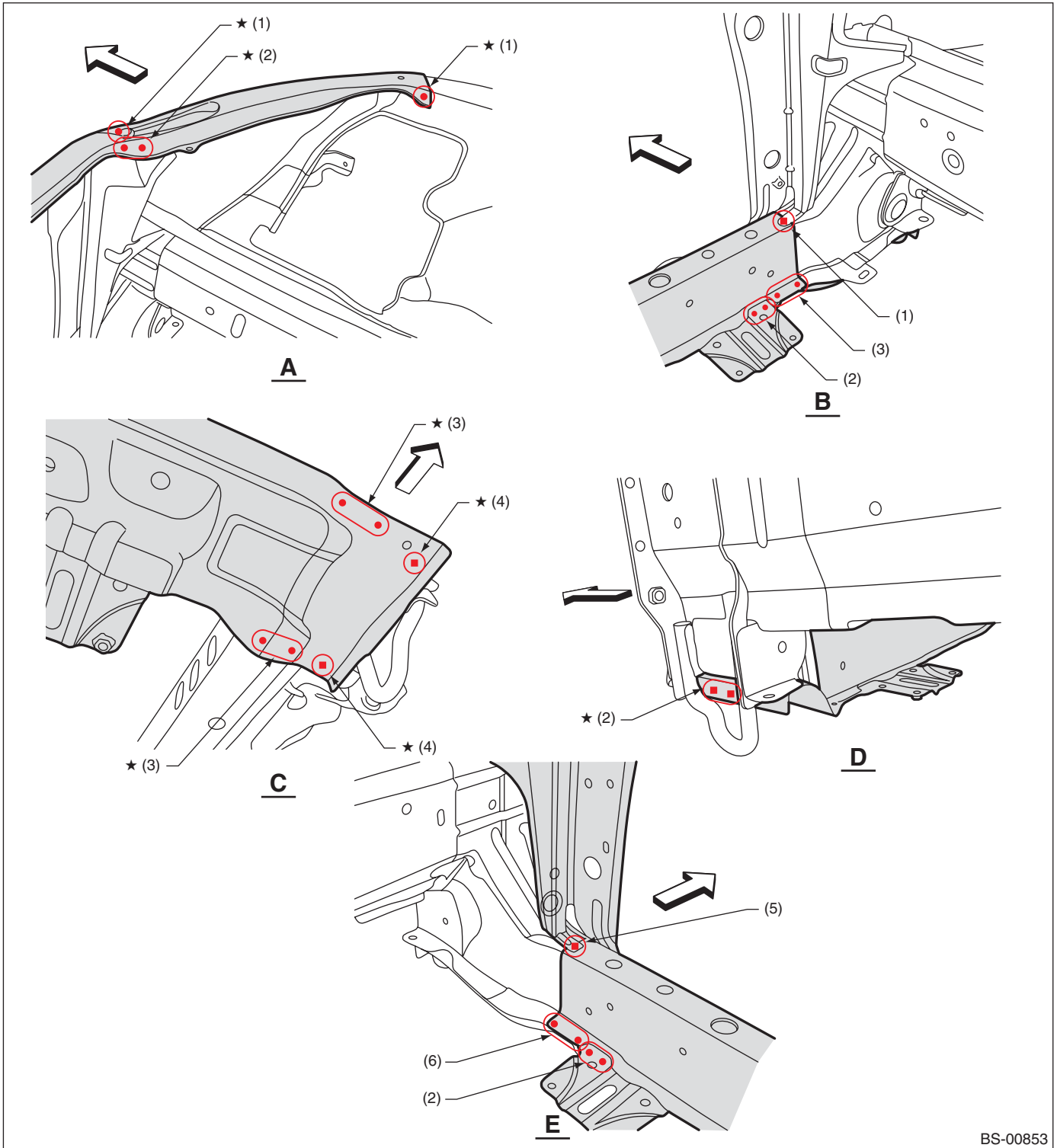
- (5) 1 point (service · matching)
- (6) 2 points (service · both surface plug)

- (7) 5 points
- (8) 10 points

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

# Radiator Panel (total replacement)

## • Views



BS-00853

(1) 1 point  
(2) 2 points

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

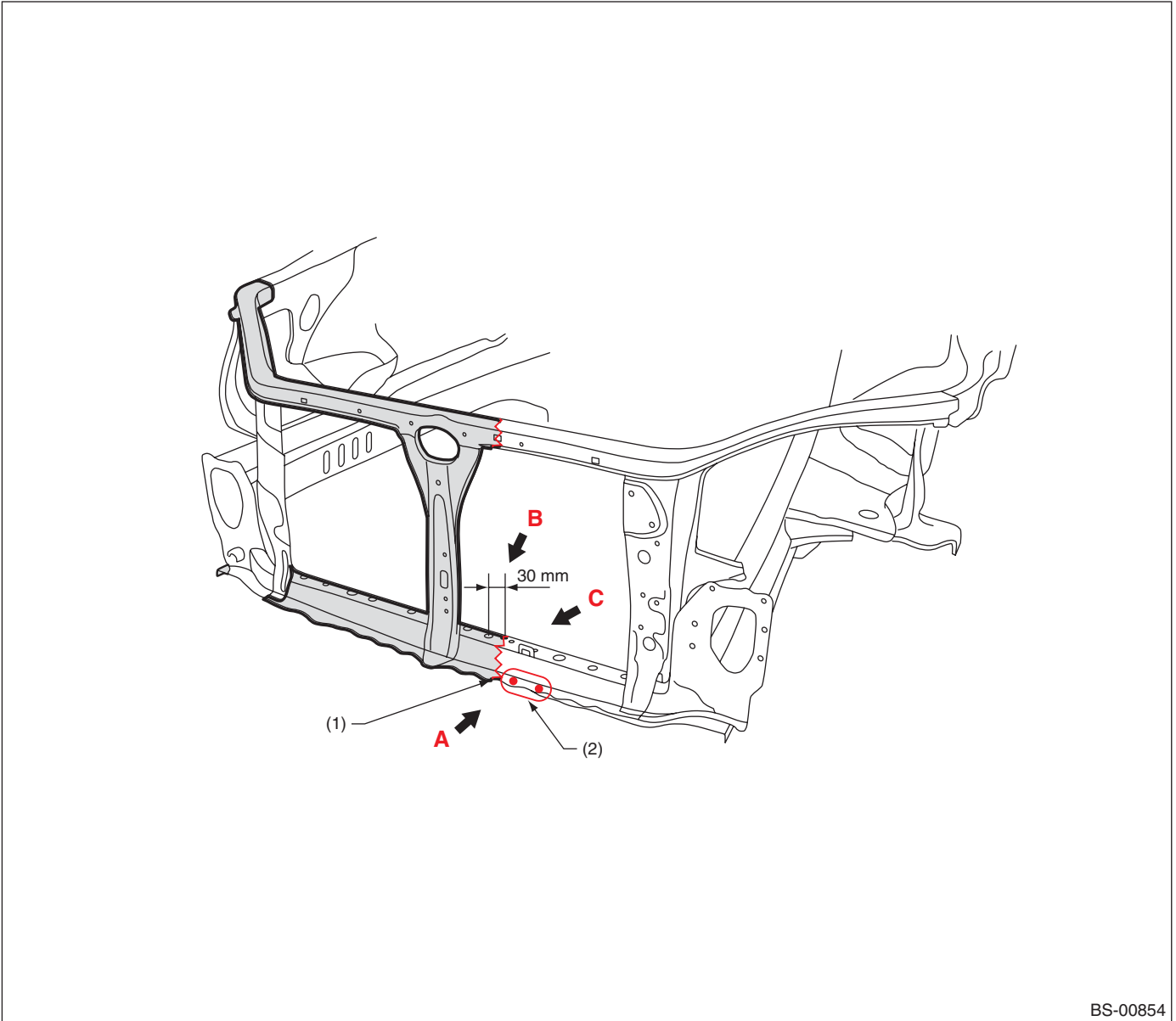
(5) 1 point (service · matching)  
(6) 4 points

# Radiator Panel (partial replacement)

## 14.Radiator Panel (partial replacement)

### A: REMOVAL

- Overall view



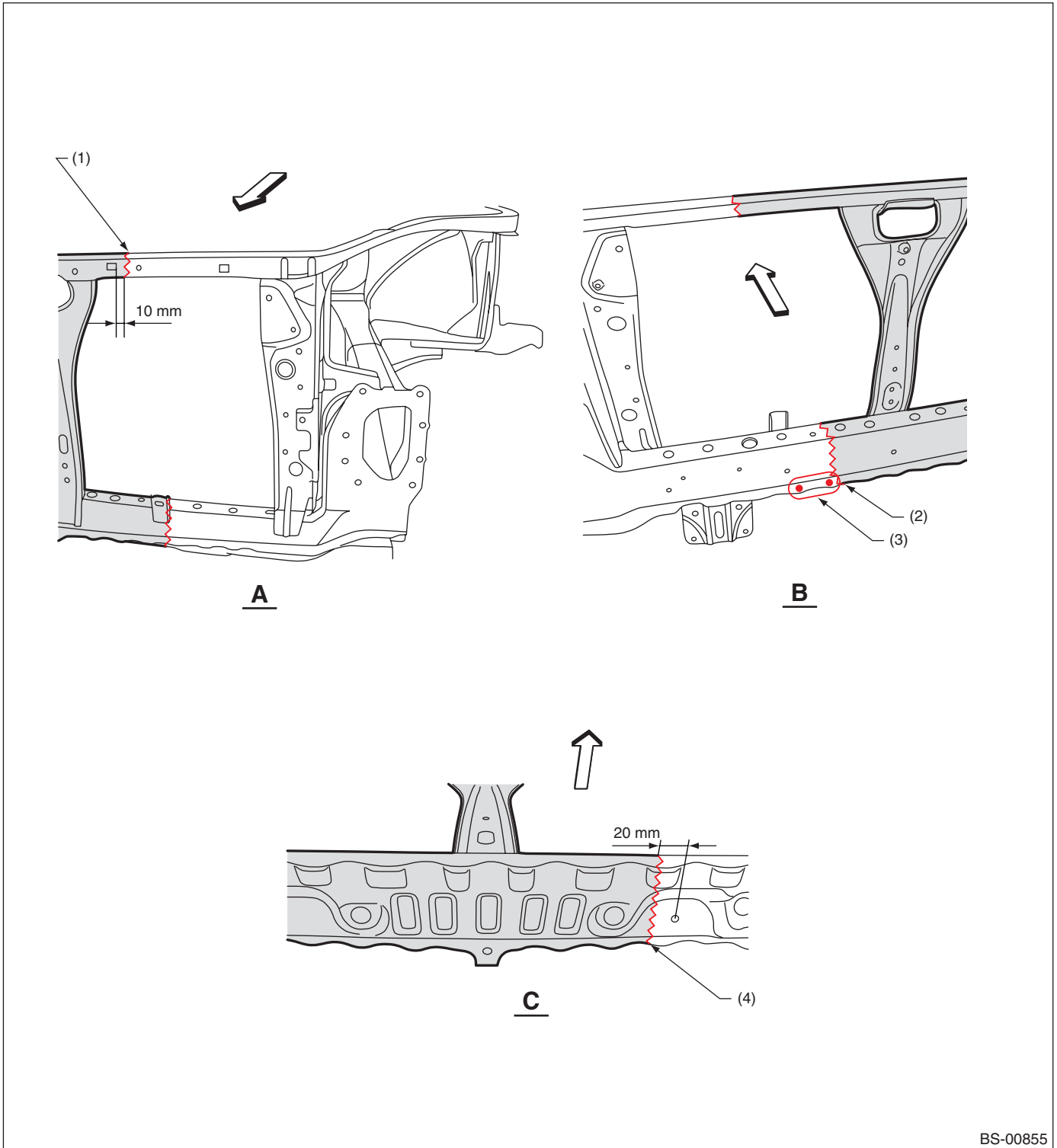
BS-00854

- (1) Rough cutting (280 mm) to make removal easier
- (2) 3 points (top · 1)



# Radiator Panel (partial replacement)

## • Views



BS-00855

(1) Rough cutting (80 mm) to make removal easier

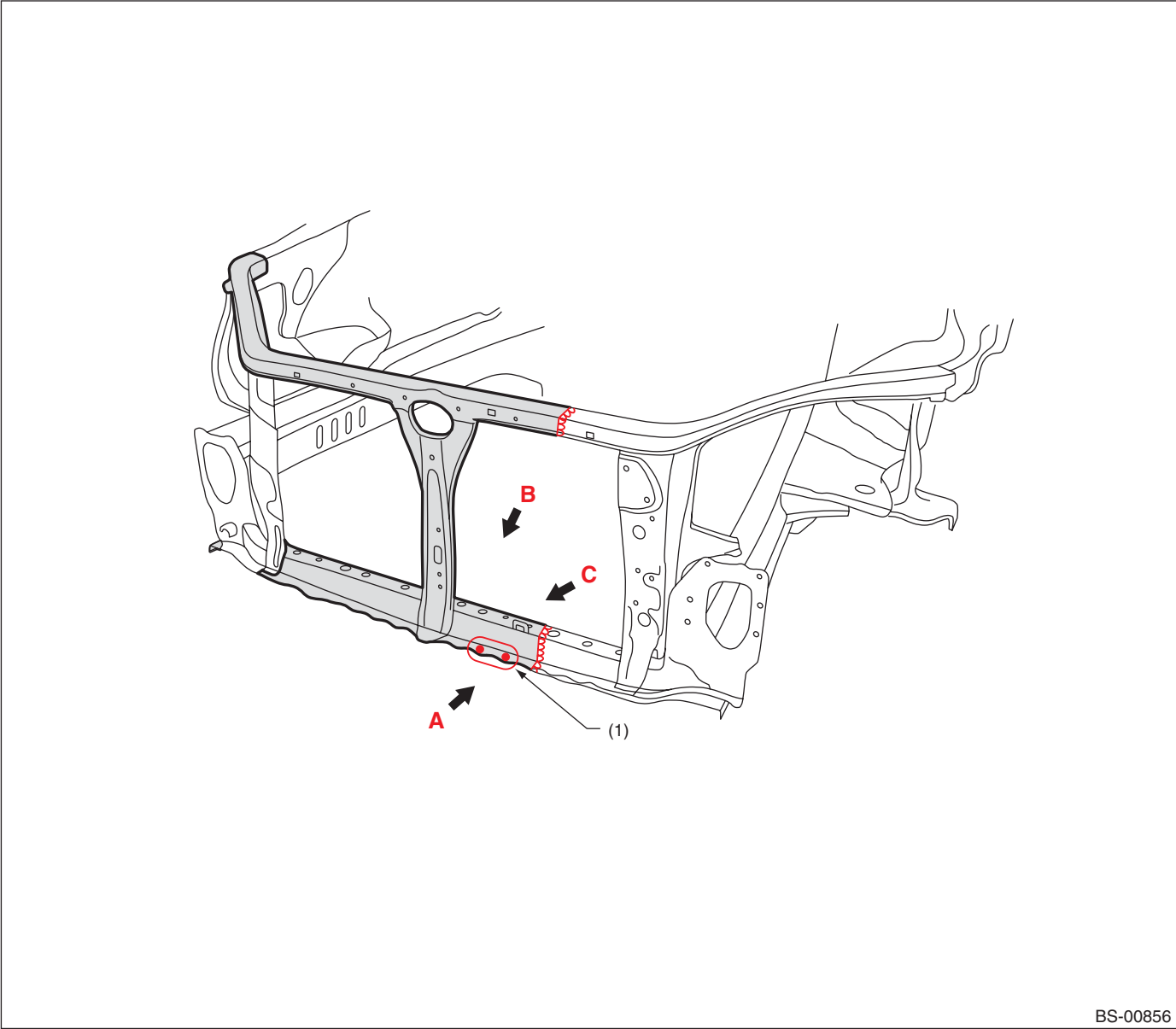
(2) Rough cutting  
(3) 2 points

(4) Rough cutting (110 mm) to make removal easier

# Radiator Panel (partial replacement)

## B: INSTALLATION

- Overall view

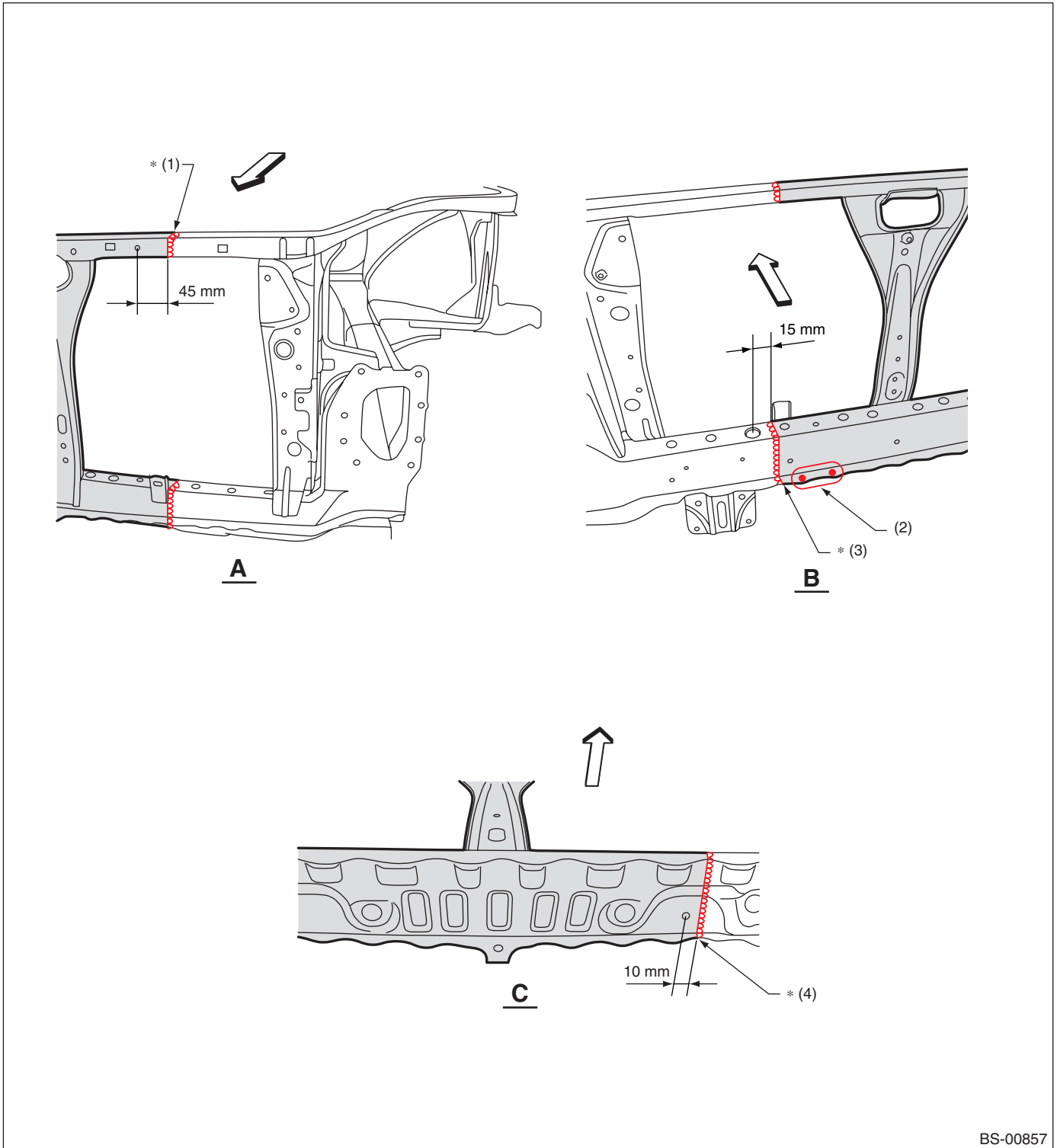


BS-00856

(1) 4 points

# Radiator Panel (partial replacement)

## • Views



(1) 1 point (both face plug) (80 mm)

(3) 1 point (180 mm)

(4) 1 point (110 mm)

(2) 3 points

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

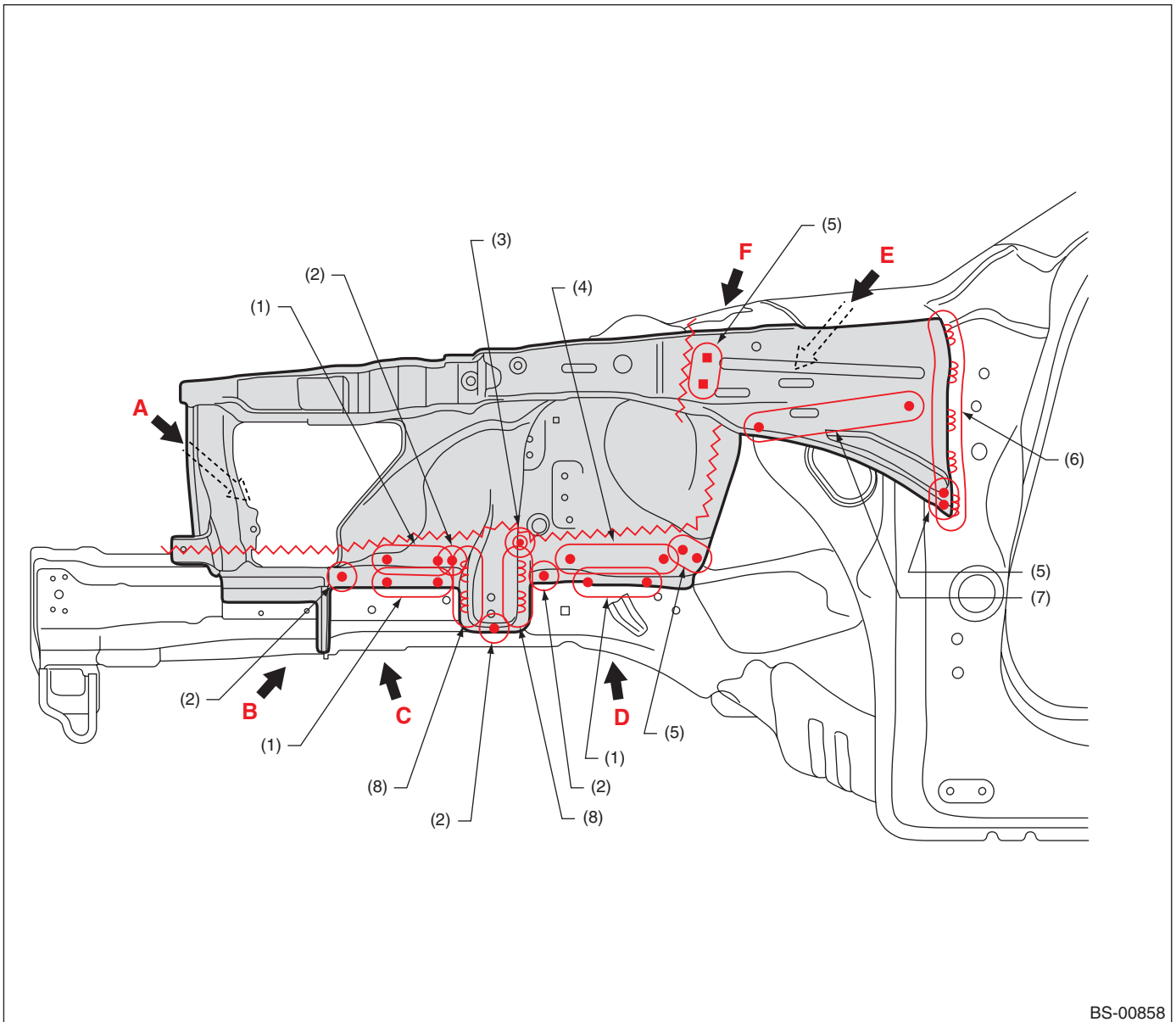
# Front Wheel Apron (total replacement)

## 15. Front Wheel Apron (total replacement)

### A: REMOVAL

1) Radiator panel removal condition

#### • Overall view



BS-00858

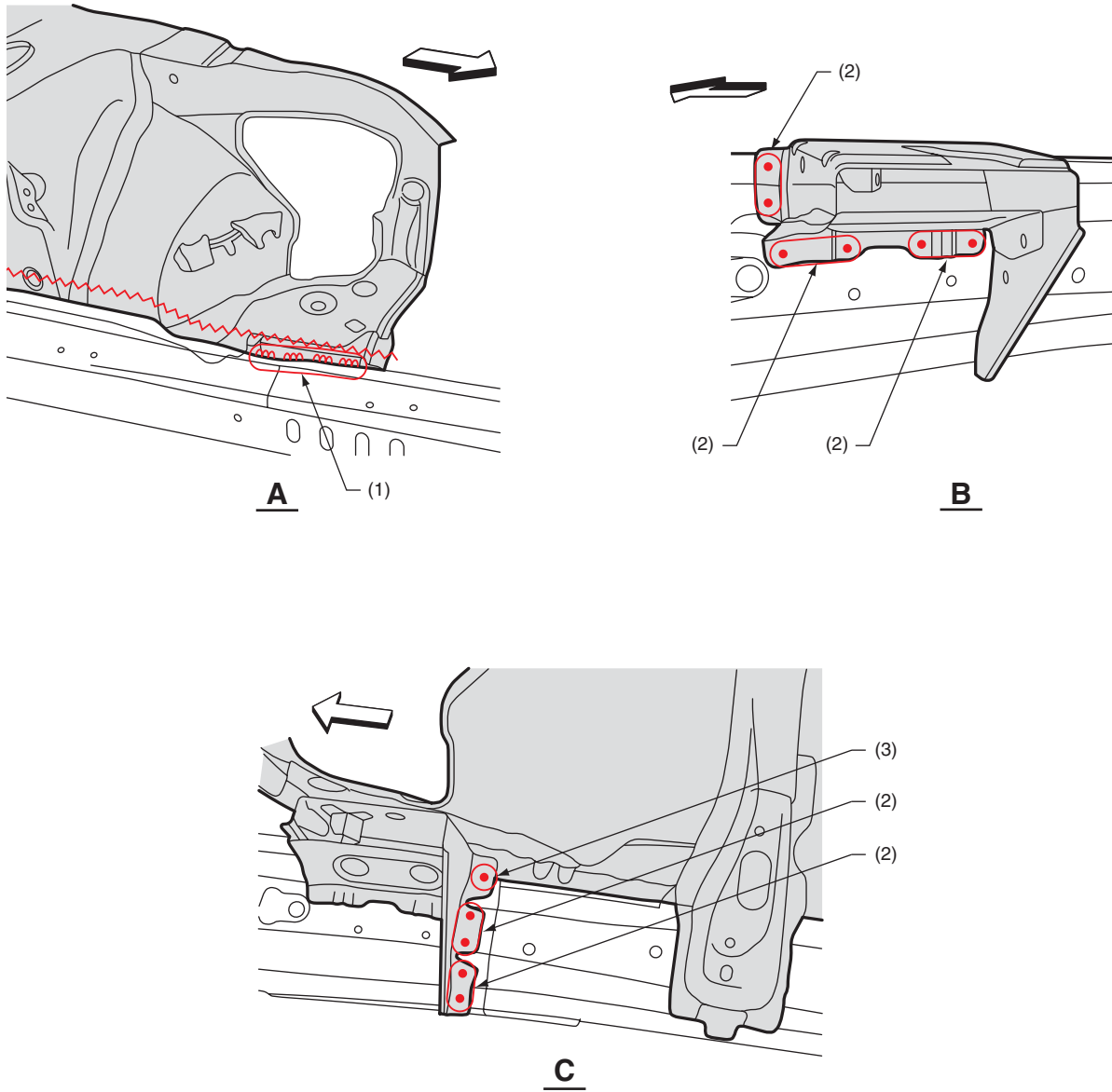
- (1) 3 points (outside · 1)
- (2) 1 point (outside · 1)
- (3) 1 point (outside · 2)

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

- (7) 7 points (outside · 1)
- (8) 2 points (outside · 1, belt sander)

# Front Wheel Apron (total replacement)

## • Views 1



BS-00859

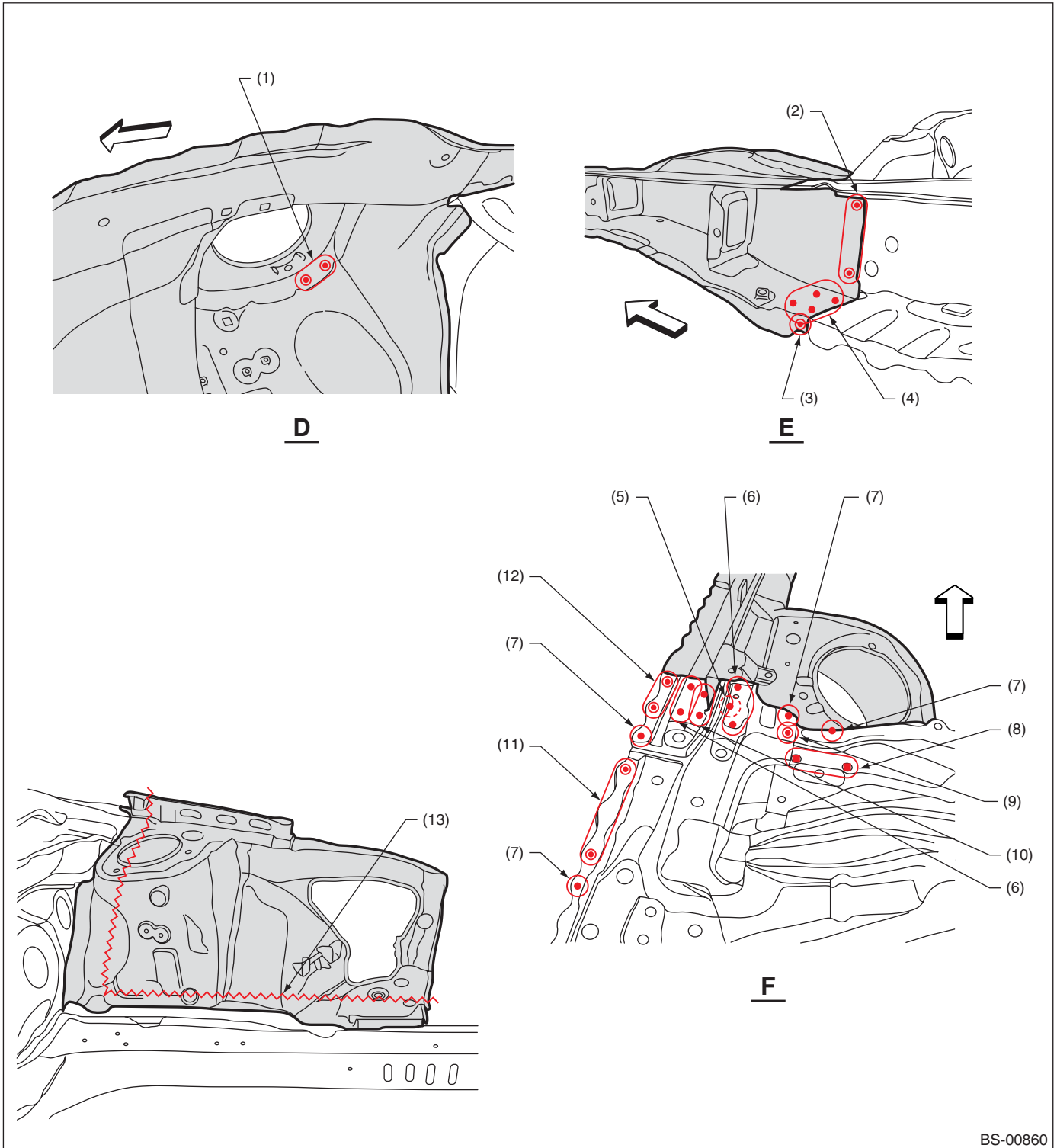
(1) 4 points (outside - 1, belt sander)

(2) 2 points (outside - 1)

(3) 1 point (outside - 1)

# Front Wheel Apron (total replacement)

## • Views 2



BS-00860

- |  |                        |                         |
|--|------------------------|-------------------------|
| (1) 2 points (inside · 2, belt sander) | (6) 3 points (top · 1) | (10) 2 points (top · 1) |
| (2) 3 points (outside · 2)             | (7) 1 point (top · 1)  | (11) 3 points (top · 2) |
| (3) 1 point (outside · 1)              | (8) 2 point plug weld  | (12) 2 points (top · 2) |
| (4) 4 points (bottom · 1)              | (9) 1 point (top · 2)  | (13) Rough cutting      |
| (5) 1 point (inside · 1, belt sander)  |                        |                         |
- ★ hidden hit point

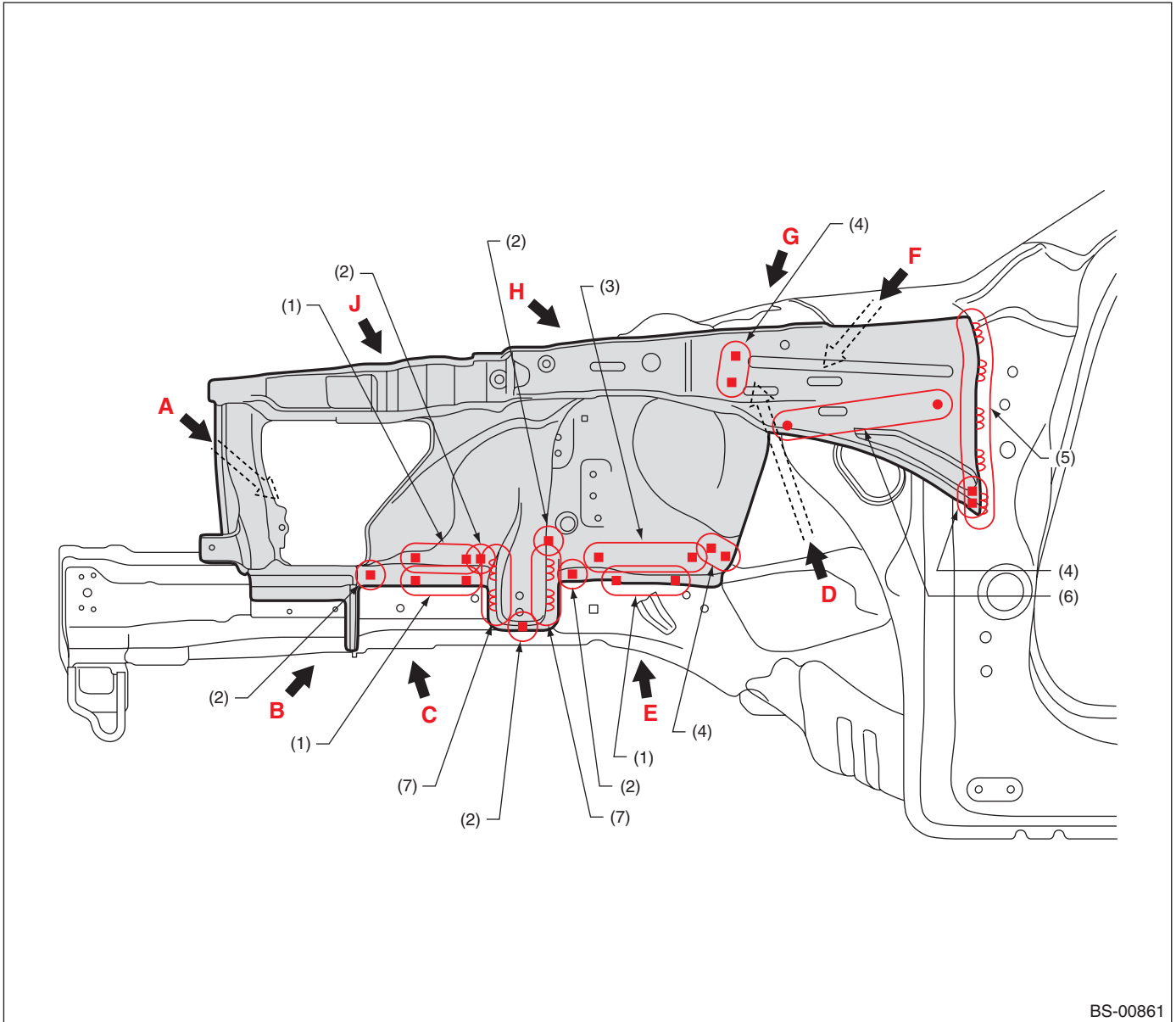
### CAUTION:

When rough cutting, be careful not to damage the duct in the front panel and the closing plate.

# Front Wheel Apron (total replacement)

## B: INSTALLATION

### • Overall view



BS-00861

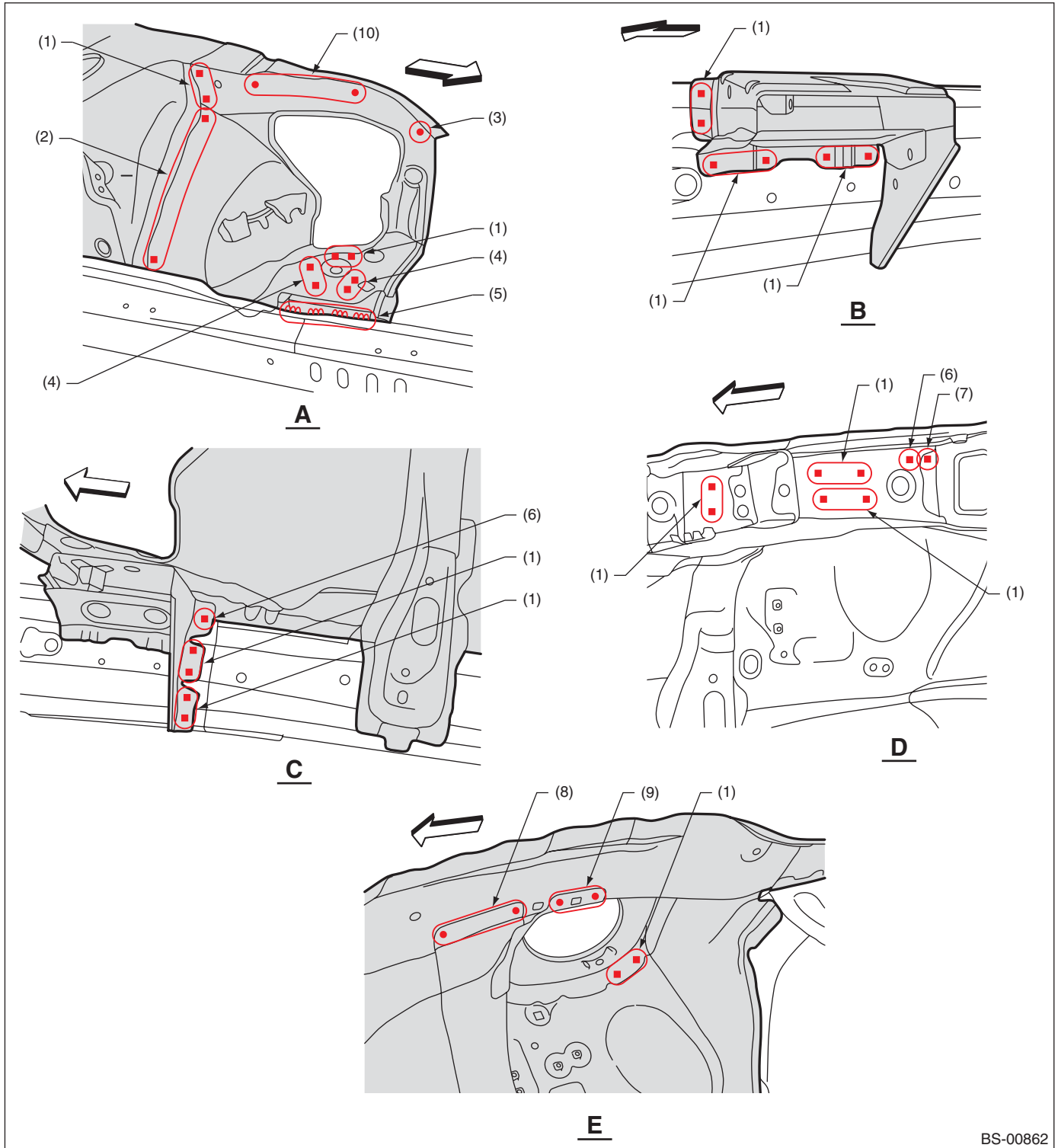
- (1) 3 points (service)
- (2) 1 point (service)
- (3) 6 points (service)

- (4) 2 points (service)
- (5) 5 points (20 mm × 5)

- (6) 9 points
- (7) 2 points (20 mm × 5)

# Front Wheel Apron (total replacement)

## • Views 1



BS-00862

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

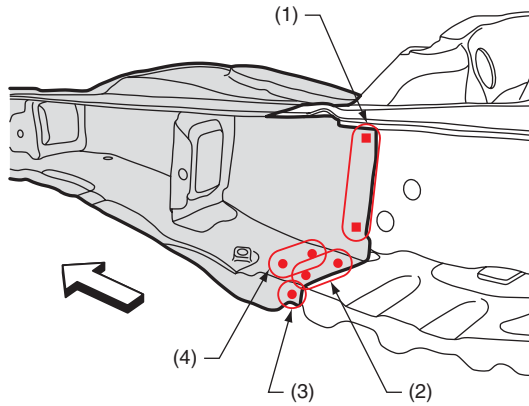
- (5) 4 points (15 mm × 4)
- (6) 1 point (service)
- (7) 1 point (service · matching)

- (8) 3 points
- (9) 2 points
- (10) 5 points

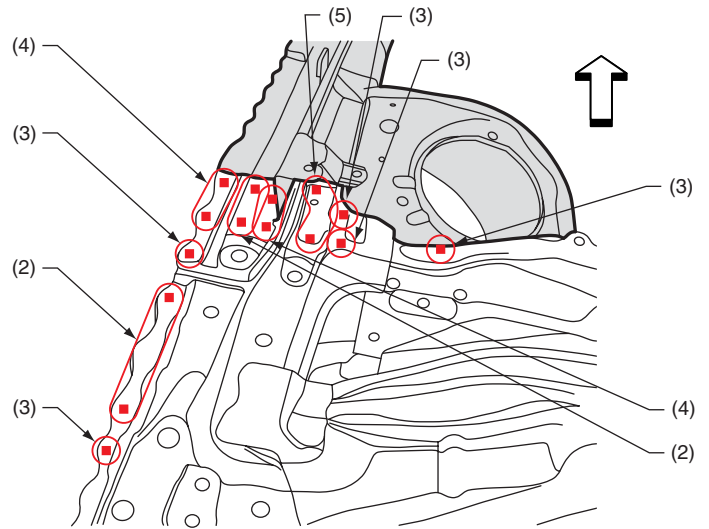


# Front Wheel Apron (total replacement)

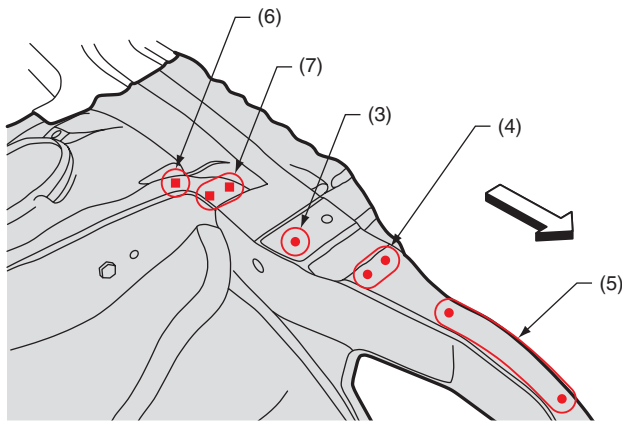
## • Views 2



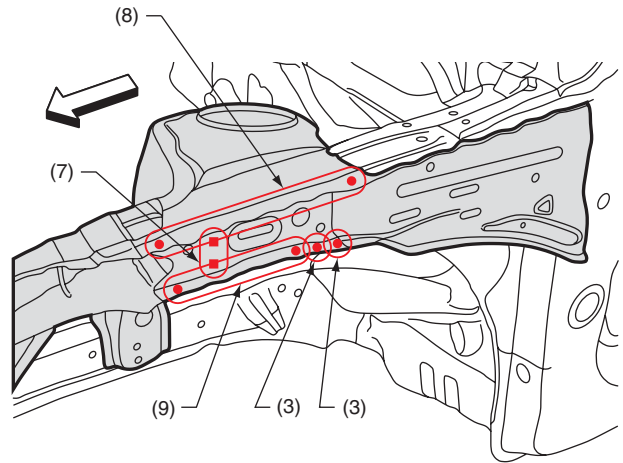
**F**



**G**



**H**



**J**

BS-00863

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

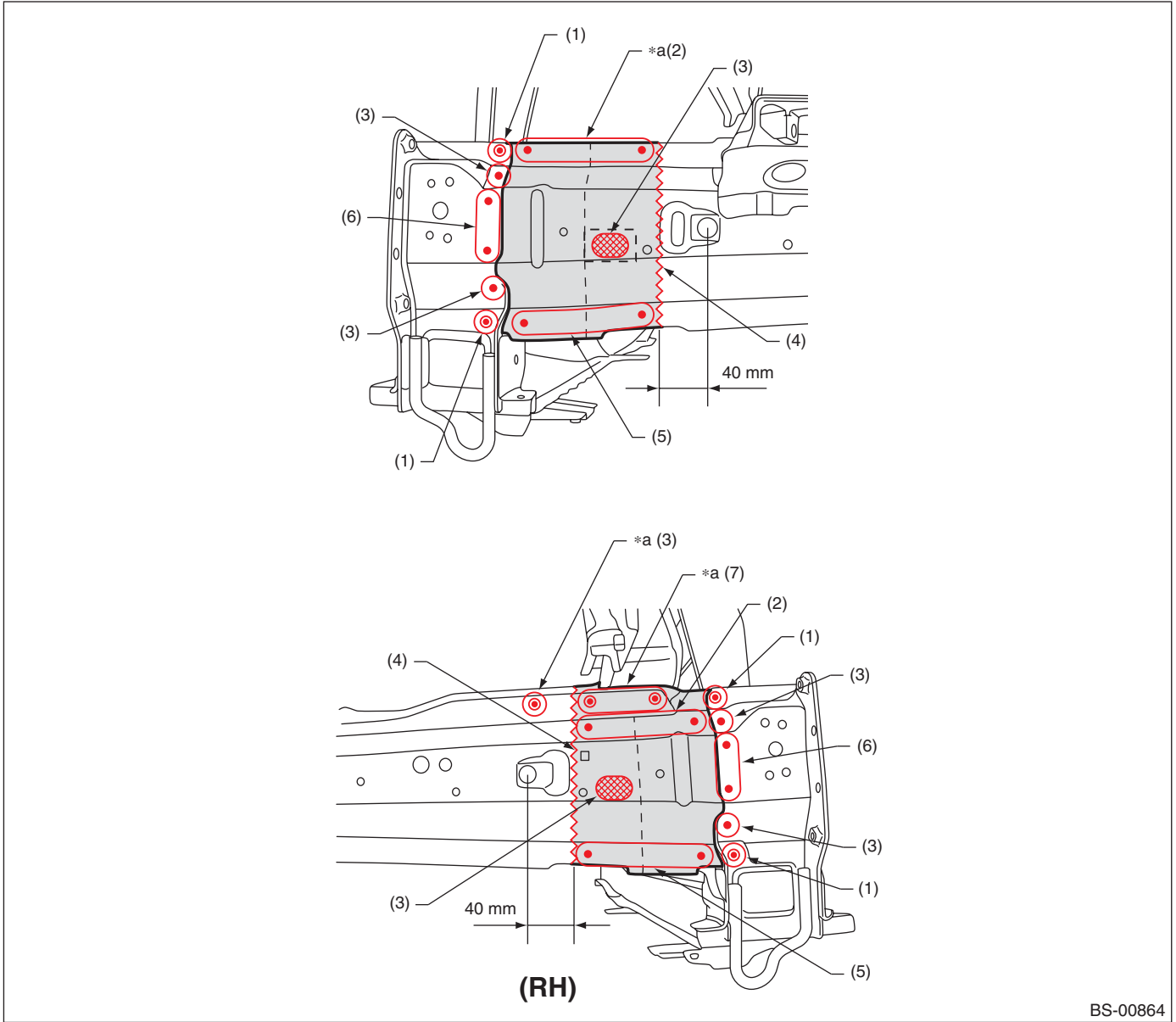
- (4) 2 points
- (5) 4 points
- (6) 1 point (service)

- (7) 2 points (service)
- (8) 10 points
- (9) 7 points

# Closing Plate (partial replacement)

## 16. Closing Plate (partial replacement)

### A: REMOVAL

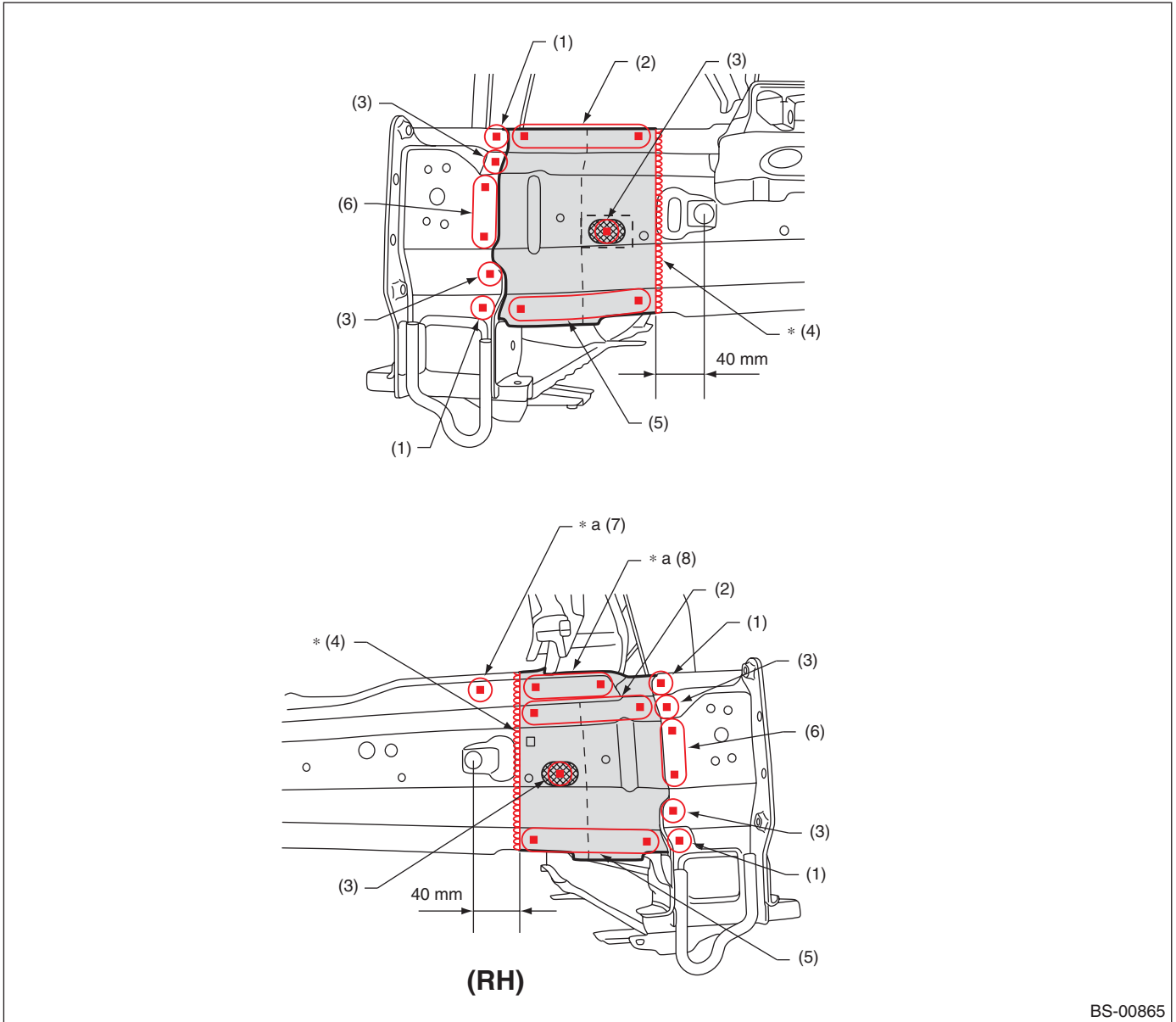


- |                            |  |                            |
|----------------------------|--|----------------------------|
| (1) 1 point (outside · 2)  | (4) Closing plate cut position (160 mm) for butt welding | (6) 3 points (outside · 1) |
| (2) 4 points (outside · 1) | (5) 5 points (outside · 1)                               | (7) 2 points (outside · 1) |
| (3) 1 point (outside · 1)  |  |                            |

For locations marked by \*a, lift a part of the front wheel apron to make it easier to cut the closing plate.

# Closing Plate (partial replacement)

## B: INSTALLATION



BS-00865

- |                                  |                        |              |
|----------------------------------|------------------------|--------------|
| (1) 1 point (service · matching) | (4) 1 point (160 mm)   | (7) 1 point  |
| (2) 4 points                     | (5) 5 points           | (8) 2 points |
| (3) 1 point (service)            | (6) 3 points (service) |              |

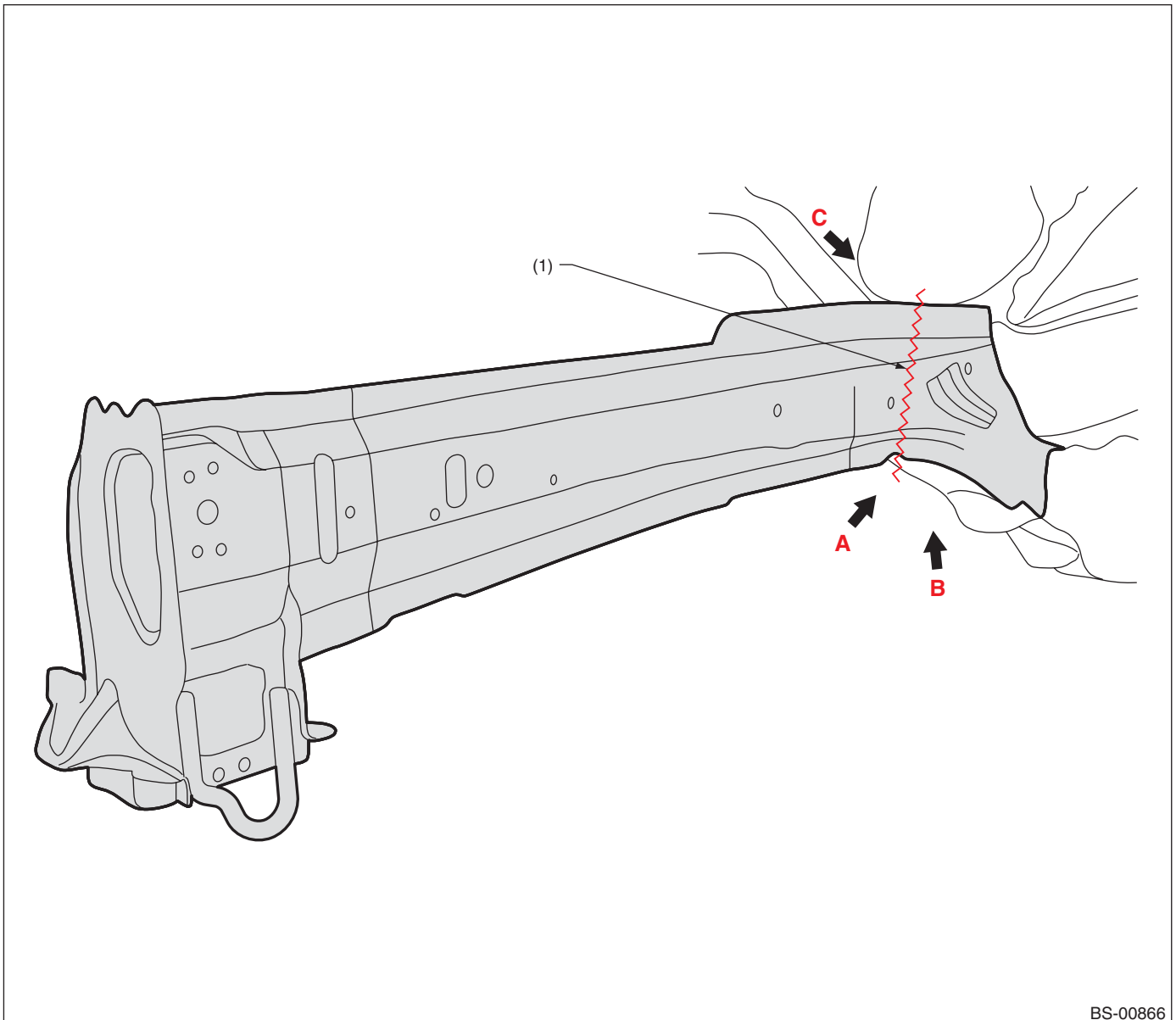
For continuous welds marked by \*, apply anticorrosion wax thoroughly on the reverse side.

### 17.Frame Side Front (partial replacement)

#### A: REMOVAL

1) Radiator panel and front wheel apron removal condition

- Overall view

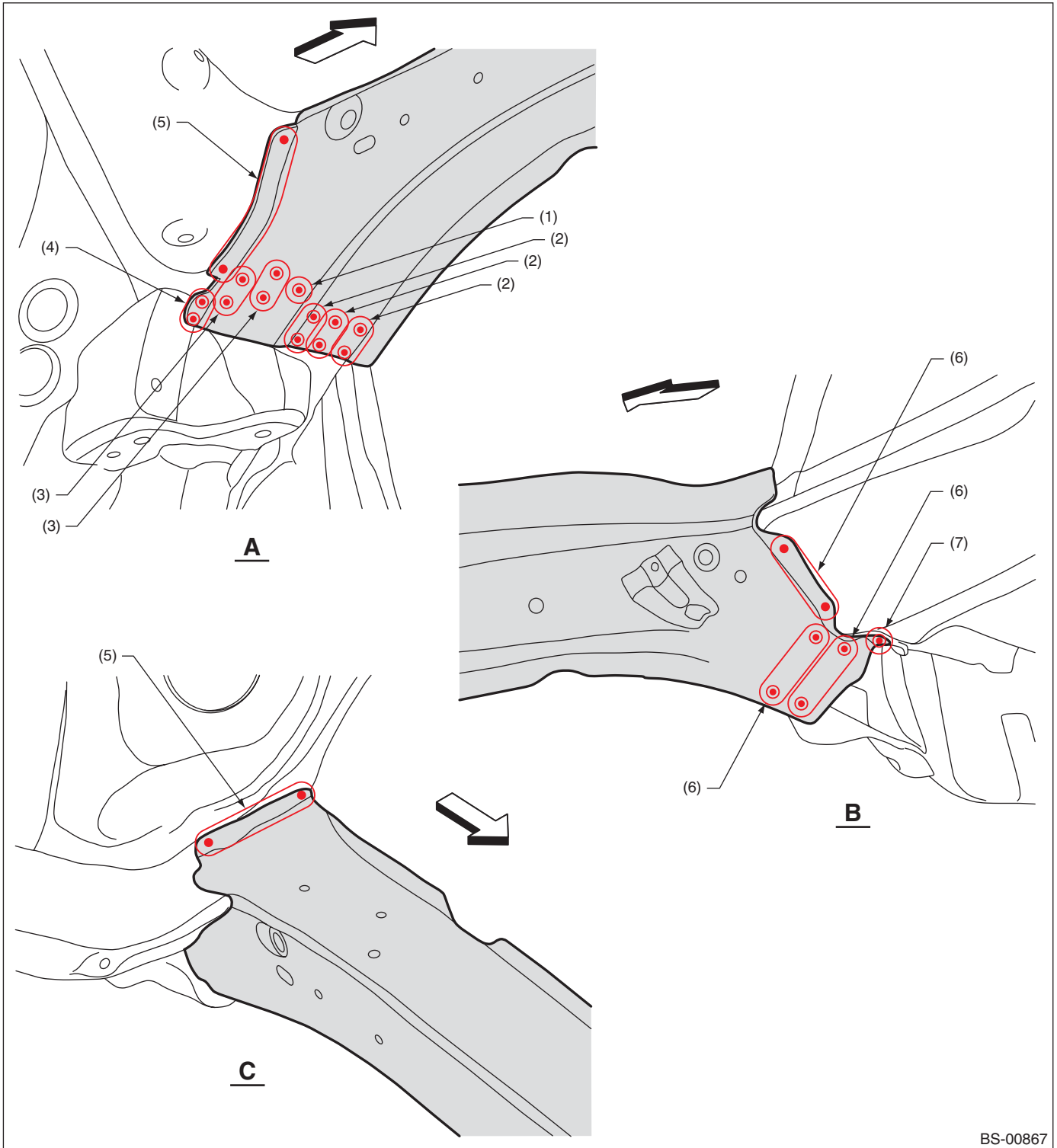


BS-00866

(1) Rough cutting (480 mm) to make removal easier

# Frame Side Front (partial replacement)

## • Views



BS-00867

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

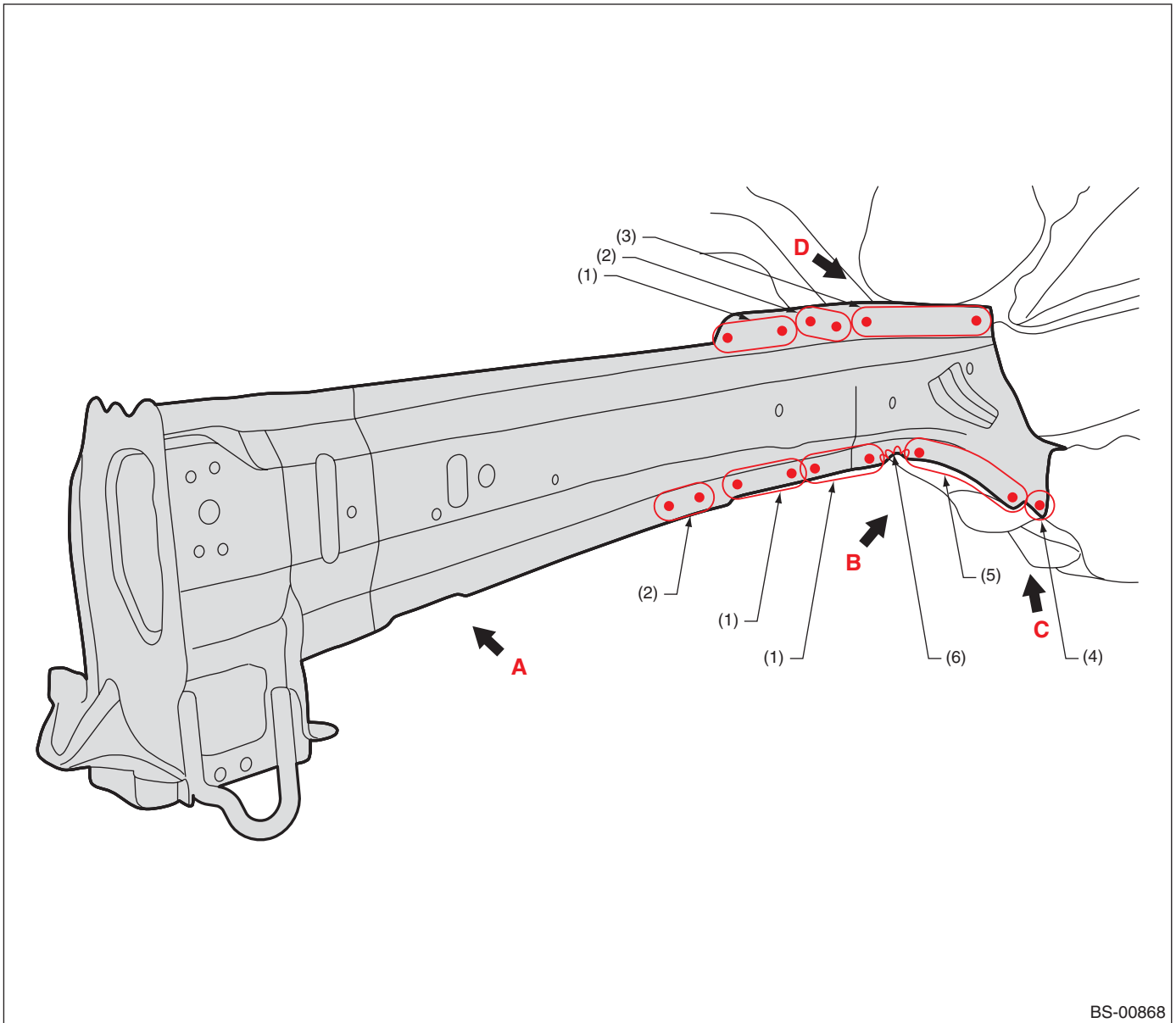
- (4) 2 points (outside · 1)
- (5) 4 points (outside · 1)

- (6) 3 points (outside · 1)
- (7) 1 point (outside · 1)

# Frame Side Front (partial replacement)

## B: INSTALLATION

### • Overall view



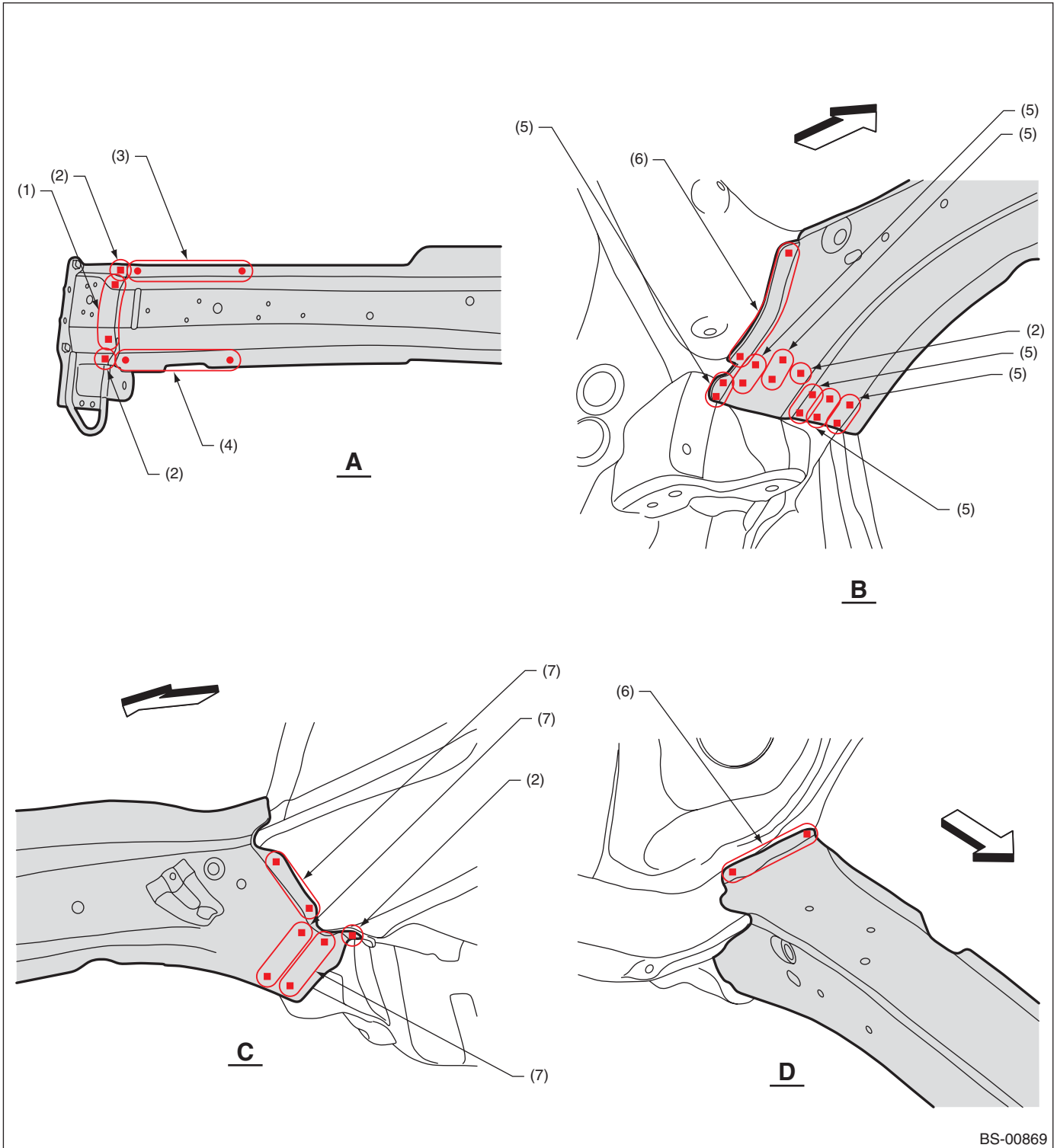
(1) 5 points  
(2) 3 points

(3) 10 points  
(4) 1 point

(5) 8 points  
(6) 1 point (40 mm × 1)

# Frame Side Front (partial replacement)

## • Views



BS-00869

(1) 5 points (service)  
 (2) 1 point (service)  
 (3) 10 points

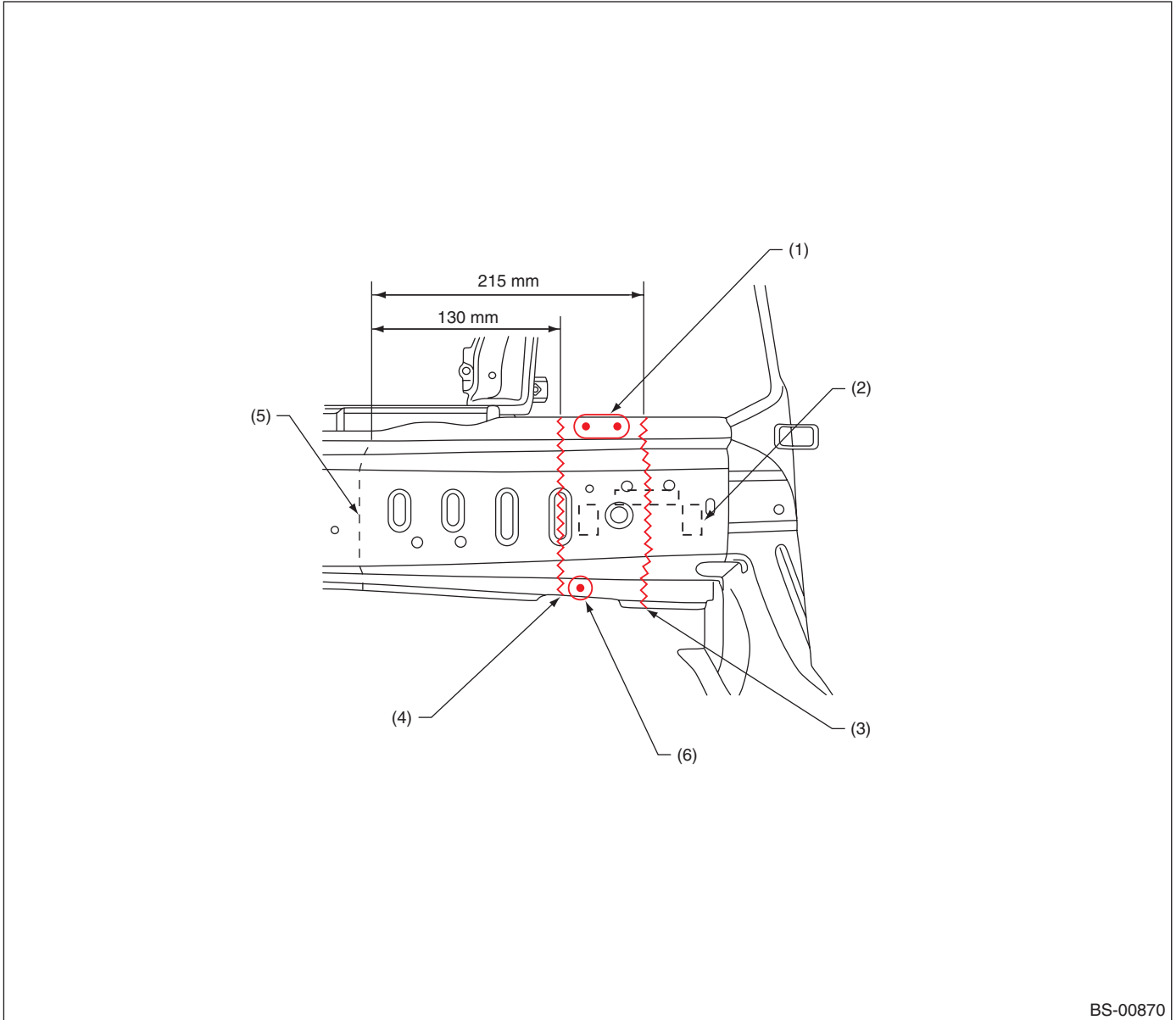
(4) 14 points  
 (5) 2 points (service)

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

## Front Side Frame (partial replacement)

### 18. Front Side Frame (partial replacement)

#### A: REMOVAL



BS-00870

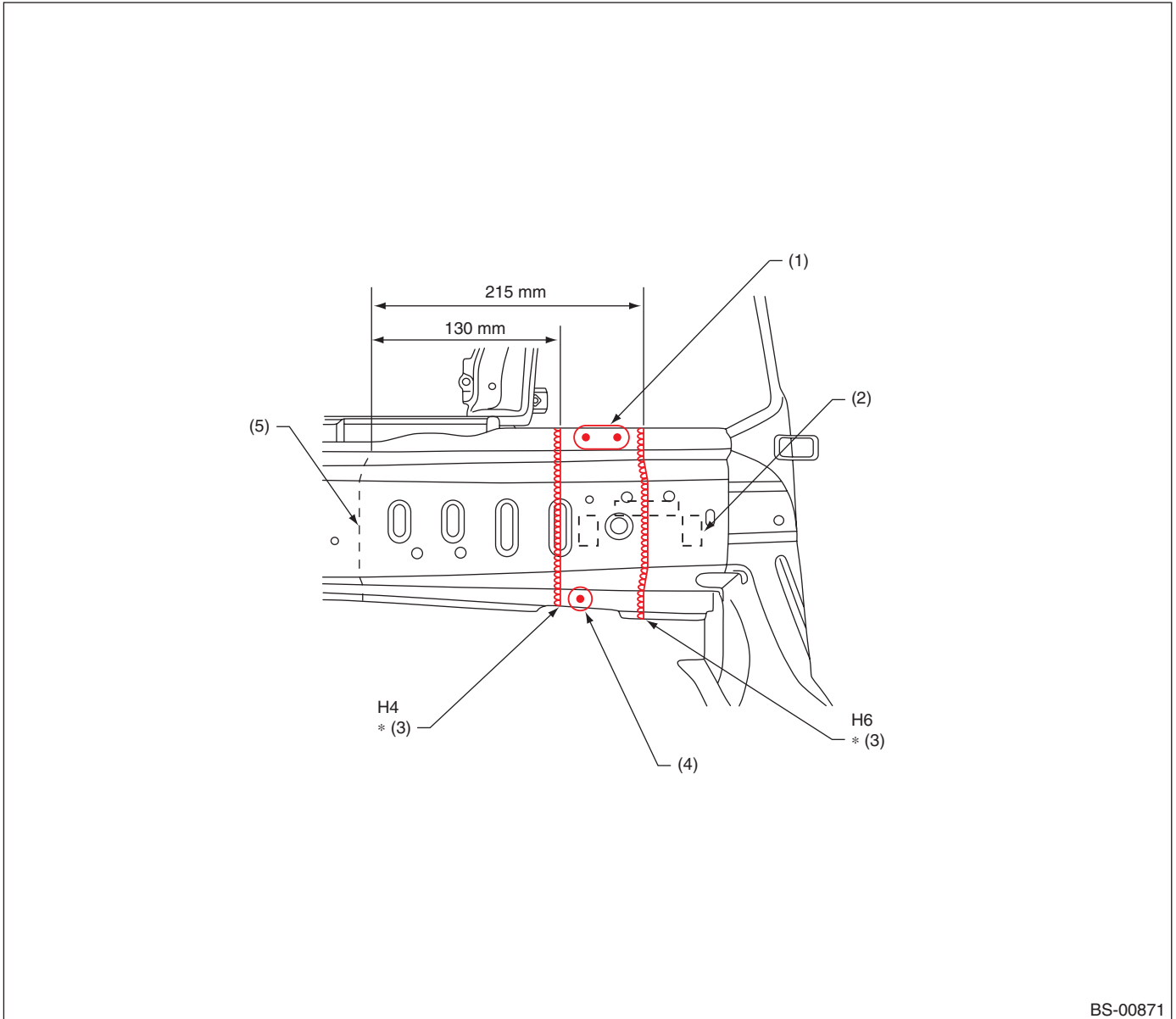
- |   |   |  |
|---|---|--|
| (1) 2 points (inside · 1) (During H4 cutting)     | (4) H4 cutting position (230 mm) for butt welding | (6) 1 point (inside · 1) (During H4 cutting) |
| (2) Separator bracket                             | (5) Tailored line                                 |  |
| (3) H6 cutting position (230 mm) for butt welding |   |  |

During H6 cutting work, replace the separator bracket (single part) in the front side frame.



# Front Side Frame (partial replacement)

## B: INSTALLATION



BS-00871

- |                                  |                                  |                   |
|----------------------------------|----------------------------------|-------------------|
| (1) 3 points (During H4 cutting) | (3) 1 point (230 mm)             | (5) Tailored line |
| (2) Separator bracket            | (4) 2 points (During H4 cutting) |                   |

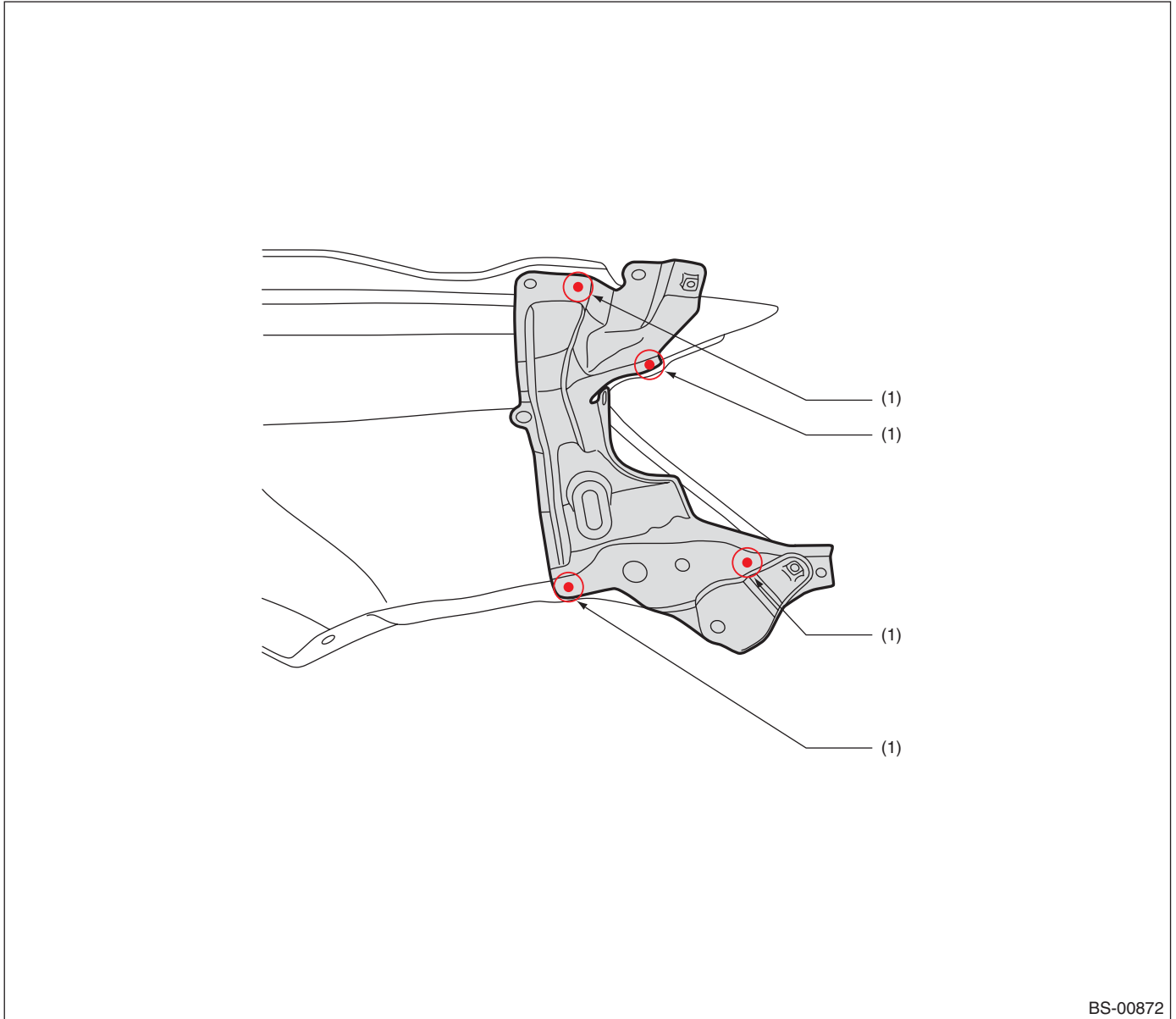
- During H6 cutting work, replace the separator bracket (single part) in the front side frame.
- For continuous welds marked by \*, apply anticorrosion wax thoroughly on the reverse side.

## Front Fender Reinforcement (total replacement)

### 19. Front Fender Reinforcement (total replacement)

#### A: REMOVAL

1) Frame fender removal condition



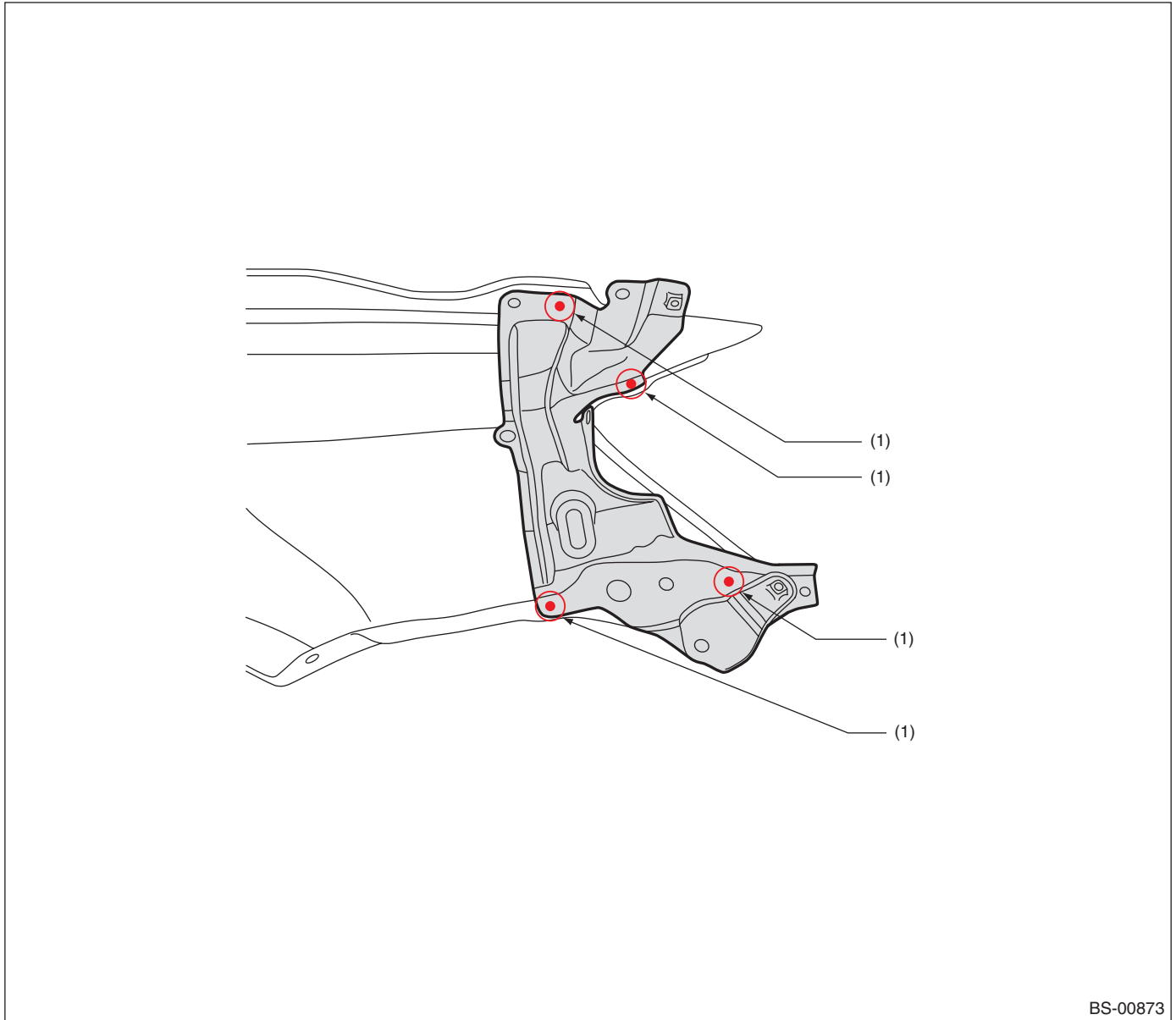
BS-00872

(1) 1 point (inside · 1)

Makes front fender tip repair easier.

# Front Fender Reinforcement (total replacement)

## B: INSTALLATION



BS-00873

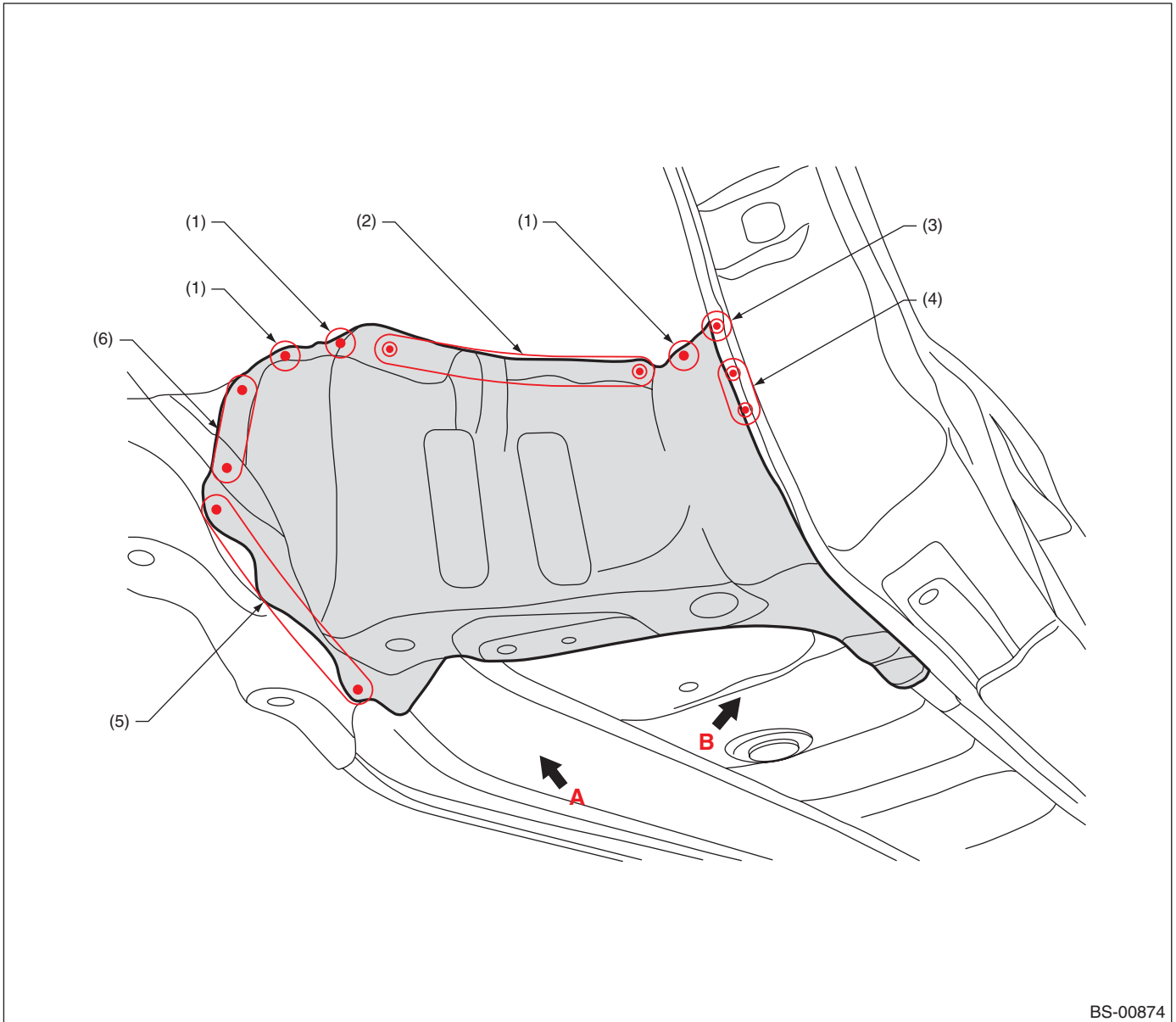
(1) 1 point

# Reinforcement Toe Board (total replacement)

## 20.Reinforcement Toe Board (total replacement)

### A: REMOVAL

- Overall view



BS-00874

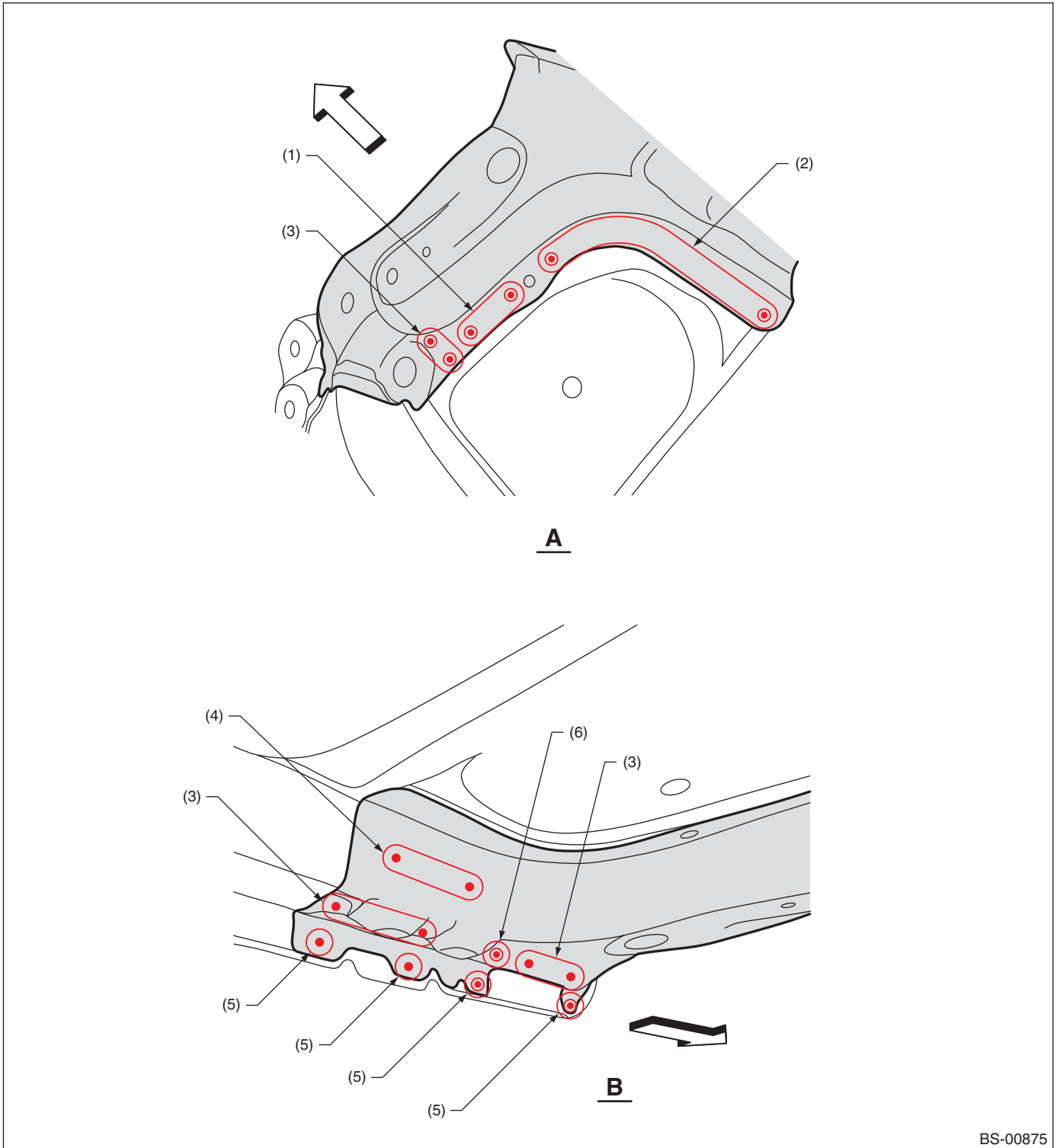
- (1) 1 point (outside · 1)
- (2) 4 points (outside · 1)

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

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

# Reinforcement Toe Board (total replacement)

- Views



BS-00875

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

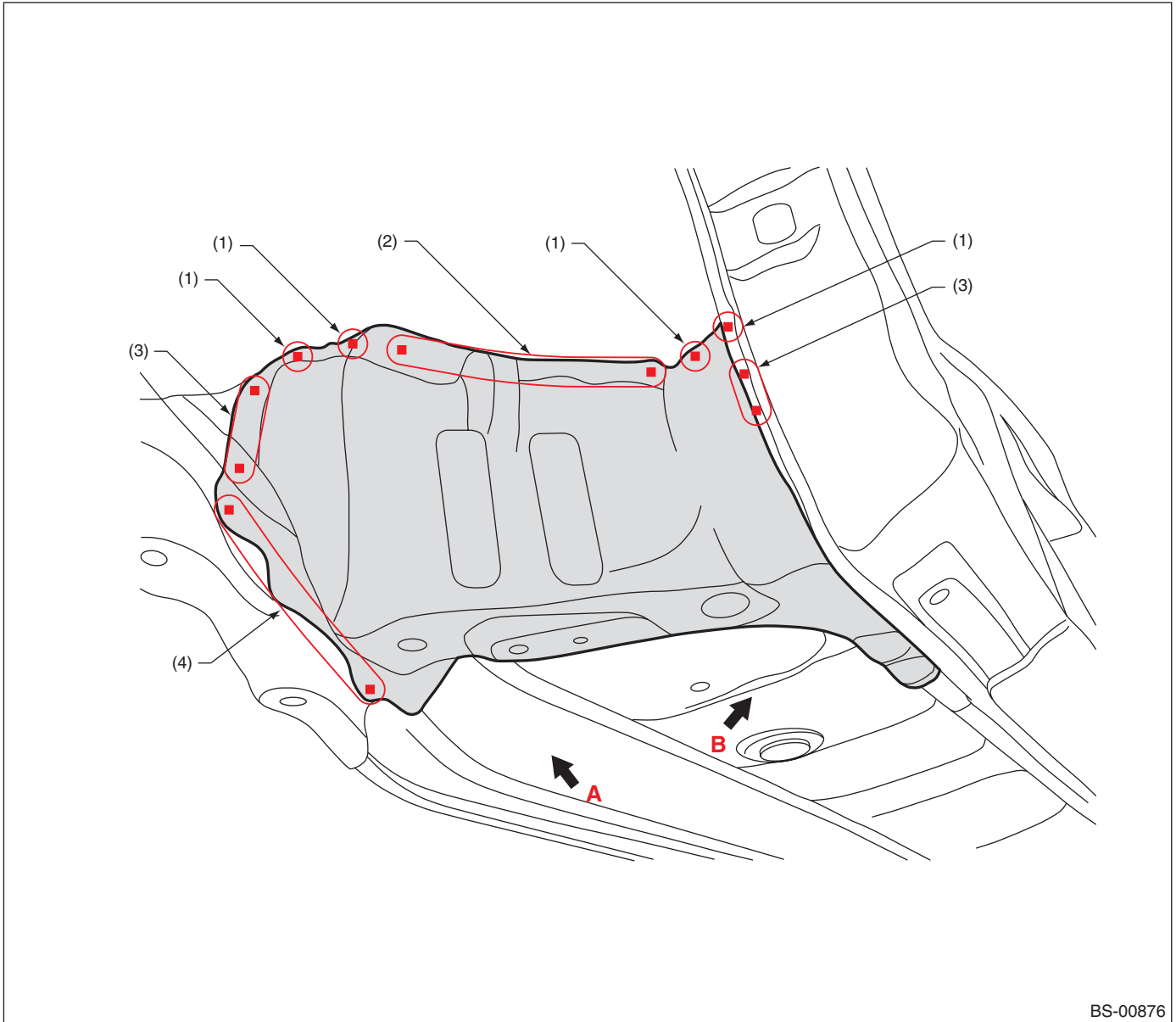
(3) 2 points (bottom · 1)  
 (4) 2 points (inside · 1)

(5) 1 point (inside · 1)  
 (6) 1 point (bottom · 0)

# Reinforcement Toe Board (total replacement)

## B: INSTALLATION

### • Overall view



BS-00876

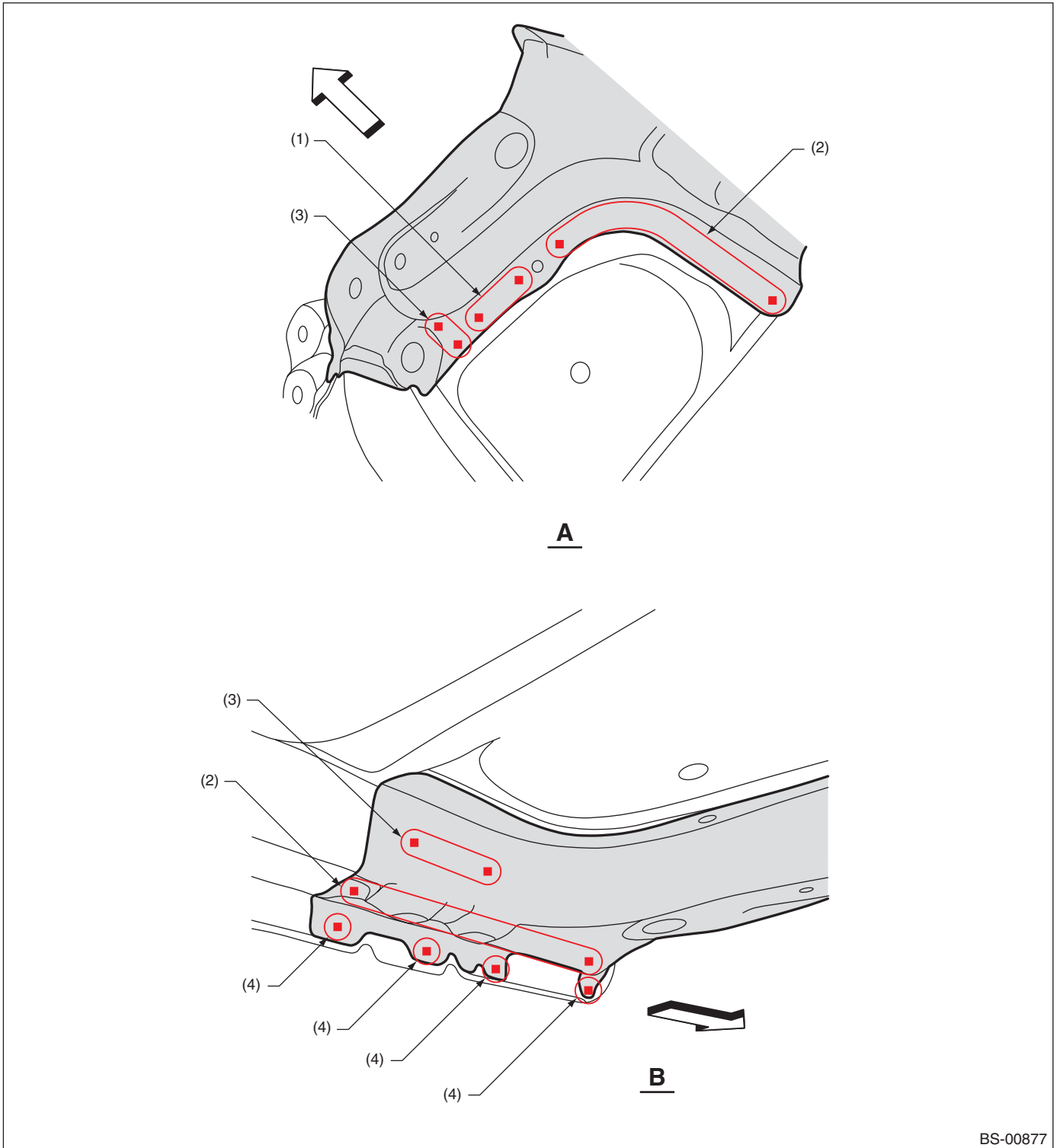
(1) 1 point (service)  
(2) 4 points (service)

(3) 2 points (service)

(4) 3 points (service)

# Reinforcement Toe Board (total replacement)

## • Views



BS-00877

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

(3) 2 points (service)

(4) 1 point (service)

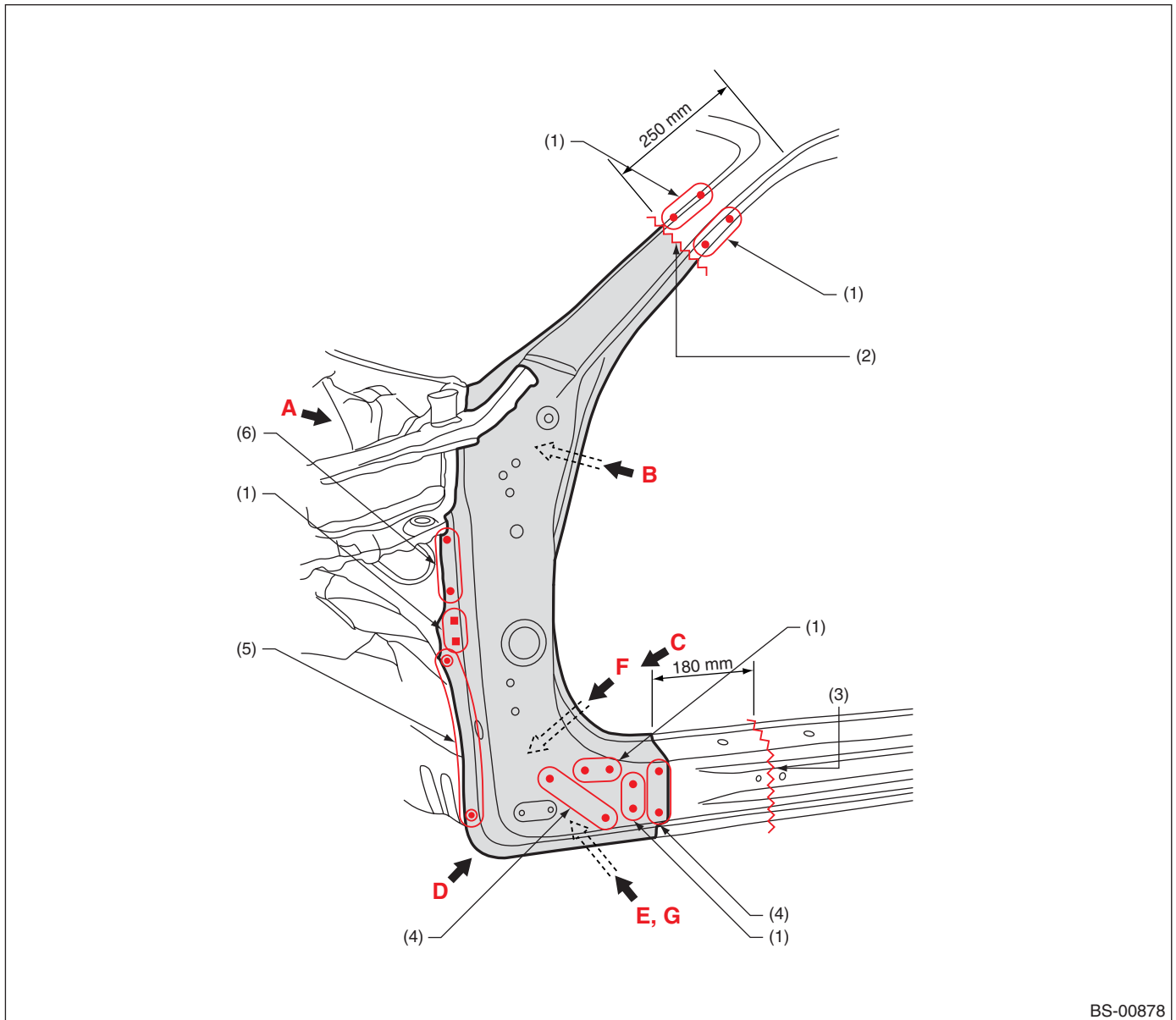
# Front Pillar (partial replacement)

## 21. Front Pillar (partial replacement)

### A: REMOVAL

1) Frame side upper removal condition

• Overall view



BS-00878

(1) 2 points (outside · 1)

(2) Rough cutting (250 mm)

(3) Cut (270 mm)

to make removal easier

Inner lower pillar

(4) 3 points (outside · 1)

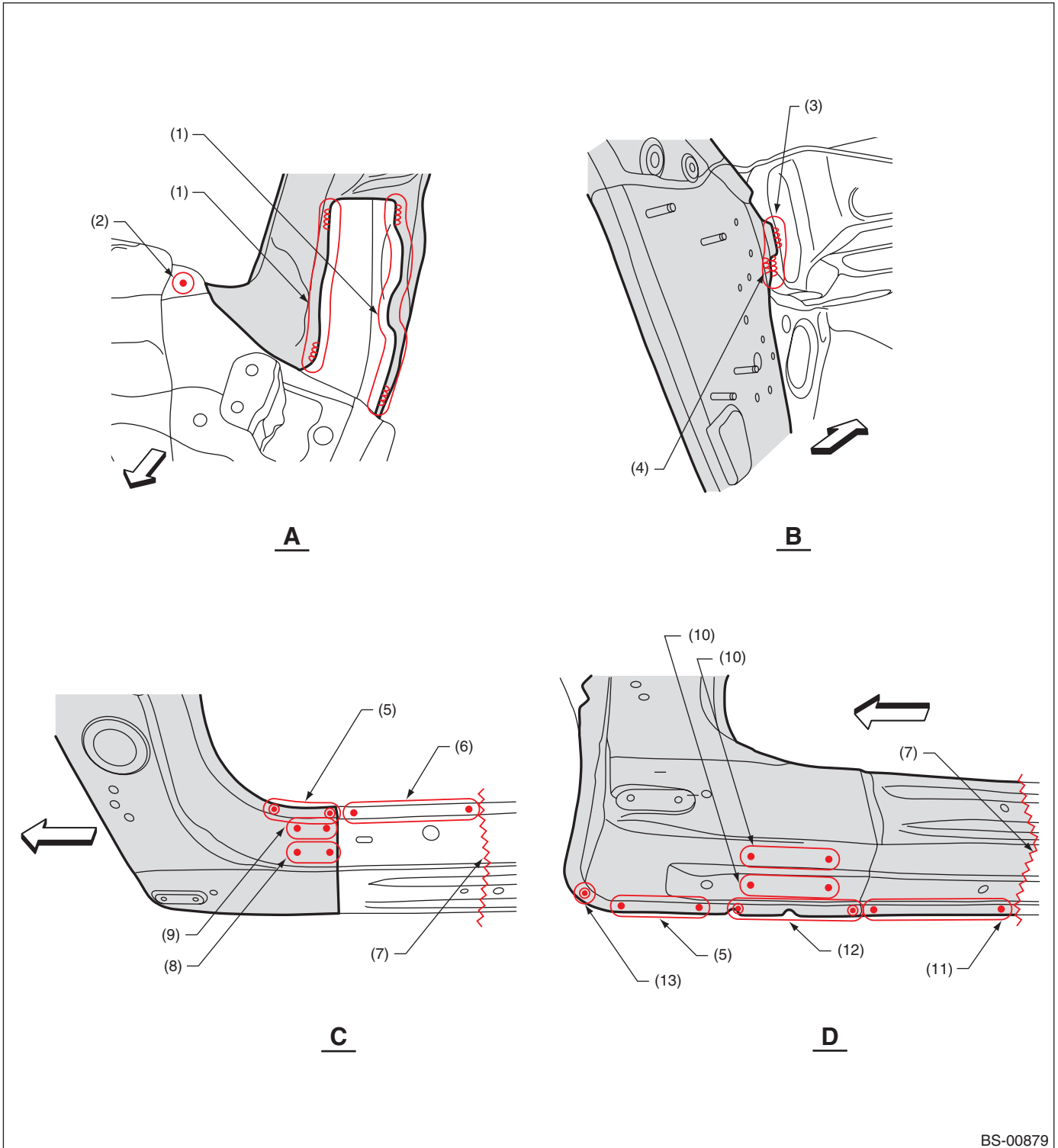
(5) 8 points (outside · 1)

(6) 4 points (outside · 1)



# Front Pillar (partial replacement)

## • Views 1

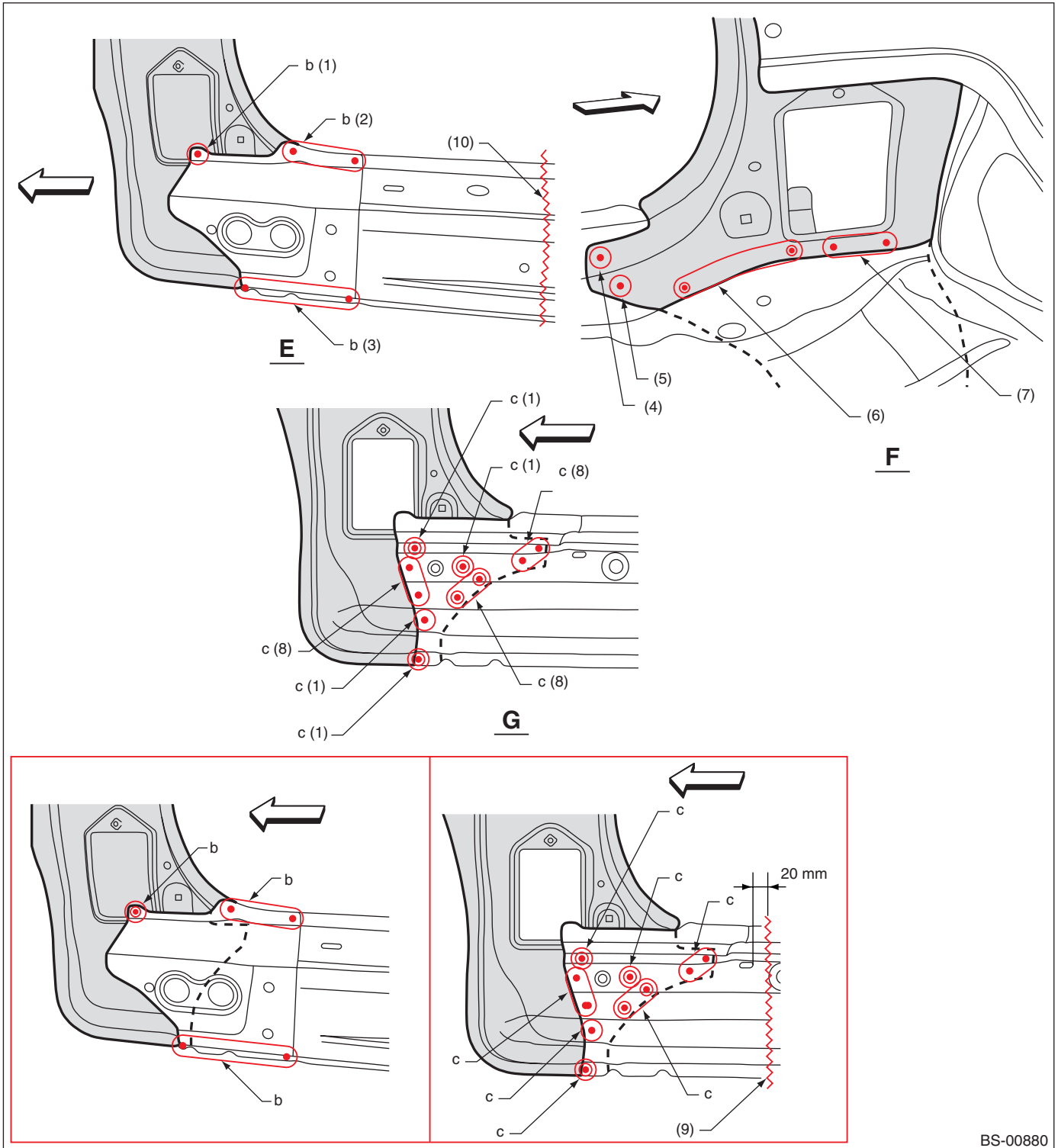


BS-00879

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

# Front Pillar (partial replacement)

## • Views 2



BS-00880

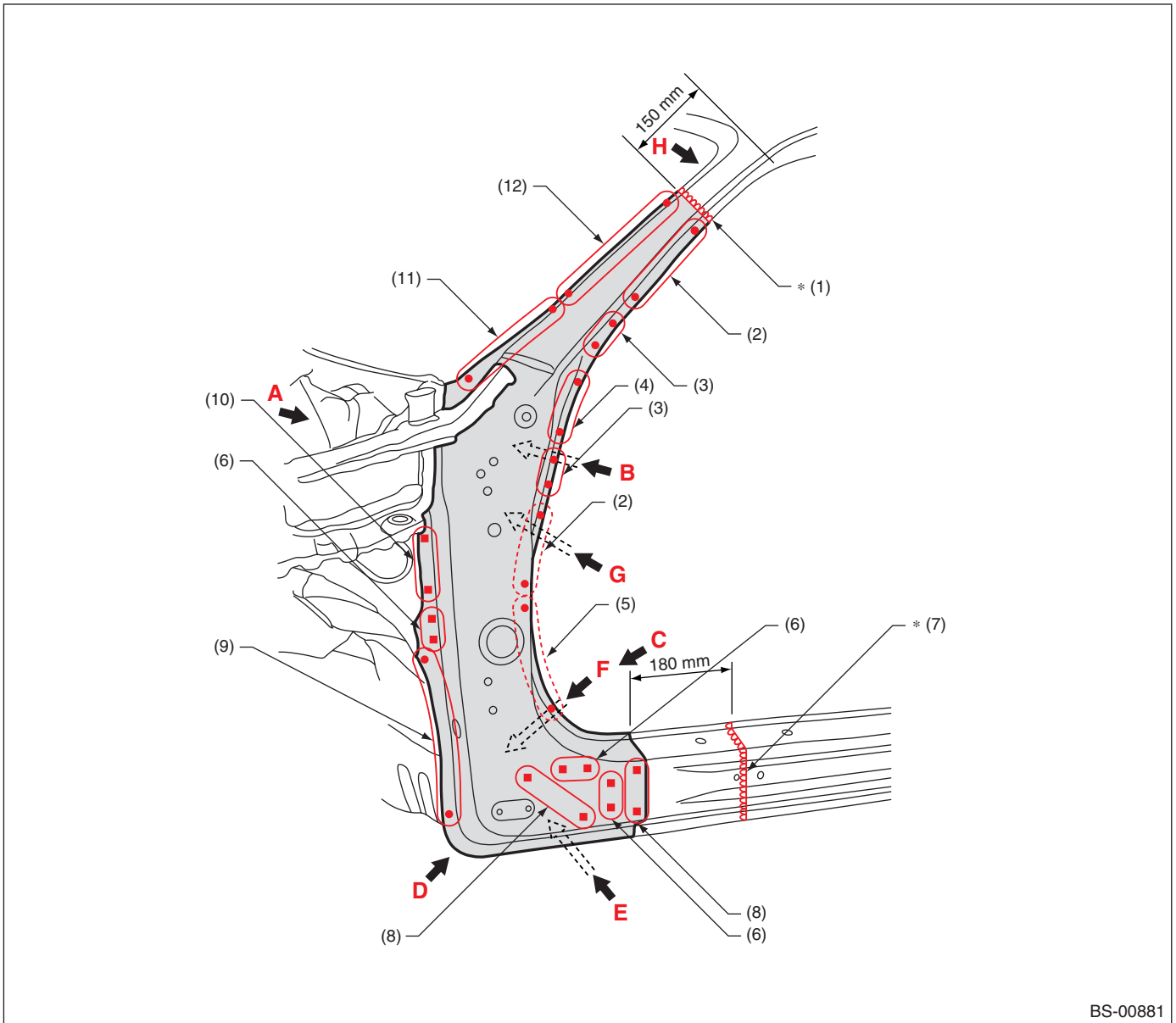
- |                            |                           |                                      |
|----------------------------|---------------------------|--------------------------------------|
| (1) 1 point (outside · 1)  | (5) 1 point (inside · 1)  | (8) 2 points (outside · 1)           |
| (2) 3 points (outside · 1) | (6) 3 points (inside · 1) | (9) Cut (240 mm) to make work easier |
| (3) 7 points (outside · 1) | (7) 2 points (inside · 1) | (10) Cut                             |
| (4) 1 point (top · 1)      |                           |                                      |

POINT: • To make removal easier, remove the front pillar and remove the welding location b.  
 • Remove the front pillar, cut the side sill inner (reuse), and remove section c.  
 View E shows the front pillar removed condition.

# Front Pillar (partial replacement)

## B: INSTALLATION

### • Overall view



BS-00881

- |                      |                        |                         |
|----------------------|------------------------|-------------------------|
| (1) 1 point (150 mm) | (5) 10 points          | (9) 10 points (service) |
| (2) 5 points         | (6) 2 points (service) | (10) 4 points (service) |
| (3) 2 points         | (7) 1 point (270 mm)   | (11) 7 points           |
| (4) 3 points         | (8) 3 points (service) | (12) 13 points          |

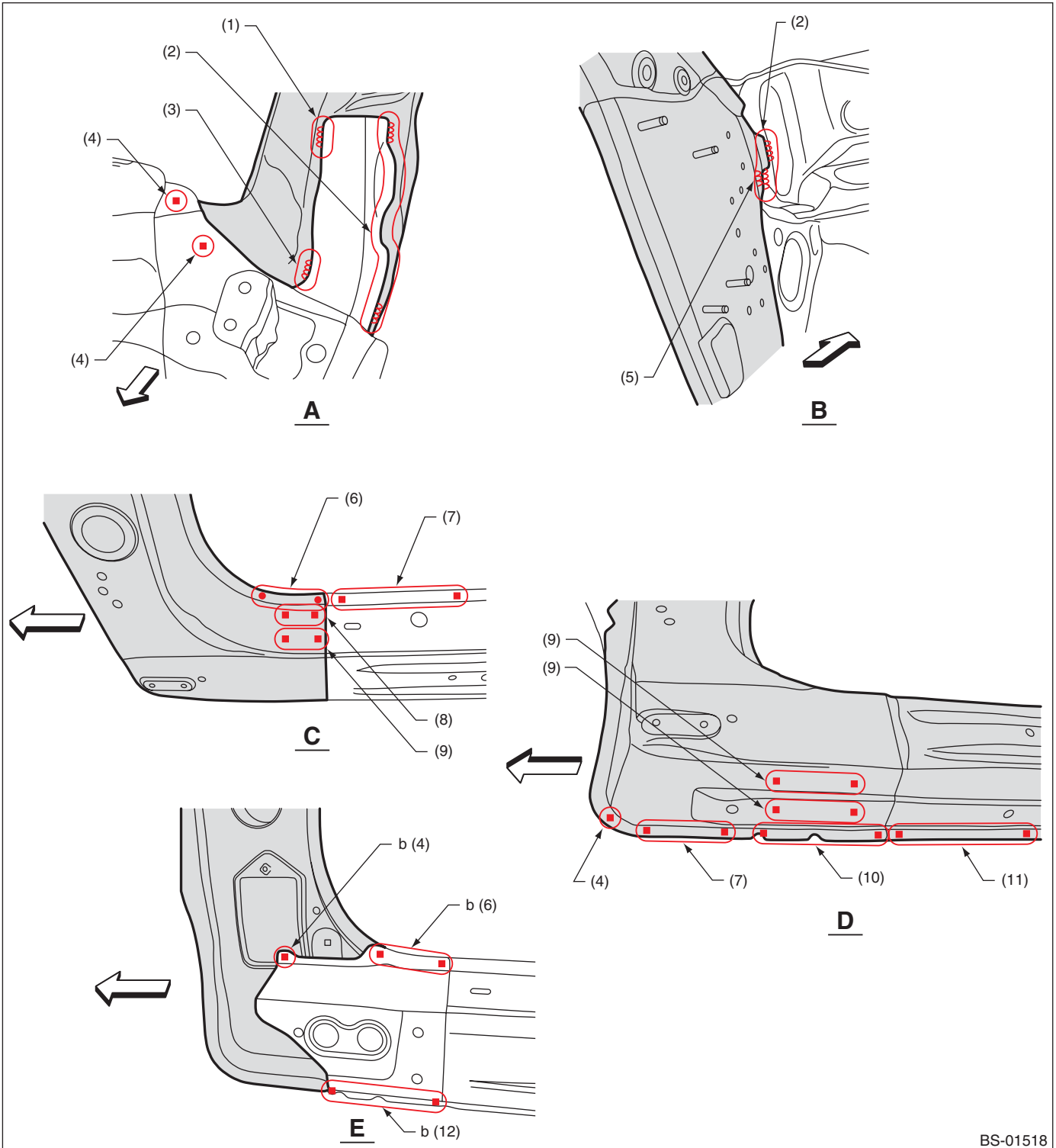
### CAUTION:

When servicing (7), after welding the section b in the View E, perform butt welding of the side sill outer.

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

# Front Pillar (partial replacement)

## • Views 1

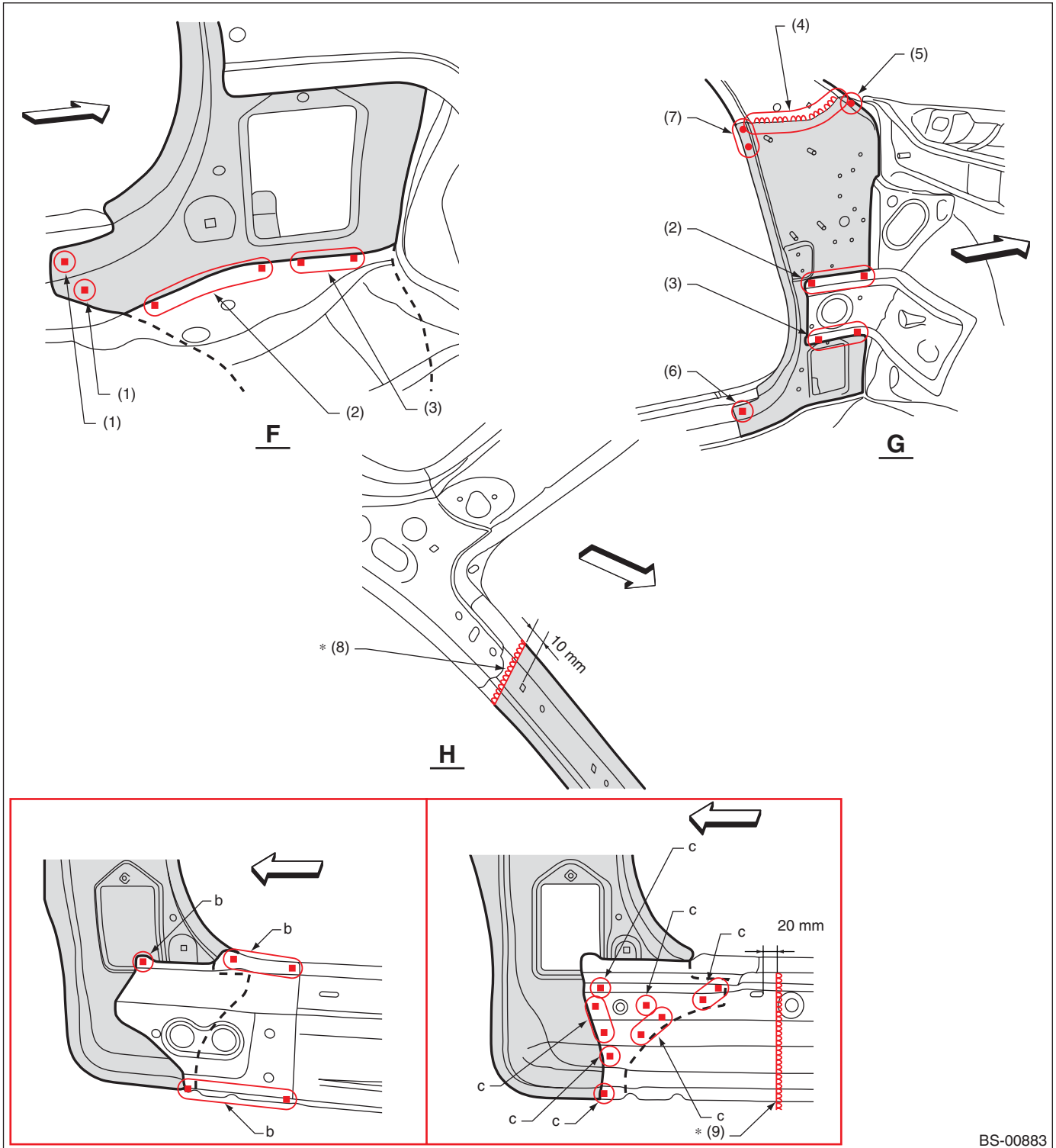


BS-01518

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

# Front Pillar (partial replacement)

## • Views 2



BS-00883

- |              |                                  |                        |
|--------------|----------------------------------|------------------------|
| (1) 1 point  | (4) 5 points (15 mm × 5)         | (7) 2 points (service) |
| (2) 3 points | (5) 1 point (service · matching) | (8) 1 point (100 mm)   |
| (3) 2 points | (6) 1 point (service)            | (9) 1 point (240 mm)   |

POINT: • After welding section b, perform butt welding of the side sill outer.

• After welding section c, perform butt welding of the side sill inner.

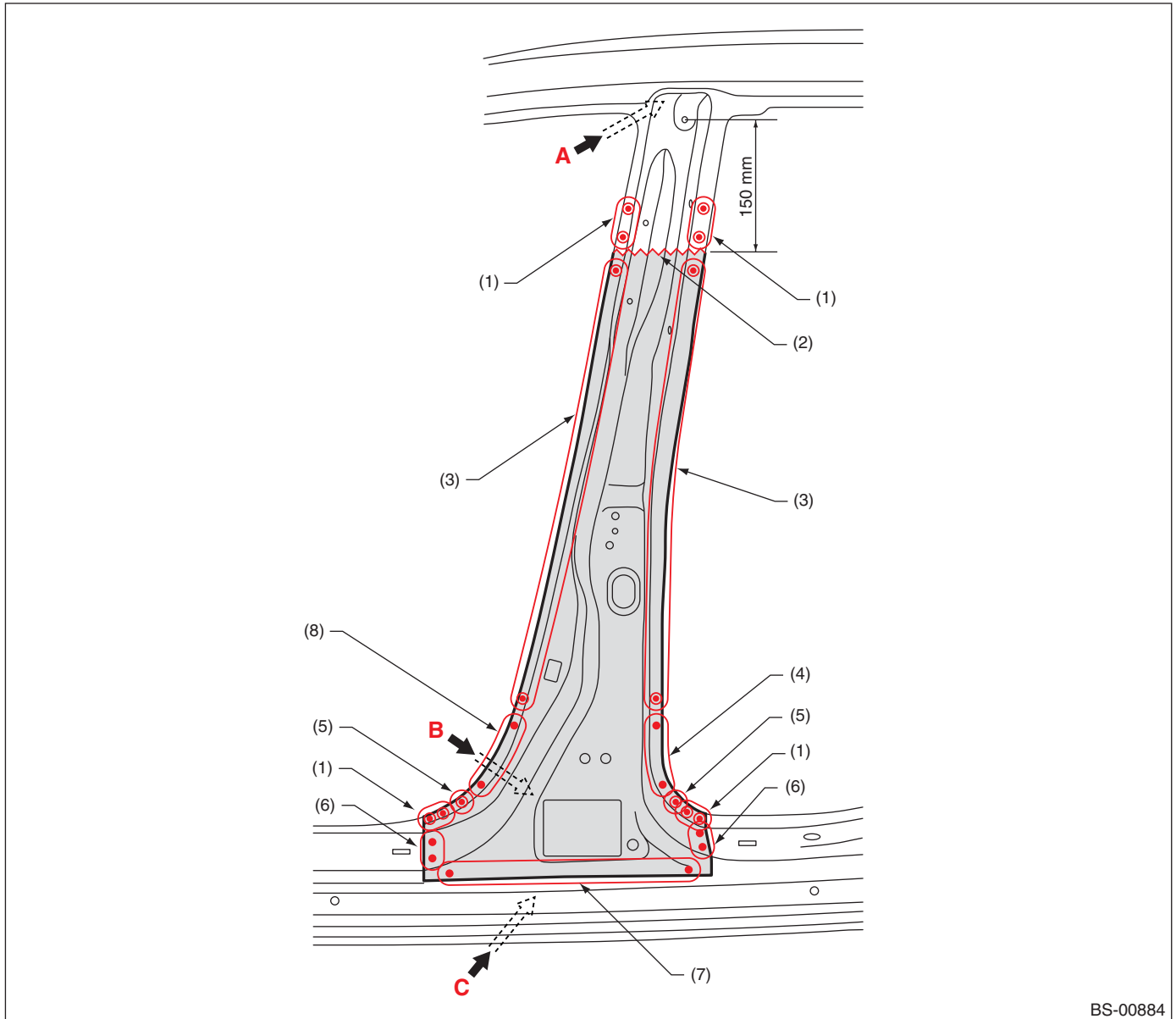
For continuous welds marked by \*, apply anticorrosion wax thoroughly on the reverse side.

## Center Pillar (partial replacement)

### 22.Center Pillar (partial replacement)

#### A: REMOVAL

##### • Overall view

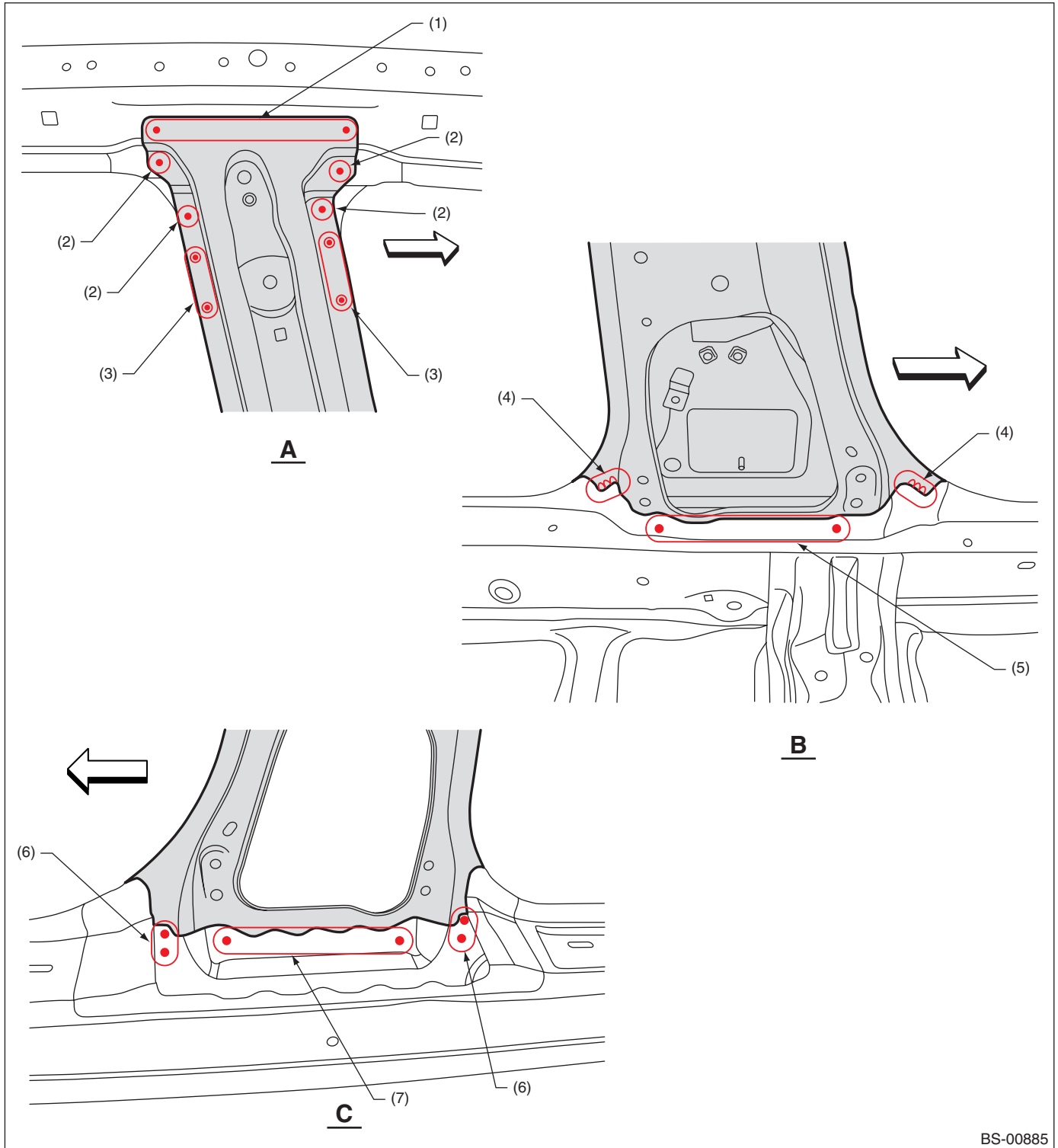


BS-00884

- |   |                             |                            |
|---|-----------------------------|----------------------------|
| (1) 2 points (outside · 1)                      | (3) 16 points (outside · 1) | (6) 2 points (top · 1)     |
| (2) Rough cutting (240 mm) outer, Reinforcement | (4) 5 points (outside · 1)  | (7) 9 points (outside · 1) |
|   | (5) 1 point (outside · 1)   | (8) 4 points (outside · 1) |

# Center Pillar (partial replacement)

## • Views



BS-00885

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

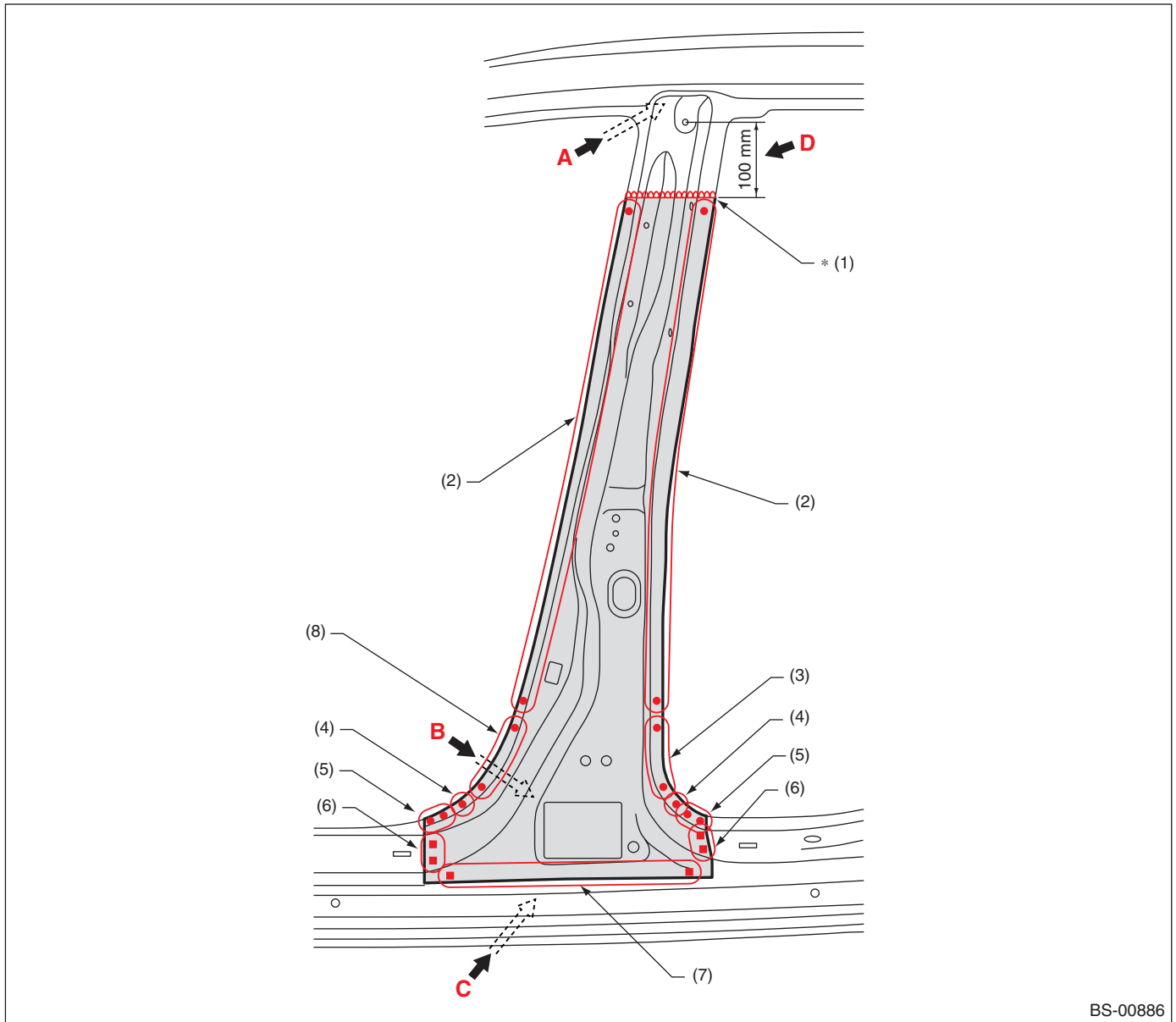
- (4) 1 point (inside · 1, belt sander)
- (5) 5 points (inside · 1)

- (6) 2 points (outside · 1, belt sander)
- (7) 5 points (outside · 1)

# Center Pillar (partial replacement)

## B: INSTALLATION

### • Overall view



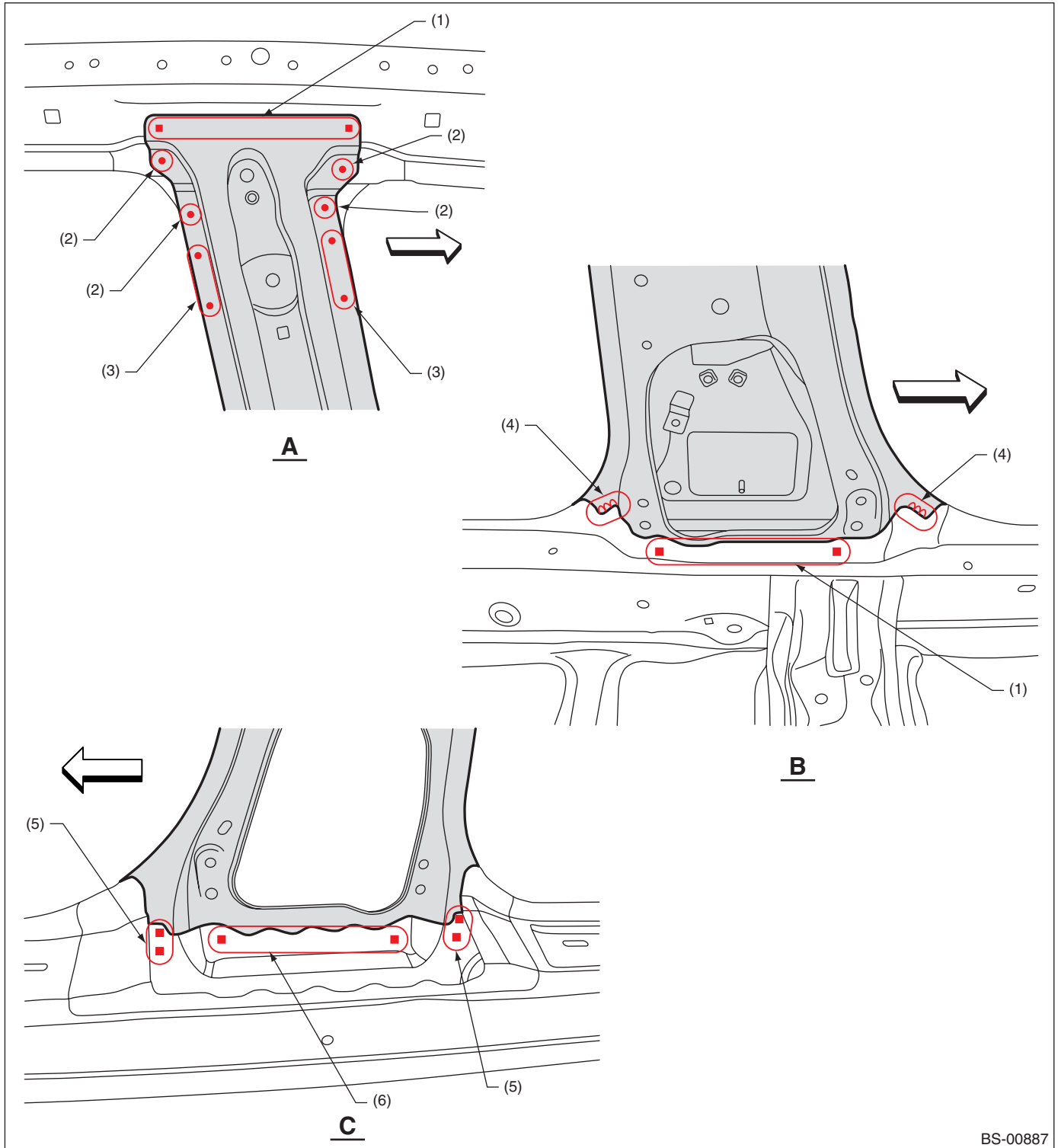
BS-00886

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



# Center Pillar (partial replacement)

## • Views



BS-00887

(1) 5 points (service)

(2) 1 point

(3) 3 points

(4) 1 point (15 mm)

(5) 2 points

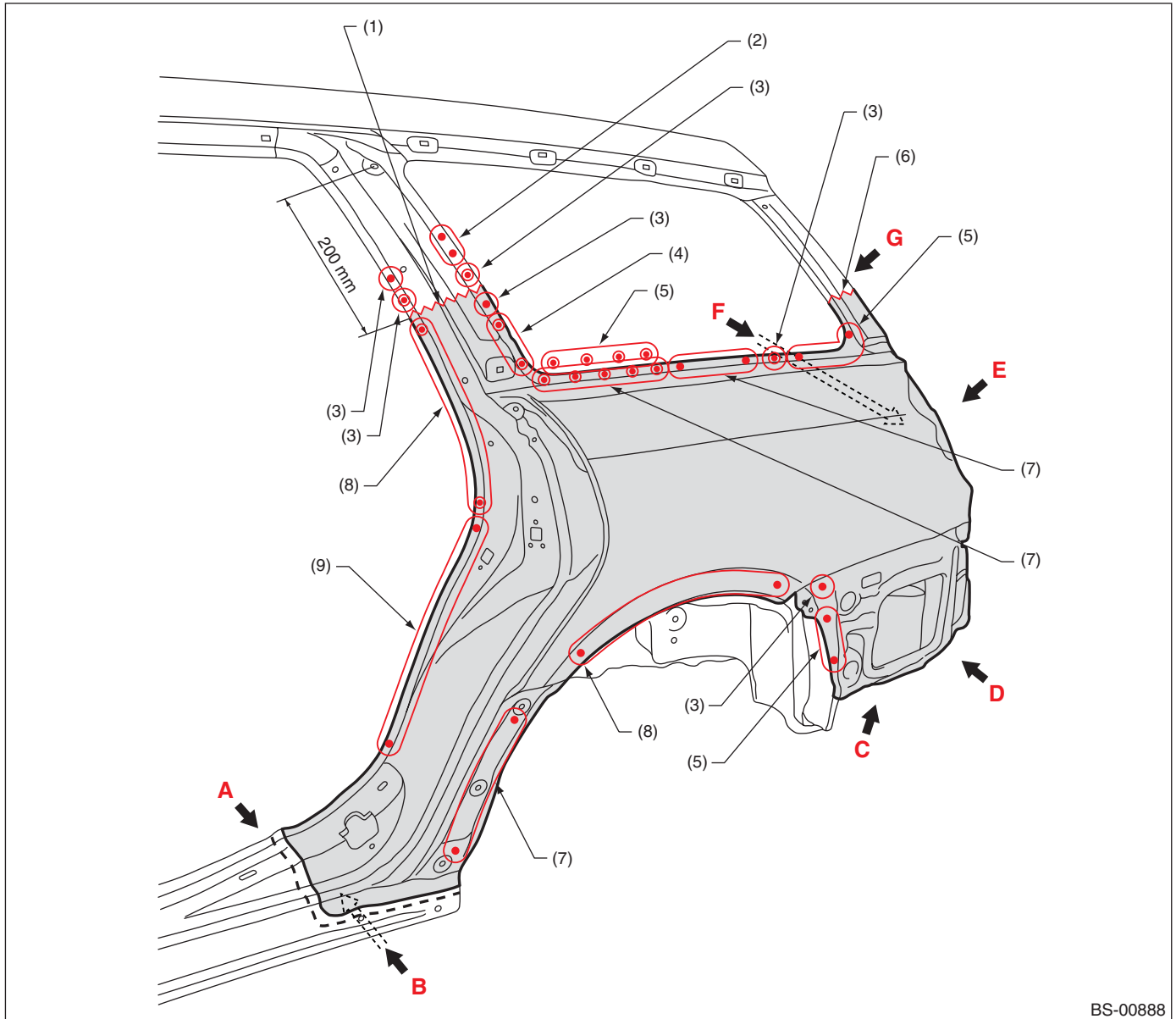
(6) 5 points

## Rear Quarter / Wagon (partial replacement)

### 23.Rear Quarter / Wagon (partial replacement)

#### A: REMOVAL

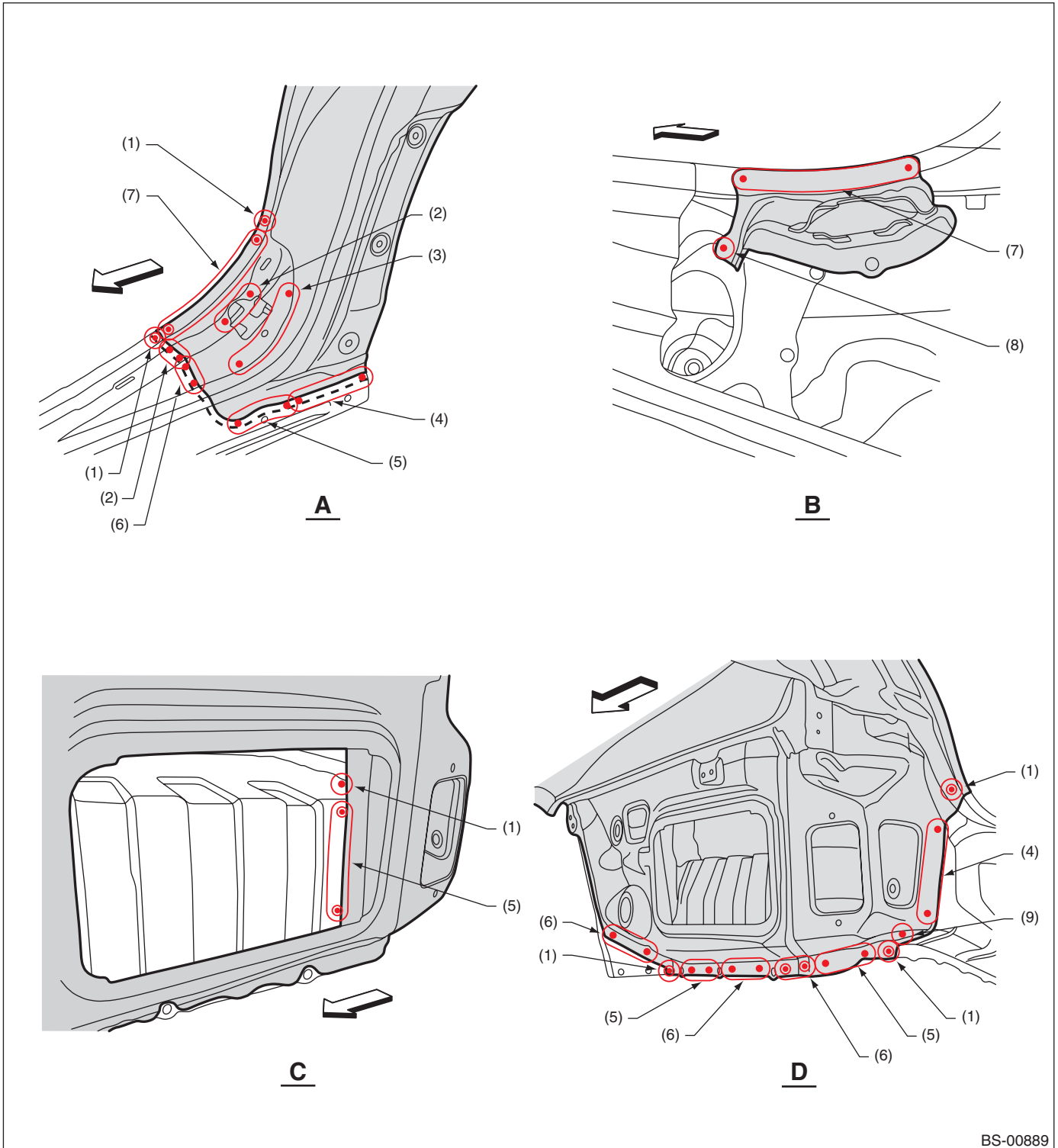
##### • Overall view



- |                            |                            |                             |
|----------------------------|----------------------------|-----------------------------|
| (1) Rough cutting (130 mm) | (4) 3 points (outside · 1) | (7) 5 points (outside · 1)  |
| (2) 2 points (outside · 1) | (5) 4 points (outside · 1) | (8) 8 points (outside · 1)  |
| (3) 1 point (outside · 1)  | (6) Rough cutting (170 mm) | (9) 12 points (outside · 1) |

# Rear Quarter / Wagon (partial replacement)

## • Views 1



BS-00889

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

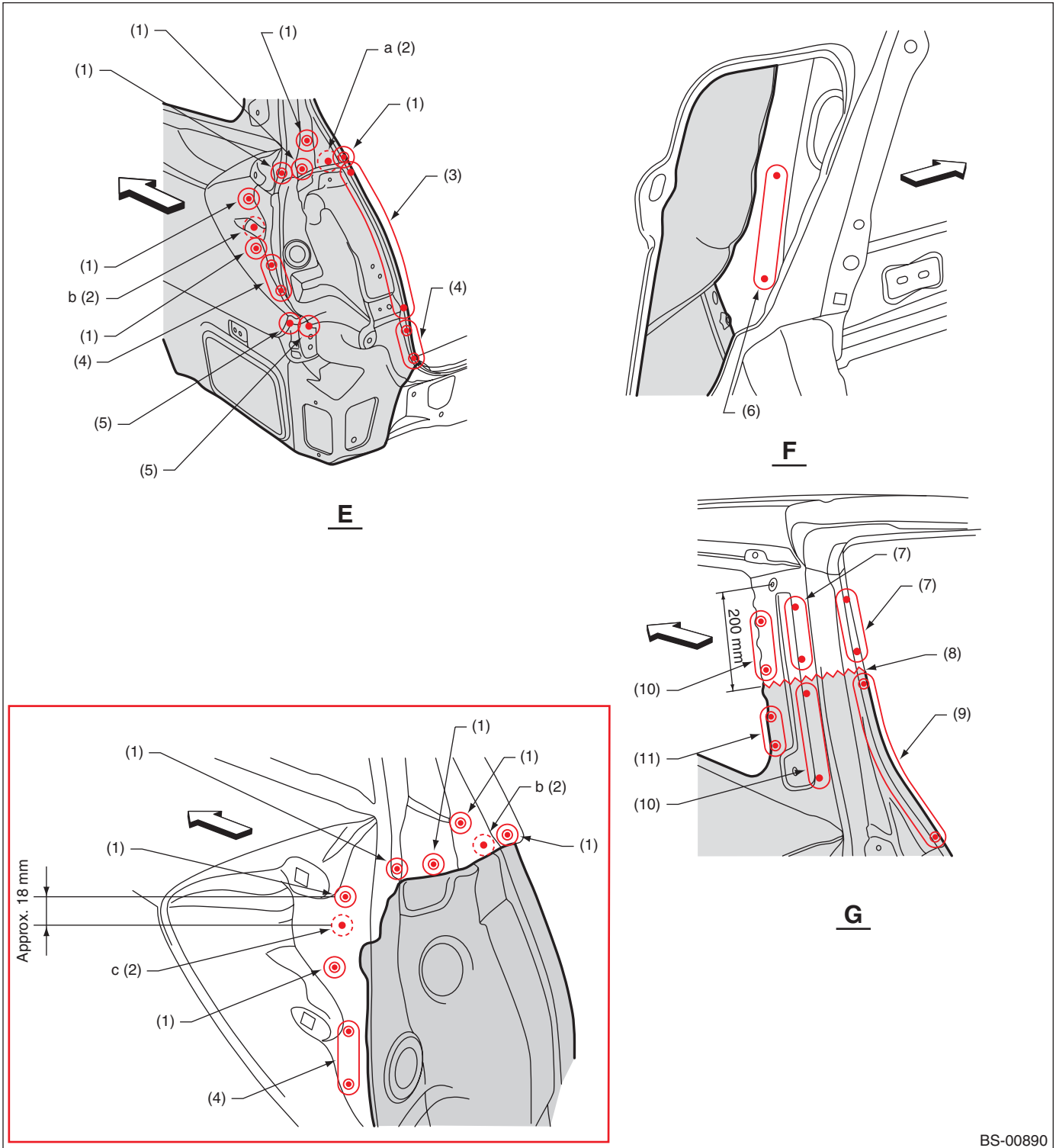
- (5) 3 points (outside · 1)
- (6) 2 points (outside · 1)
- (7) 4 points (outside · 1)

- (8) 1 point (outside · 1), hidden hit point
- (9) 1 point (bottom · 1)

- Rear quarter removal condition
- Detach the hidden hit point between the rear door catcher BKT and side sill reinforcement.

# Rear Quarter / Wagon (partial replacement)

## • Views 2



BS-00890

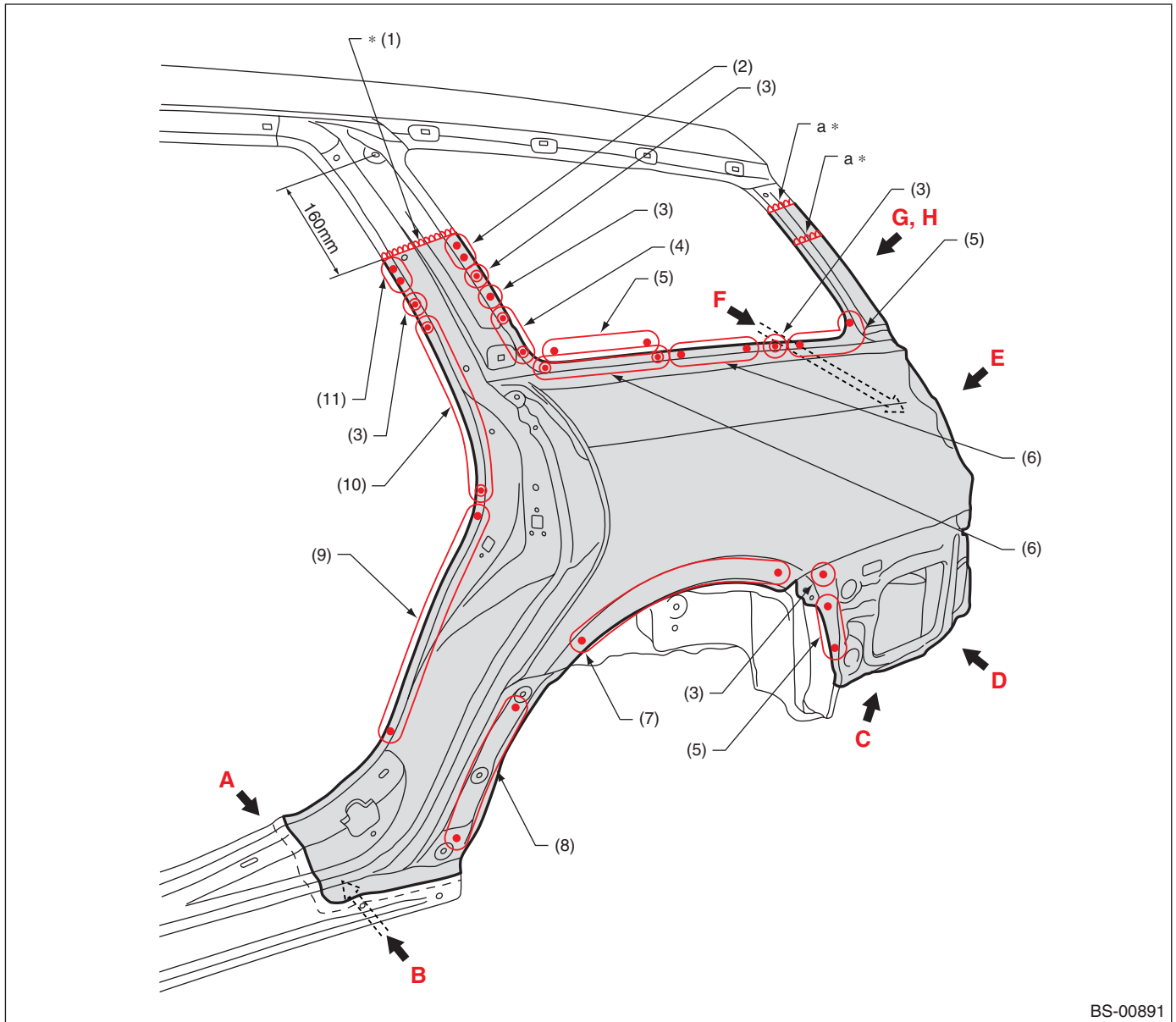
- |   |  |                             |
|---|--|-----------------------------|
| (1) 1 point (outside · 2)                   | (4) 2 points (outside · 2)             | (8) Rough cutting (170 mm)  |
| (2) 1 point (outside · 1), hidden hit point | (5) 1 point (outside · 1)              | (9) 6 points (outside · 1)  |
| (3) 9 points (outside · 1)                  | (6) 3 points (inside · 1, belt sander) | (10) 4 points (outside · 1) |
|   | (7) 3 points (outside · 1)             | (11) 2 points (outside · 1) |

POINT: When replacing the D-pillar by itself, there are two weld locations a and b (hidden hit point).

# Rear Quarter / Wagon (partial replacement)

## B: INSTALLATION

### • Overall view



BS-00891

(1) 1 point (130 mm)

(2) 3 points

(3) 1 point

(4) 4 points

(5) 5 points

(6) 6 points

(7) 9 points

(8) 7 points

(9) 14 points

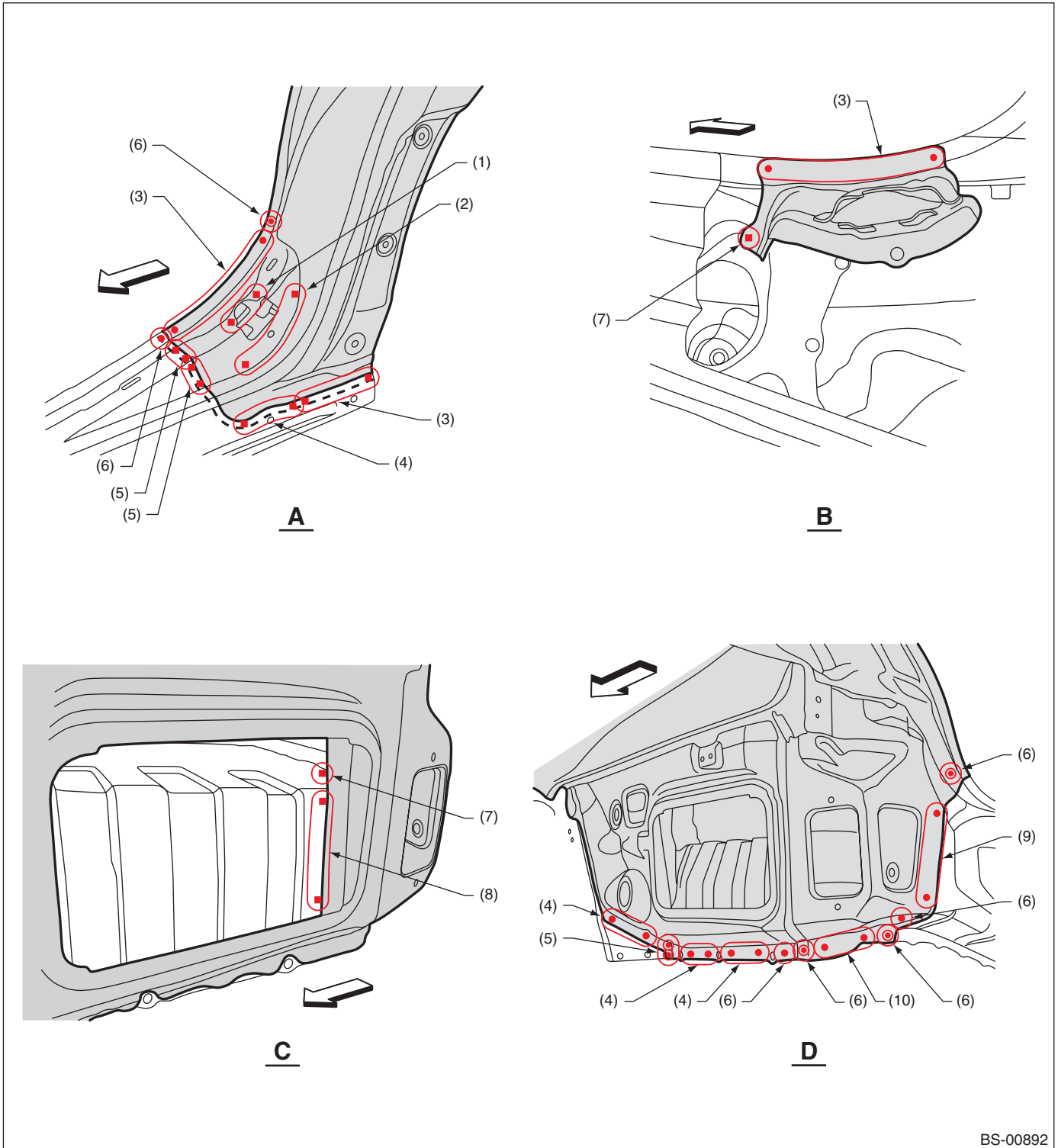
(10) 10 points

(11) 2 points

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

# Rear Quarter / Wagon (partial replacement)

## • Views 1



BS-00892

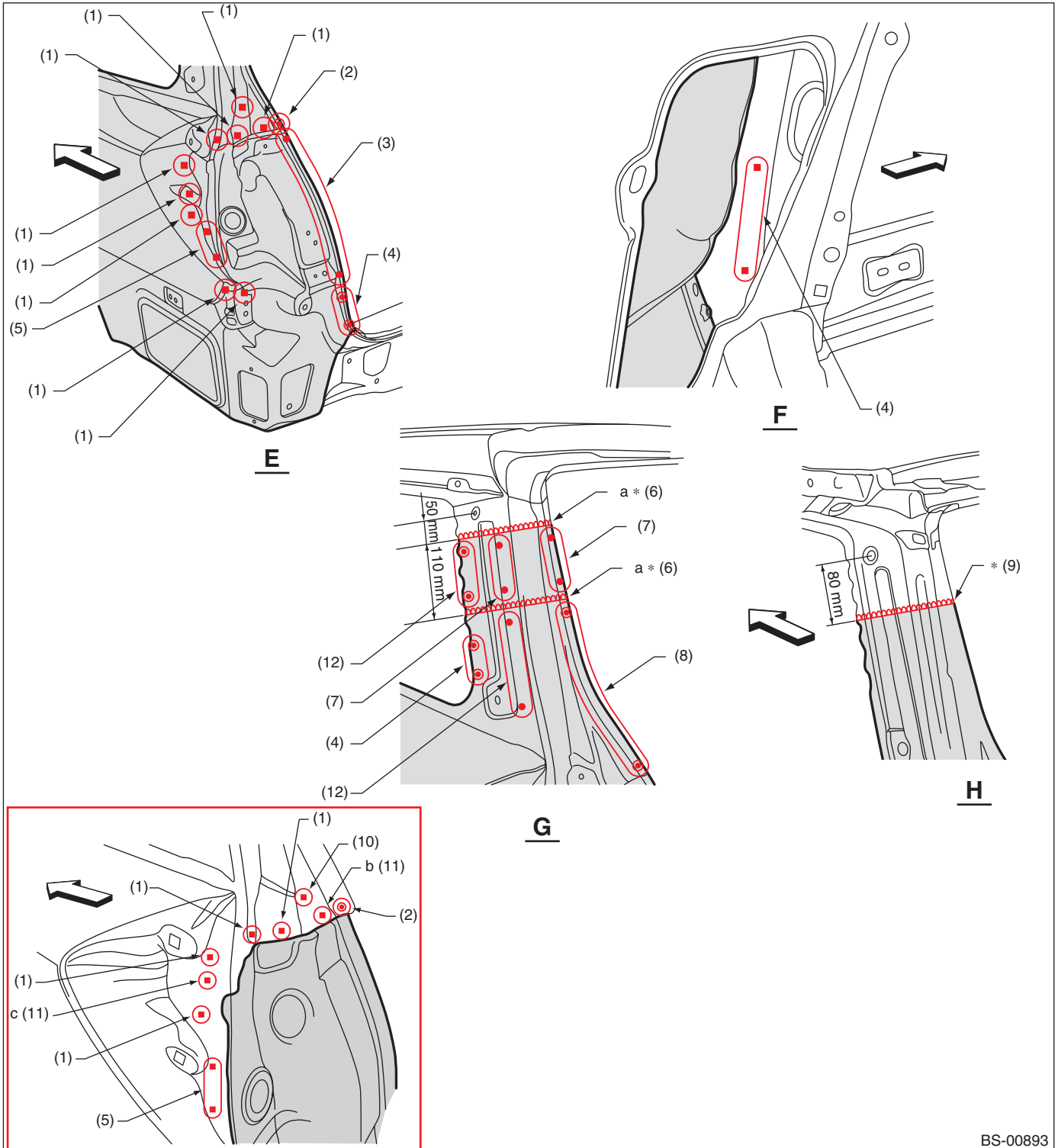
- (1) 2 points (service)
- (2) 4 points (service)
- (3) 5 points
- (4) 3 points

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

- (8) 3 points (service)
- (9) 6 points
- (10) 4 points

# Rear Quarter / Wagon (partial replacement)

## • Views 2



BS-00893

- |                        |                       |  |
|------------------------|-----------------------|--|
| (1) 1 point (service)  | (6) 2 points (170 mm) | (10) 1 point (outside · 2)                             |
| (2) 1 point            | (7) 4 points          | (11) 1 point (service · matching),<br>hidden hit point |
| (3) 10 points          | (8) 7 points          | (12) 5 points  |
| (4) 3 points           | (9) 1 point (170 mm)  |  |
| (5) 2 points (service) |                       |  |

POINT: When replacing the D-pillar by itself, there are two weld locations b and c (hidden hit point).

## Rear Quarter / Wagon (partial replacement)

---

**CAUTION:**

Repair weld location a (2 locations on the D-pillar) after butt welding the inner H.  
For continuous welds marked by \*, apply anticorrosion wax thoroughly on the reverse side.

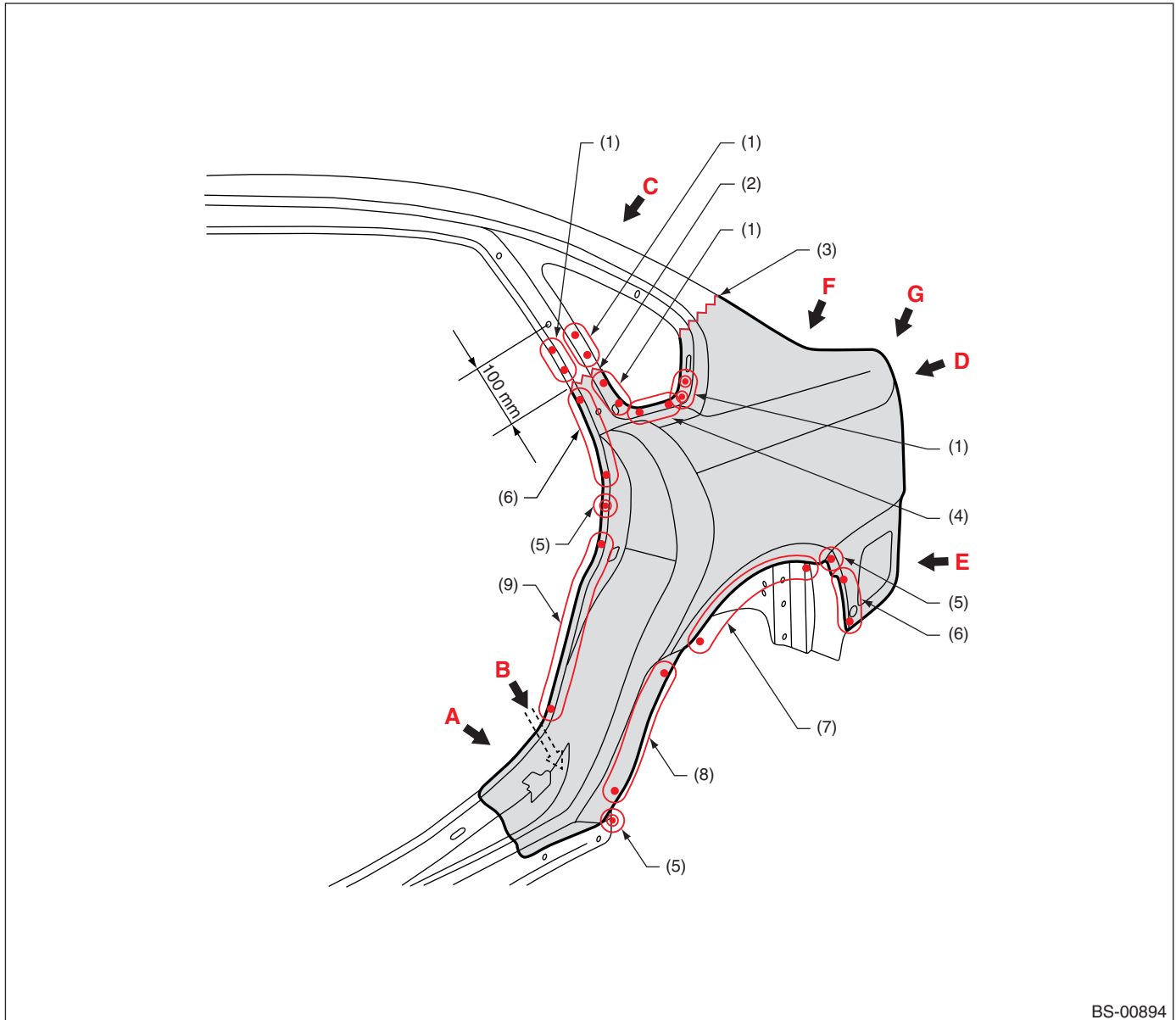


## Rear Quarter / Sedan (partial replacement)

### 24.Rear Quarter / Sedan (partial replacement)

#### A: REMOVAL

##### • Overall view

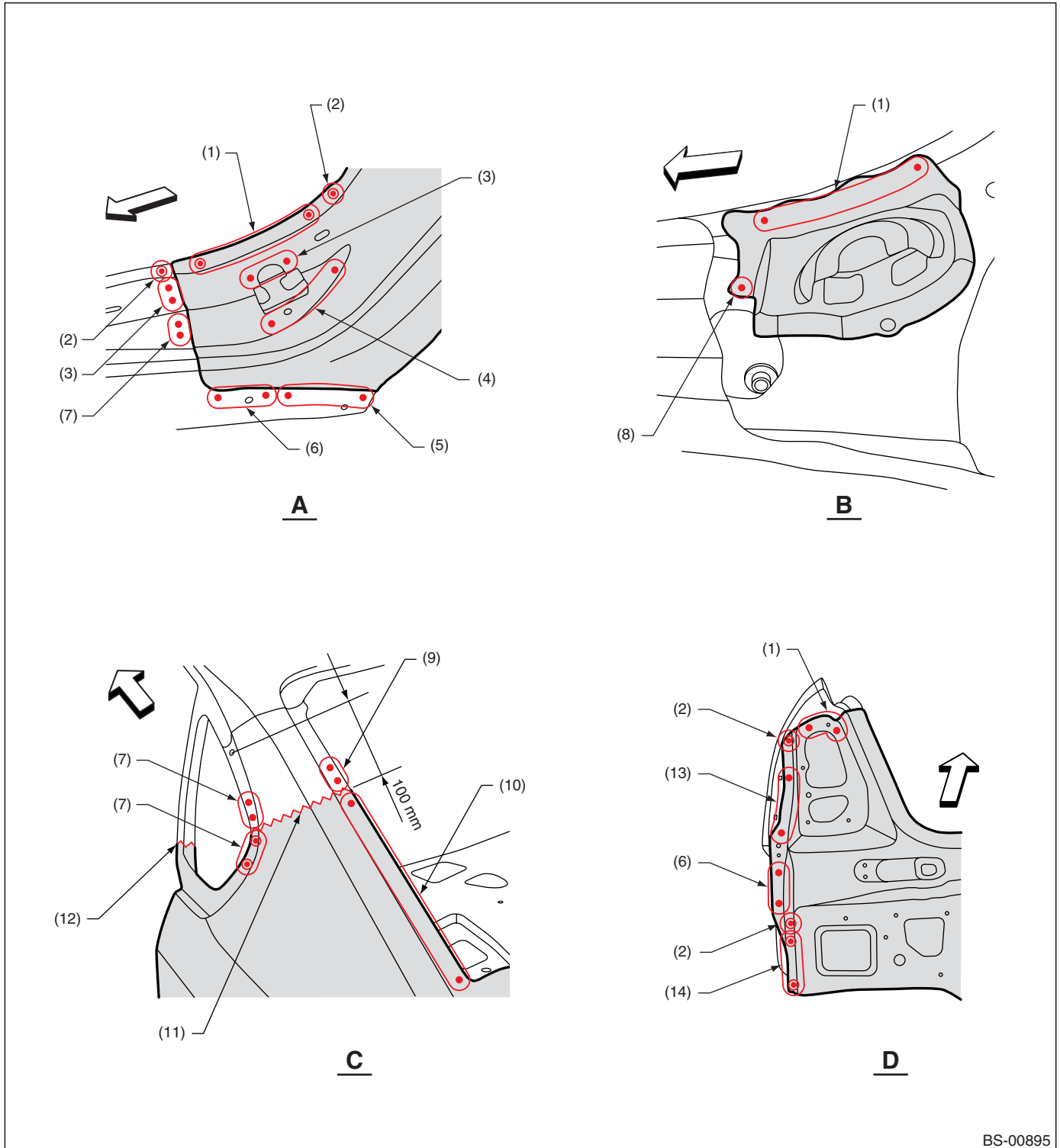


BS-00894

- |                            |                            |                             |
|----------------------------|----------------------------|-----------------------------|
| (1) 2 points (outside · 1) | (4) 3 points (outside · 1) | (7) 8 points (bottom · 1)   |
| (2) Rough cutting (80 mm)  | (5) 1 point (outside · 1)  | (8) 5 points (outside · 1)  |
| (3) Rough cutting (230 mm) | (6) 4 points (outside · 1) | (9) 12 points (outside · 1) |

## Rear Quarter / Sedan (partial replacement)

### • Views 1



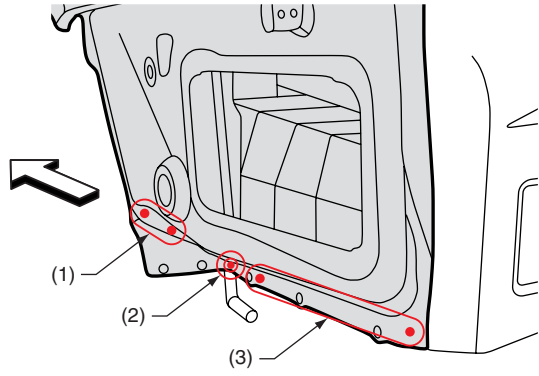
BS-00895

- |                            |   |                             |
|----------------------------|---|-----------------------------|
| (1) 4 points (outside · 1) | (6) 3 points (outside · 1)                  | (10) 8 points (top · 1)     |
| (2) 1 point (outside · 1)  | (7) 2 points (outside · 1)                  | (11) Rough cutting (230 mm) |
| (3) 2 points (top · 1)     | (8) 1 point (outside · 1), hidden hit point | (12) Rough cutting          |
| (4) 4 points (top · 1)     | (9) 3 points (top · 1)                      | (13) 6 points (outside · 1) |
| (5) 5 points (outside · 1) |   | (14) 4 points (outside · 2) |

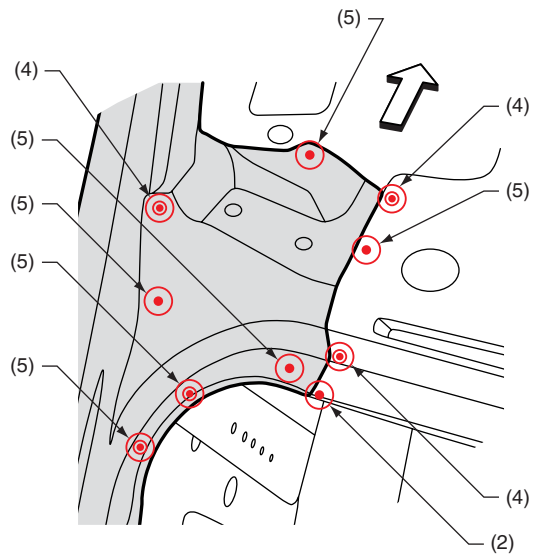
- Rear quarter removal condition
- Detach the hidden hit point between the rear door catcher bracket and side sill reinforcement.

# Rear Quarter / Sedan (partial replacement)

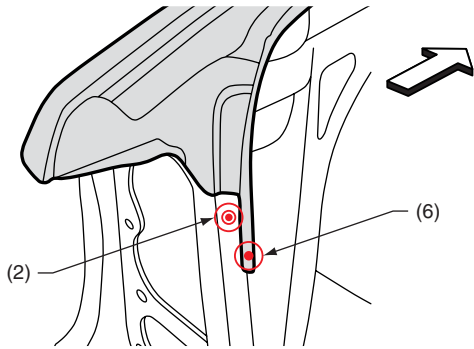
## • Views 2



E



F



G

BS-00896

(1) 2 points (outside · 1)

(2) 1 point (outside · 1)

(3) 7 points (outside · 1)

(4) 1 point (top · 2)

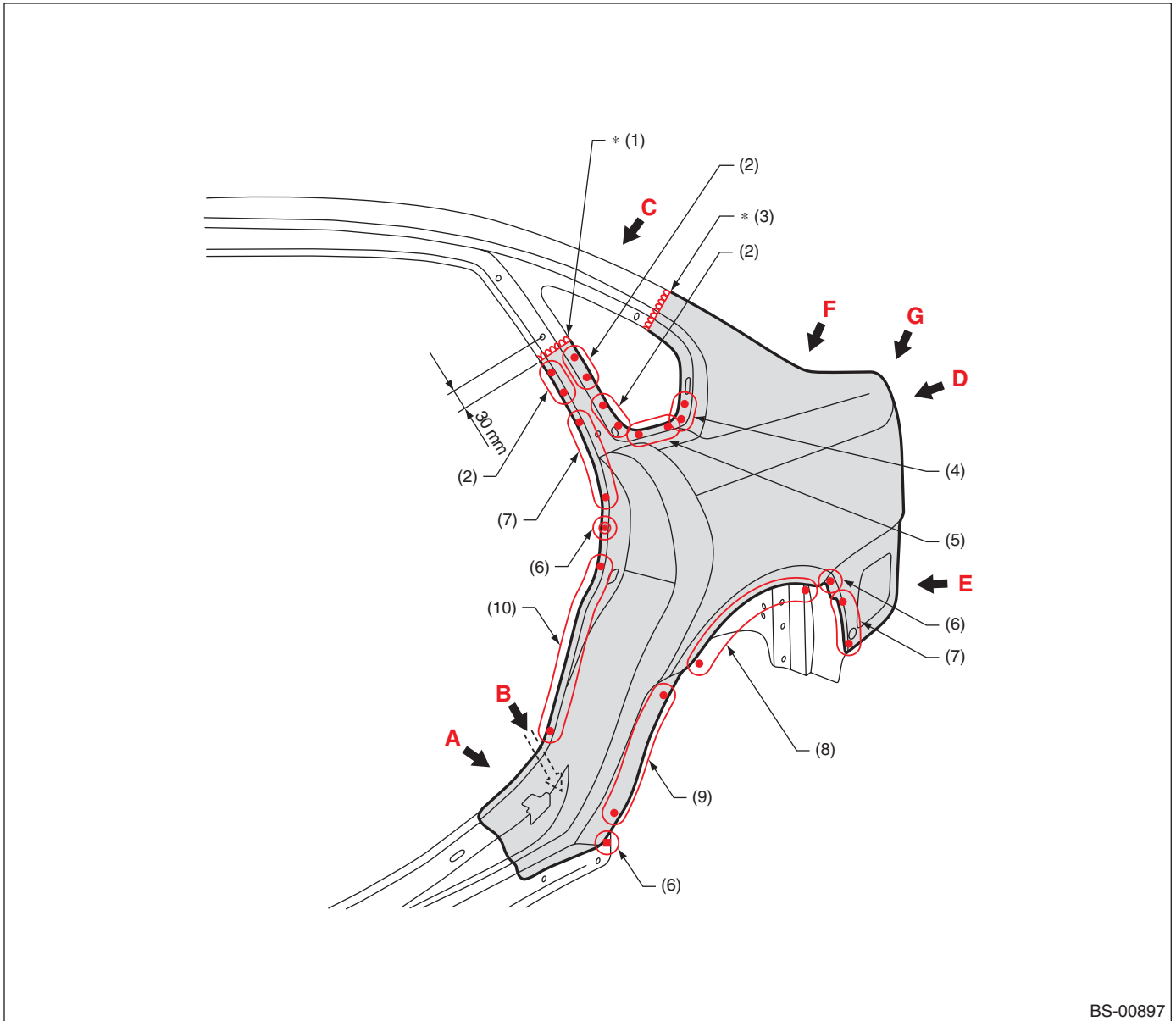
(5) 1 point (top · 1)

(6) 1 point (inside · 1)

# Rear Quarter / Sedan (partial replacement)

## B: INSTALLATION

### • Overall view



BS-00897

- (1) 1 point (80 mm)
- (2) 3 points
- (3) 1 point (210 mm)
- (4) 2 points

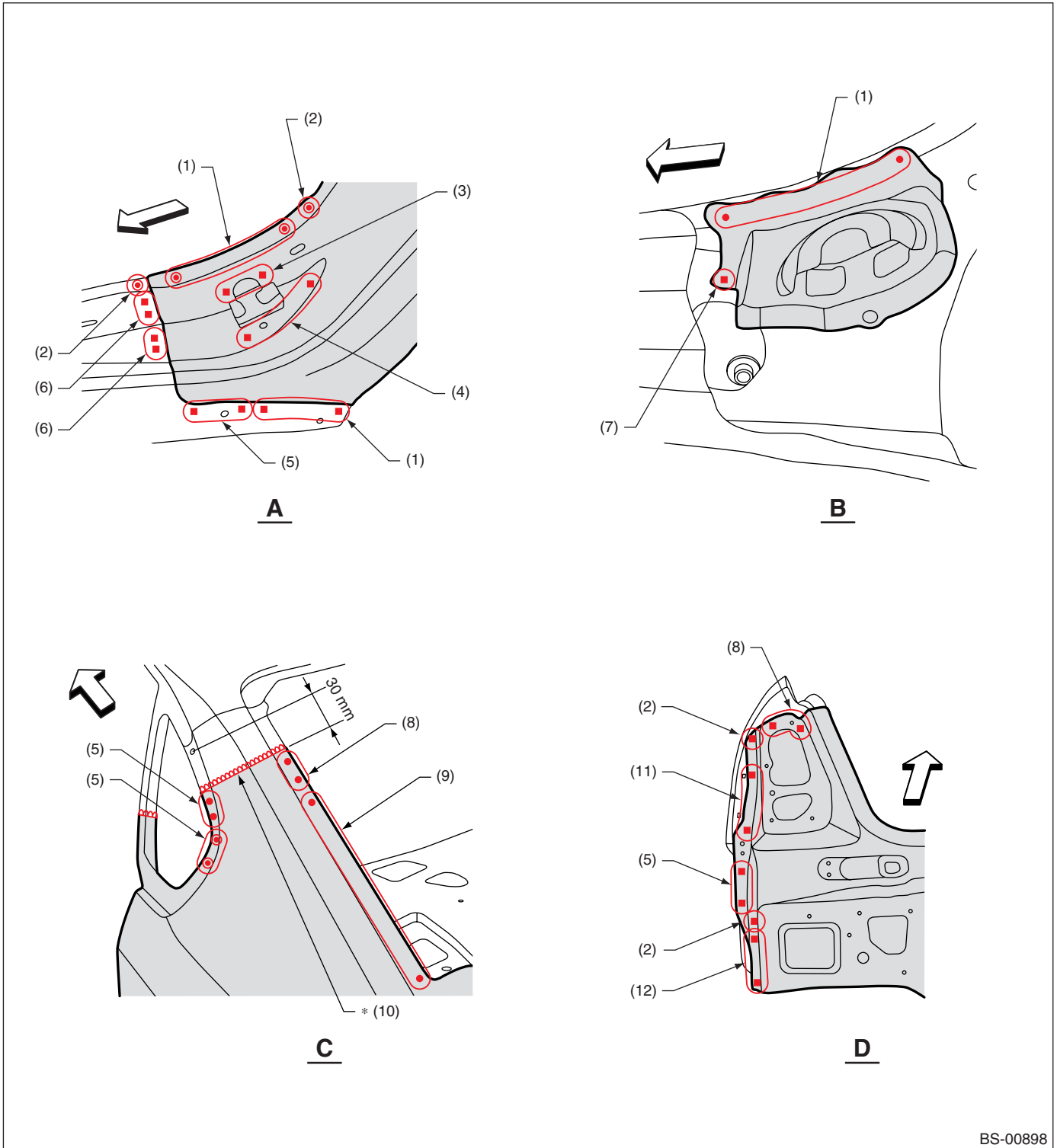
- (5) 4 points
- (6) 1 point
- (7) 5 points

- (8) 11 points
- (9) 6 points
- (10) 15 points

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

# Rear Quarter / Sedan (partial replacement)

## • Views 1



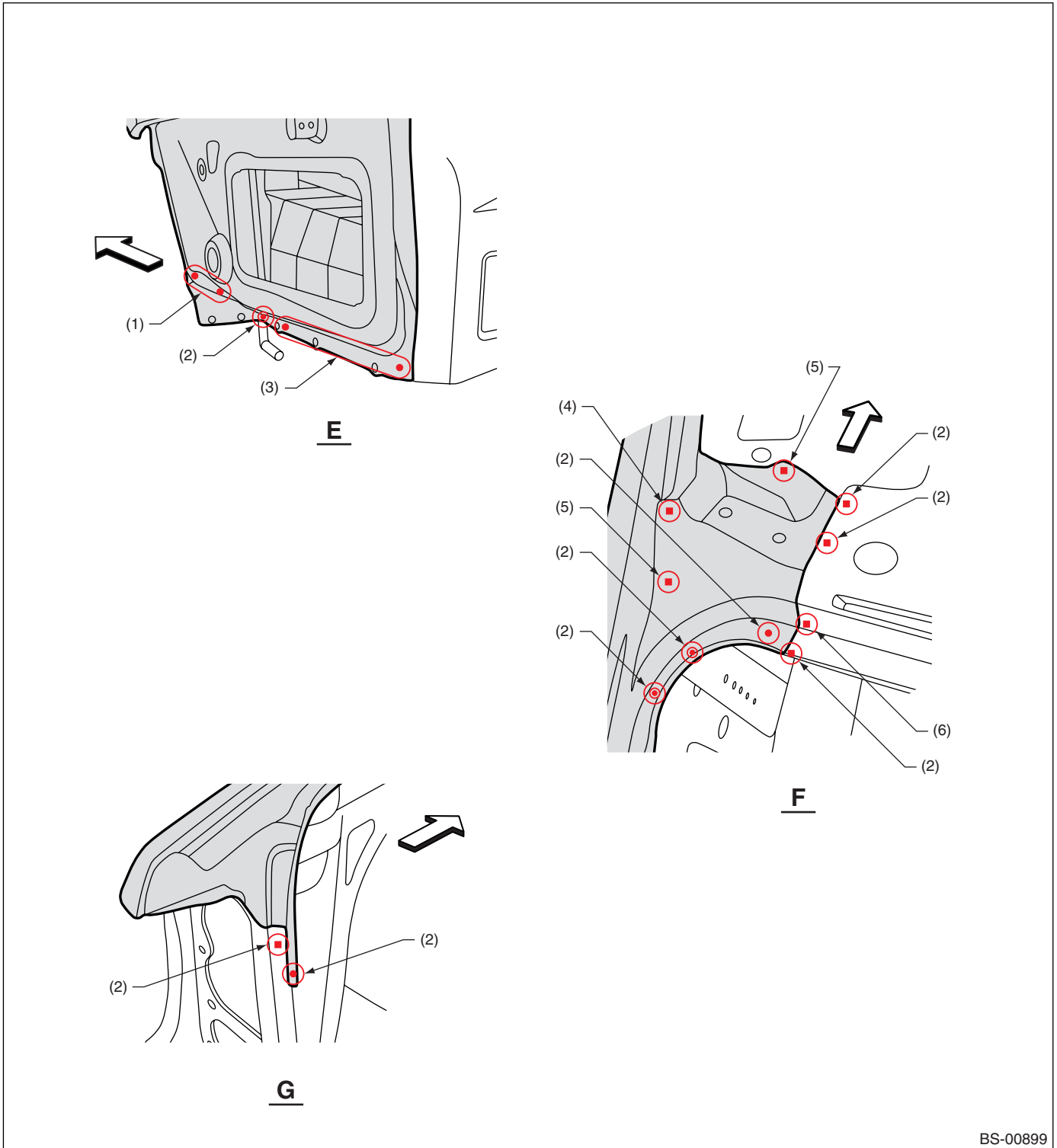
BS-00898

- |                        |   |                          |
|------------------------|---|--------------------------|
| (1) 5 points           | (5) 3 points                            | (9) 10 points            |
| (2) 1 point            | (6) 2 points                            | (10) 1 point (230 mm)    |
| (3) 2 points (service) | (7) 1 point (service), hidden hit point | (11) 6 points            |
| (4) 4 points (service) | (8) 4 points                            | (12) 4 points (matching) |

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

# Rear Quarter / Sedan (partial replacement)

## • Views 2



BS-00899

(1) 3 points

(2) 1 point

(3) 9 points

(4) 1 point (service · matching)

(5) 1 point (service)

(6) 1 point (matching)

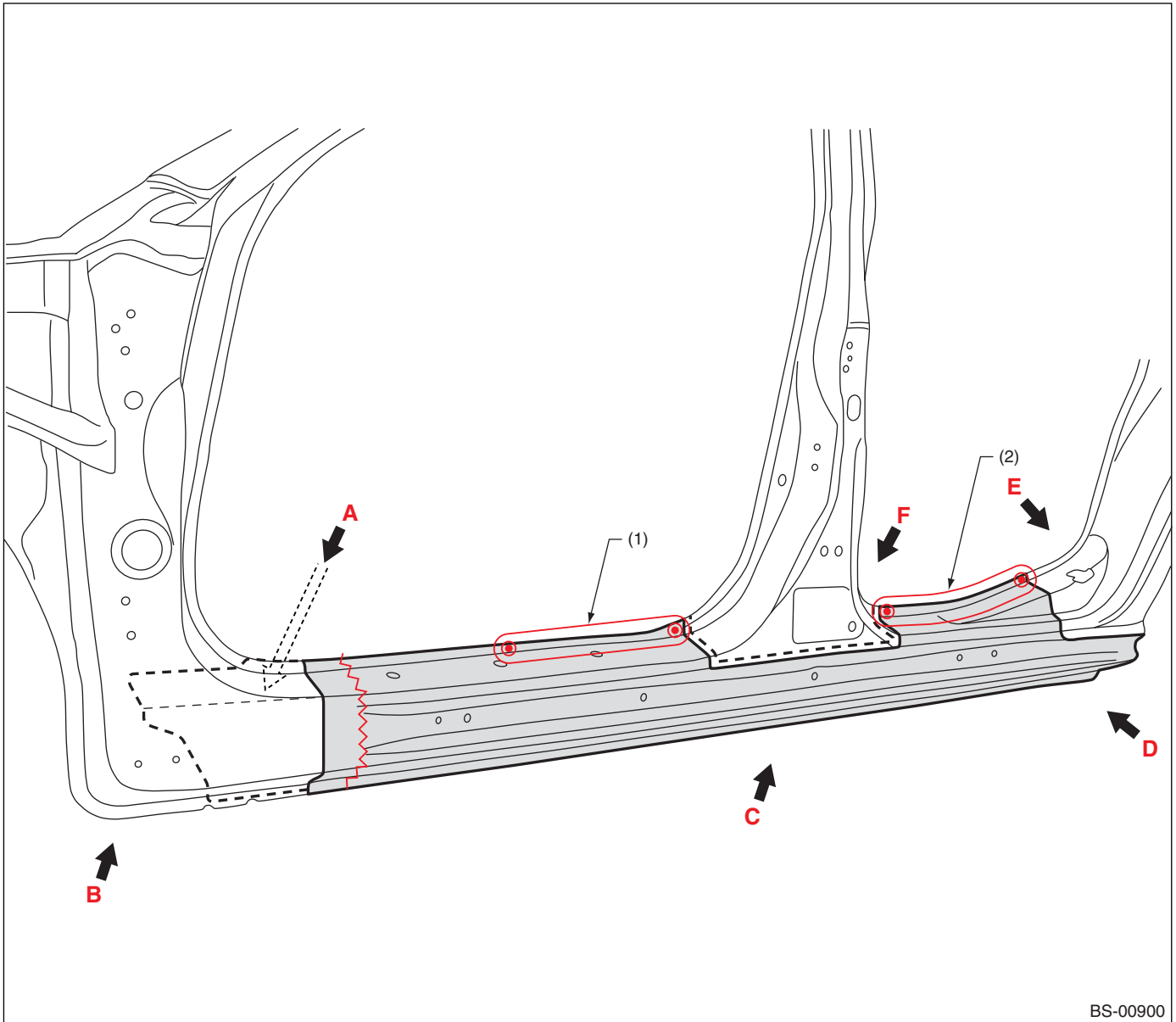
For continuous welds marked by \*, apply anticorrosion wax thoroughly on the reverse side.

# Side Sill Outer (partial replacement)

## 25.Side Sill Outer (partial replacement)

### A: REMOVAL

- Overall view



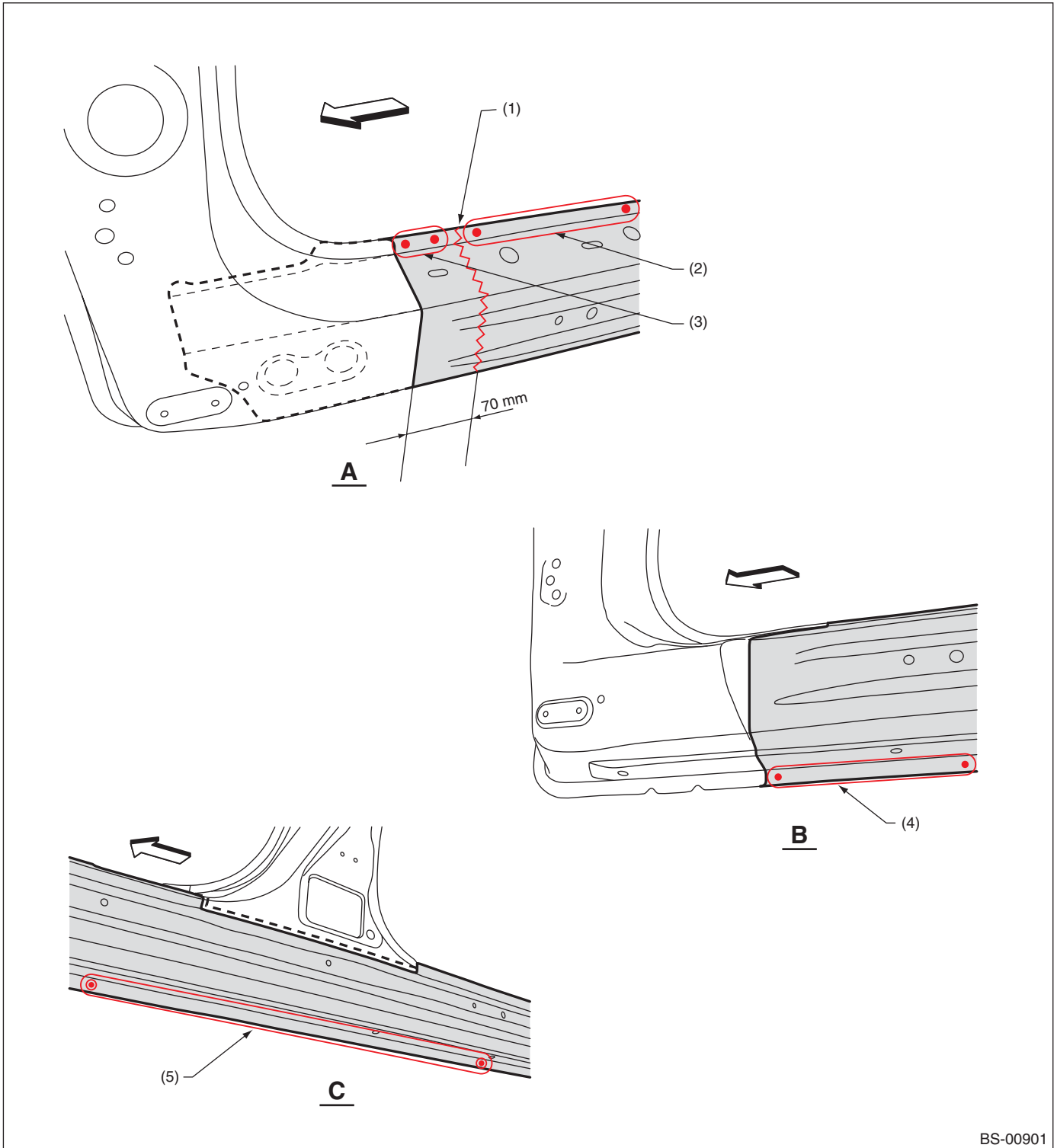
BS-00900

(1) 7 points (outside · 1)

(2) 13 points (outside · 1)

# Side Sill Outer (partial replacement)

## • Views 1



(1) Cut (270 mm)

(2) 6 points (outside · 1)

(3) 2 points (outside · 1)

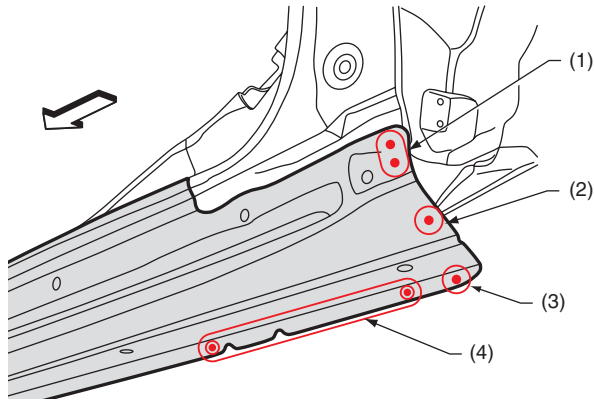
(4) 9 points (outside · 1)

(5) 24 points (outside · 1)

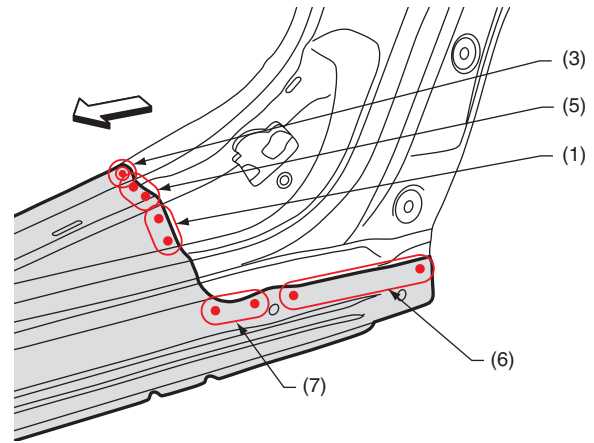
- The side sill outer is inside the front pillar
- (1) is to make work easier.



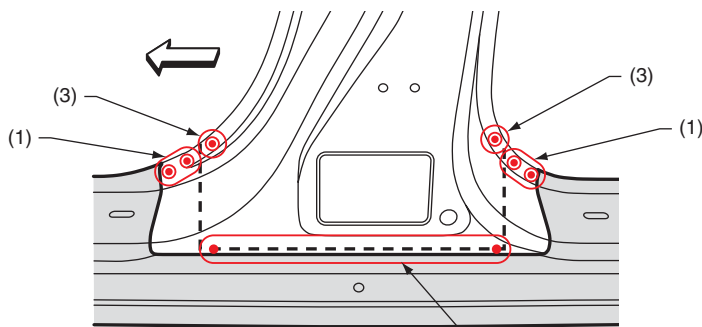
## Side Sill Outer (partial replacement)



**D**



**E**



**F**

BS-00902

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

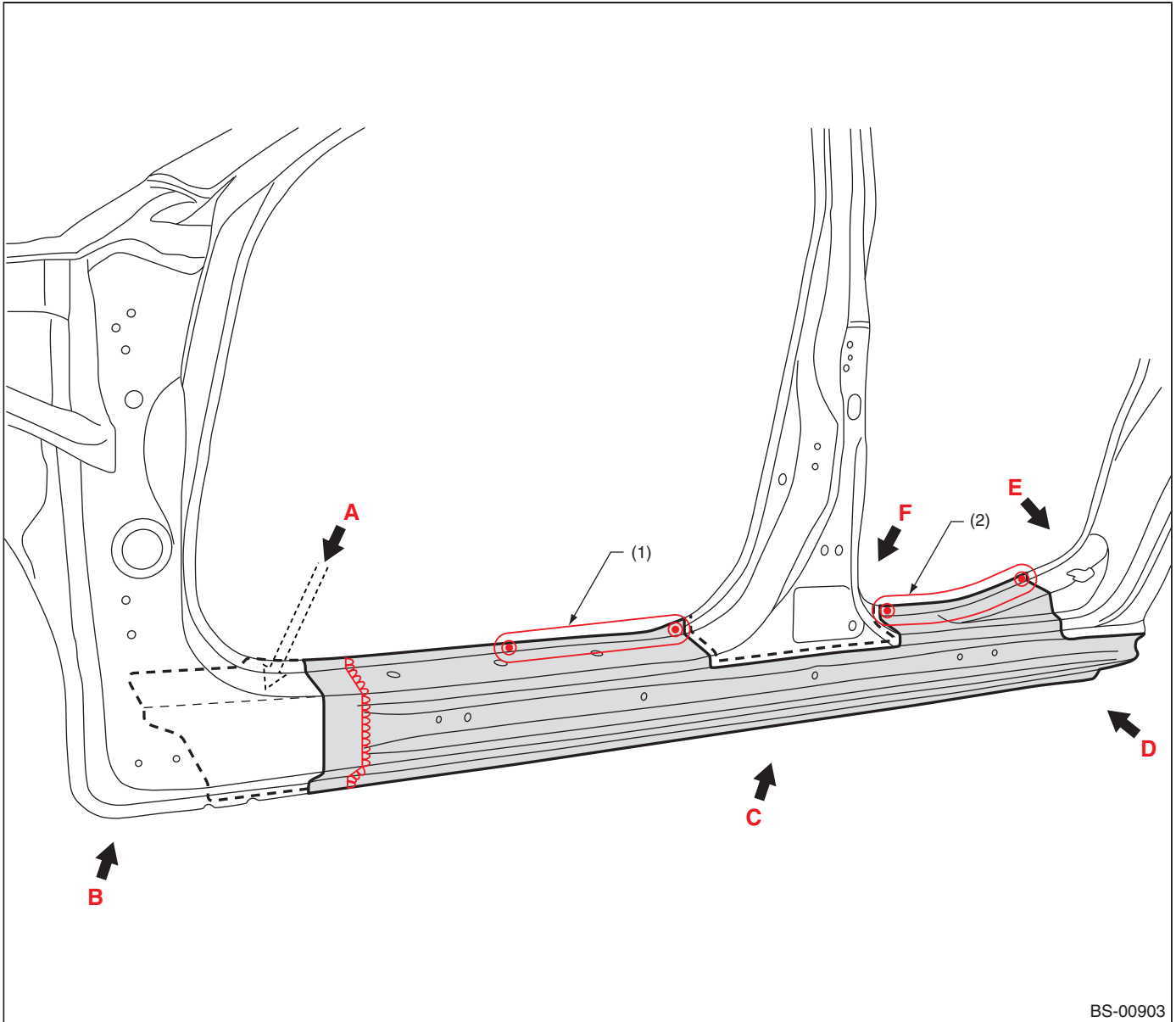
- (4) 10 points (outside · 1)
- (5) 2 points (top · 1)
- (6) 5 points (outside · 1)

- (7) 3 points (outside · 1)
- (8) 9 points (outside · 1)

# Side Sill Outer (partial replacement)

## B: INSTALLATION

- Overall view



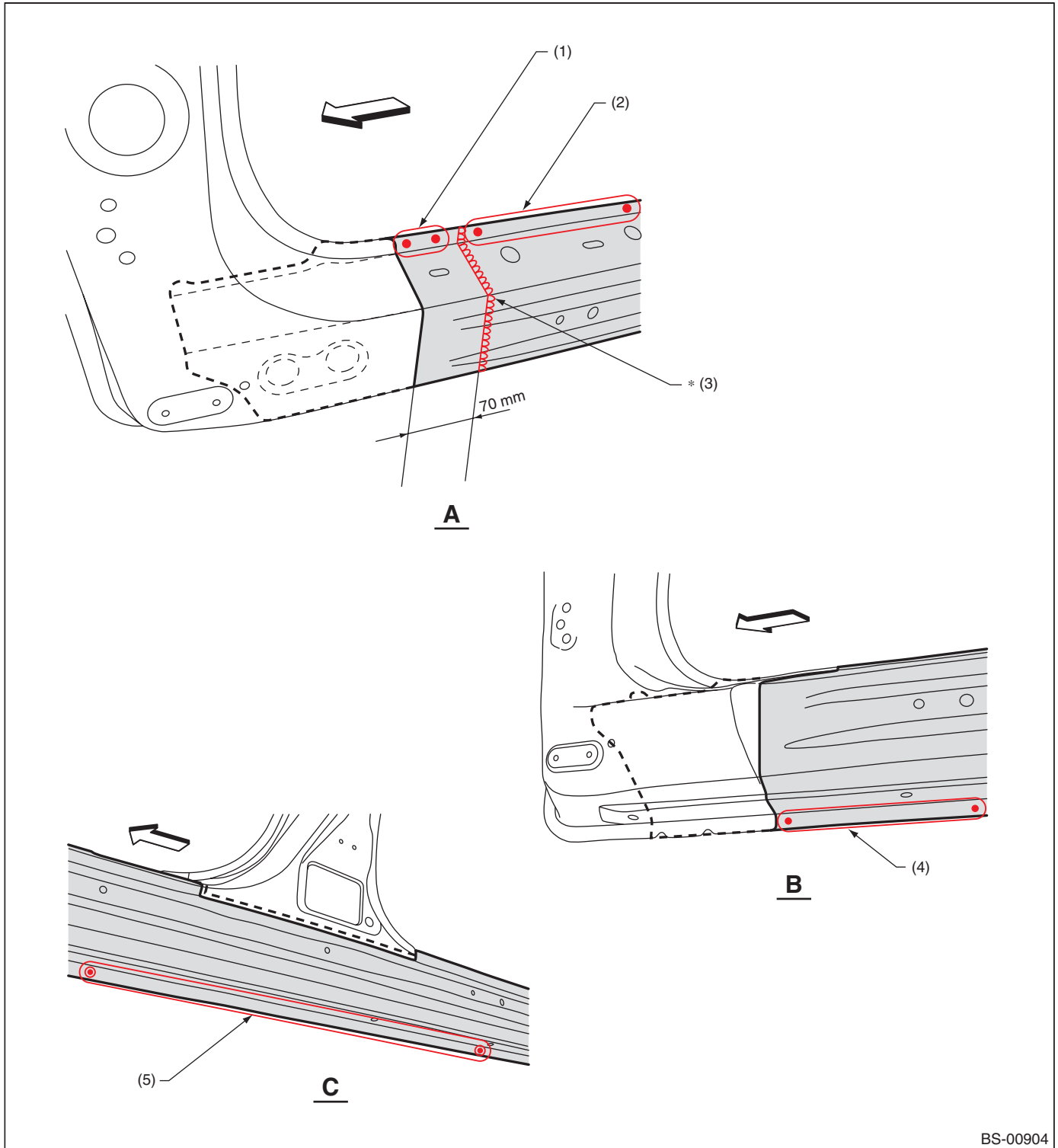
(1) 9 points

(2) 16 points

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

# Side Sill Outer (partial replacement)

## • Views 1



BS-00904

(1) 3 points  
(2) 7 points

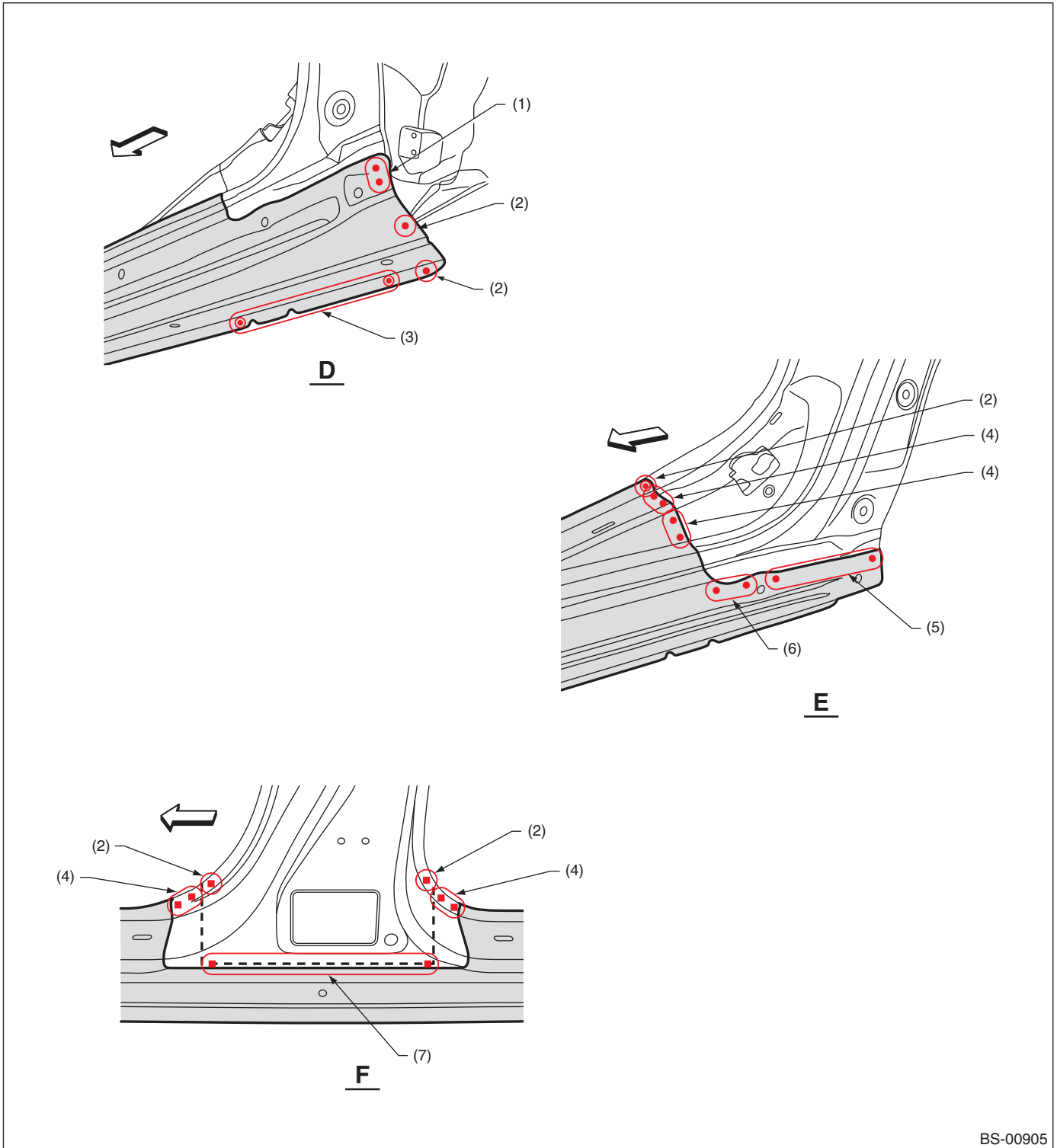
(3) 1 point (270 mm)  
(4) 11 points

(5) 29 points

- The side sill outer is inside the front pillar.
- For continuous welds marked by \*, apply anticorrosion wax thoroughly on the reverse side.

# Side Sill Outer (partial replacement)

## • Views 2



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

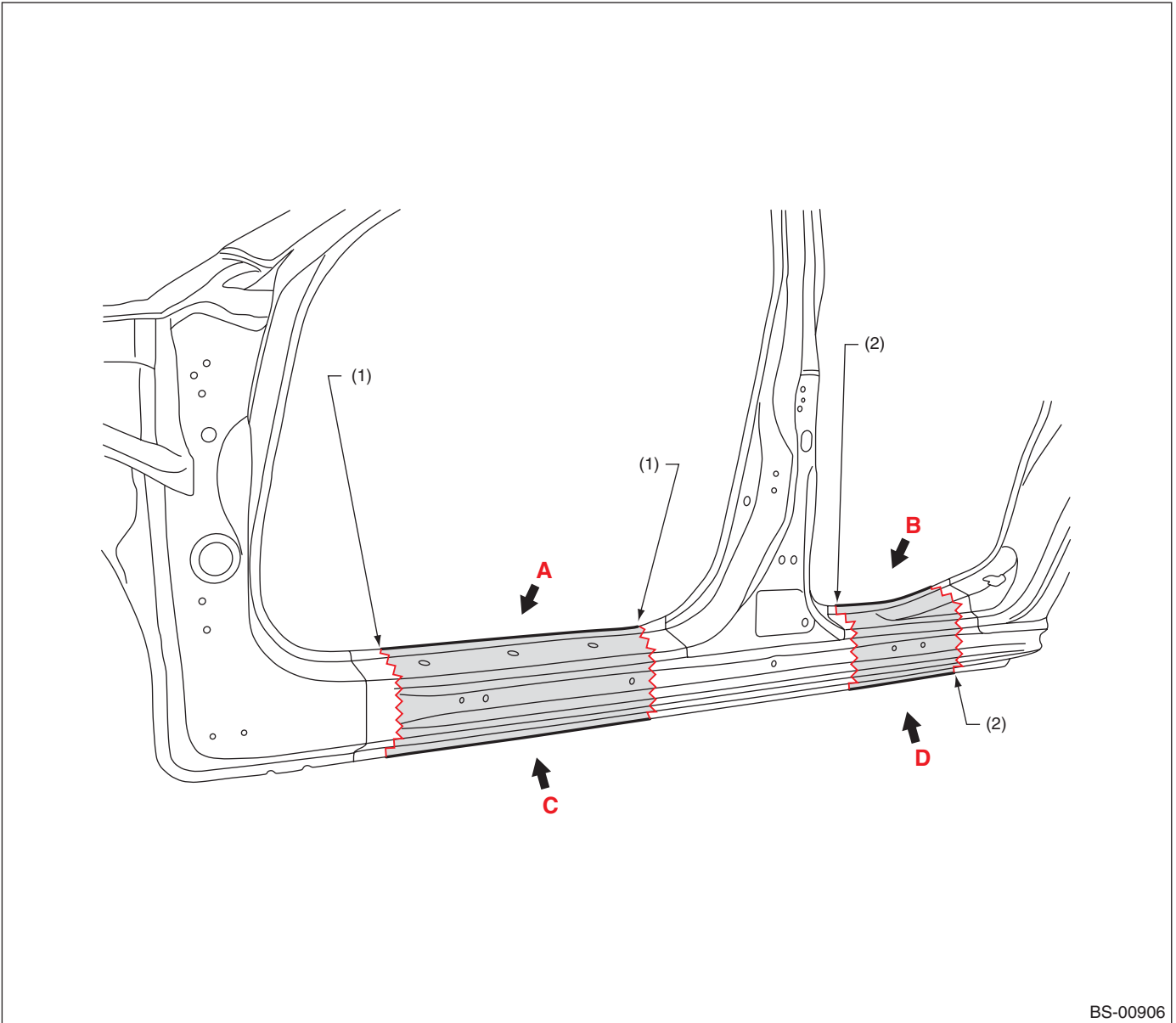
- (4) 2 points
- (5) 6 points

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

# Side Sill Outer (partial replacement)

## C: REMOVAL

- Overall view



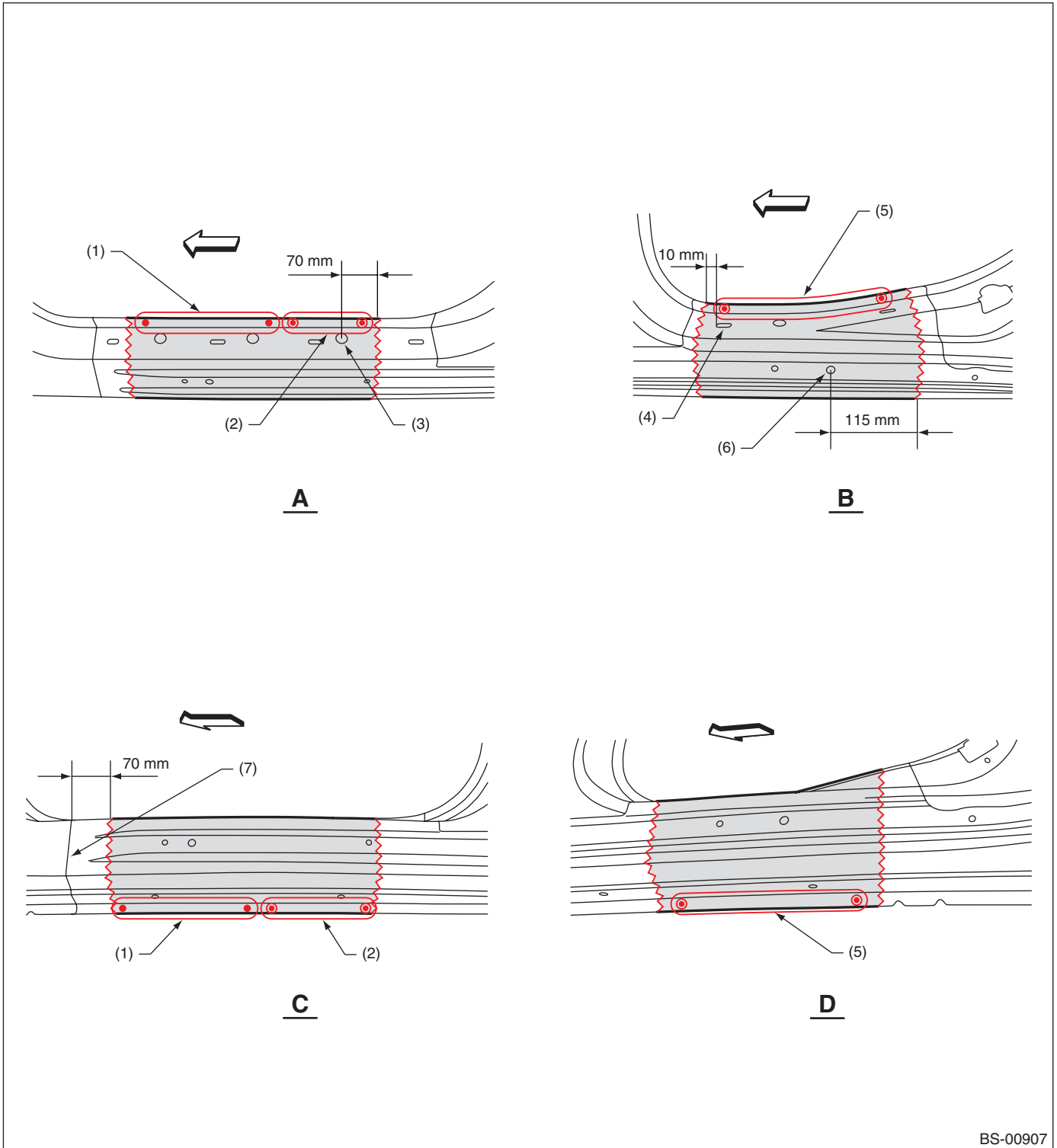
BS-00906

(1) Front cutting position (270 mm)  
(for butt welding)

(2) Rear cutting position (270 mm)  
(for butt welding)

# Side Sill Outer (partial replacement)

## • Views



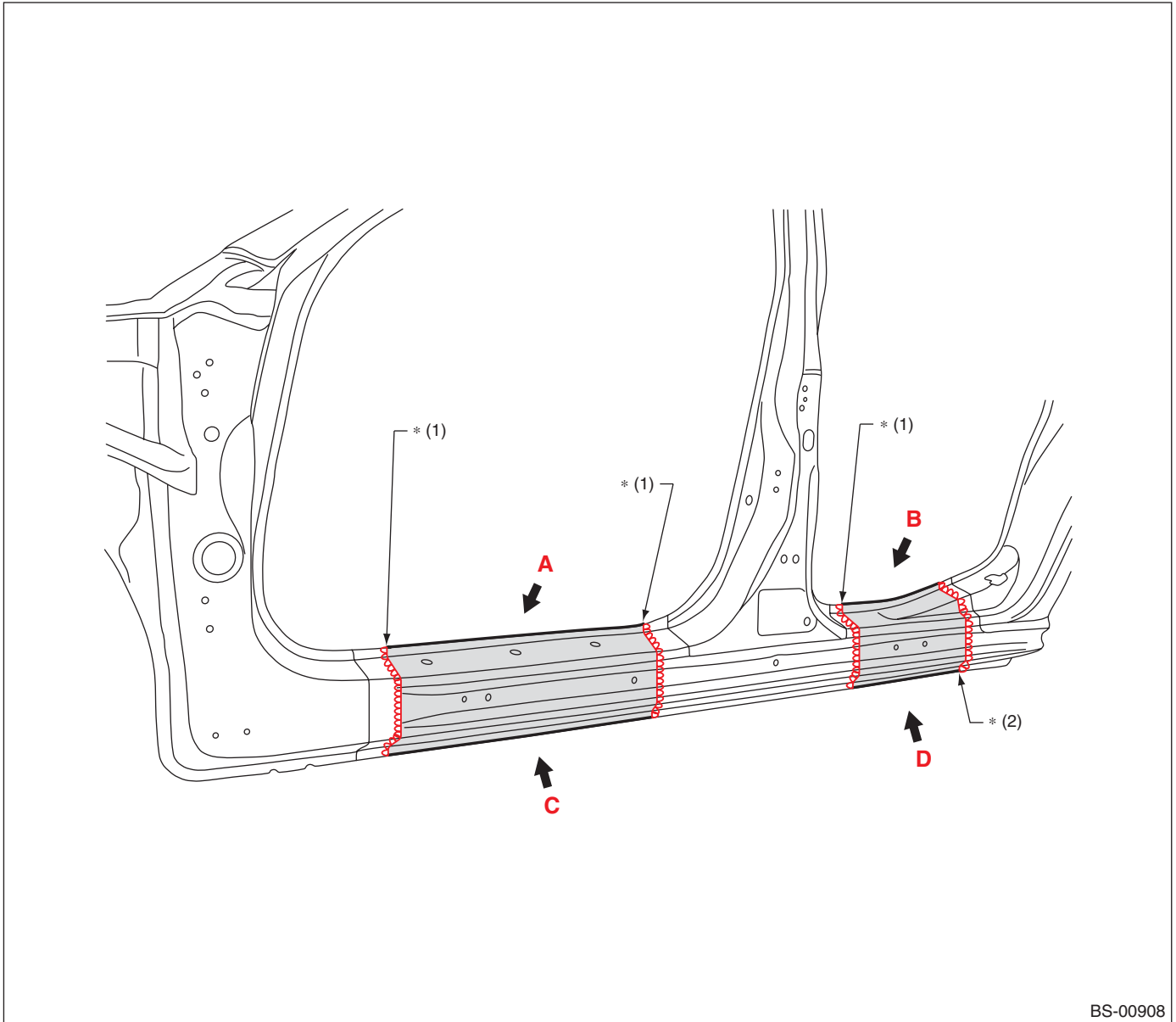
BS-00907

- |                            |                             |                     |
|----------------------------|-----------------------------|---------------------|
| (1) 7 points (outside · 1) | (4) 8 × 25 elongated hole   | (6) 12 mm dia. hole |
| (2) 5 points (outside · 1) | (5) 10 points (outside · 1) | (7) Front pillar    |
| (3) 20 mm dia. hole        |                             |                     |

## Side Sill Outer (partial replacement)

### D: INSTALLATION

- Overall view



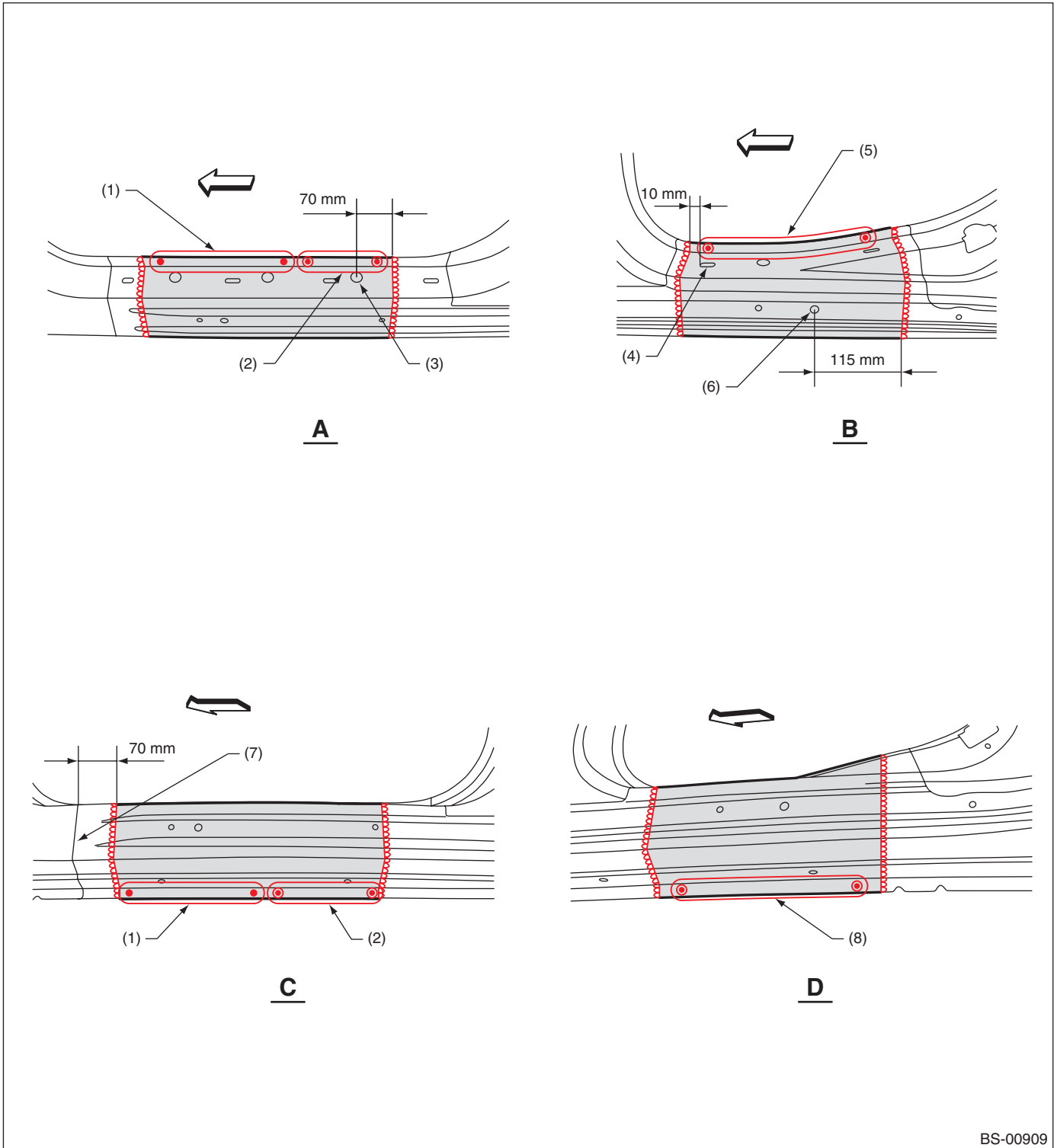
BS-00908

(1) 1 point (270 mm) (butt welding)      (2) 1 point (300 mm) (butt welding)

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

# Side Sill Outer (partial replacement)

## • Views



BS-00909

- (1) 9 points
- (2) 7 points
- (3) 20 mm dia. hole

- (4) 8 x 25 elongated hole
- (5) 14 points
- (6) 12 mm dia. hole

- (7) Front pillar
- (8) 13 points

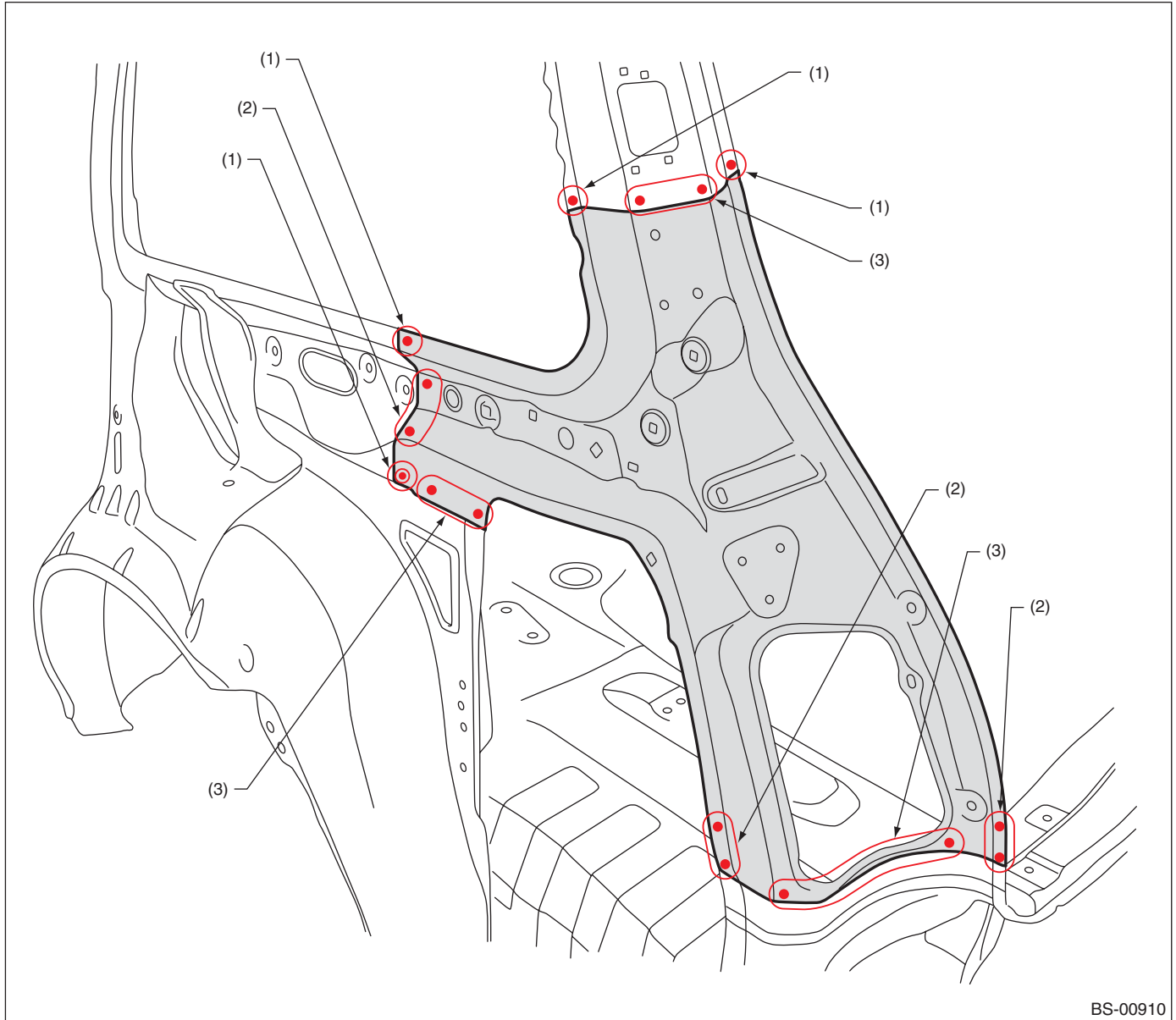


# Rear Quarter Upper / Wagon (total replacement)

## 26.Rear Quarter Upper / Wagon (total replacement)

### A: REMOVAL

1) Rear quarter and reinforcement D-pillar removed condition



BS-00910

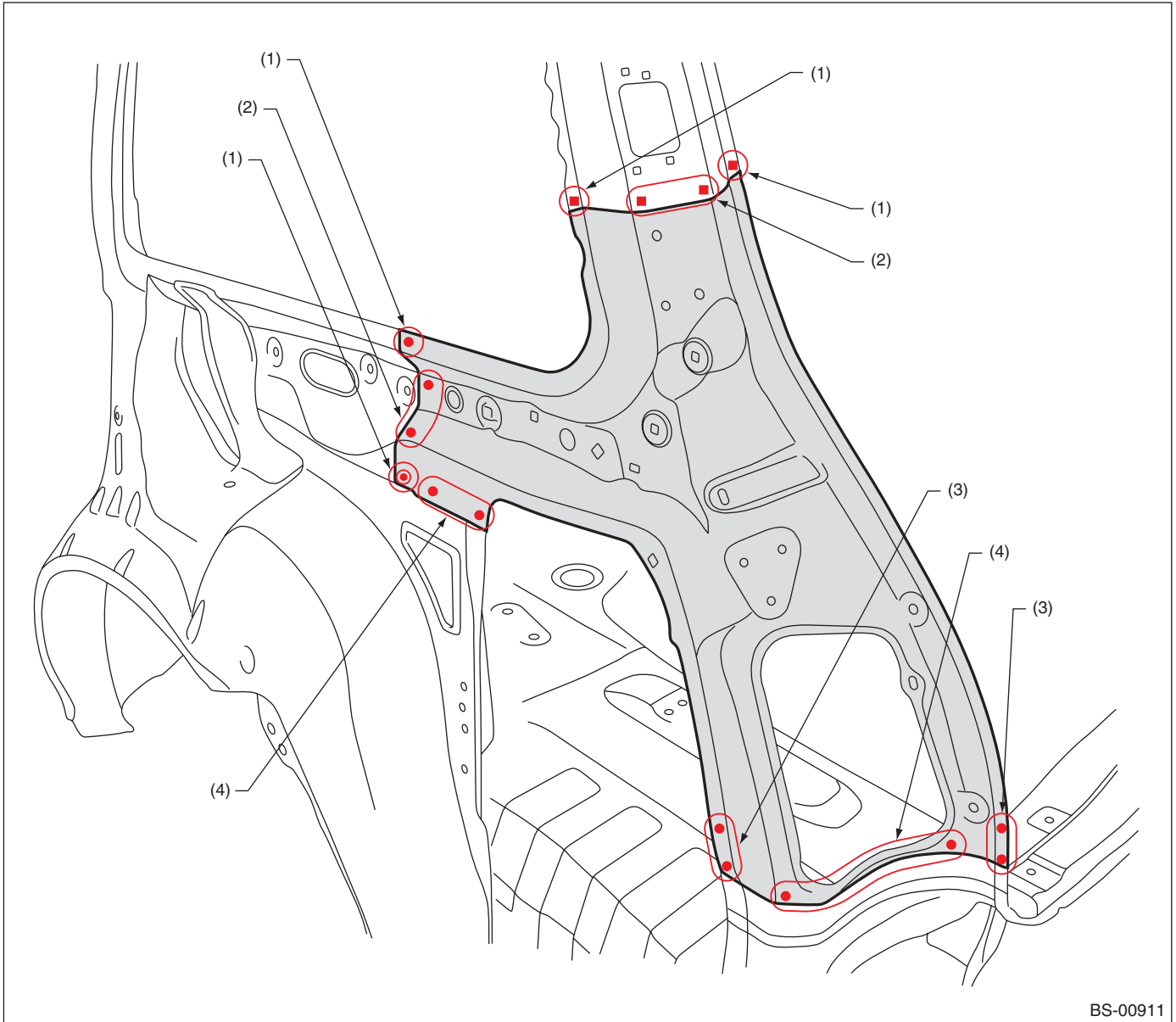
(1) 1 point (inside · 1)

(2) 2 points (inside · 1)

(3) 3 points (inside · 1)

# Rear Quarter Upper / Wagon (total replacement)

## B: INSTALLATION



BS-00911

(1) 1 point  
(2) 3 points

(3) 2 points

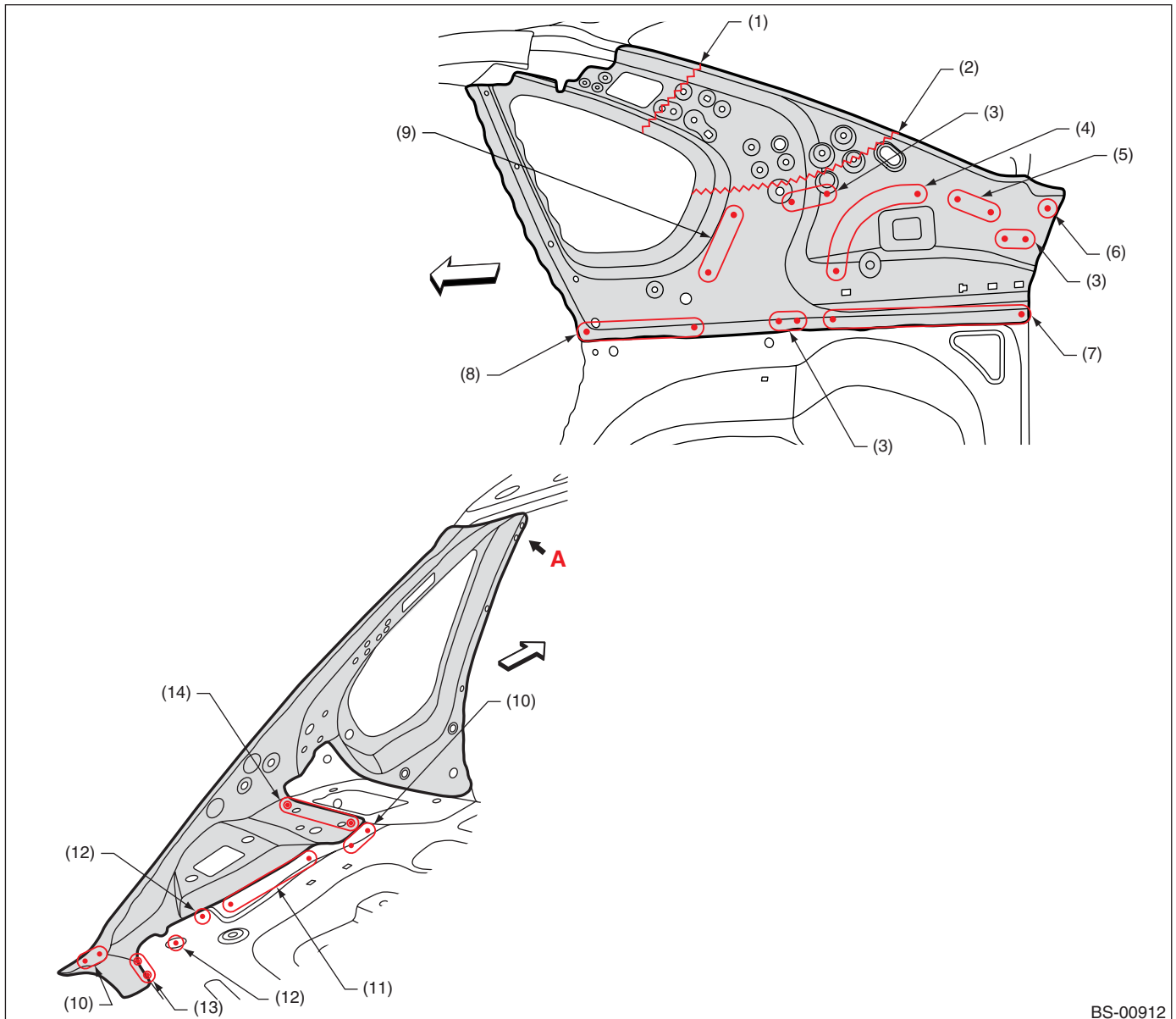
(4) 4 points

## 27.Rear Quarter Inner Upper / Sedan (total replacement)

### A: REMOVAL

1) Rear quarter and reinforcement removed condition

• Overall view

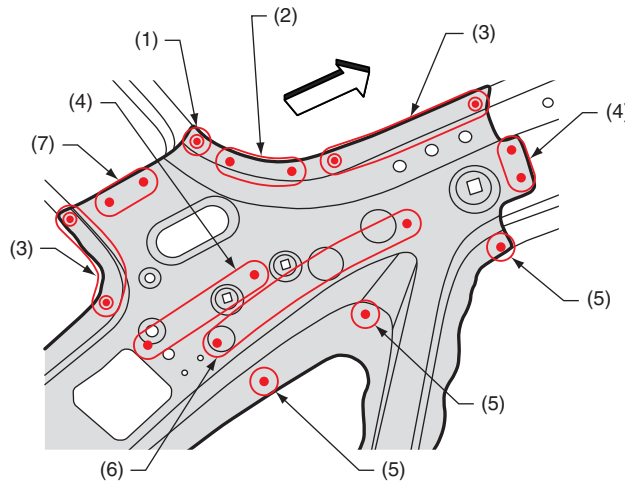


BS-00912

- |   |                            |                         |
|---|----------------------------|-------------------------|
| (1) Make removal easier<br>Rough cutting (170 mm) | (5) 3 points (outside · 1) | (10) 2 points (top · 1) |
| (2) Make removal easier<br>Rough cutting (320 mm) | (6) 1 point (outside · 1)  | (11) 4 points (top · 1) |
| (3) 2 points (outside · 1)                        | (7) 9 points (outside · 1) | (12) 1 point (top · 1)  |
| (4) 6 points (outside · 1)                        | (8) 5 points (outside · 1) | (13) 2 points (top · 2) |
|   | (9) 4 points (outside · 1) | (14) 3 points (top · 1) |

# Rear Quarter Inner Upper / Sedan (total replacement)

- Views



**A**

BS-01519

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

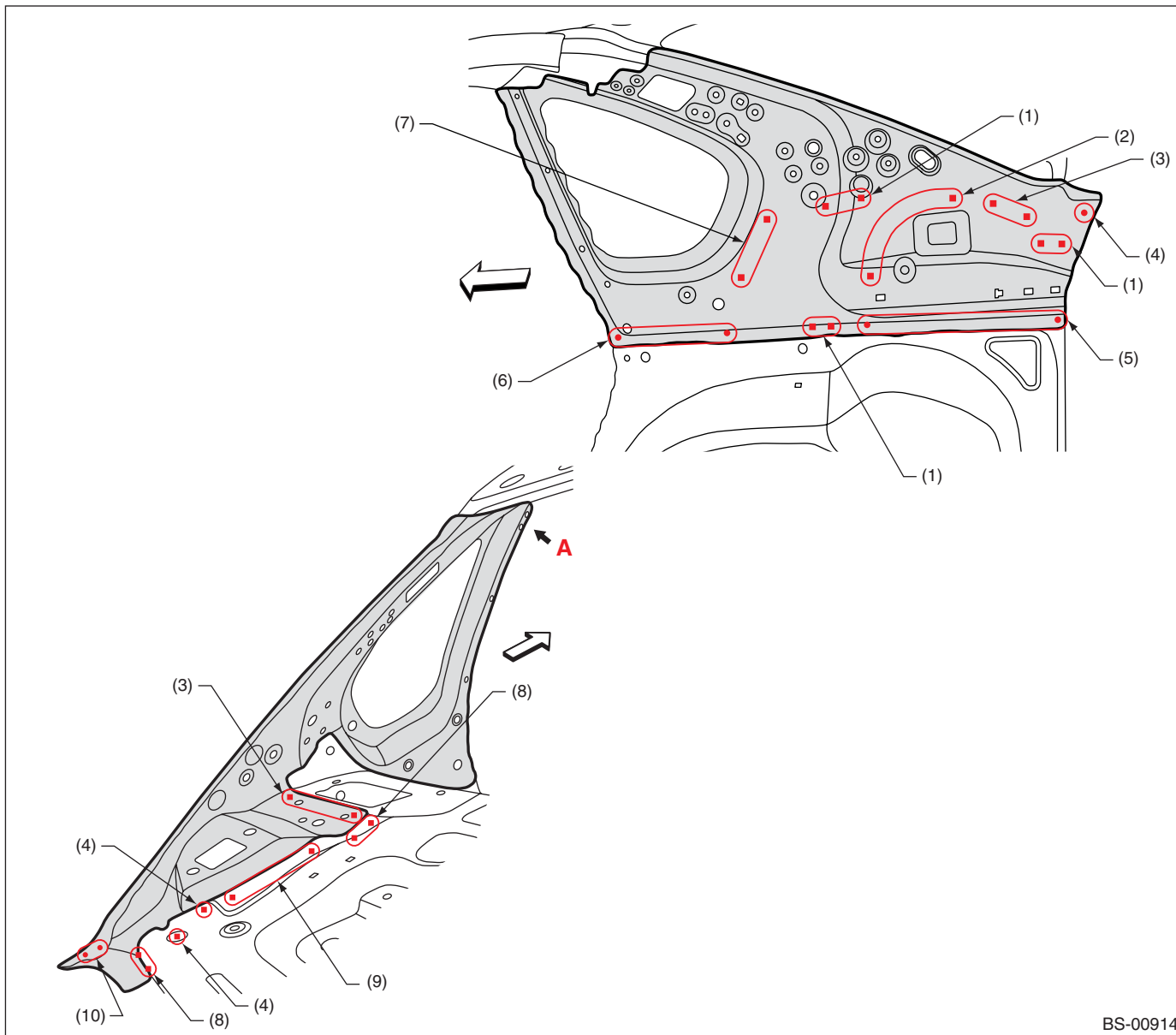
- (4) 3 points (inside · 1)
- (5) 1 point (inside · 1)

- (6) 4 points (inside · 1)
- (7) 2 points (bottom · 1)

# Rear Quarter Inner Upper / Sedan (total replacement)

## B: INSTALLATION

### • Overall view



BS-00914

(1) 2 points (service)

(2) 6 points (service)

(3) 3 points (service)

(4) 1 point

(5) 12 points

(6) 6 points

(7) 4 points (service)

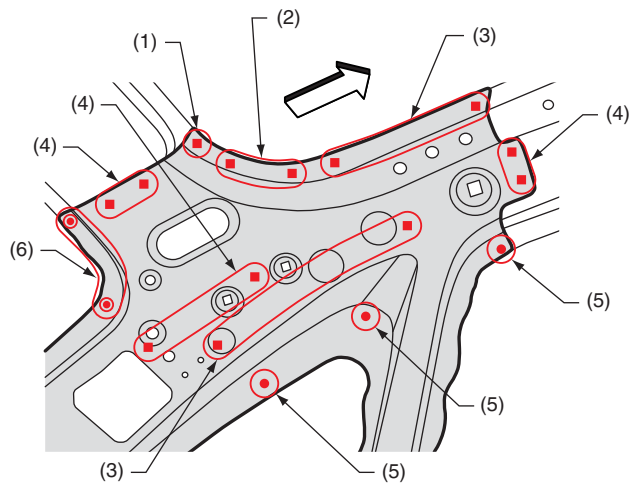
(8) 2 points

(9) 4 points

(10) 3 points

# Rear Quarter Inner Upper / Sedan (total replacement)

- Views



**A**

BS-00915

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

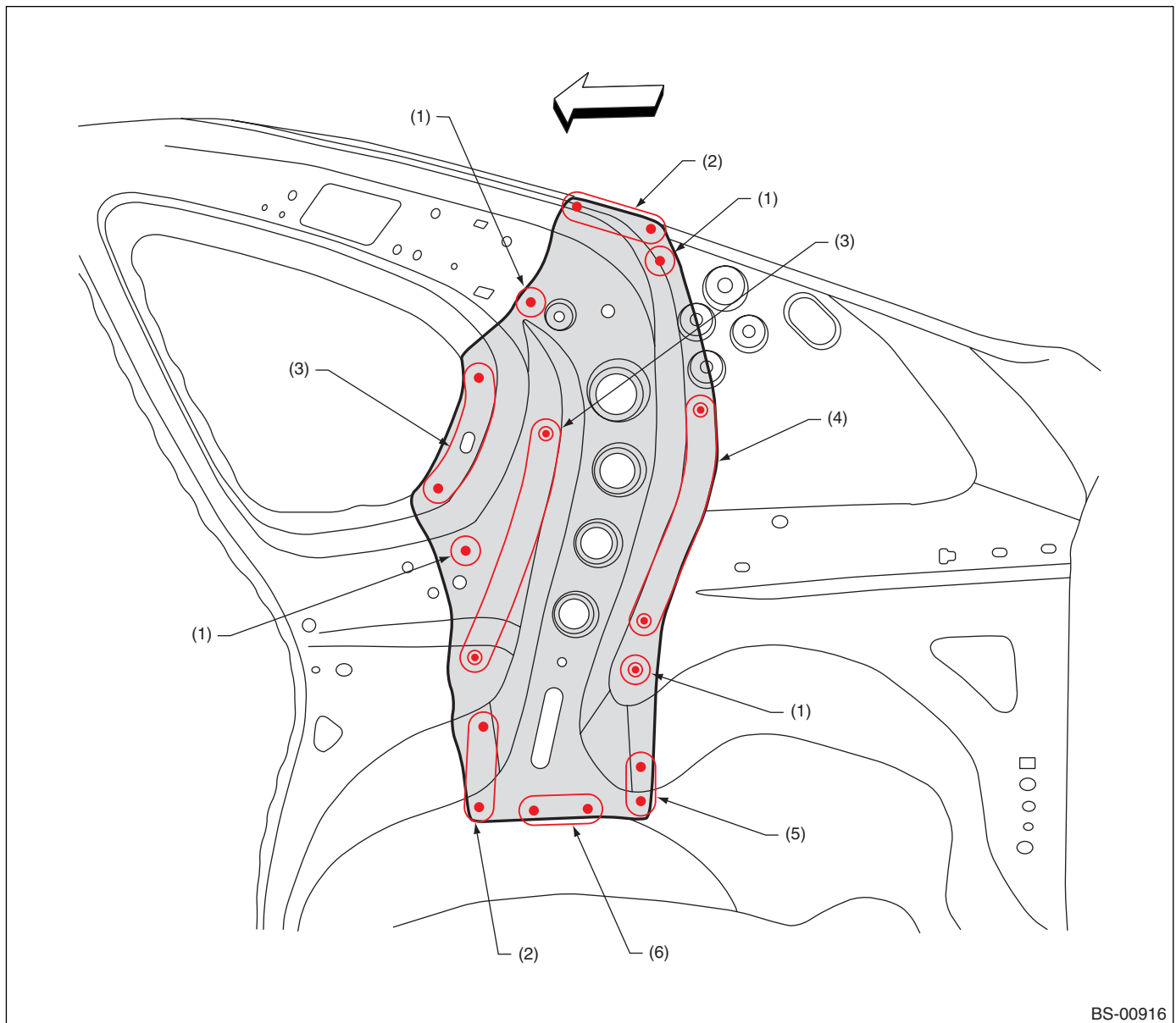
(3) 4 points (service)  
(4) 2 points (service)

(5) 1 point  
(6) 5 points

## 28.Rear Quarter Inner Reinforcement / Sedan (total replacement)

### A: REMOVAL

1) Rear quarter removal condition



BS-00916

(1) 1 point (outside · 1)

(2) 3 points (top · 1)

(3) 5 points (outside · 1)

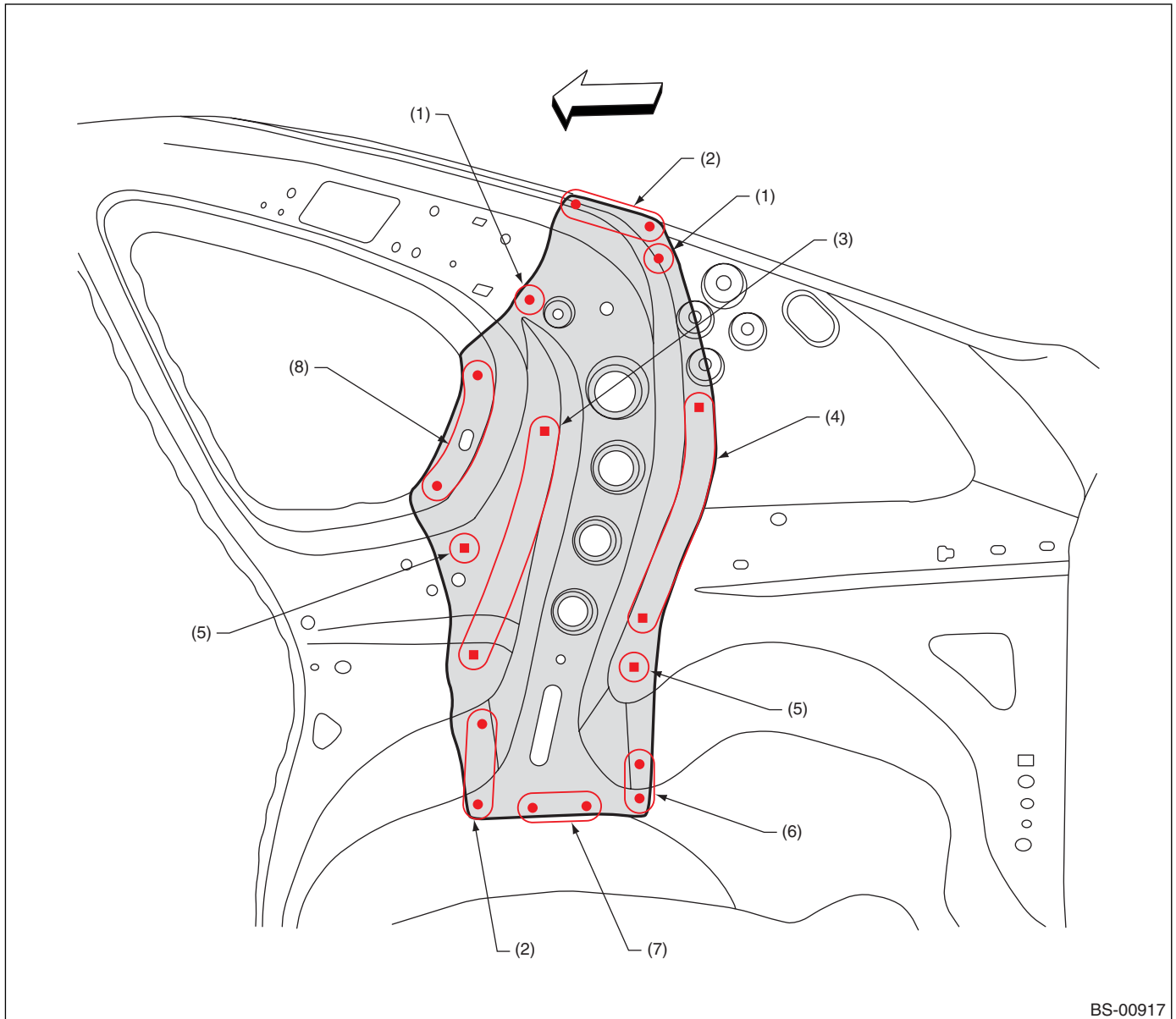
(4) 3 points (outside · 1)

(5) 2 points (top · 1)

(6) 2 points (outside · 1)

# Rear Quarter Inner Reinforcement / Sedan (total replacement)

## B: INSTALLATION



BS-00917

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



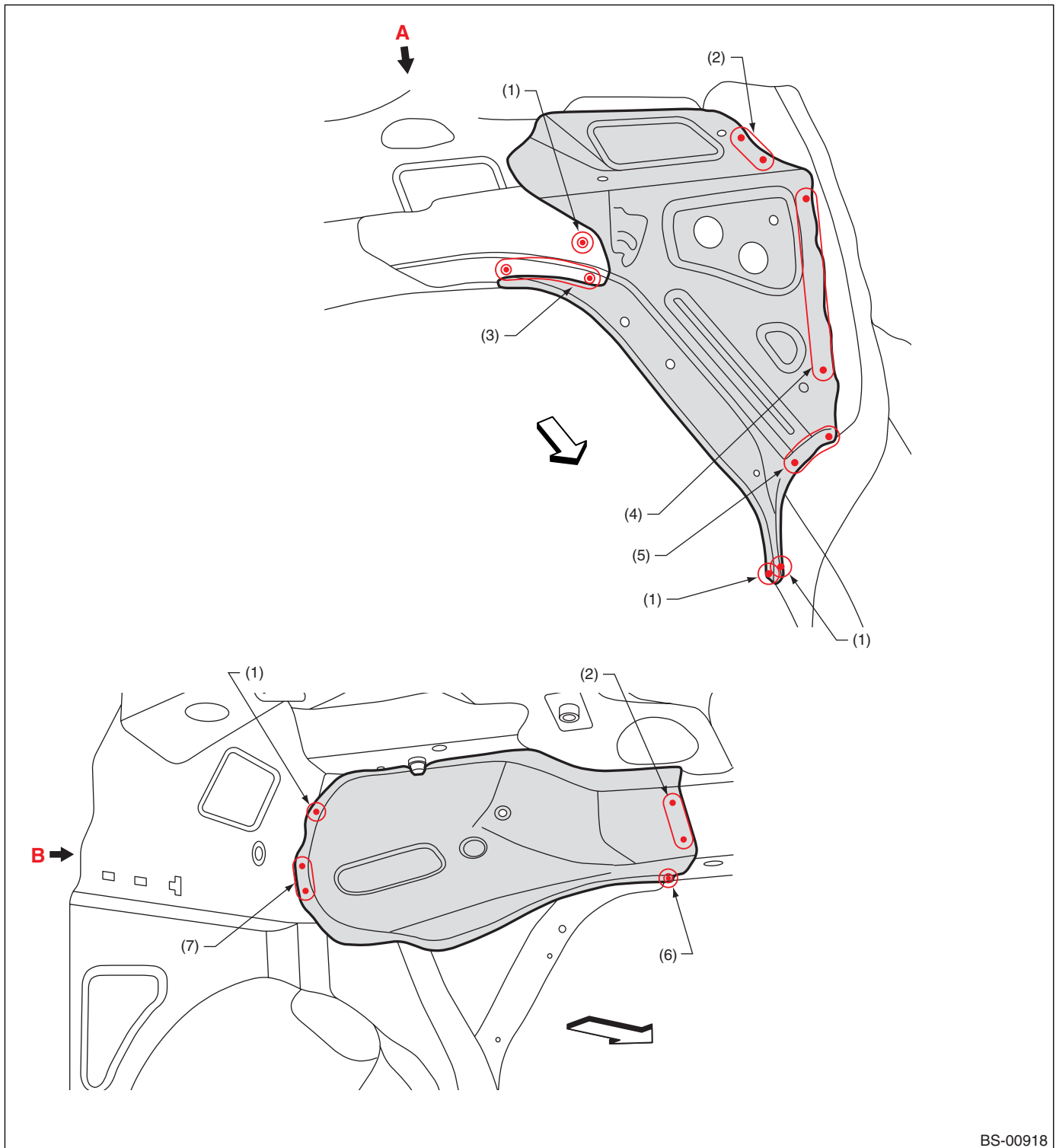
## Rear Bulkhead / Sedan (total replacement)

### 29.Rear Bulkhead / Sedan (total replacement)

#### A: REMOVAL

1) Rear quarter, rear quarter inner upper and reinforcement removed condition

#### • Overall view



BS-00918

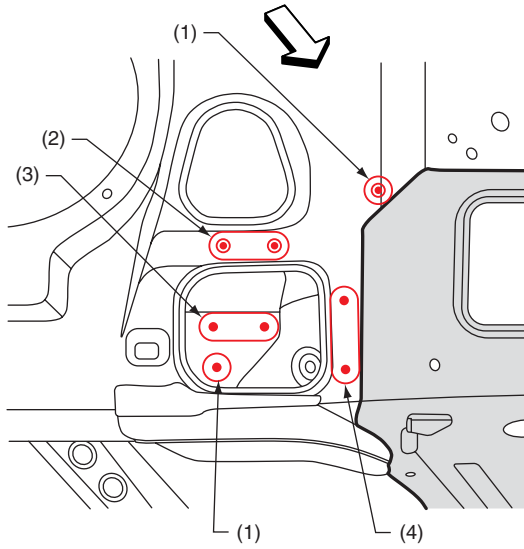
- (1) 1 point (inside · 1)
- (2) 2 points (outside · 1)
- (3) 3 points (inside · 1)

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

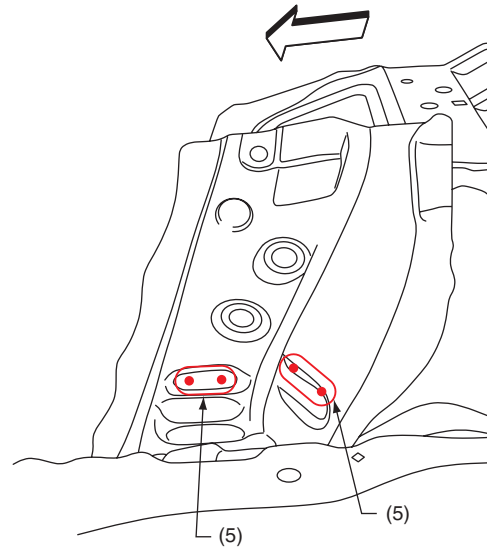
- (6) 1 point (outside · 1)
- (7) 2 points (inside · 1)

# Rear Bulkhead / Sedan (total replacement)

## • Views



**A**



**B**

BS-00919

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

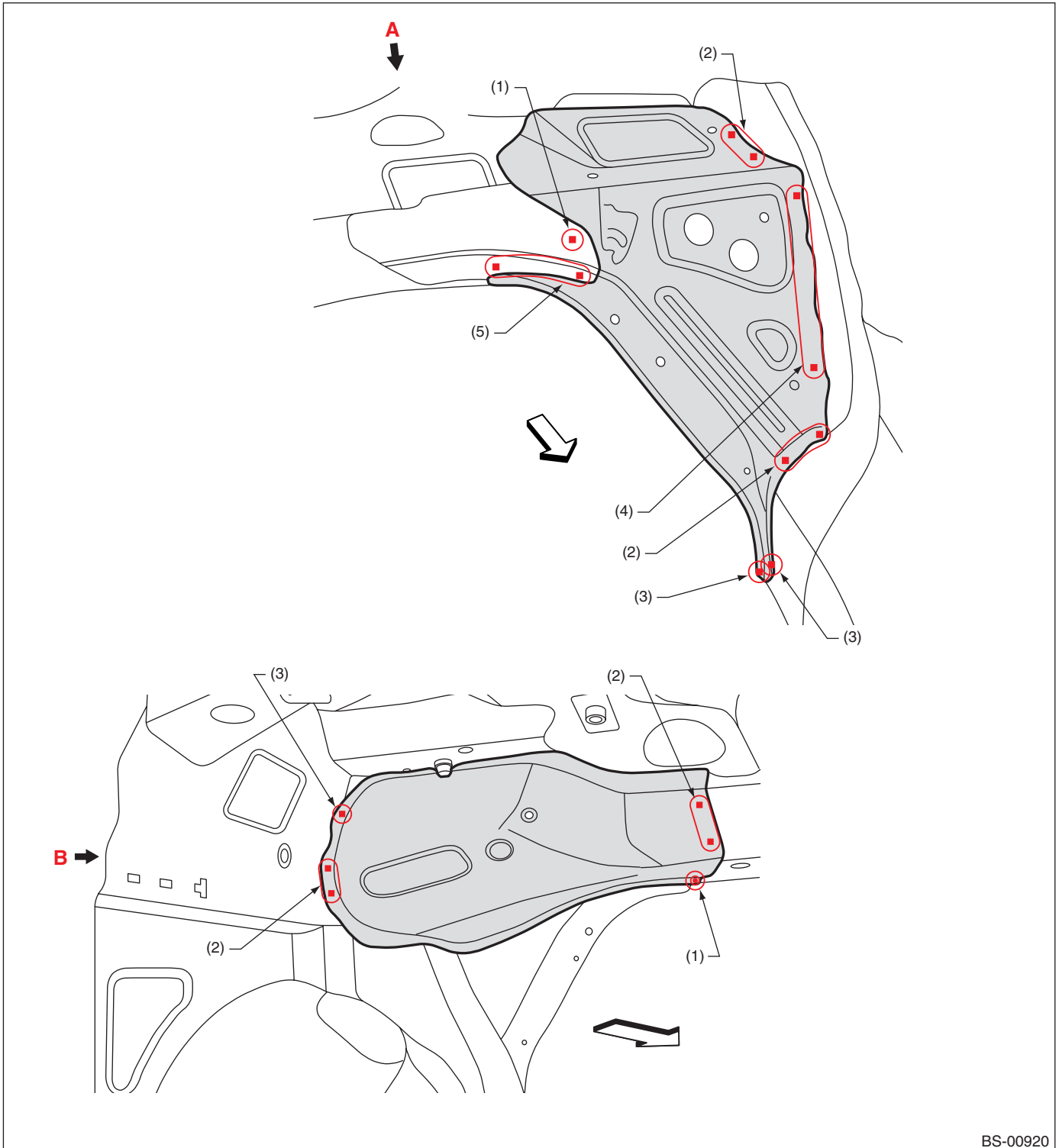
(3) 2 points (top · 1)  
(4) 3 points (top · 1)

(5) 2 points (outside · 1)

# Rear Bulkhead / Sedan (total replacement)

## B: INSTALLATION

### • Overall view



BS-00920

(1) 1 point

(2) 2 points (service)

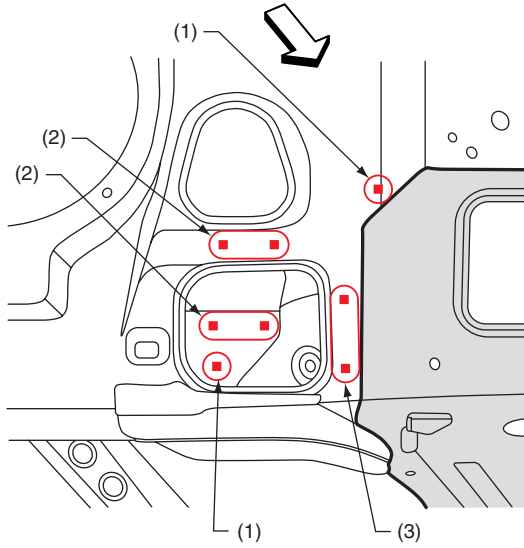
(3) 1 point (service)

(4) 5 points (service)

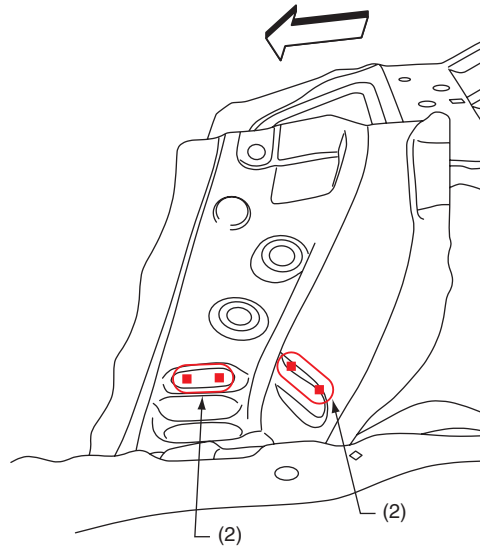
(5) 3 points

# Rear Bulkhead / Sedan (total replacement)

## • Views



A



B

BS-00921

(1) 1 point

(2) 2 points

(3) 3 points

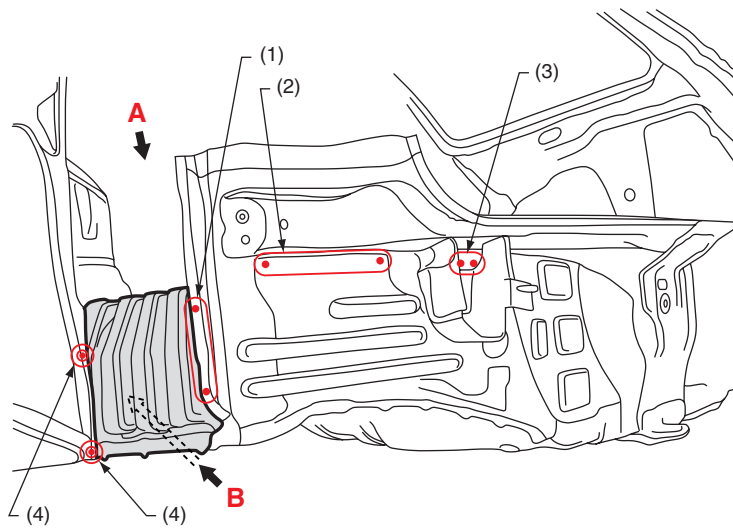
## Rear Floor Side / Wagon (total replacement)

### 30.Rear Floor Side / Wagon (total replacement)

#### A: REMOVAL

1) Rear quarter and reinforcement D-pillar removed condition

- Overall view



BS-00922

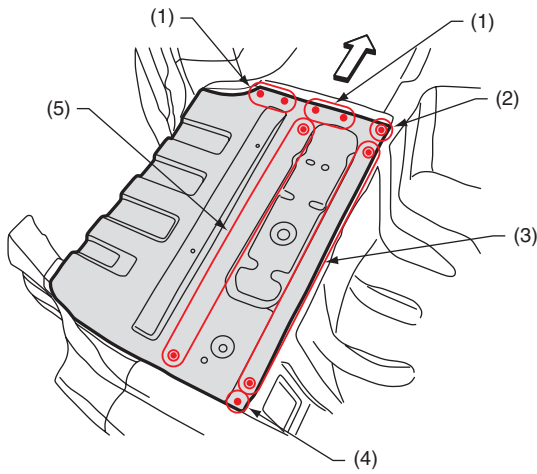
(1) 3 points (outside · 1)  
(2) 4 points (outside · 1)

(3) 2 points (outside · 1)

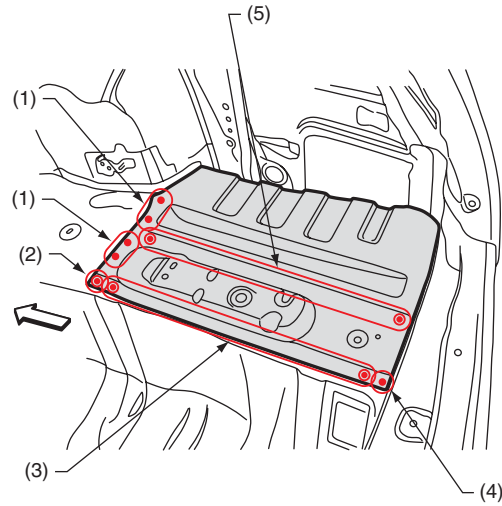
(4) 1 point (outside · 1)

# Rear Floor Side / Wagon (total replacement)

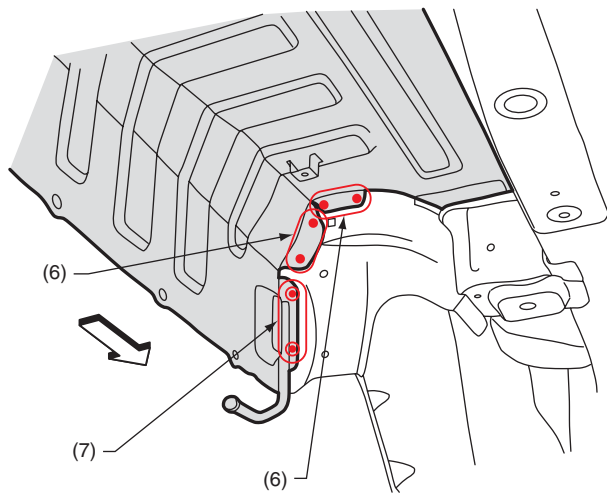
## • Views



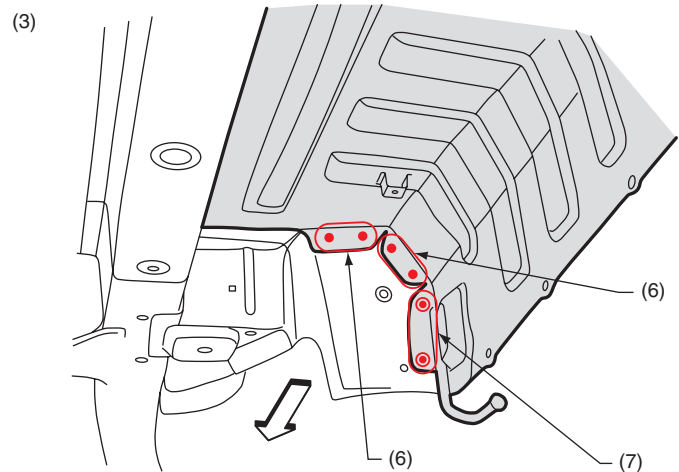
**A**



**A (RH)**



**B**



**B (RH)**

BS-00923

- (1) 2 points (top · 1)
- (2) 1 point (top · 1)
- (3) 14 points (top · 1)

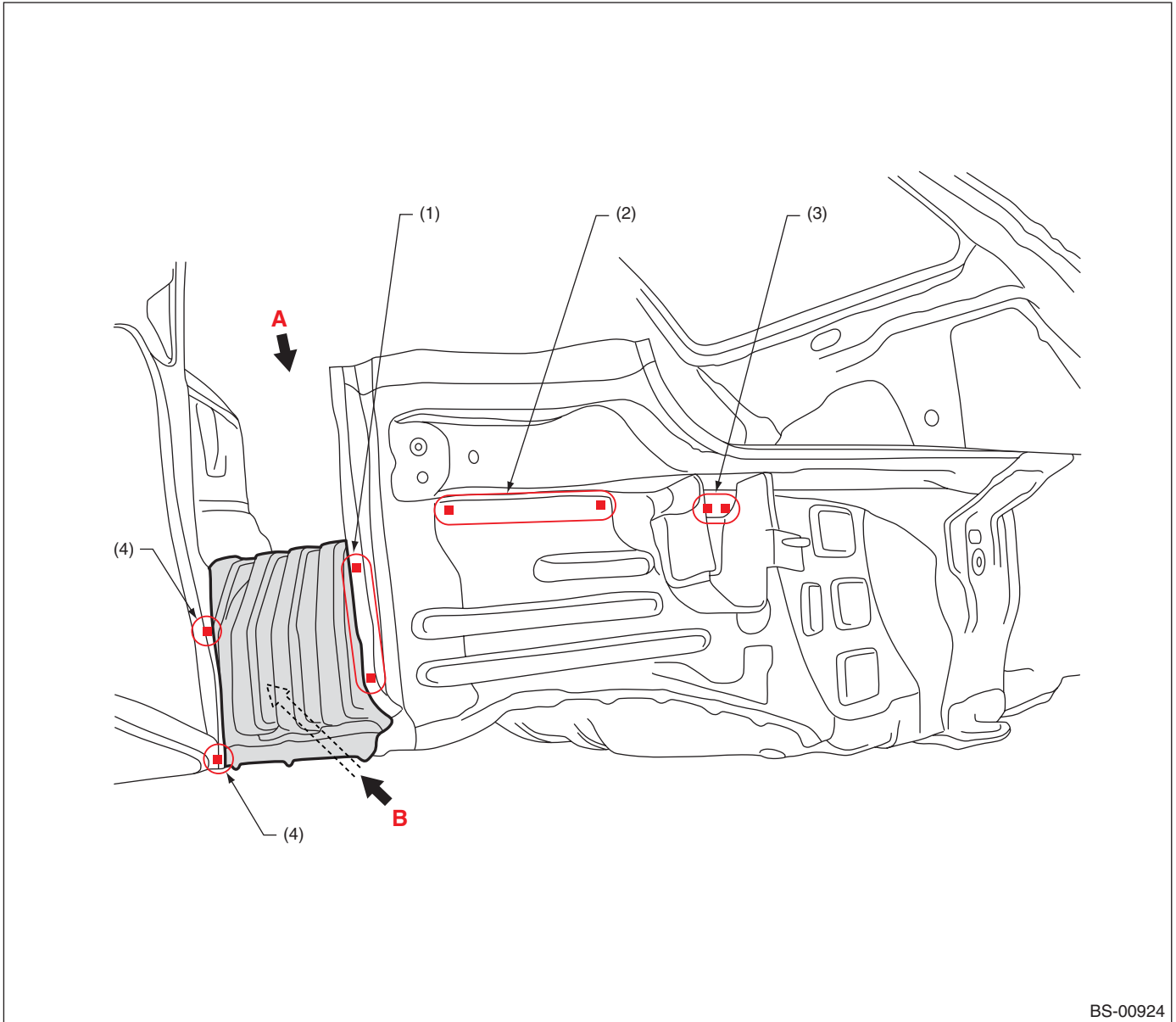
- (4) 1 point (inside · 1)
- (5) 13 points (top · 1)

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

# Rear Floor Side / Wagon (total replacement)

## B: INSTALLATION

- Overall view



BS-00924

(1) 3 points

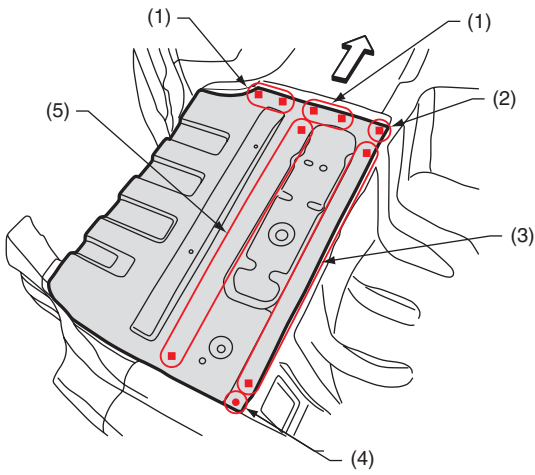
(3) 2 points

(4) 1 point

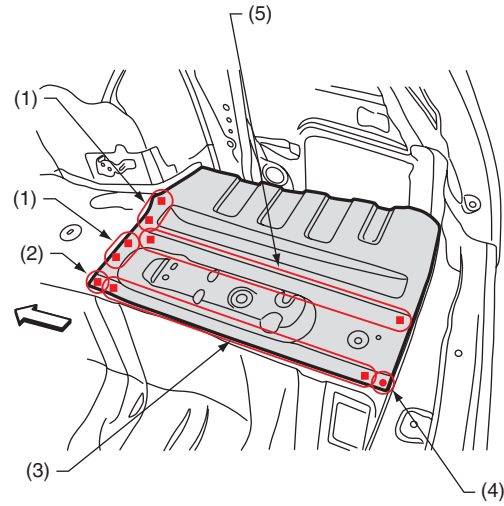
(2) 4 points

# Rear Floor Side / Wagon (total replacement)

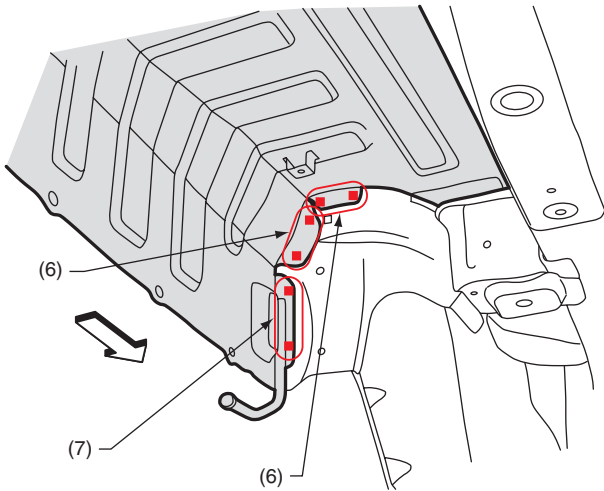
## • Views



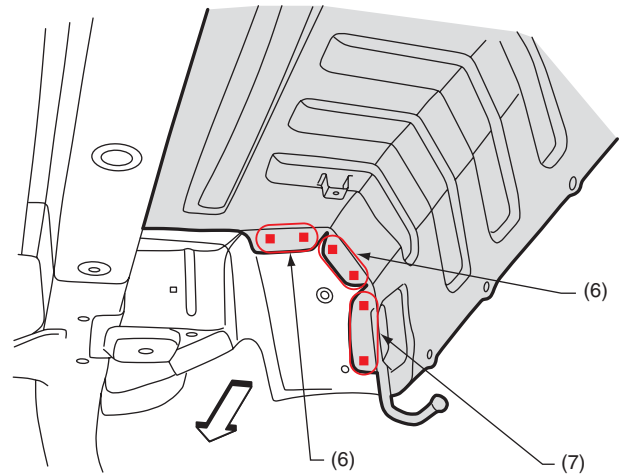
**A**



**A (RH)**



**B**



**B (RH)**

BS-00925

- (1) 2 points (service)
- (2) 1 point (service)
- (3) 14 points (service)

- (4) 1 point
- (5) 13 points (service)

- (6) 2 points
- (7) 3 points



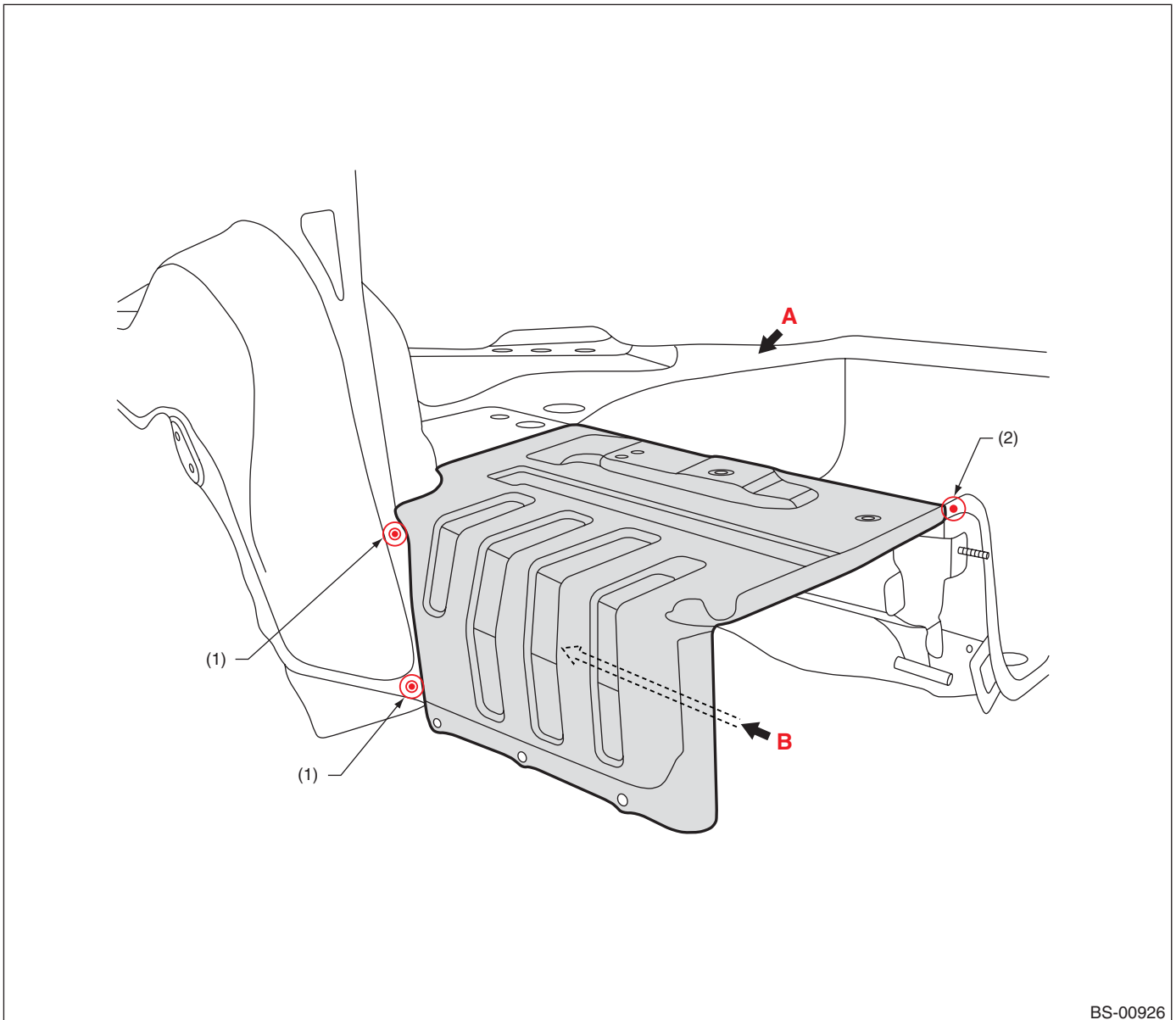
## Rear Floor Side / Sedan (total replacement)

### 31.Rear Floor Side / Sedan (total replacement)

#### A: REMOVAL

1) Rear quarter and rear skirt removed condition

#### • Overall view



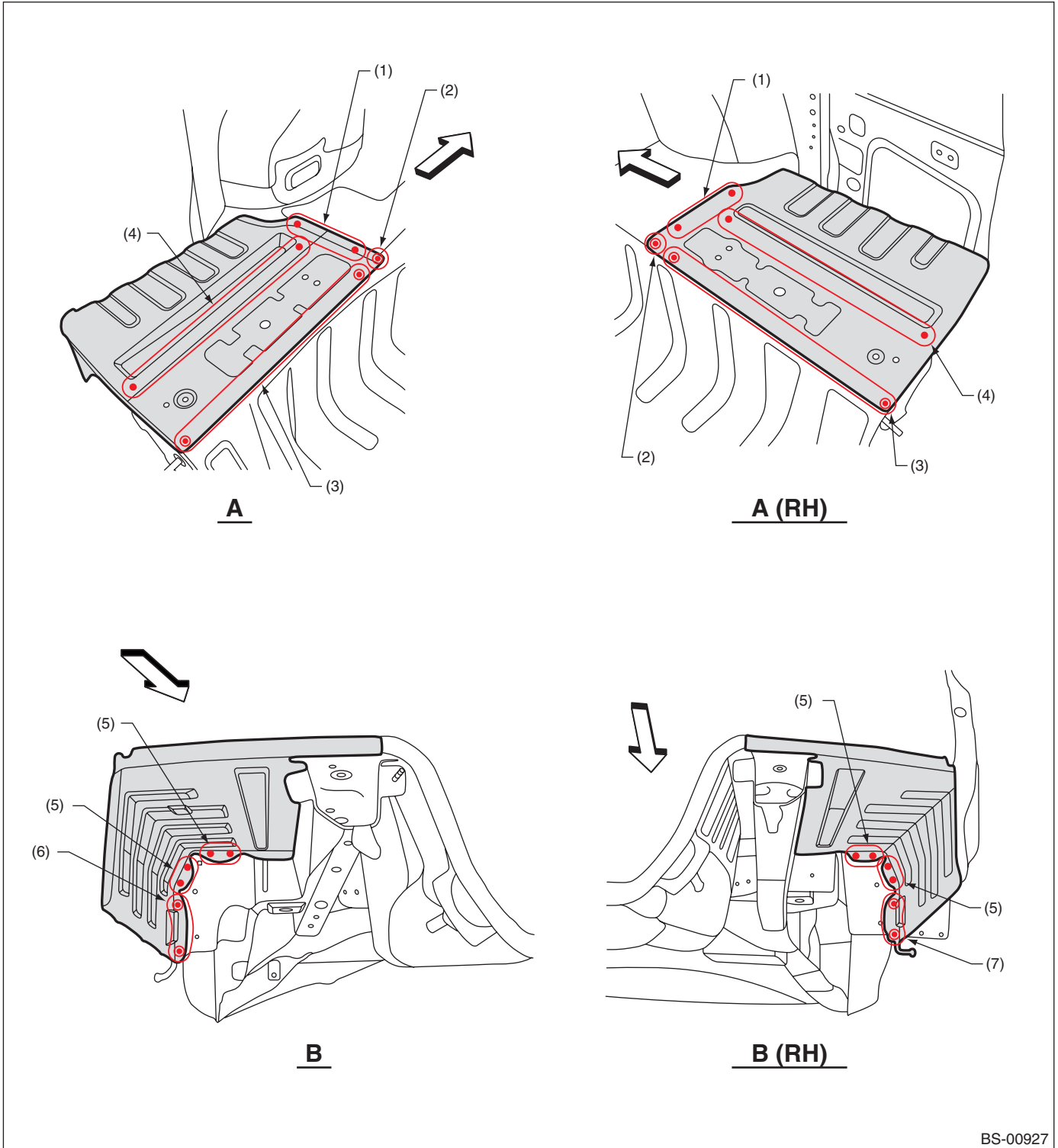
BS-00926

(1) 1 point (outside · 2)

(2) 1 point (outside · 1)

# Rear Floor Side / Sedan (total replacement)

## • Views



BS-00927

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

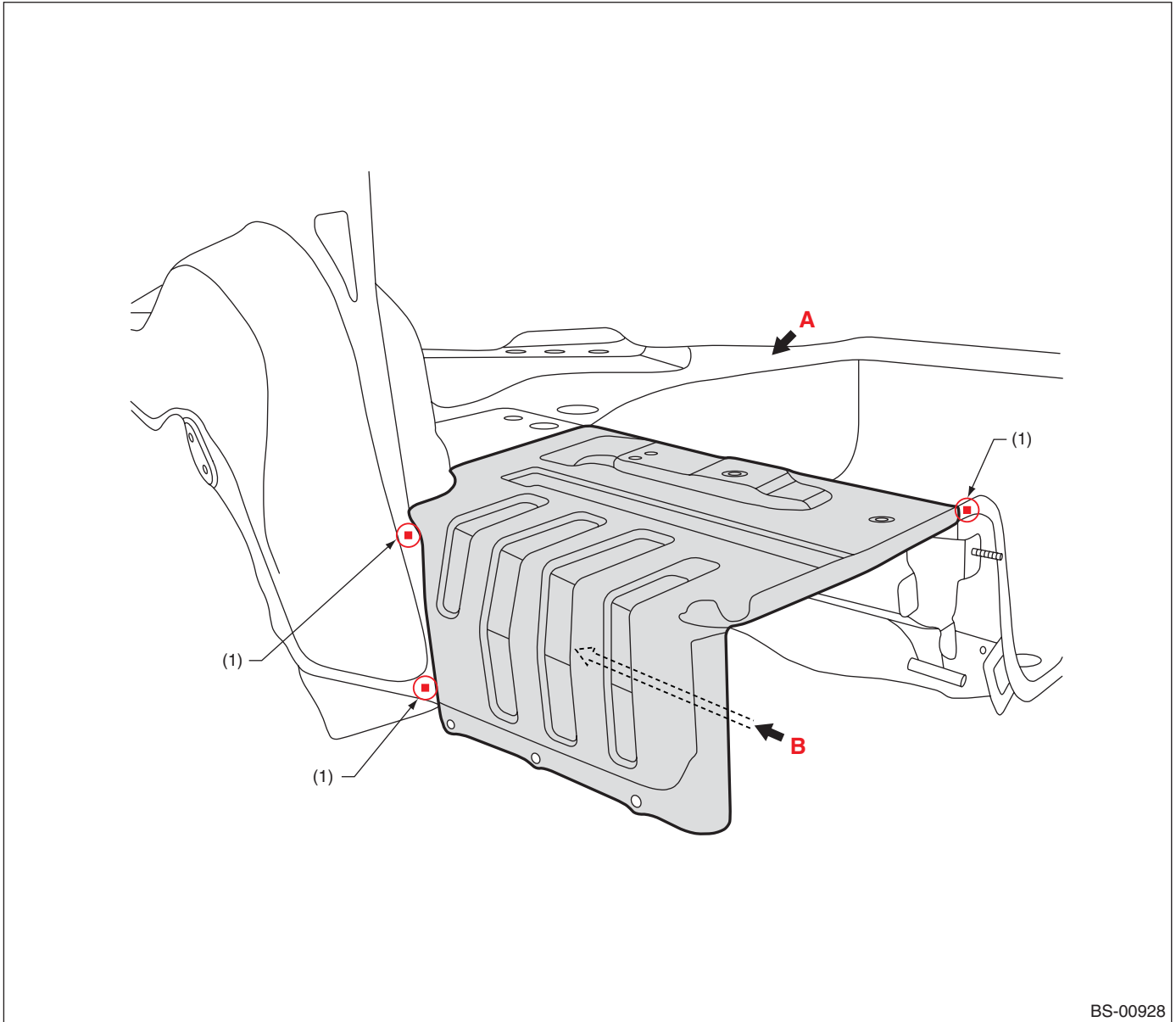
- (4) 13 points (top · 1)
- (5) 2 points (inside · 1)

- (6) 3 points (inside · 2)
- (7) 3 points (inside · 1)

## Rear Floor Side / Sedan (total replacement)

### B: INSTALLATION

- Overall view

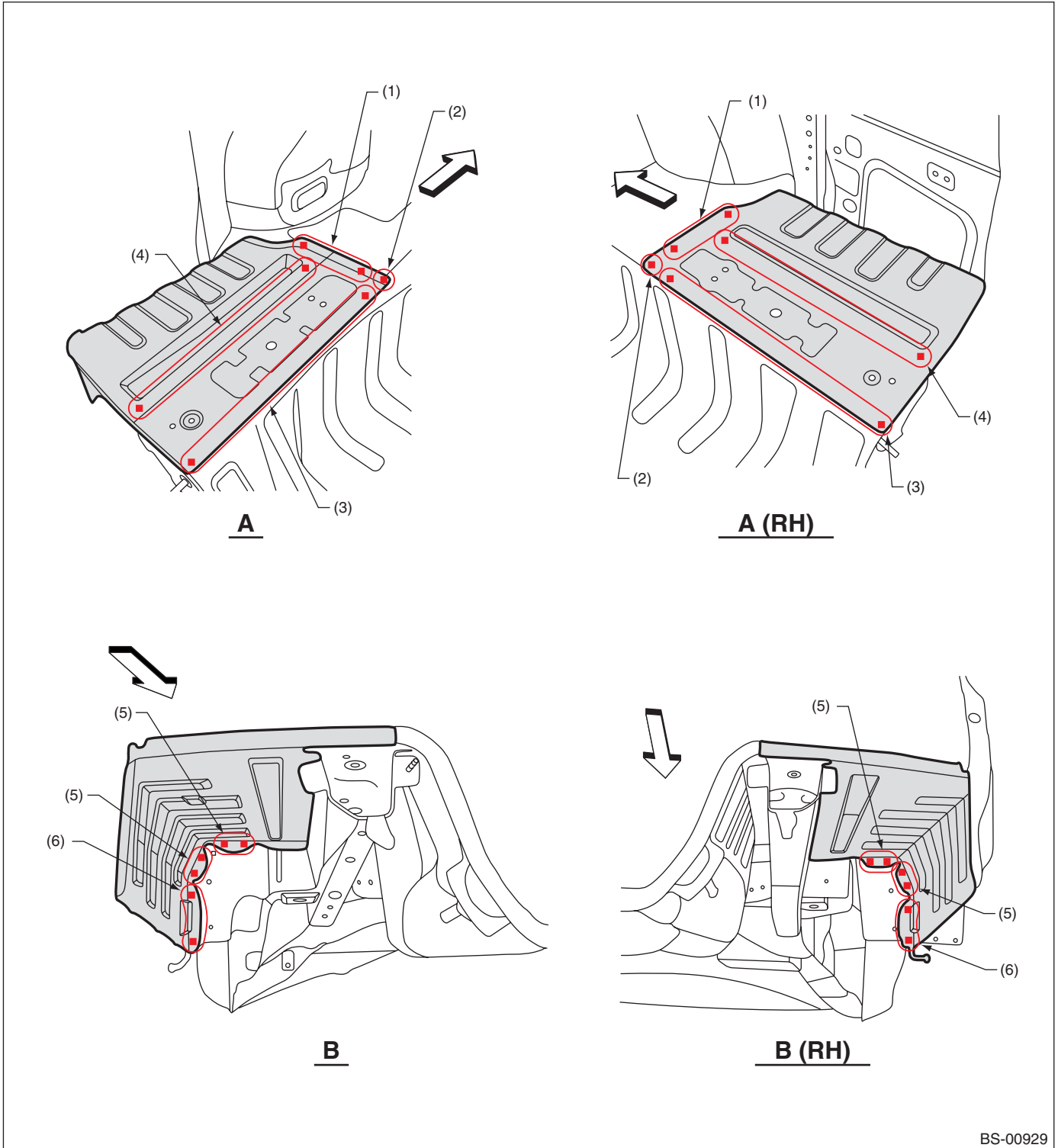


BS-00928

(1) 1 point

# Rear Floor Side / Sedan (total replacement)

## • Views



BS-00929

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

(3) 14 points (service)  
 (4) 13 points (service)

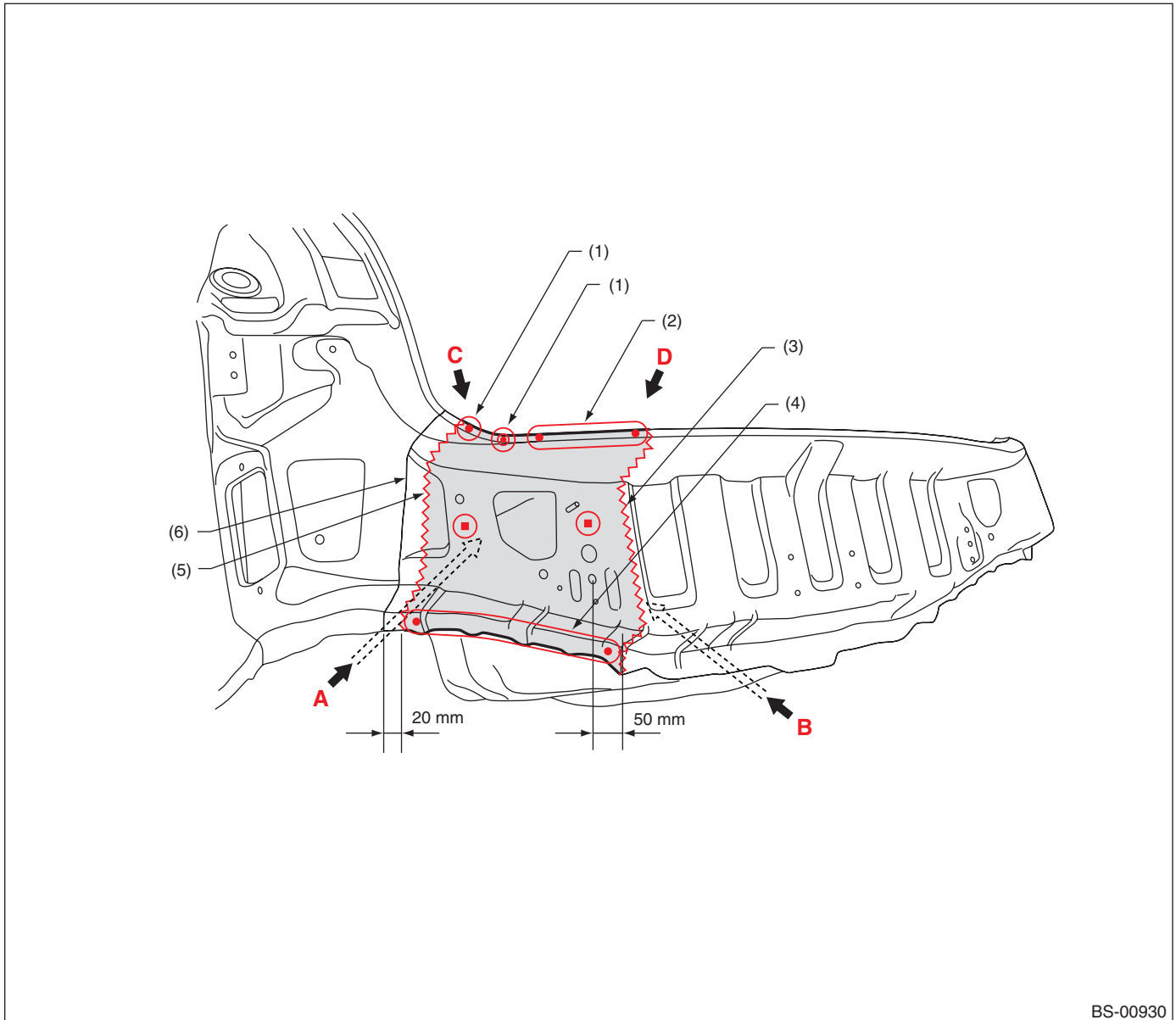
(5) 2 points  
 (6) 3 points

## Rear Skirt / Wagon (partial replacement)

### 32.Rear Skirt / Wagon (partial replacement)

#### A: REMOVAL

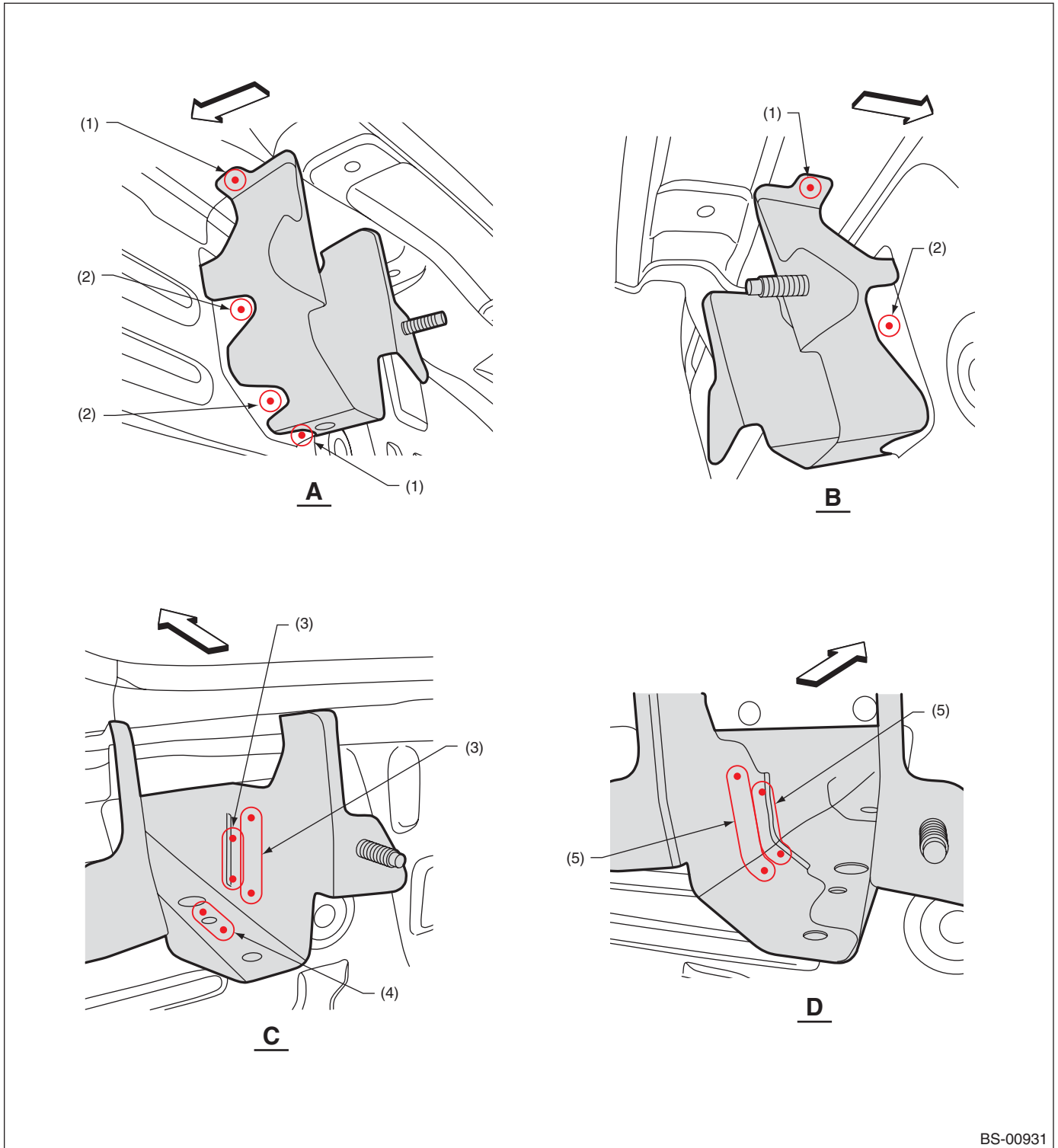
##### • Overall view



- |  |                                     |                    |
|--|-------------------------------------|--------------------|
| (1) 1 point (outside · 1)                    | (4) 5 points (outside · 1)          | (6) D-pillar outer |
| (2) 3 points (outside · 1)                   | (5) Cut (300 mm) (for butt welding) |                    |
| (3) Cut position (320 mm) (for butt welding) |                                     |                    |

# Rear Skirt / Wagon (partial replacement)

## • Views



BS-00931

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

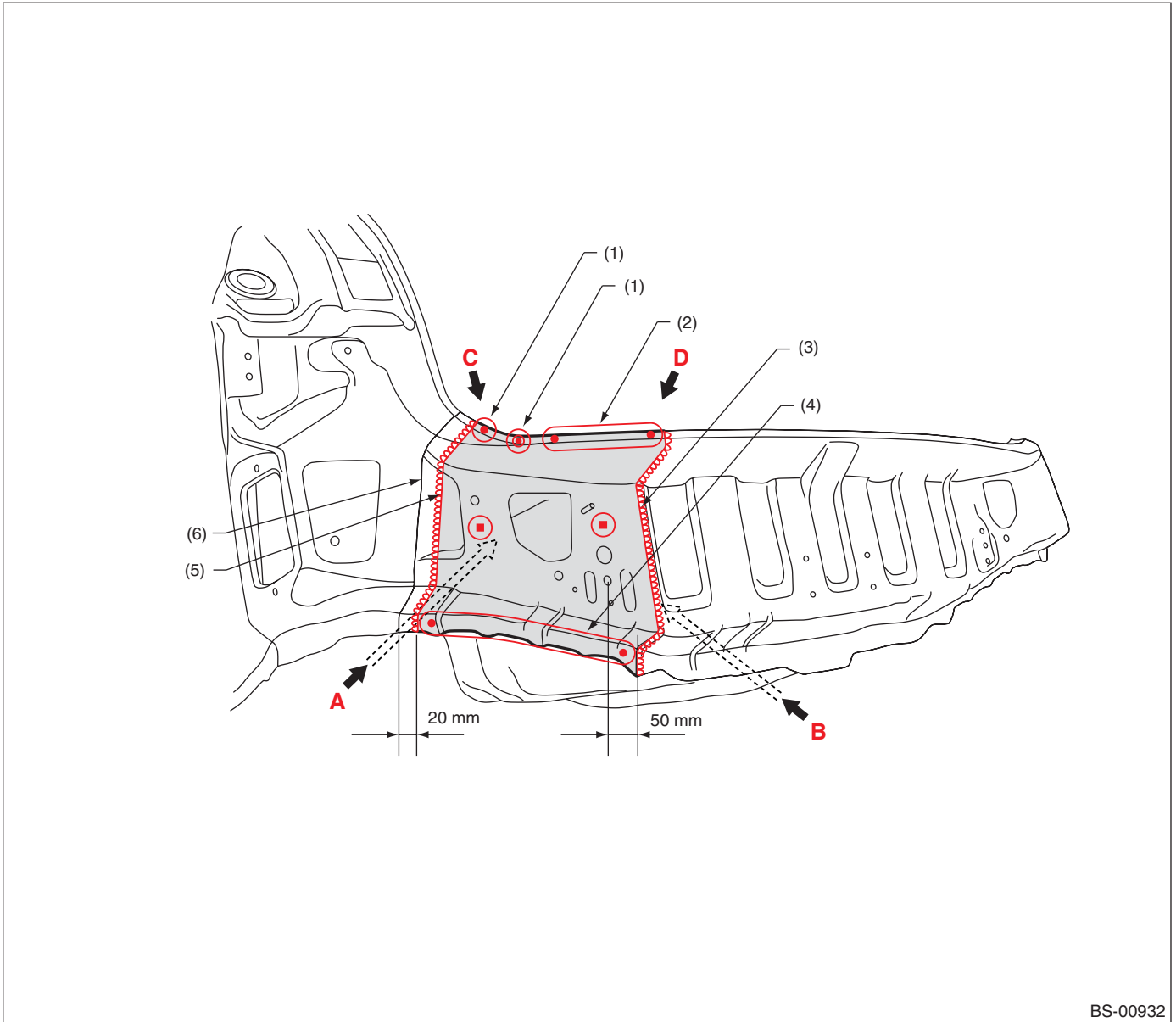
- (3) 2 points (inside · 1, belt sander)
- (4) 2 points (top · 1, belt sander)

- (5) 3 points (inside · 1, belt sander)

# Rear Skirt / Wagon (partial replacement)

## B: INSTALLATION

### • Overall view



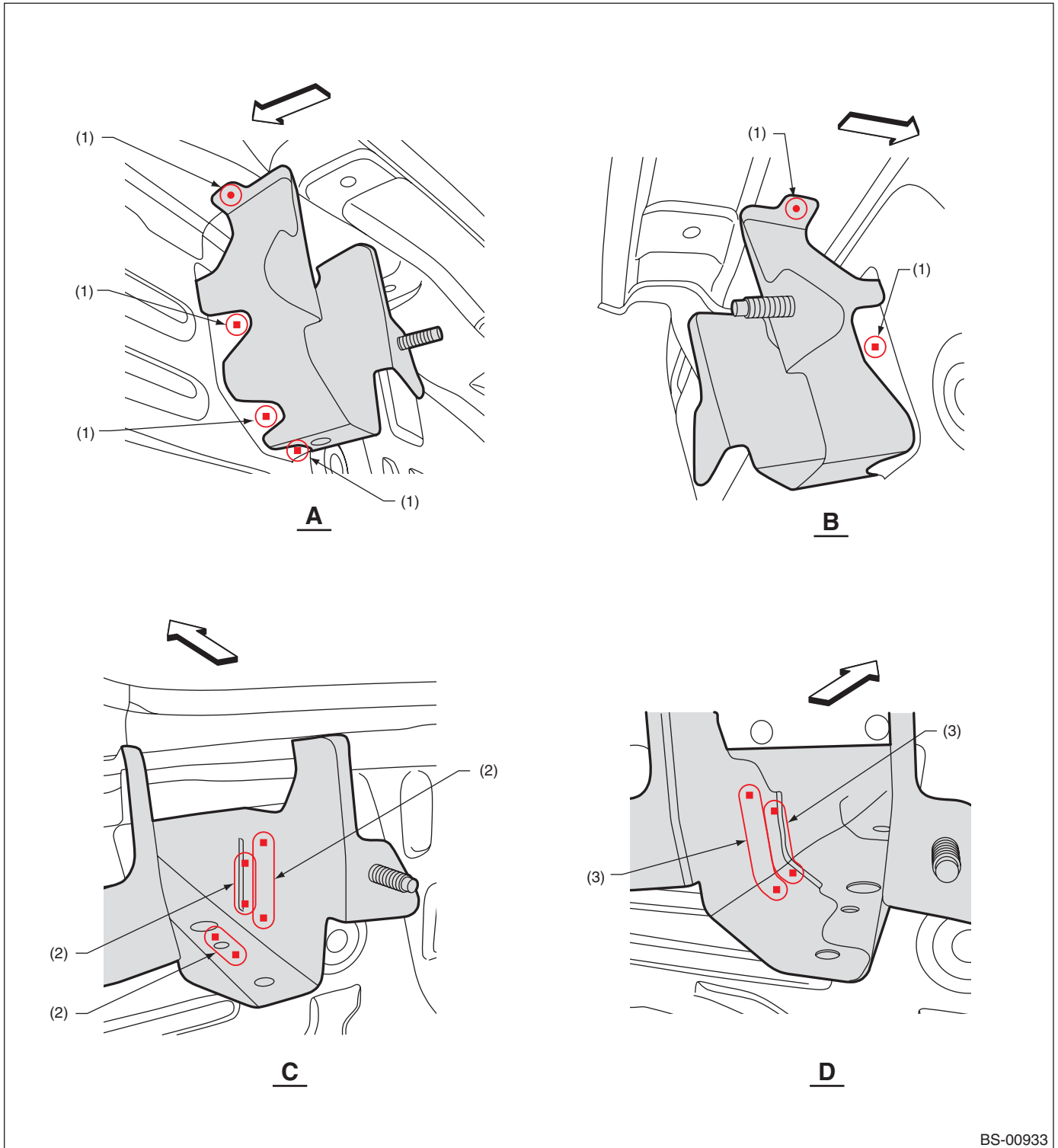
(1) 1 point  
(2) 3 points

(3) 1 point (320 mm)  
(4) 5 points

(5) 1 point (300 mm)  
(6) D-pillar outer

# Rear Skirt / Wagon (partial replacement)

## • Views



BS-00933

(1) 1 point

(2) 2 points

(3) 3 points

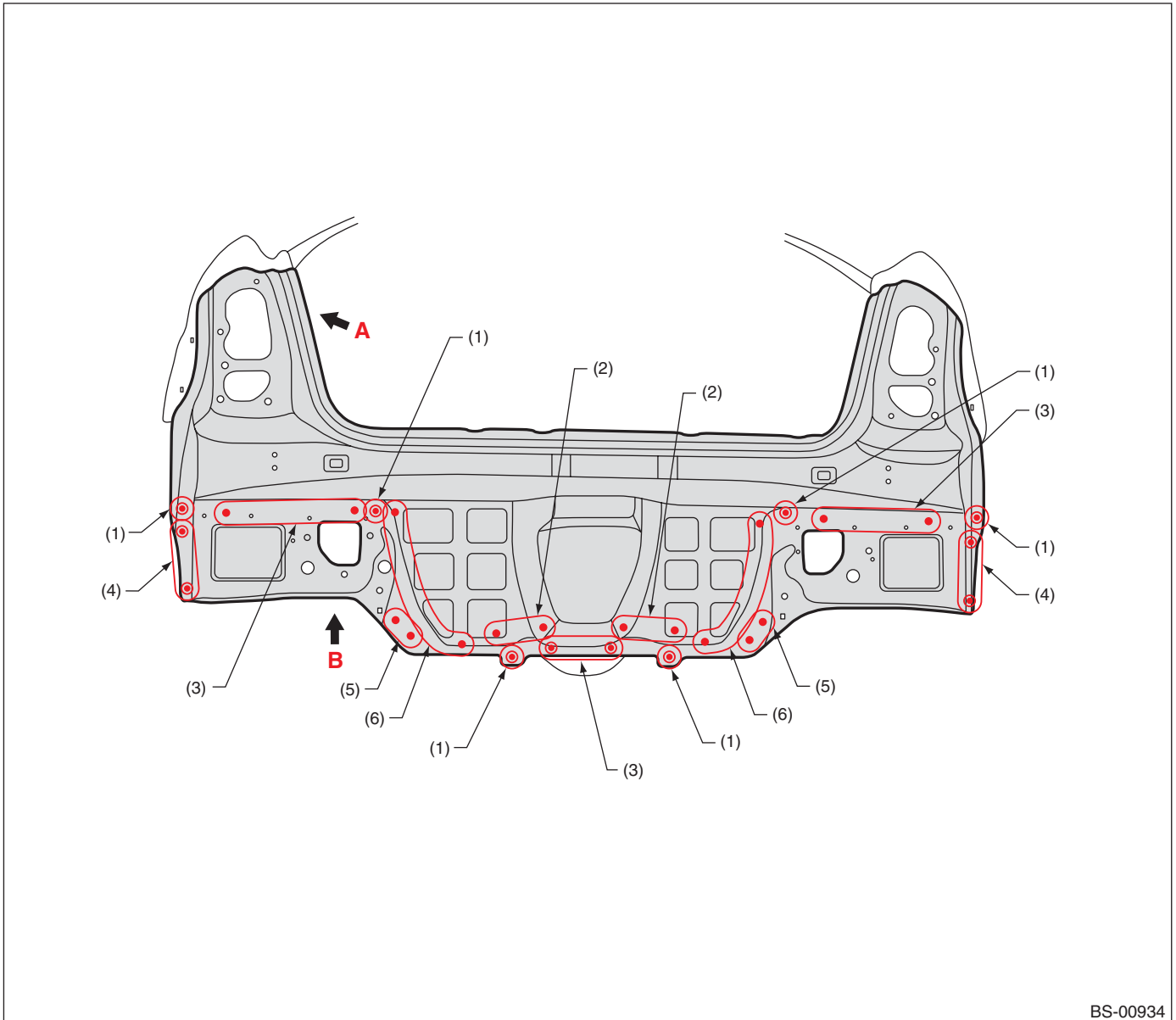


## Rear Skirt / Sedan (total replacement)

### 33.Rear Skirt / Sedan (total replacement)

#### A: REMOVAL

##### • Overall view



BS-00934

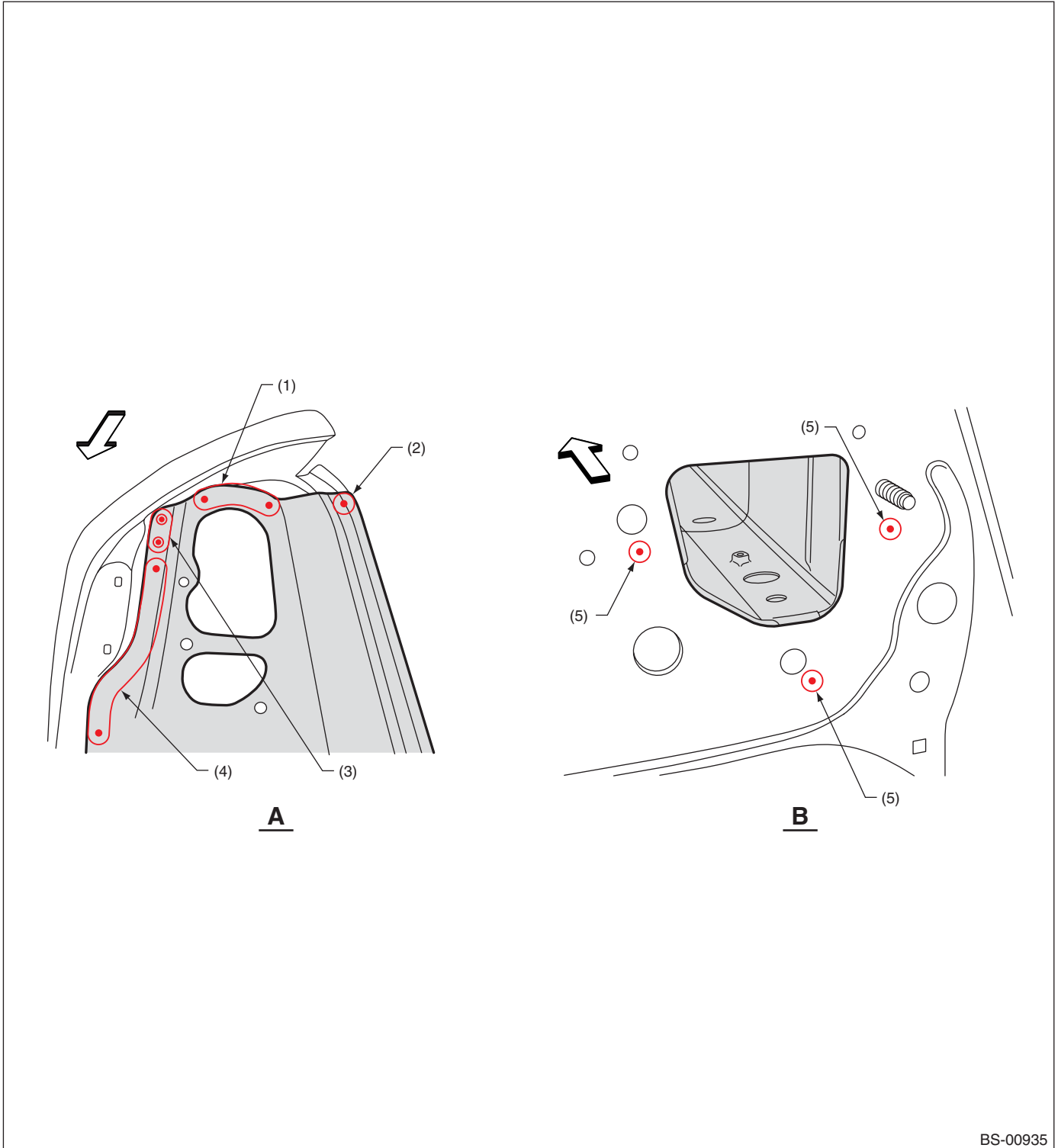
(1) 1 point (outside · 1)  
(2) 3 points (outside · 1)

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

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

# Rear Skirt / Sedan (total replacement)

## • Views



BS-00935

(1) 3 points (outside · 1)

(2) 1 point (inside · 1)

(3) 2 points (outside · 1)

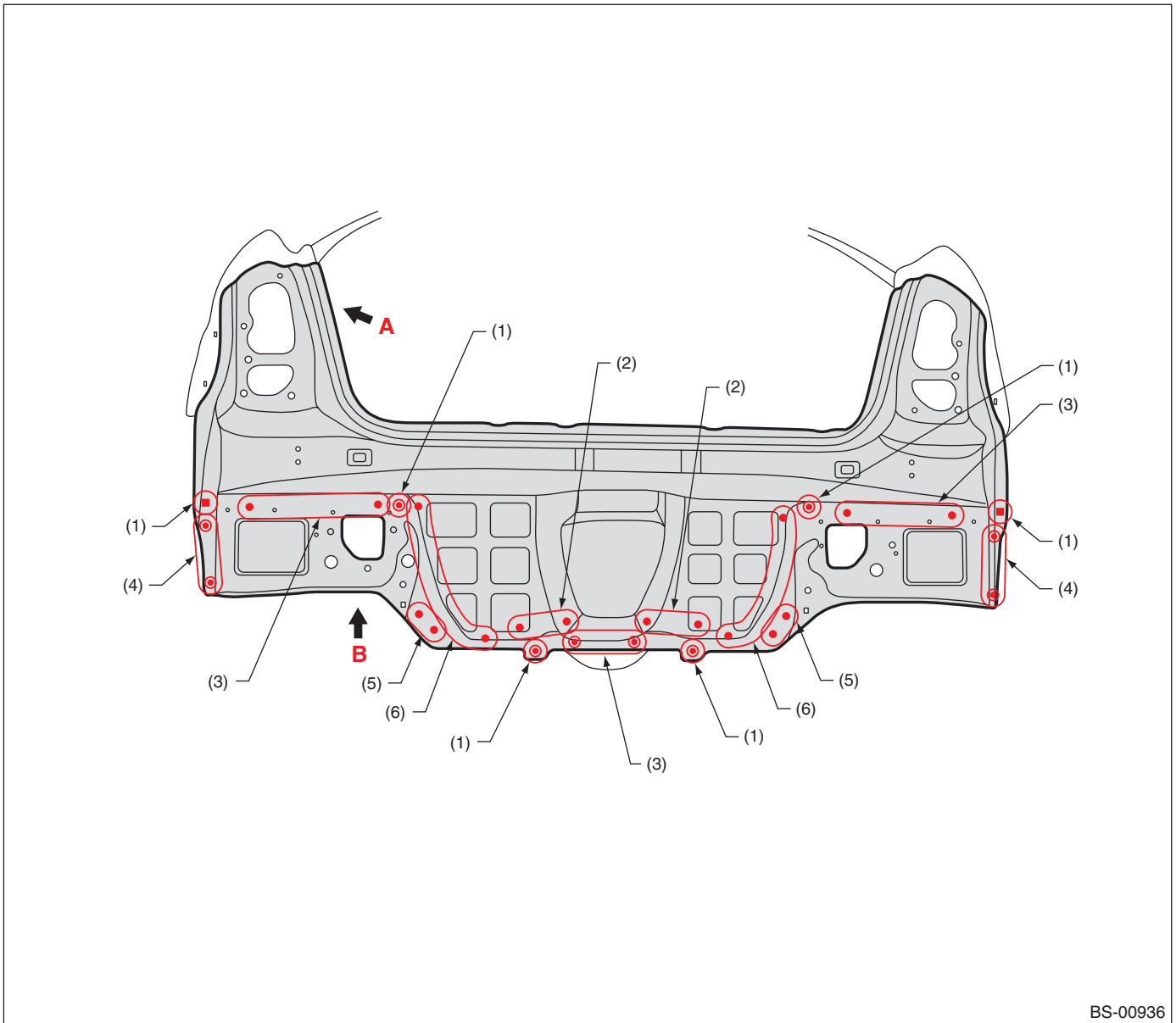
(4) 10 points (outside · 1)

(5) 1 point (outside · 1)

# Rear Skirt / Sedan (total replacement)

## B: INSTALLATION

### • Overall view



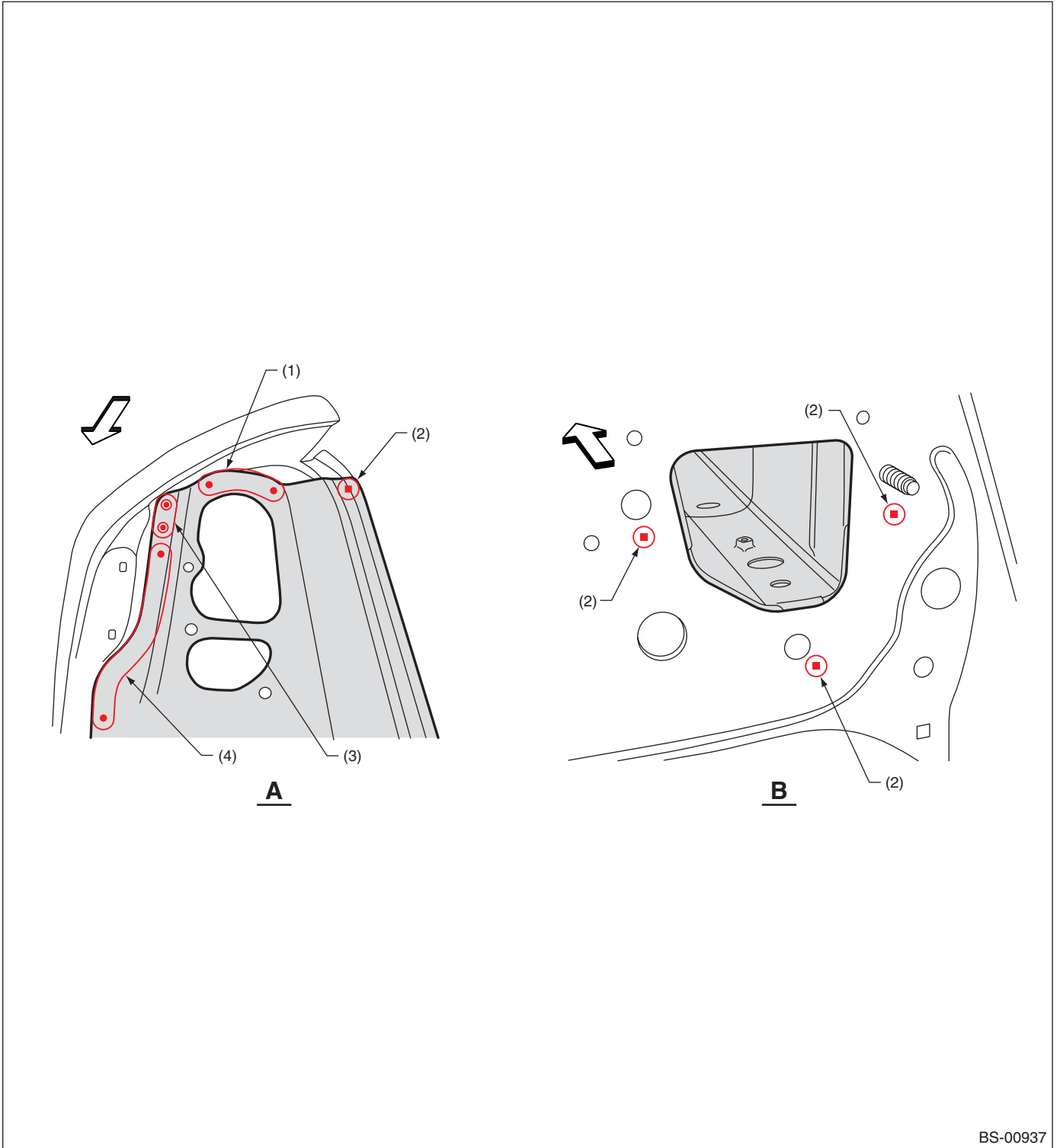
(1) 1 point  
(2) 4 points

(3) 7 points  
(4) 5 points

(5) 3 points  
(6) 8 points

# Rear Skirt / Sedan (total replacement)

## • Views



BS-00937

(1) 4 points  
(2) 1 point

(3) 3 points

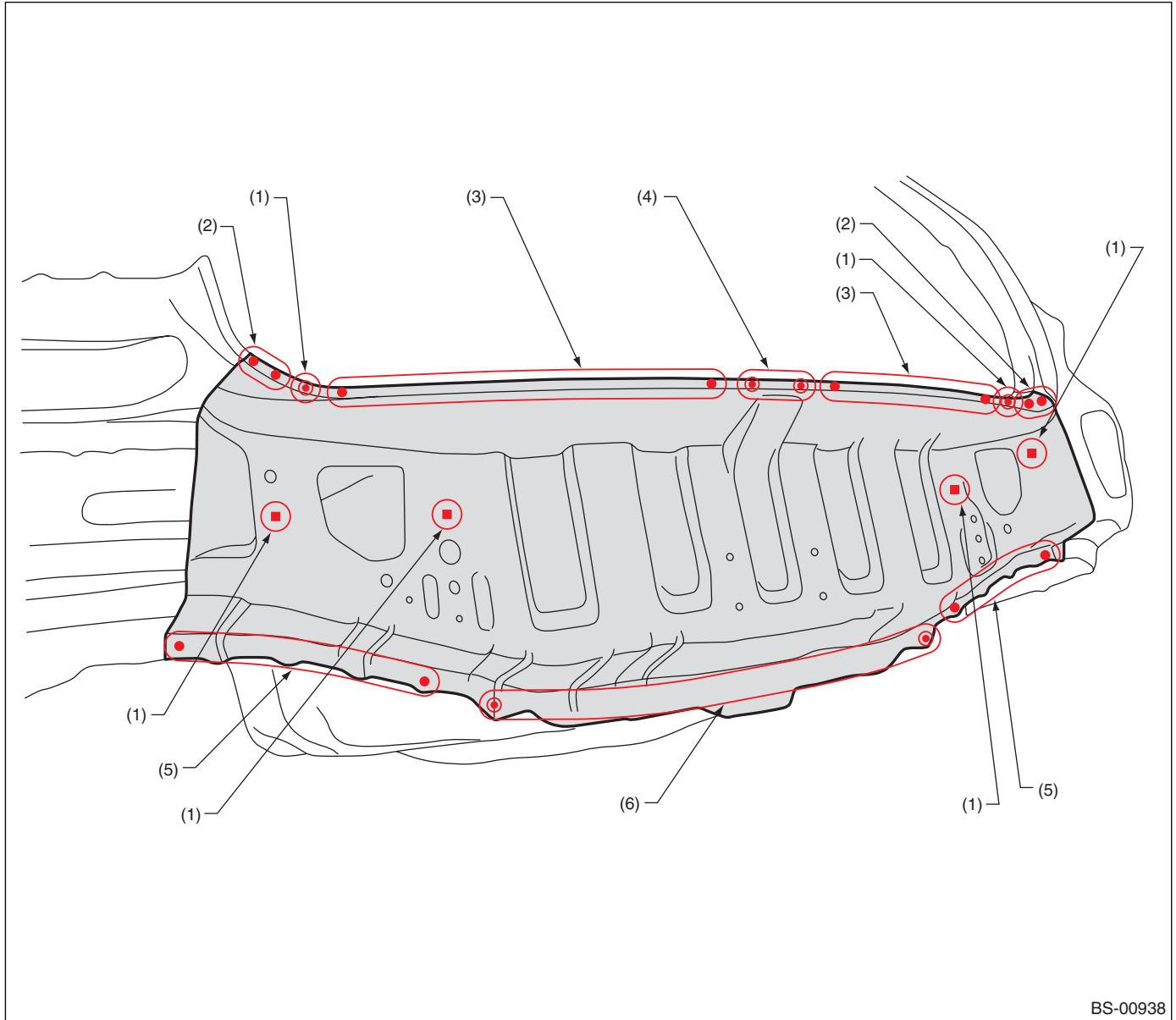
(4) 12 points

# Rear Skirt Outer / Wagon (total replacement)

## 34.Rear Skirt Outer / Wagon (total replacement)

### A: REMOVAL

1) D-pillar removed condition



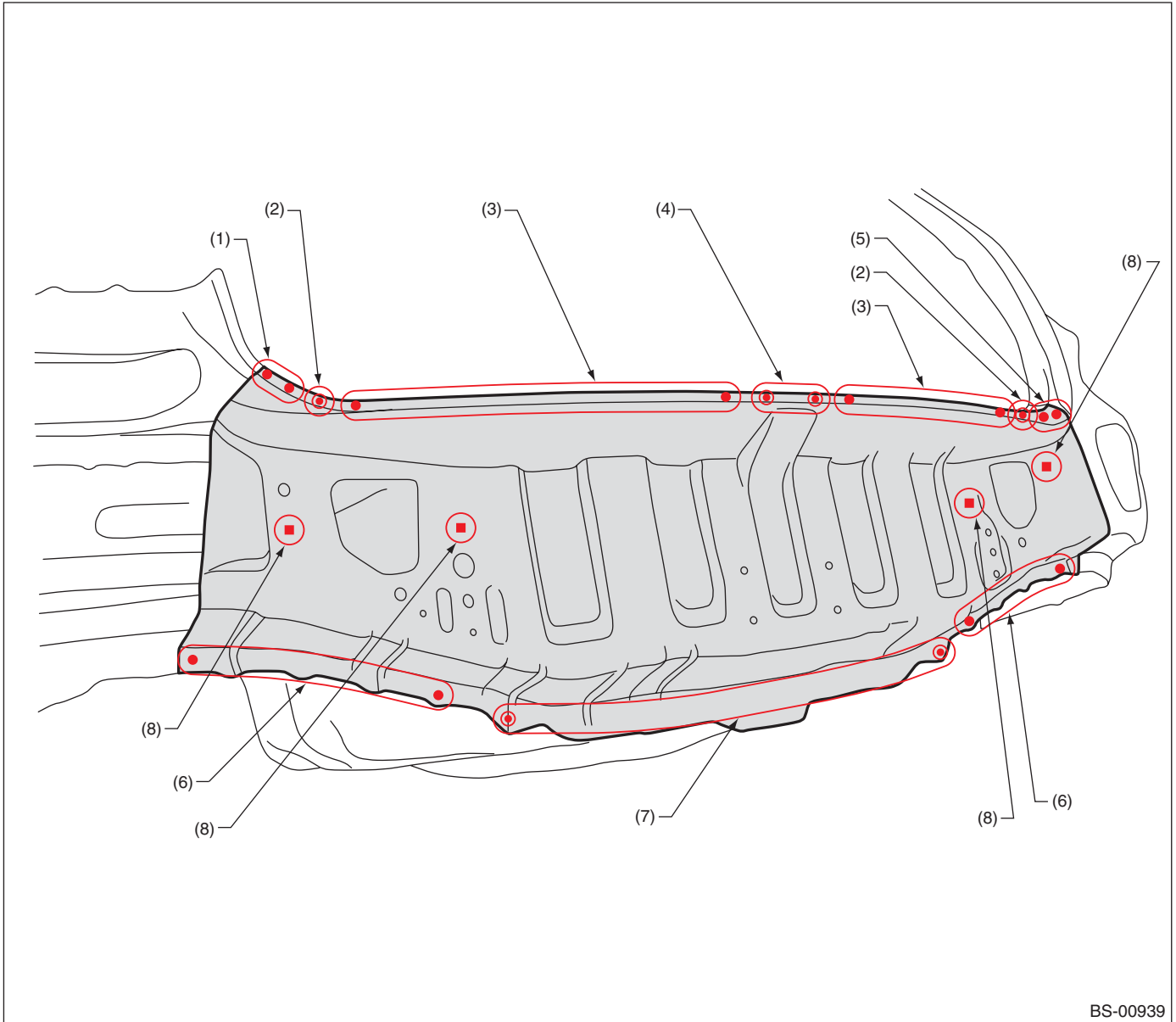
(1) 1 point (outside · 1)  
(2) 2 points (outside · 1)

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

(5) 4 points (outside · 1)  
(6) 10 points (outside · 1)

# Rear Skirt Outer / Wagon (total replacement)

## B: INSTALLATION



BS-00939

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

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

- (7) 12 points
- (8) 1 point (service)

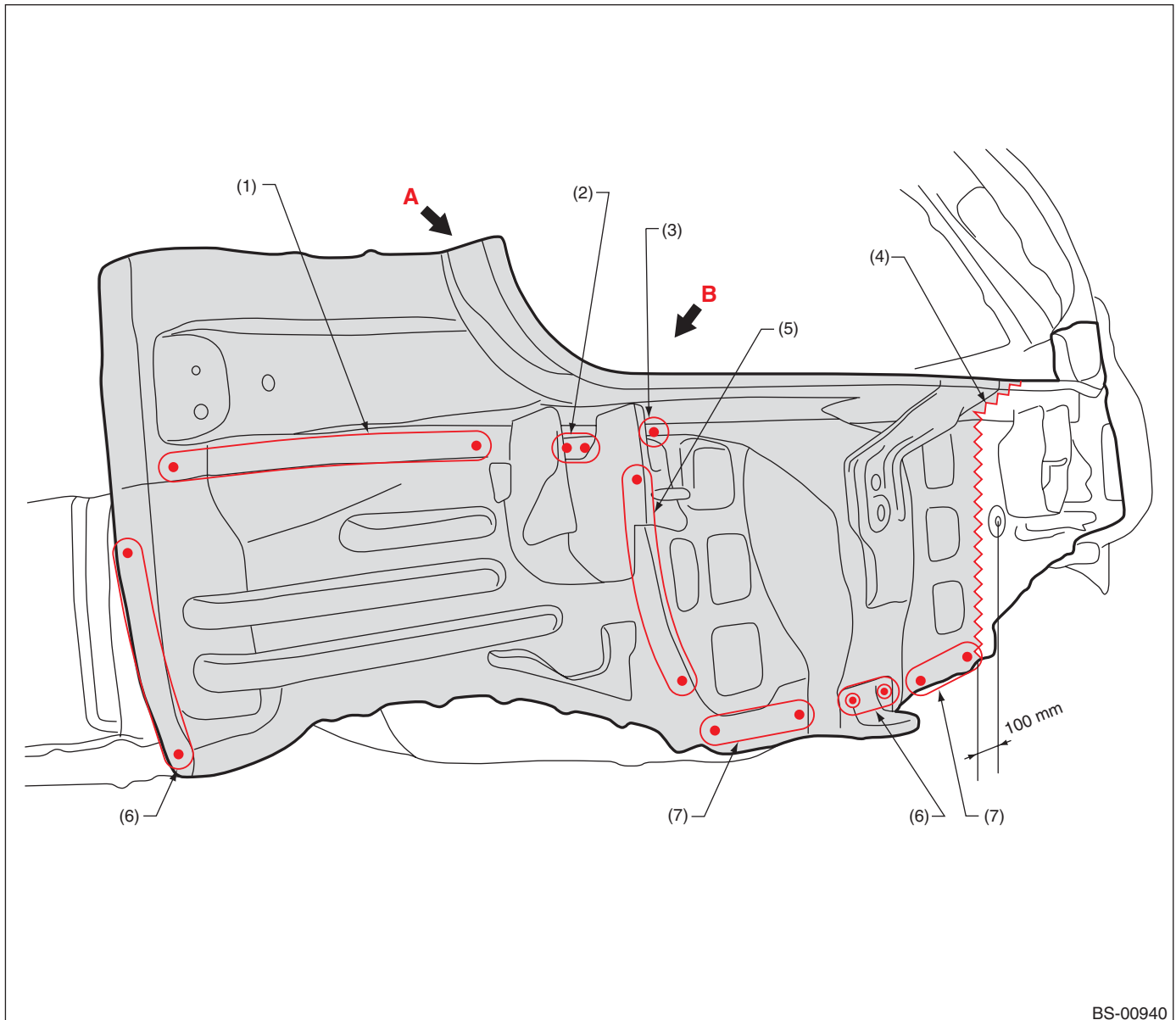
## Rear Skirt Inner / Wagon (partial replacement)

### 35.Rear Skirt Inner / Wagon (partial replacement)

#### A: REMOVAL

1) Rear quarter reinforcement D-pillar and rear skirt outer removed condition

#### • Overall view



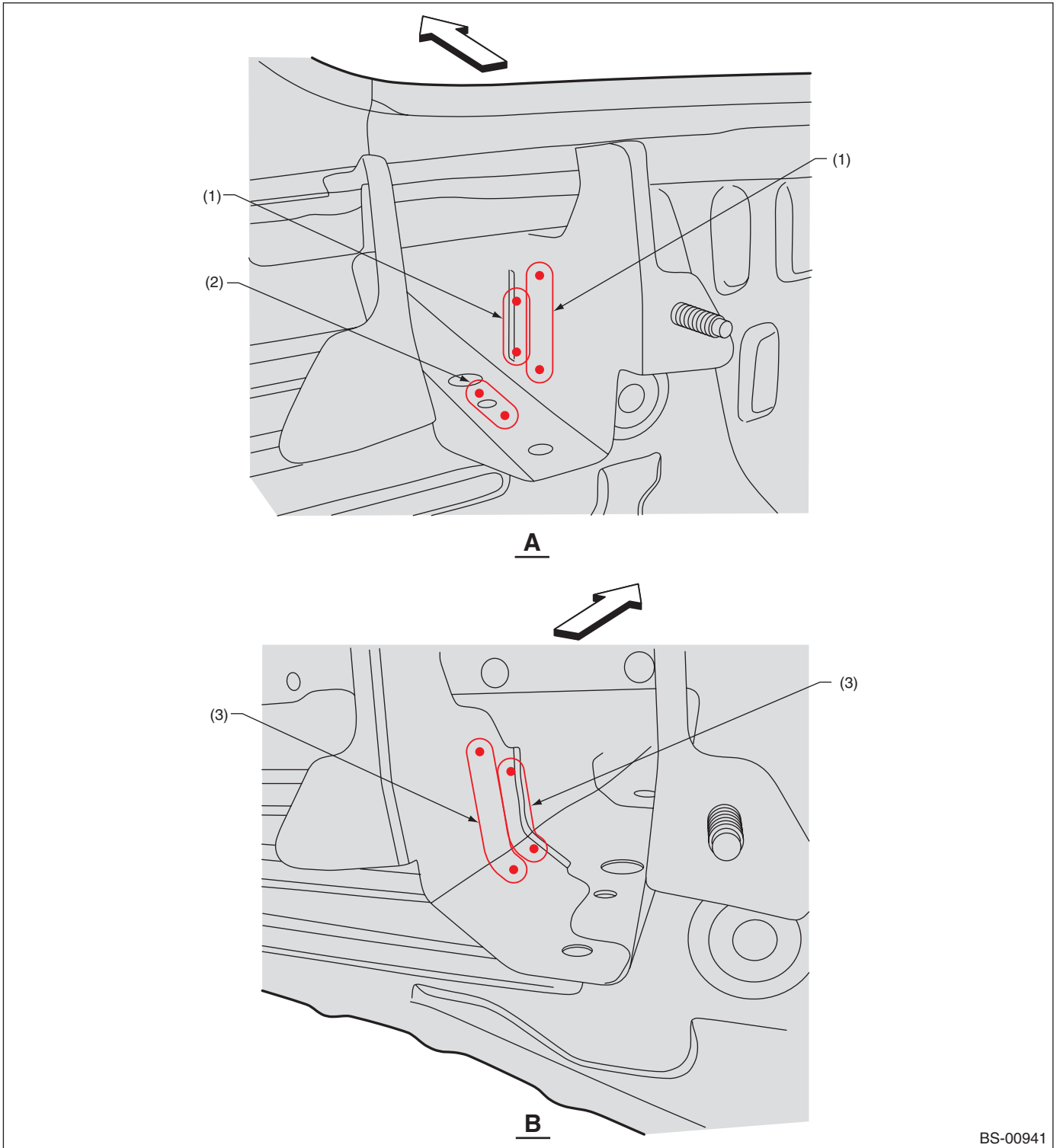
(1) 4 points (outside · 1)  
(2) 2 points (outside · 1)  
(3) 1 point (outside · 1)

(4) Rough cutting (350 mm)  
(5) 5 points (outside · 1)

(6) 3 points (outside · 1)  
(7) 7 points (outside · 1)

# Rear Skirt Inner / Wagon (partial replacement)

## • Views



BS-00941

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

(2) 2 points (top · 1, belt sander)

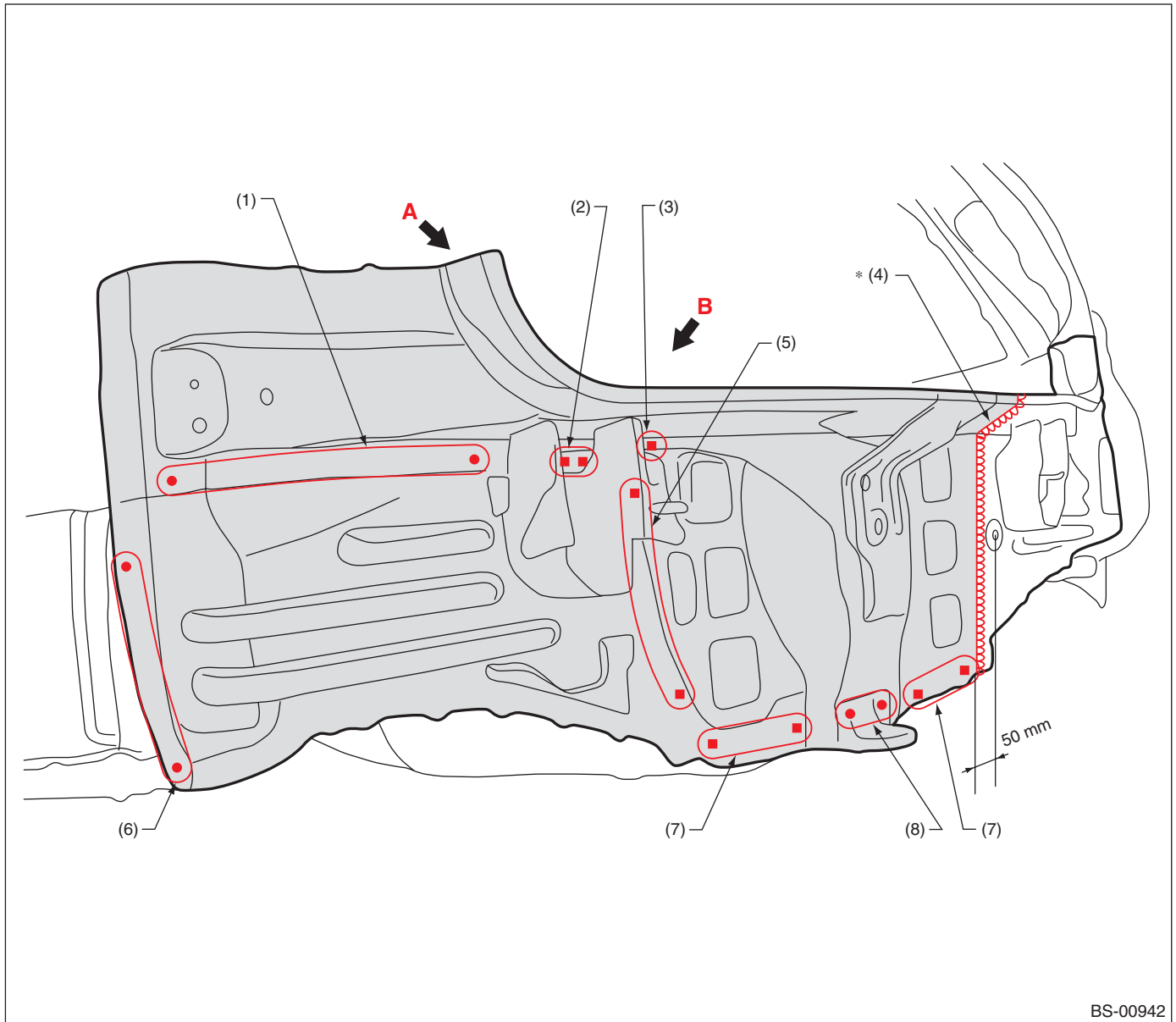
(3) 3 points (inside · 1, belt sander)



# Rear Skirt Inner / Wagon (partial replacement)

## B: INSTALLATION

### • Overall view



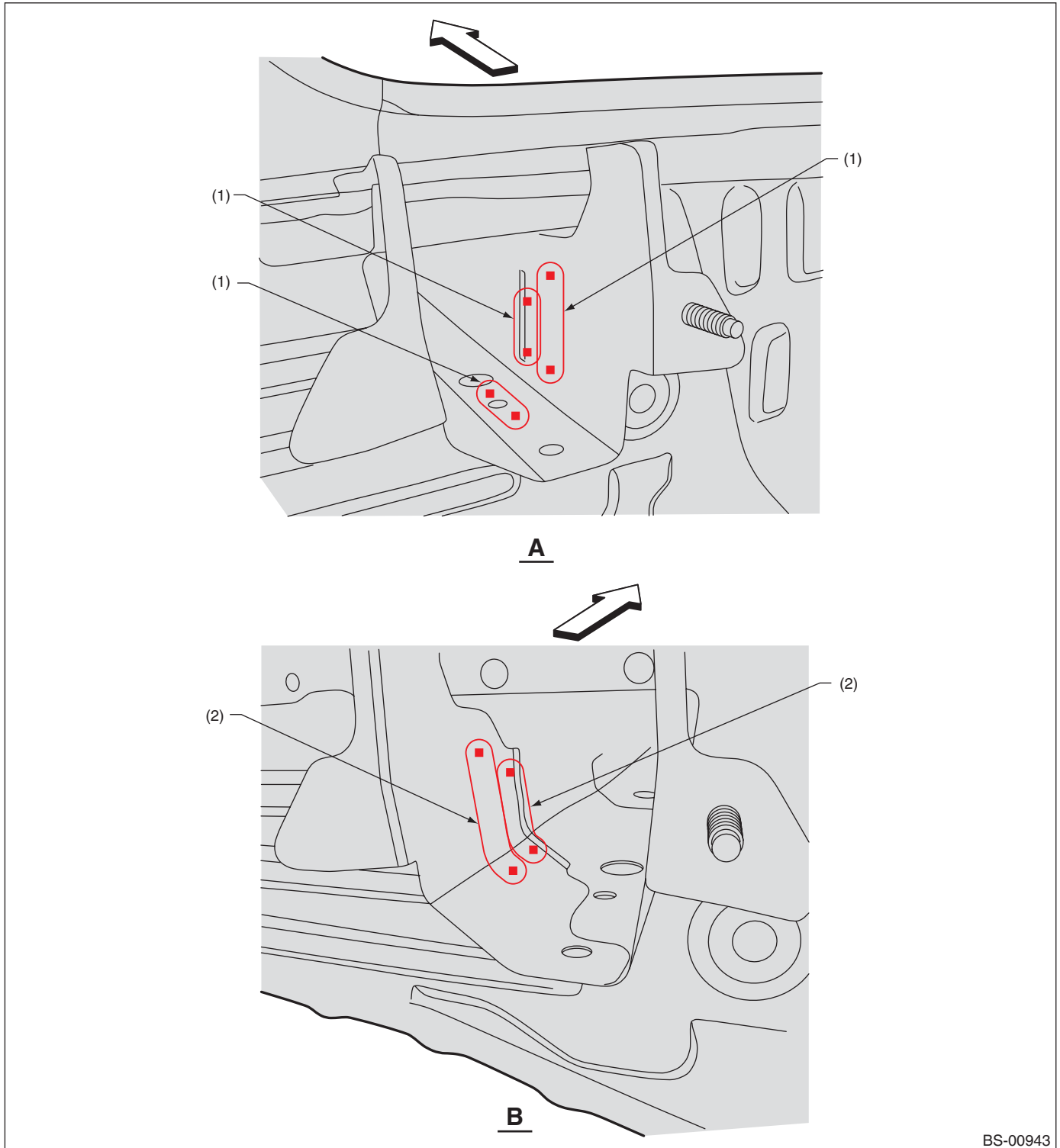
BS-00942

- |                        |                        |                        |
|------------------------|------------------------|------------------------|
| (1) 5 points           | (4) 1 point (350 mm)   | (7) 7 points (service) |
| (2) 2 points (service) | (5) 5 points (service) | (8) 3 points (service) |
| (3) 1 point (service)  | (6) 4 points           |                        |

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

# Rear Skirt Inner / Wagon (partial replacement)

## • Views



BS-00943

(1) 2 points (service)

(2) 3 points (service)

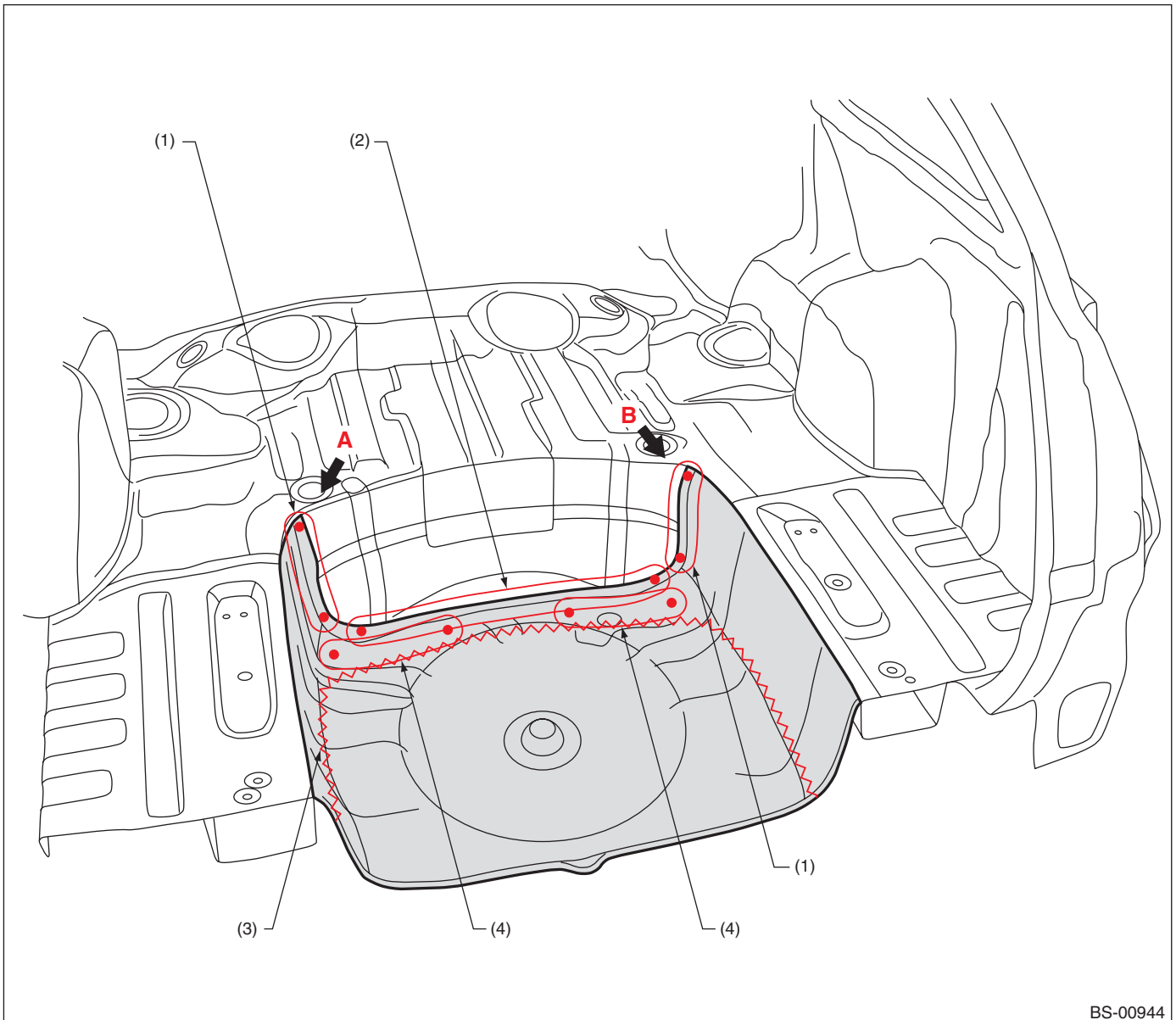
## Rear Floor Pan (total replacement)

### 36.Rear Floor Pan (total replacement)

#### A: REMOVAL

1) Rear skirt outer and rear skirt inner removed condition

#### • Overall view



BS-00944

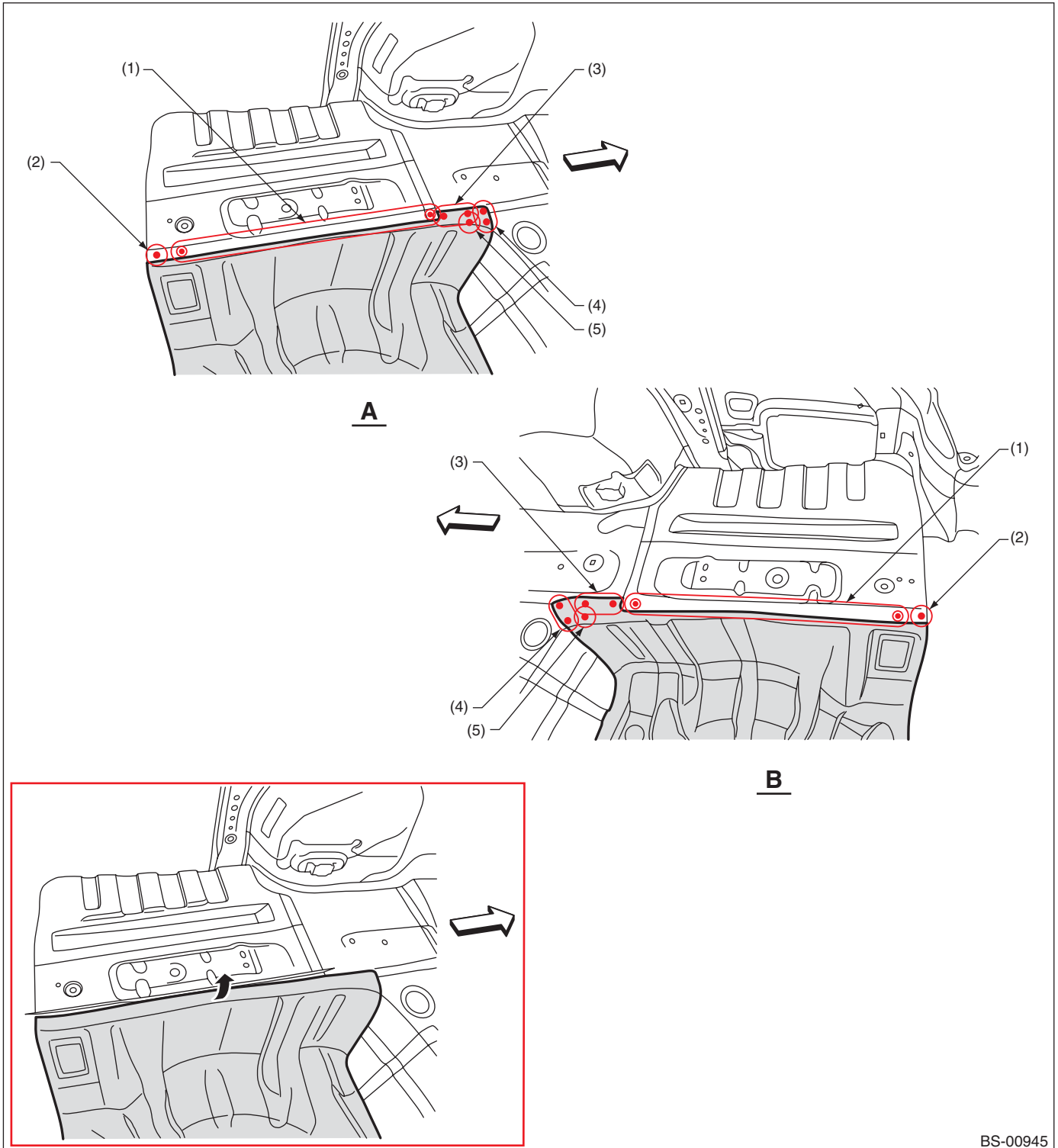
(1) 5 points (inside · 1)  
(2) 9 points (top · 1)

(3) Rough cutting (2300 mm)

(4) 4 points (top · 1)

# Rear Floor Pan (total replacement)

## • Views



(1) 15 points (top · 2)

(2) 1 point (outside · 1)

(3) 3 points (top · 1)

(4) 2 points (top · 1)

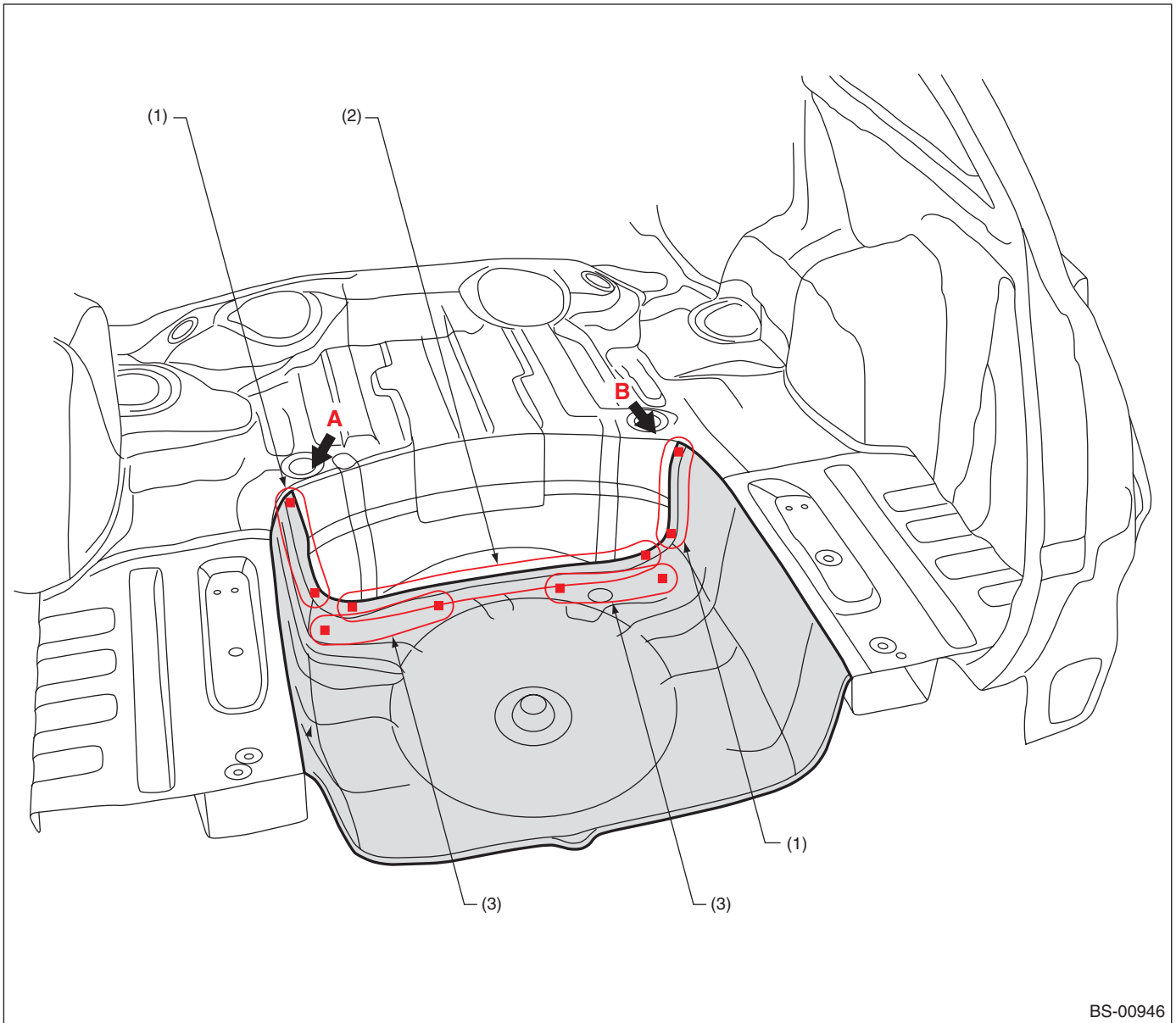
(5) 1 point (top · 1)

**POINT:** To make removal easier, remove the rear floor side when working.

# Rear Floor Pan (total replacement)

## B: INSTALLATION

- Overall view



BS-00946

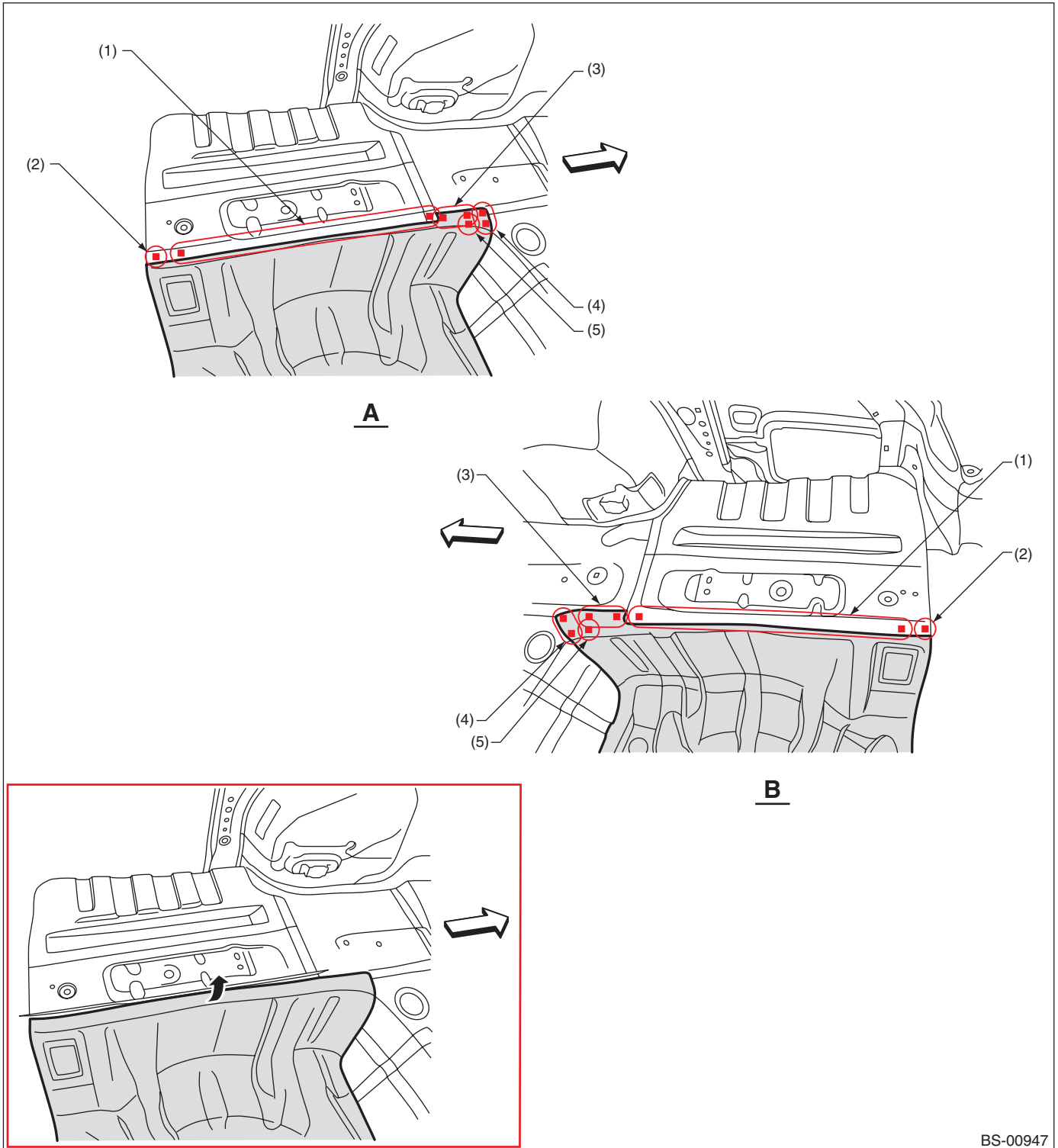
(1) 5 points (service)

(2) 9 points (service)

(3) 4 points (service)

# Rear Floor Pan (total replacement)

## • Views



BS-00947

(1) 15 points

(2) 1 point

(3) 3 points (service)

(4) 2 points (service)

(5) 1 point (service)

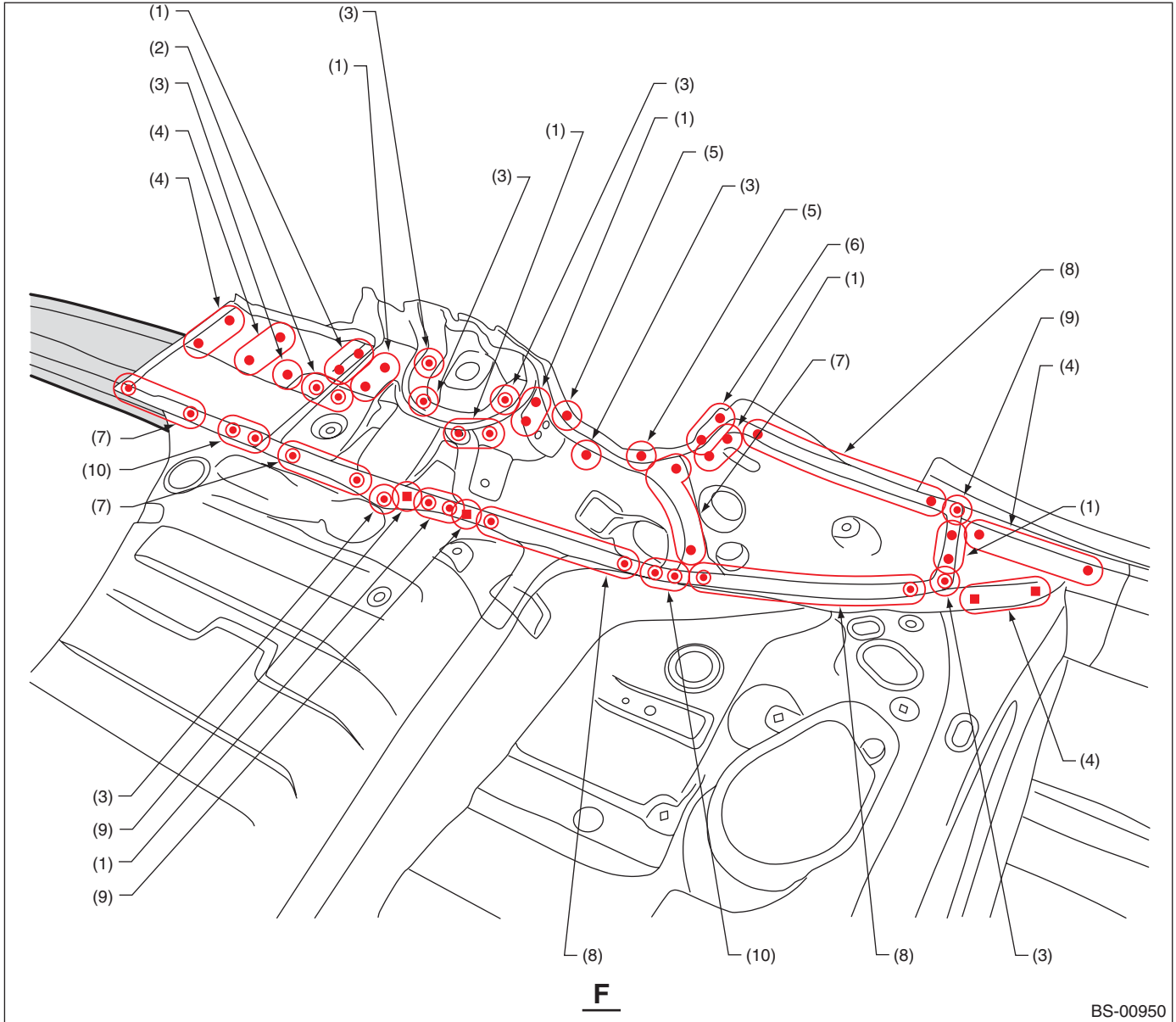
POINT: To make removal easier, remove the rear floor side when working.

# Closing Plate (total replacement)

## 37. Closing Plate (total replacement)

### A: REMOVAL

#### • Views



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

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

- (8) 5 points (top · 1)
- (9) 1 point (top · 2)
- (10) 2 points (top · 2)

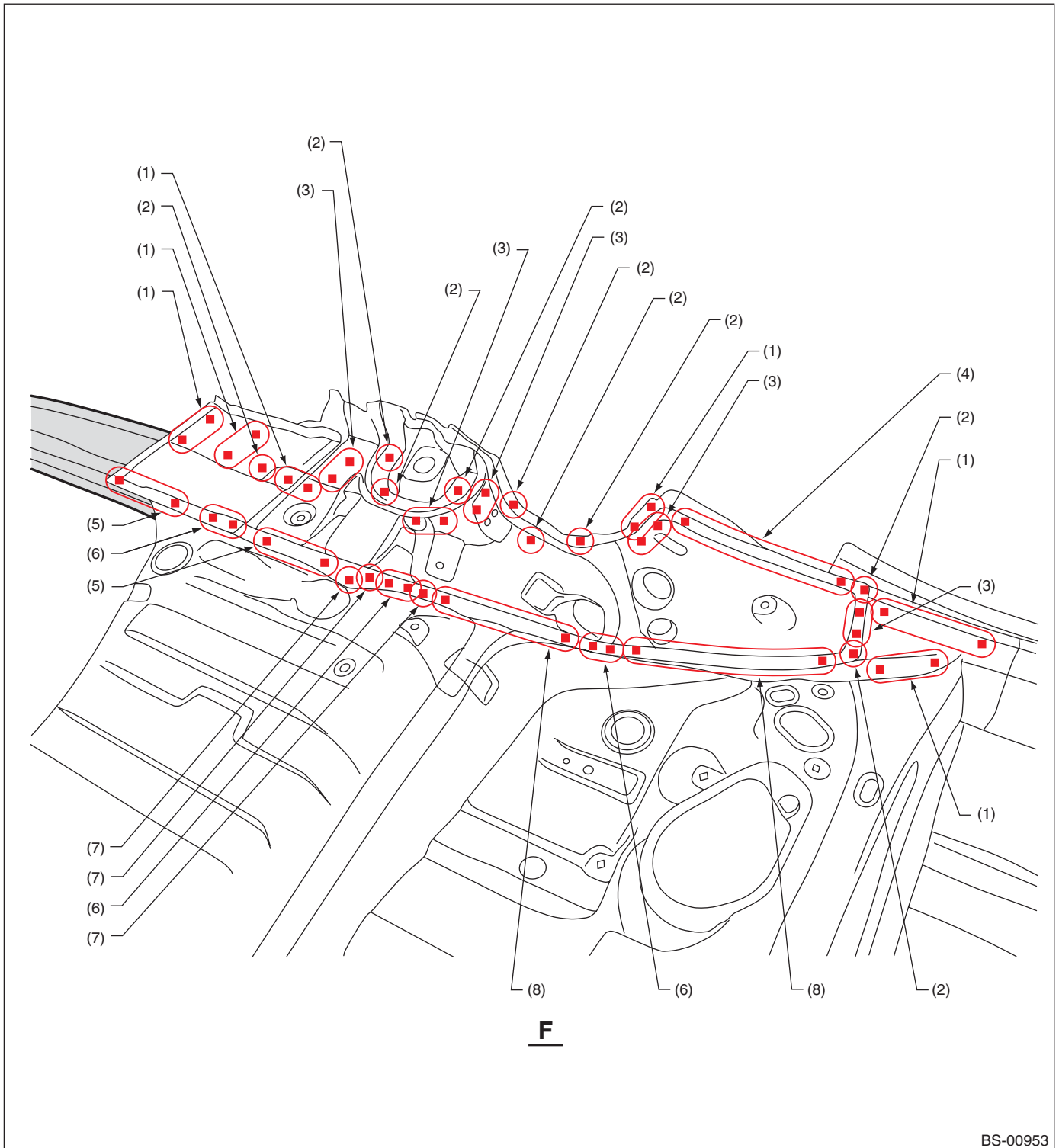
#### CAUTION:

Remove the closing plate front CP to make rear frame removal easier.

# Closing Plate (total replacement)

## B: INSTALLATION

### • Views



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

- (4) 5 points
- (5) 4 points (matching)
- (6) 2 points (matching)

- (7) 1 point (matching)
- (8) 5 points (matching)



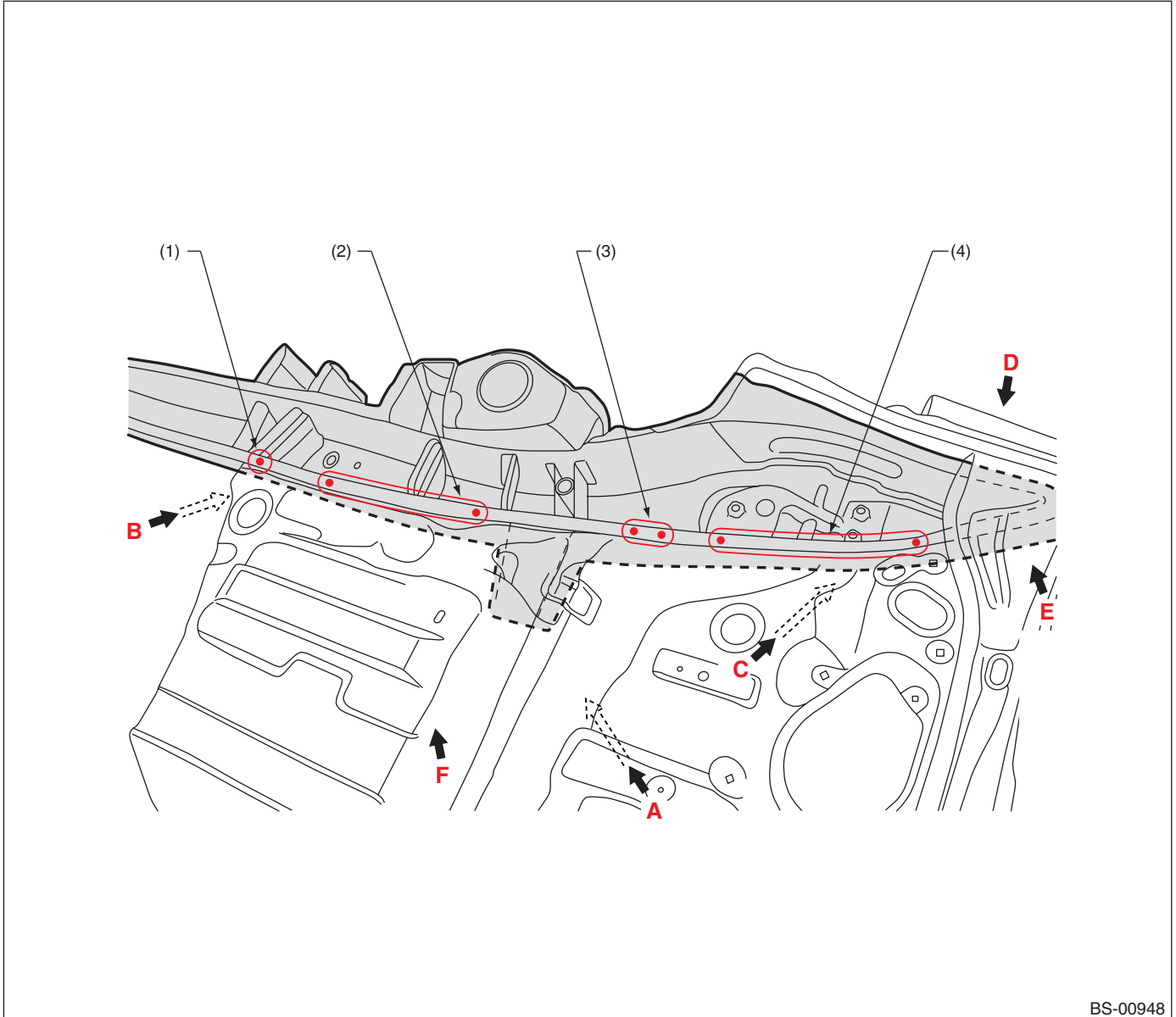
## Rear Frame / Wagon (total replacement)

### 38.Rear Frame / Wagon (total replacement)

#### A: REMOVAL

1) Rear quarter, reinforcement, D-pillar, closing plate front CP, rear wheel apron, rear floor pan, rear skirt outer and rear skirt inner removed condition

#### • Overall view



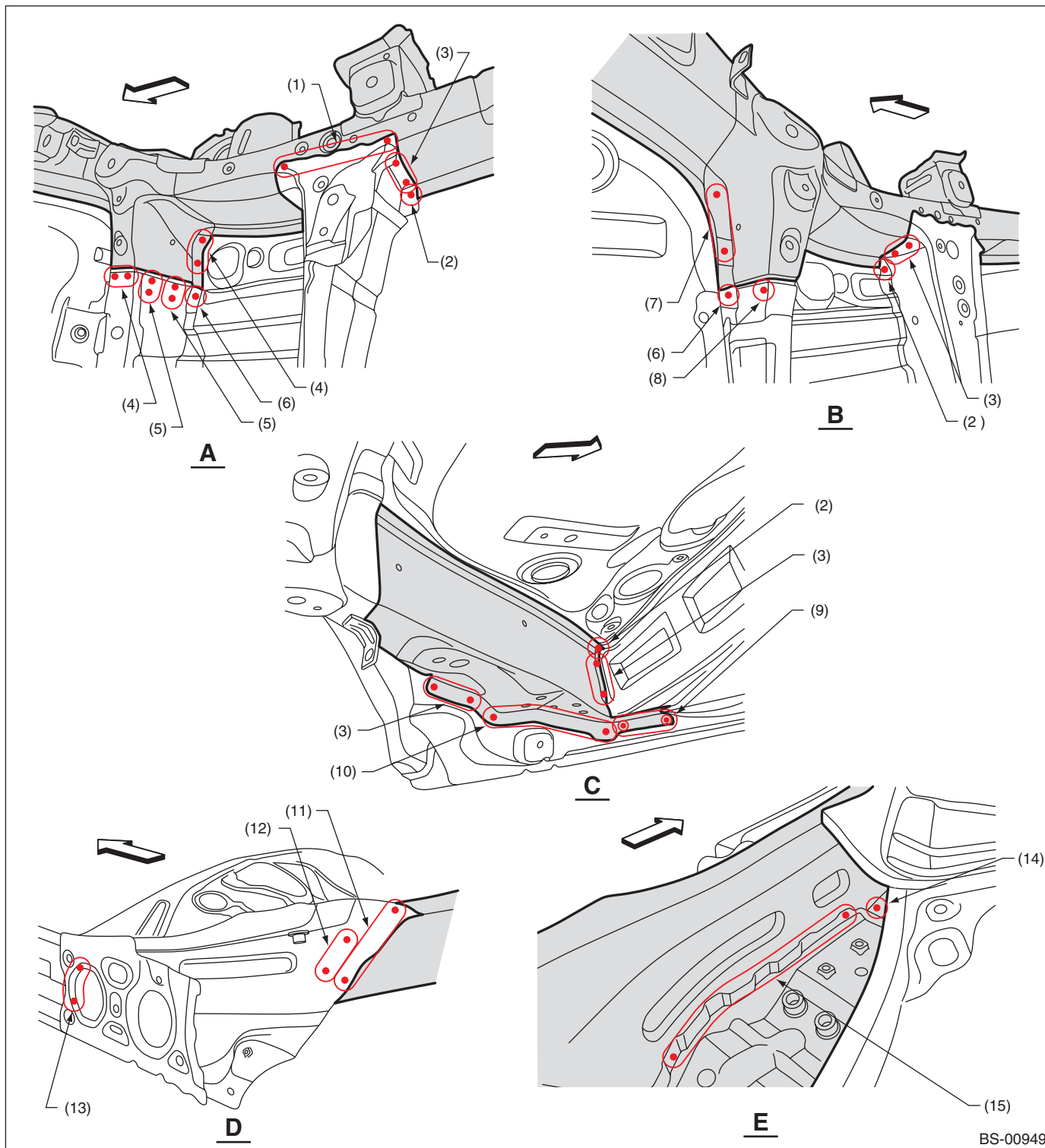
(1) 1 point (top · 1)  
(2) 4 points (top · 1)

(3) 3 points (top · 1)

(4) 5 points (top · 1)

# Rear Frame / Wagon (total replacement)

## • Views



BS-00949

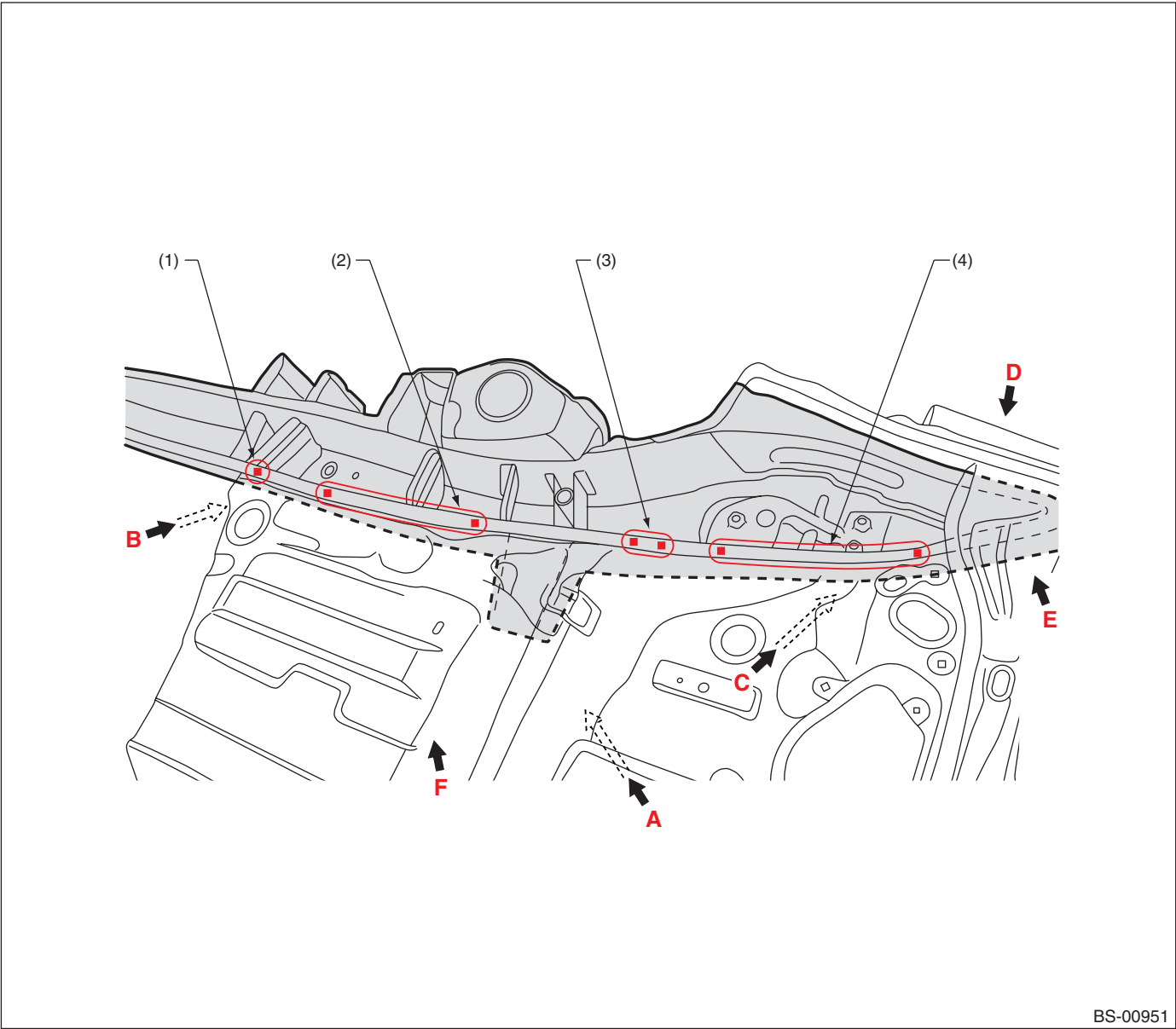
- |                                     |                                     |   |
|-------------------------------------|-------------------------------------|---|
| (1) 5 points (bottom · 1)           | (6) 1 point (bottom · penetration)  | (11) 4 points (outside · 1)             |
| (2) 1 point (bottom · 1)            | (7) 3 points (inside · penetration) | (12) 2 points (outside · 1)             |
| (3) 3 points (inside · 1)           | (8) 1 point (inside · penetration)  | (13) 3 points (outside · 1)             |
| (4) 2 points (bottom · penetration) | (9) 4 points (inside · 2)           | (14) 1 point (inside · 1)               |
| (5) 2 points (inside · penetration) | (10) 6 points (inside · 1)          | (15) 5 points (inside · 1, belt sander) |

View E shows the closing plate front complete removed.

# Rear Frame / Wagon (total replacement)

## B: INSTALLATION

- Overall view



BS-00951

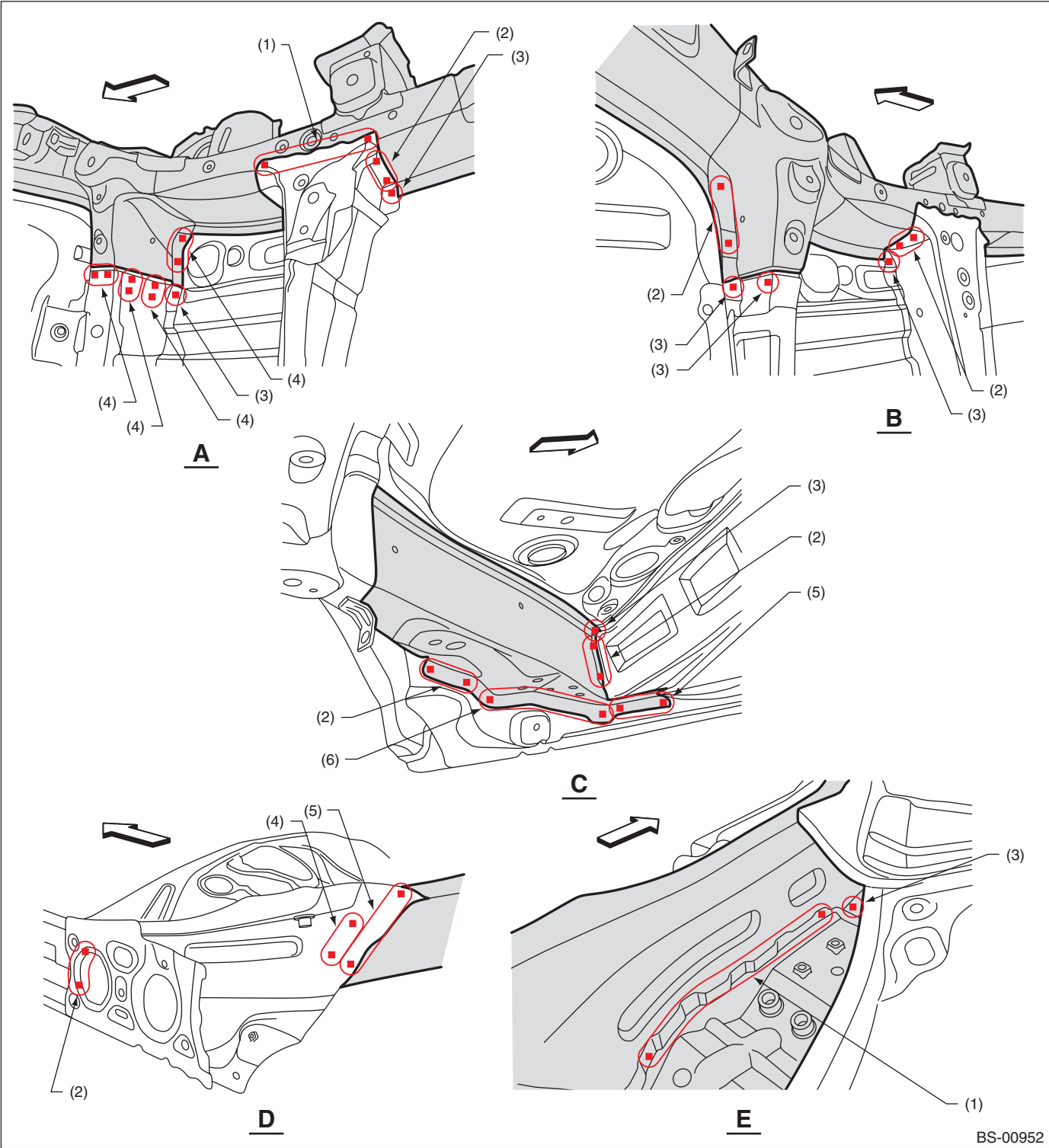
(1) 1 point  
(2) 4 points

(3) 3 points

(4) 5 points

# Rear Frame / Wagon (total replacement)

• Views



BS-00952

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

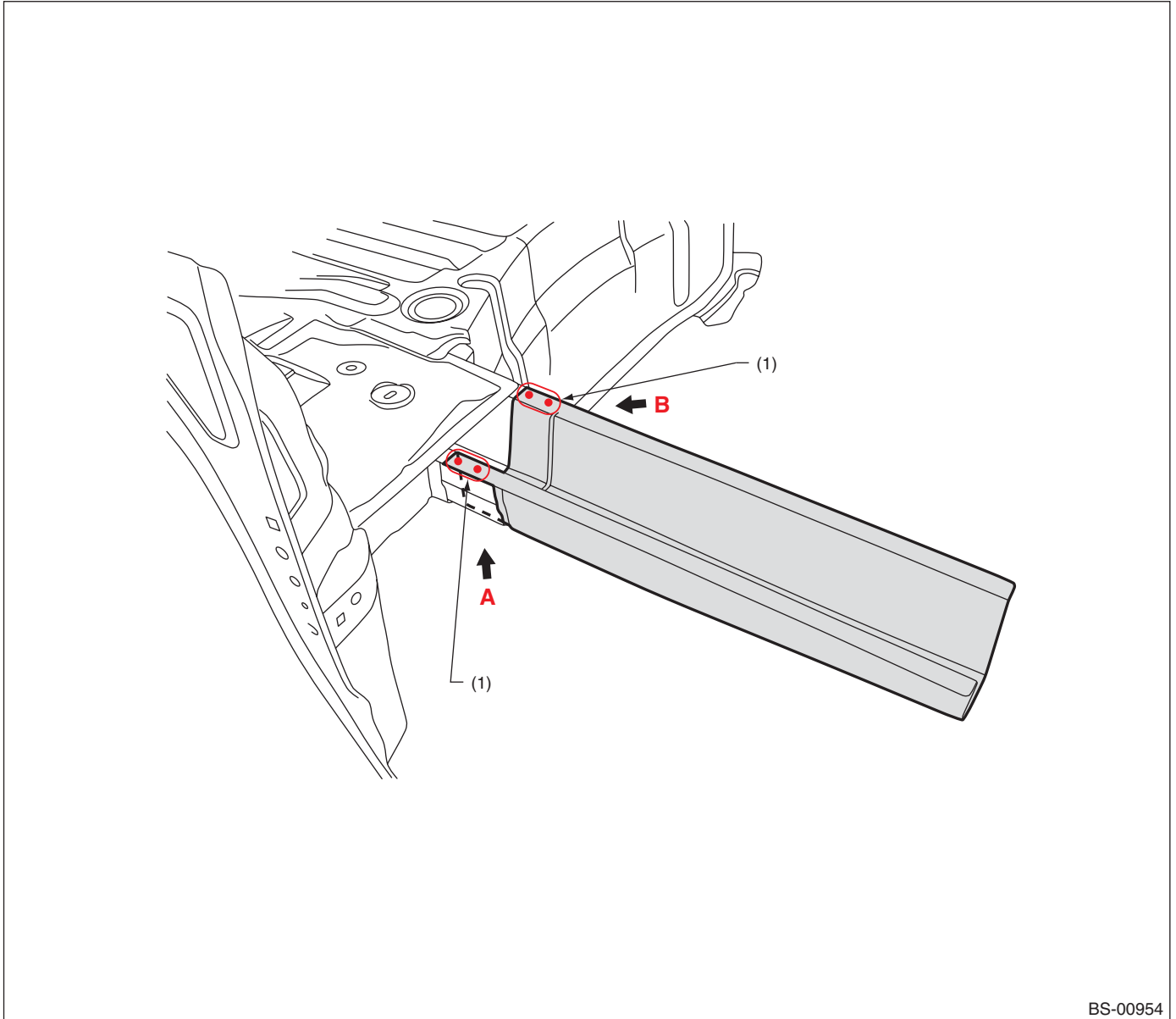
View E shows the closing plate front complete removed.

## Rear Side Frame Rear (partial replacement)

### 39.Rear Side Frame Rear (partial replacement)

#### A: REMOVAL

- Overall view

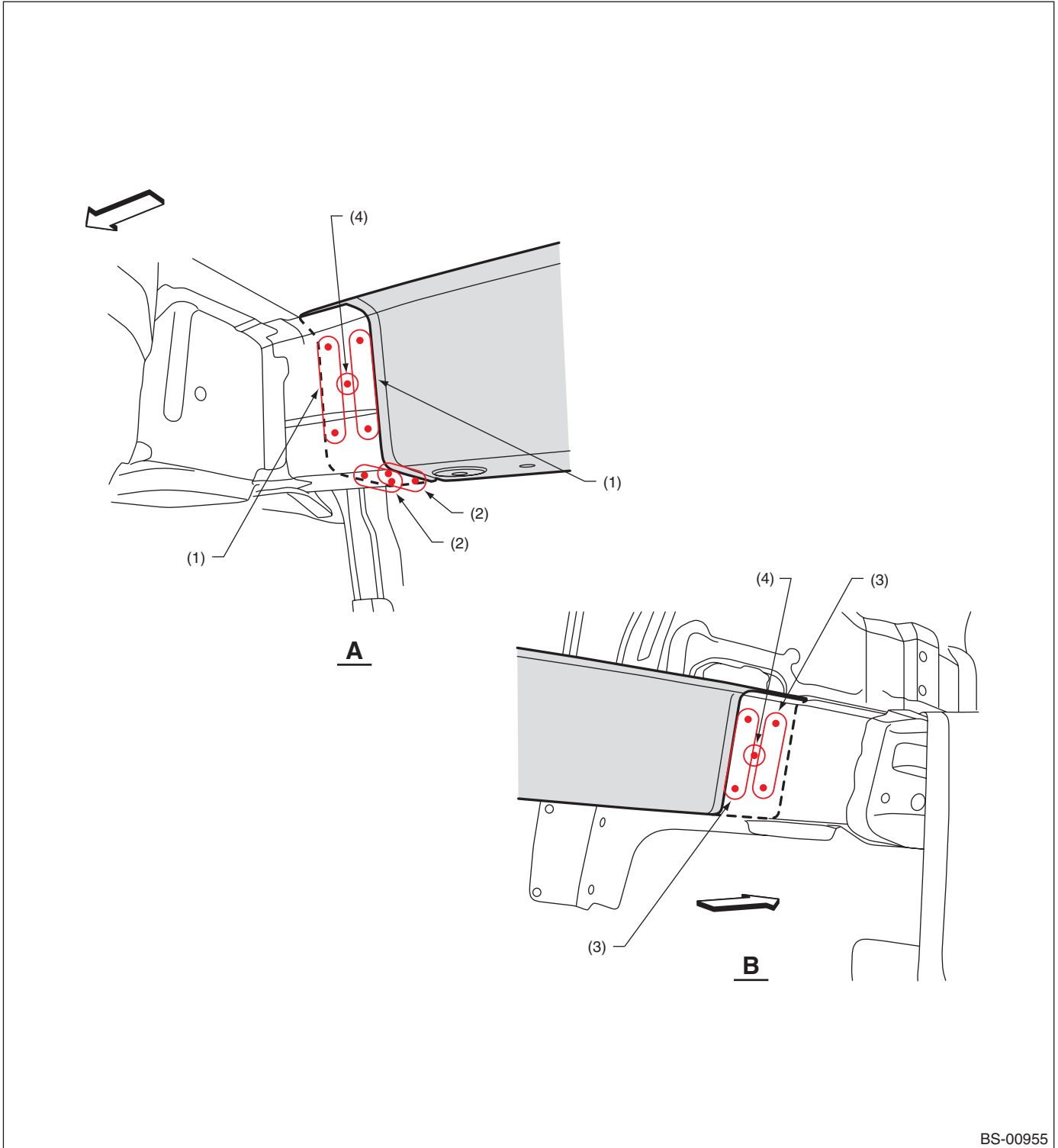


BS-00954

(1) 2 points (top · 2)

# Rear Side Frame Rear (partial replacement)

## • Views



BS-00955

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

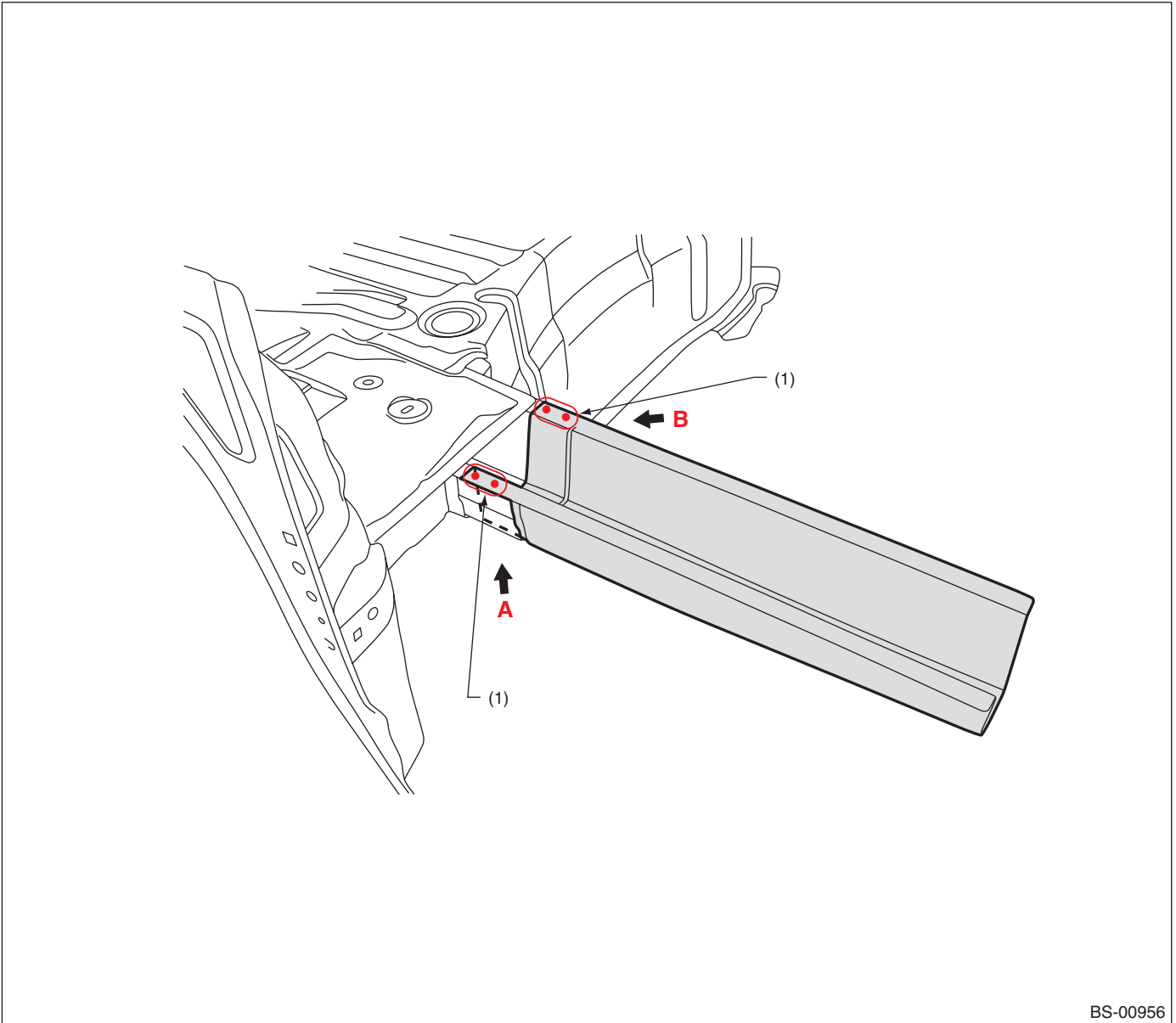
(3) 2 points (inside · 1)

(4) 1 point (inside · 1)

# Rear Side Frame Rear (partial replacement)

## B: INSTALLATION

- Overall view

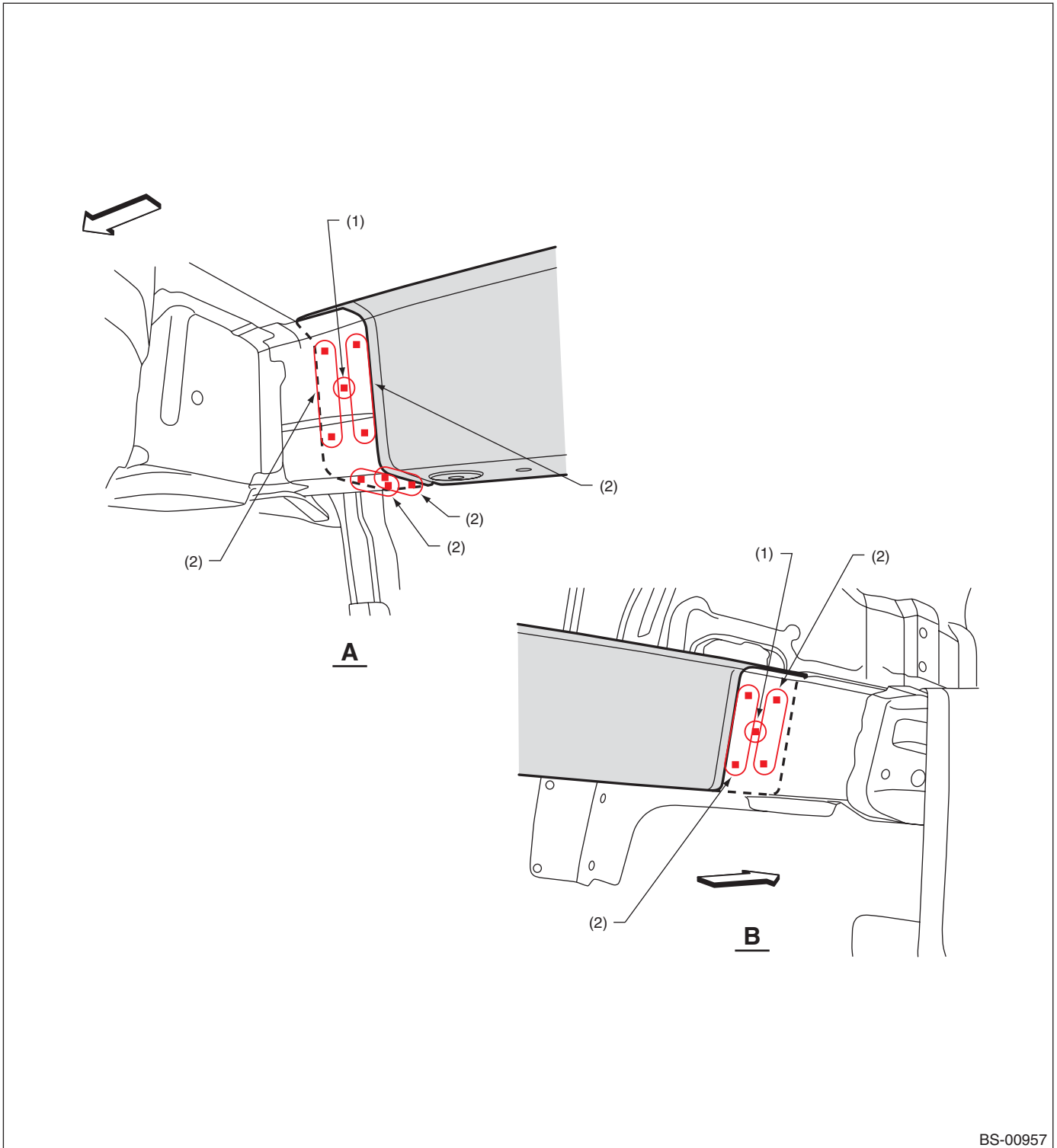


BS-00956

(1) 2 points

# Rear Side Frame Rear (partial replacement)

- Views



BS-00957

(1) 1 point

(2) 2 points

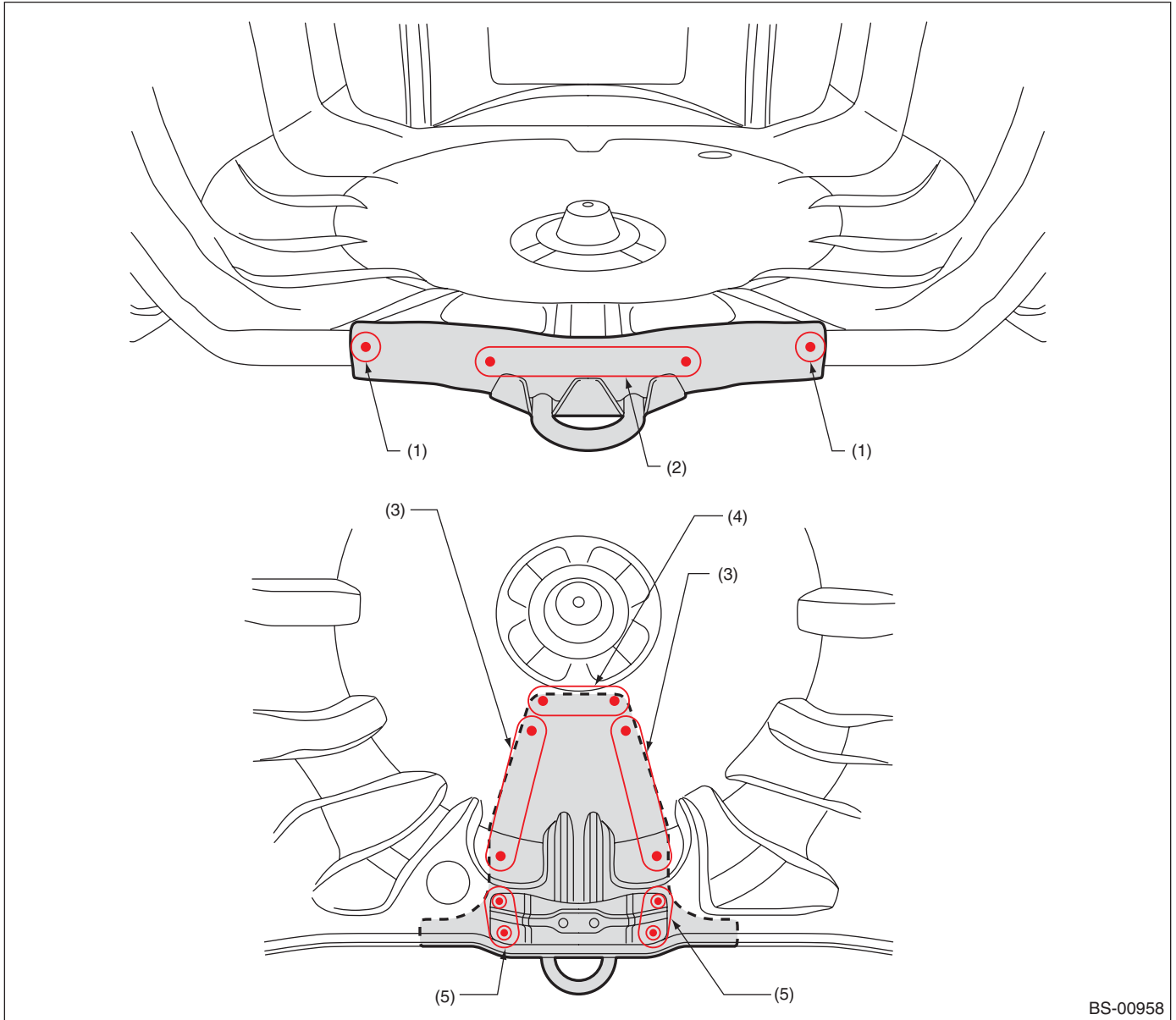


# Plate Tractive (total replacement)

## 40. Plate Tractive (total replacement)

### A: REMOVAL

1) Rear skirt outer and rear skirt inner removed condition



BS-00958

(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

(3) 4 points (top · 1)

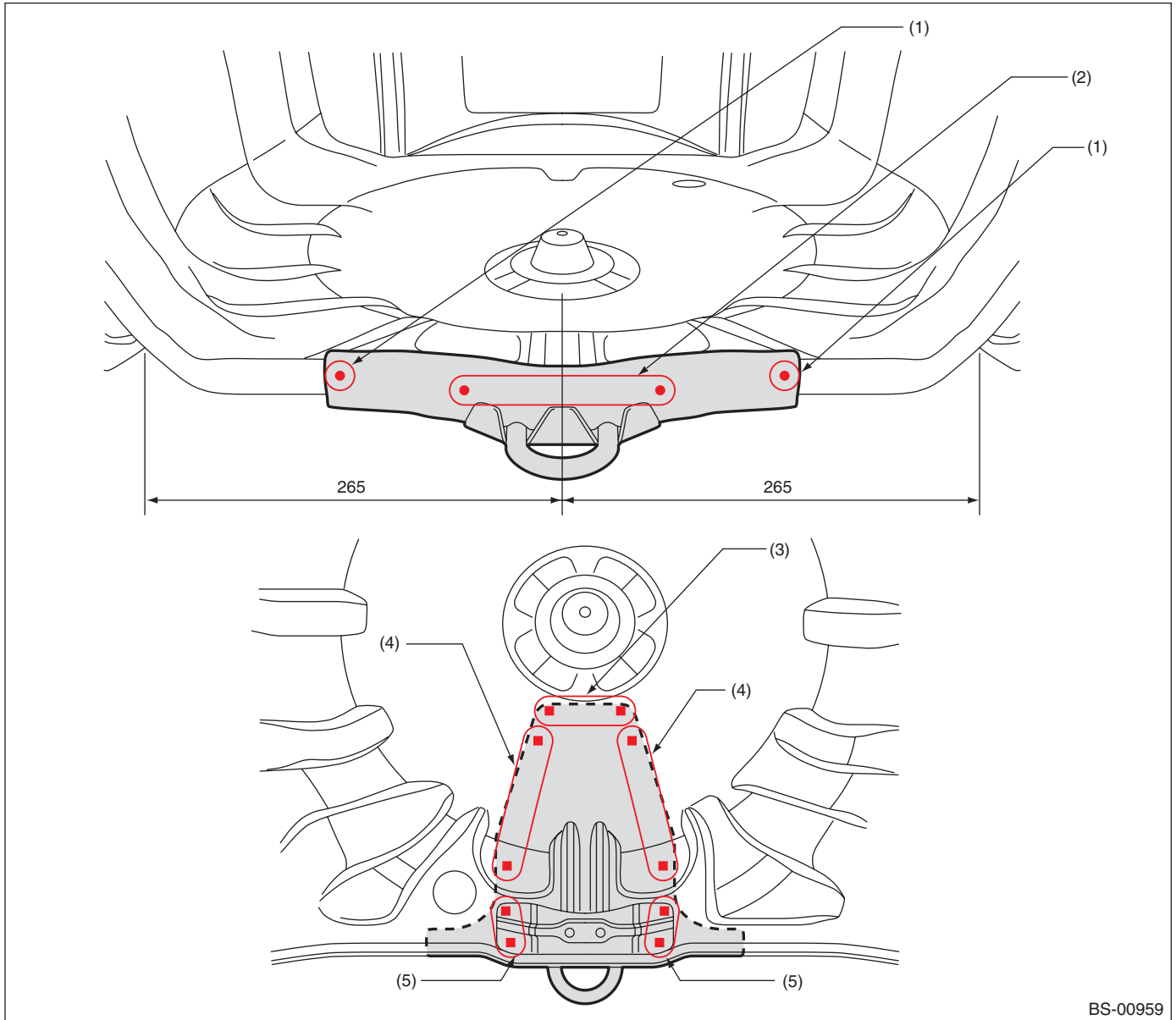
(4) 3 points (top · 1)

(5) 2 points (top · 2)

On sedans: rear skirt outer removed condition

# Plate Tractive (total replacement)

## B: INSTALLATION



(1) 1 point  
(2) 5 points

(3) 3 points  
(4) 4 points

(5) 2 points (service · matching)

On sedans: rear skirt outer removed condition

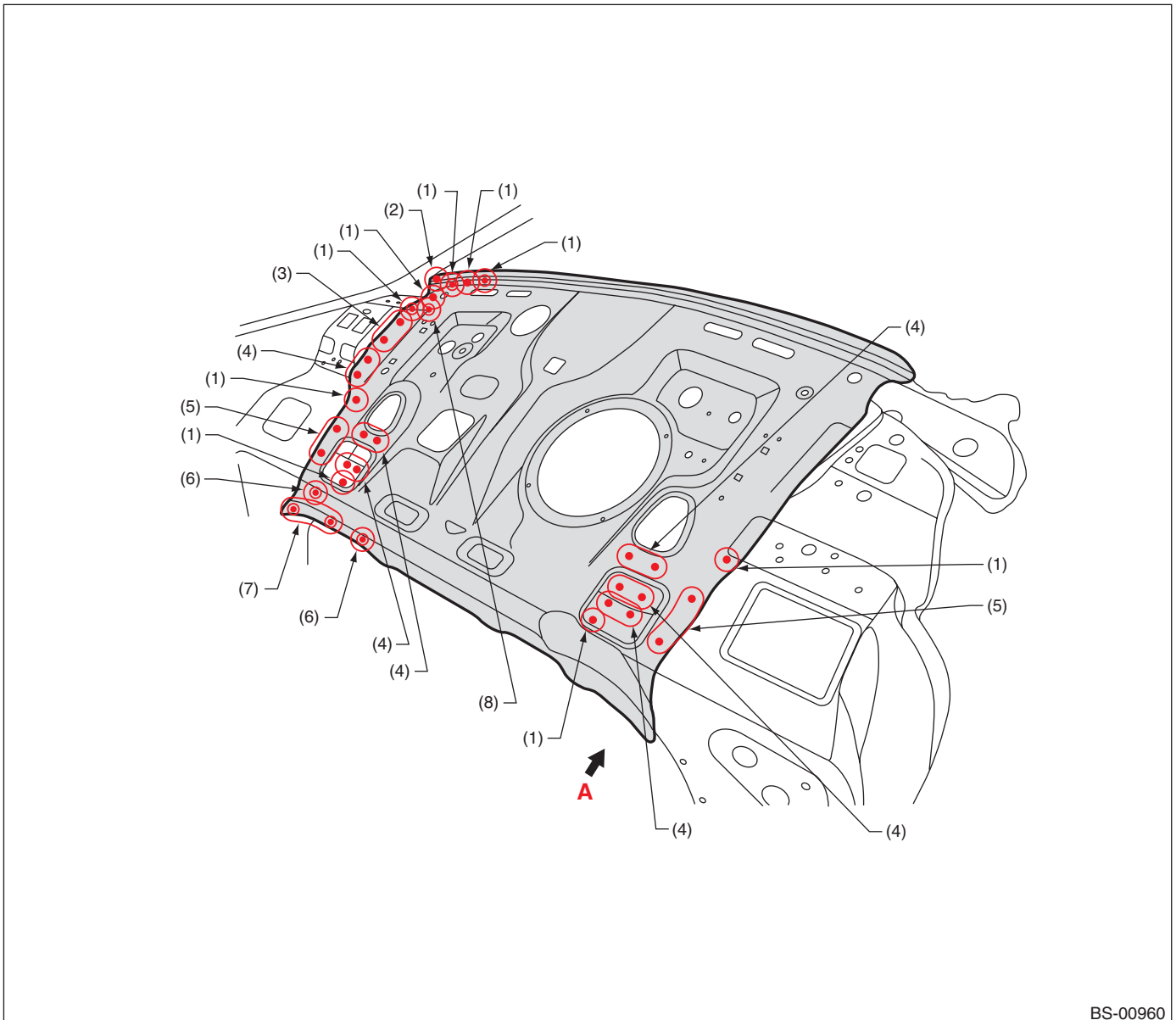
## Rear Panel / Sedan (total replacement)

### 41.Rear Panel / Sedan (total replacement)

#### A: REMOVAL

1) Rear quarter, rear quarter inner upper and reinforcement removed condition

#### • Overall view

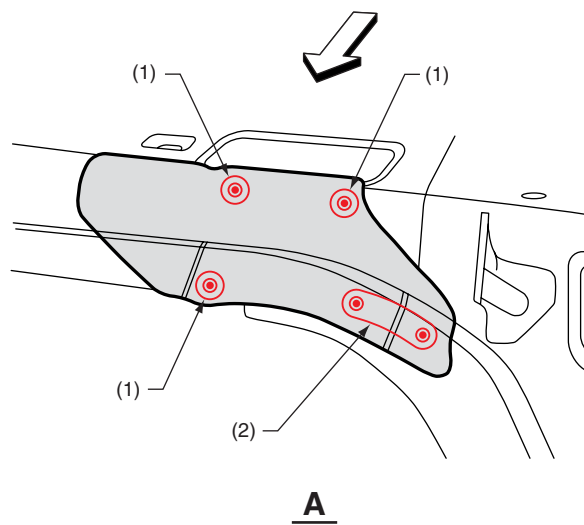


BS-00960

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

# Rear Panel / Sedan (total replacement)

- Views



BS-00961

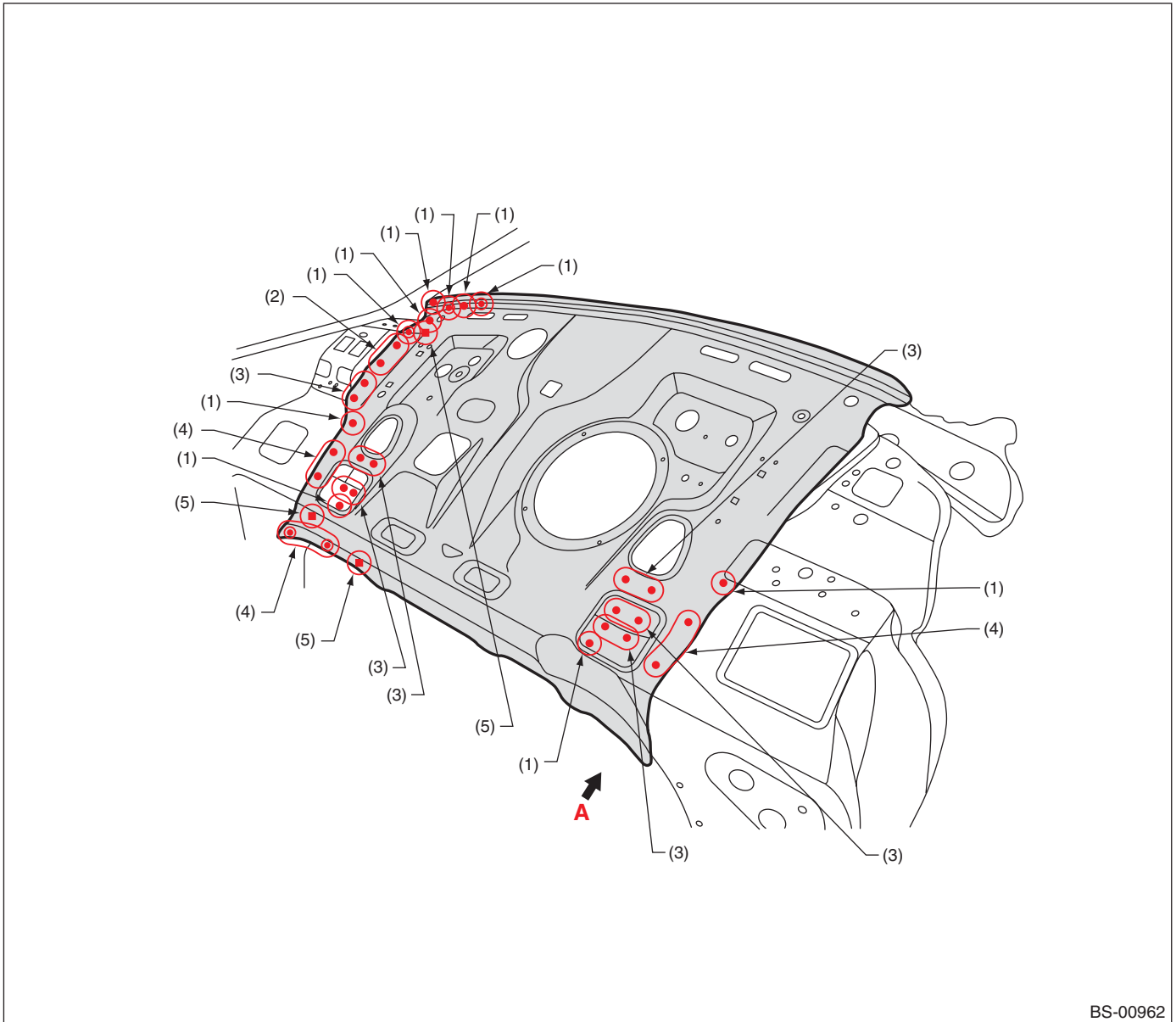
(1) 1 point (inside · 2)

(2) 3 points (inside · 1)

# Rear Panel / Sedan (total replacement)

## B: INSTALLATION

### • Overall view



BS-00962

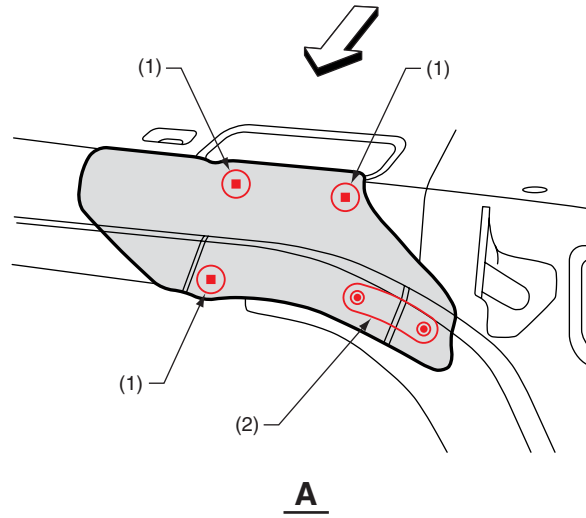
(1) 1 point  
(2) 5 points

(3) 3 points  
(4) 4 points

(5) 1 point (service · matching)

# Rear Panel / Sedan (total replacement)

- Views



BS-00963

(1) 1 point (service · matching)

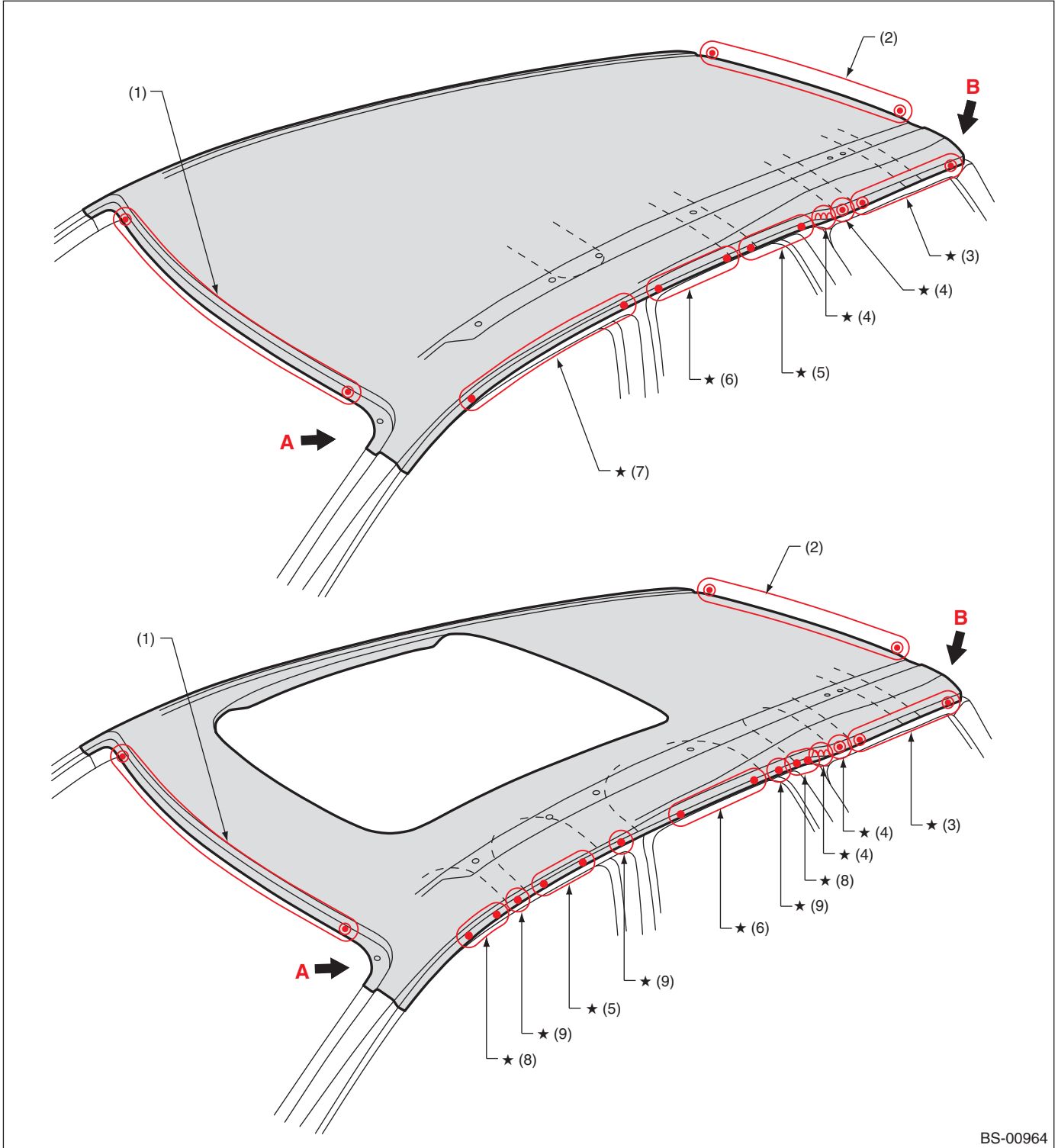
(2) 4 points

## Roof Panel / Wagon (total replacement)

### 42. Roof Panel / Wagon (total replacement)

#### A: REMOVAL

##### • Overall view



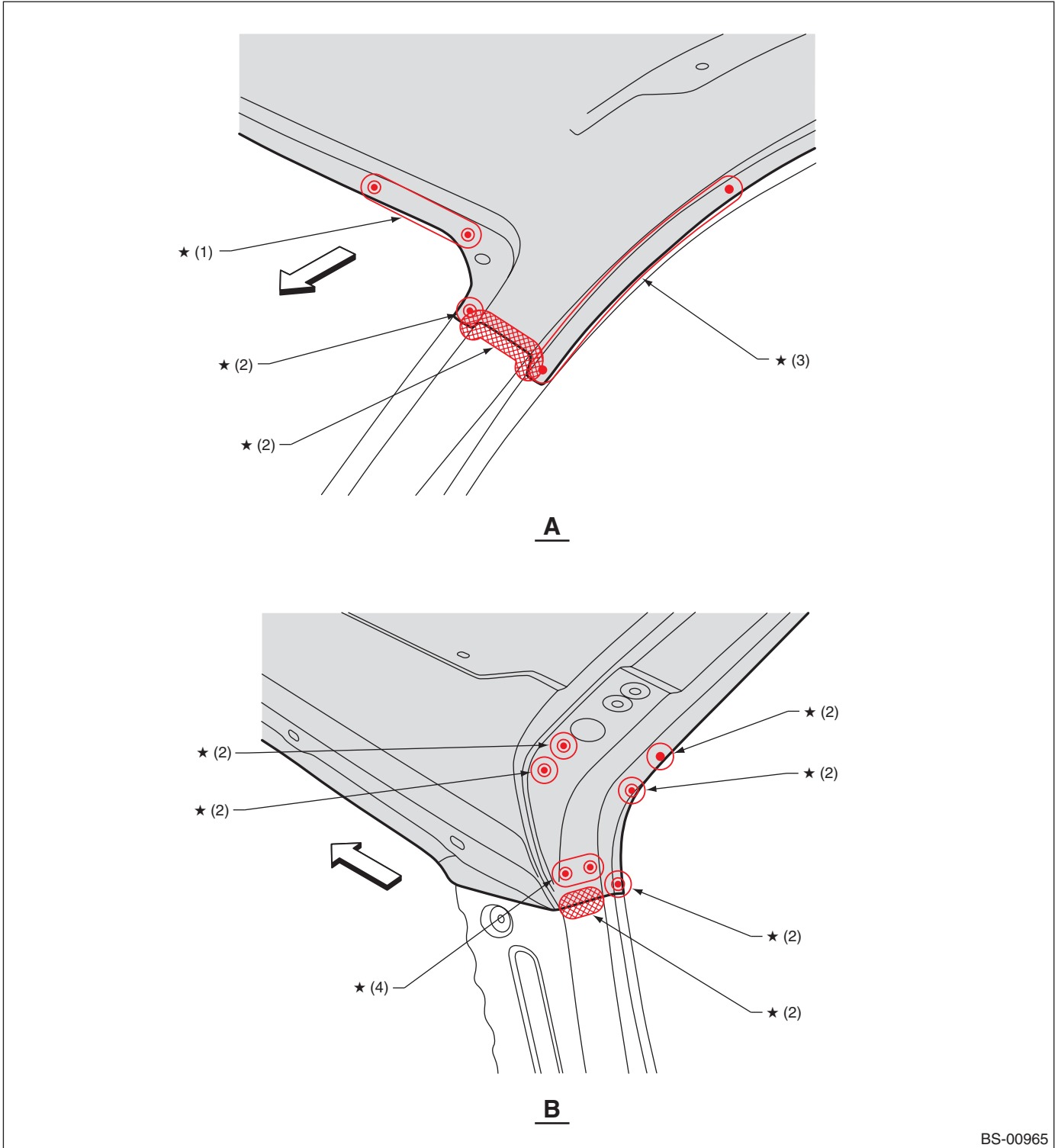
BS-00964

- |                             |                           |                        |
|-----------------------------|---------------------------|------------------------|
| (1) 15 points (top · 1)     | (4) 1 point (outside · 1) | (7) 7 points           |
| (2) 16 points (top · 1)     | (5) 3 points (top · 1)    | (8) 2 points (top · 1) |
| (3) 17 points (outside · 1) | (6) 5 points (top · 1)    | (9) 1 point (top · 1)  |

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

# Roof Panel / Wagon (total replacement)

## • Views



BS-00965

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

(3) 4 points (top · 1)

(4) 2 points (top · 1)

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

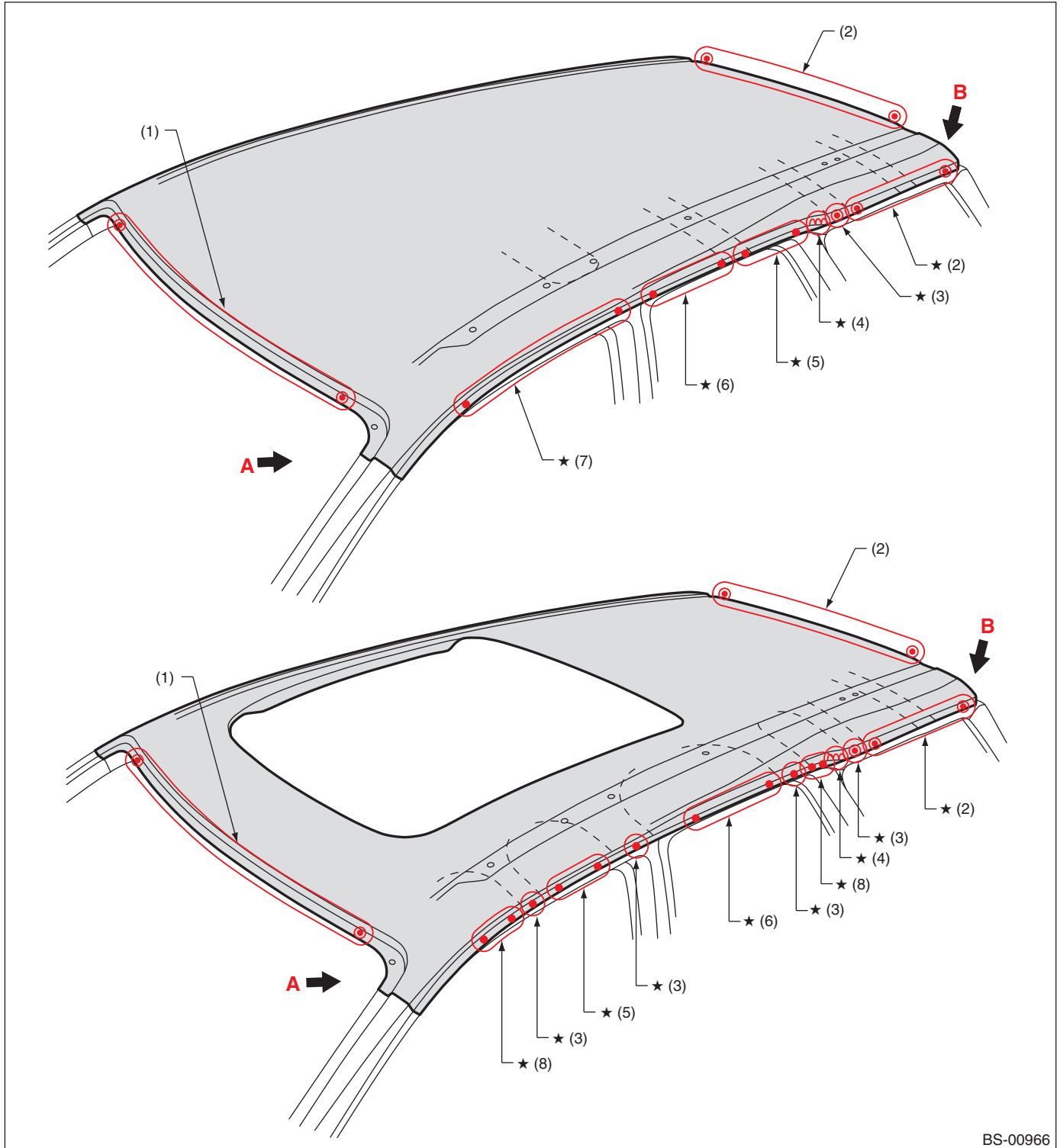


# Roof Panel / Wagon (total replacement)

## B: INSTALLATION

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

### • Overall view



BS-00966

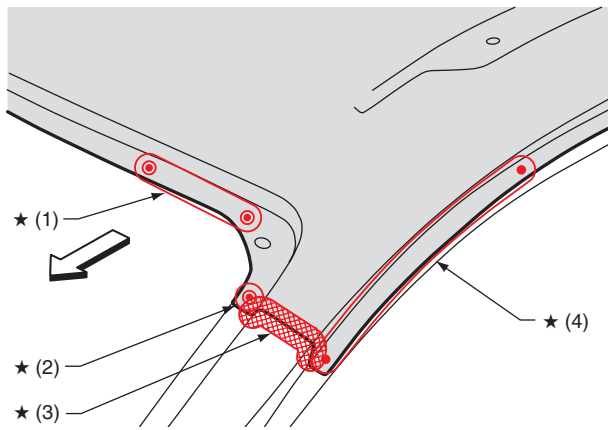
- (1) 20 points
- (2) 21 points
- (3) 1 point

- (4) 1 point (10 mm)
- (5) 4 points
- (6) 6 points

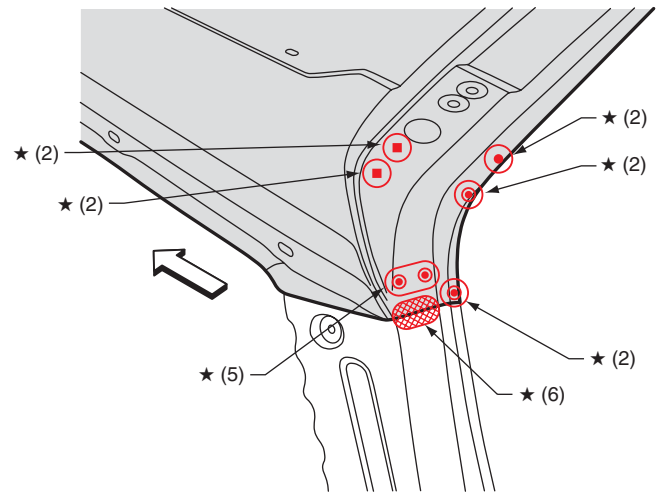
- (7) 10 points
- (8) 3 points

# Roof Panel / Wagon (total replacement)

## • Views



**A**



**B**

BS-00967

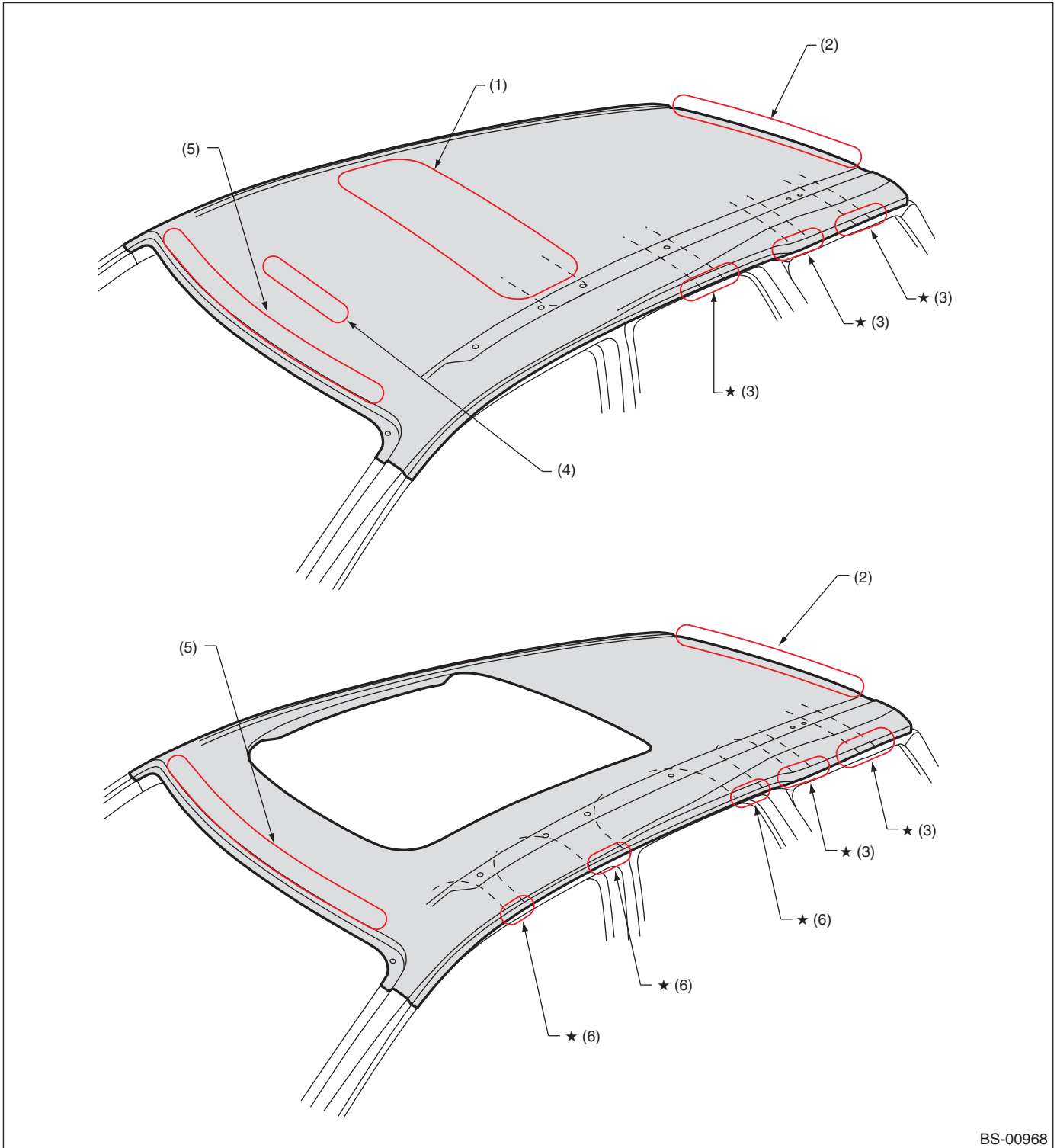
(1) 4 points  
(2) 1 point

(3) 1 point (120 mm × 1)  
(4) 5 points

(5) 3 points  
(6) 1 point (60 mm × 1)

# Roof Panel / Wagon (total replacement)

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



BS-00968

- (1) 15 points
- (2) 8 points
- (3) 3 points

- (4) 3 points (Only on overhead console equipped vehicles)

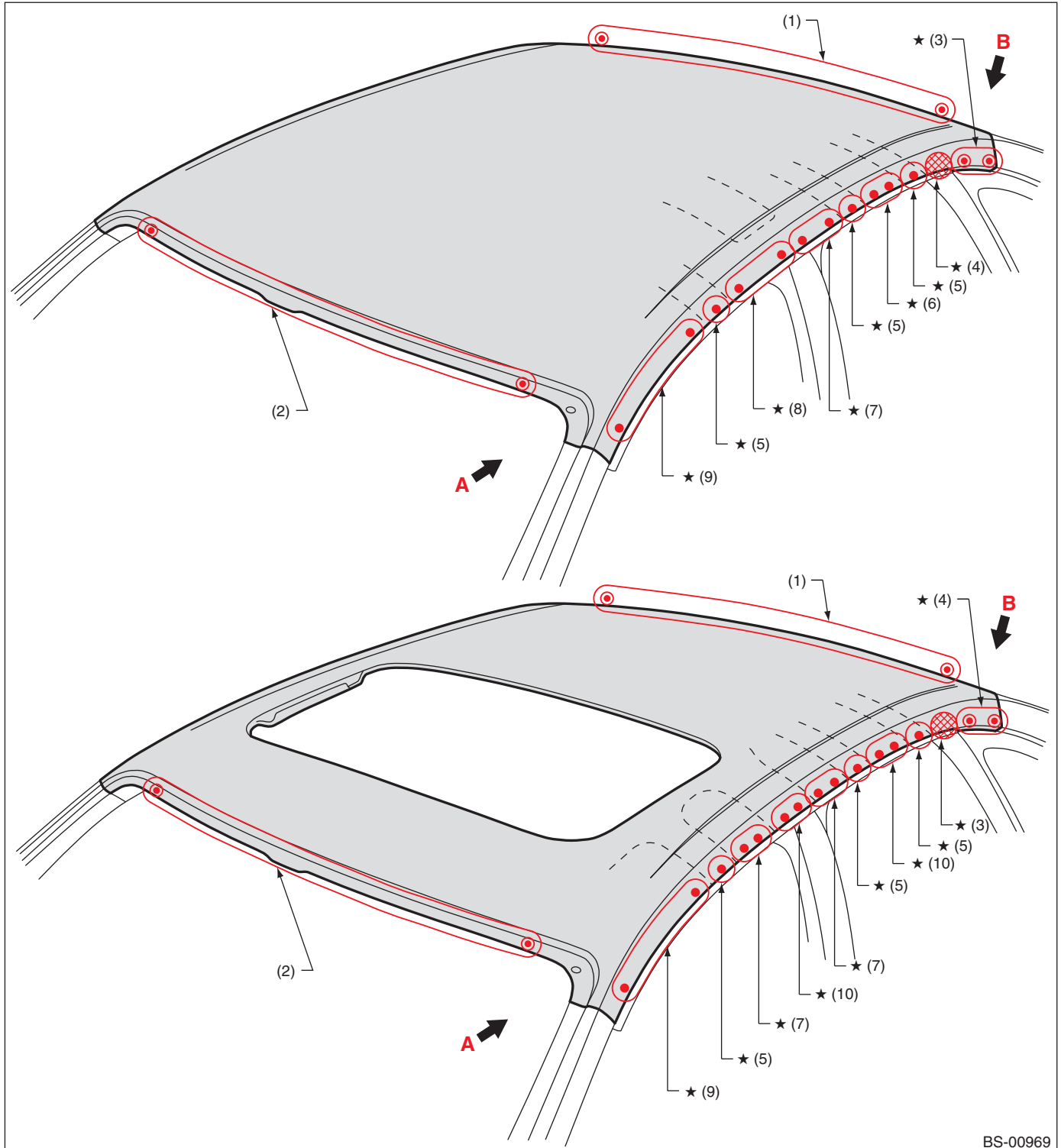
- (5) 9 points
- (6) 2 points

# Roof Panel / Sedan (total replacement)

## 43. Roof Panel / Sedan (total replacement)

### A: REMOVAL

#### • Overall view



BS-00969

- (1) 17 points (top · 1)
- (2) 15 points (top · 1)
- (3) 1 point (outside · 1)
- (4) 4 points (outside · 1)

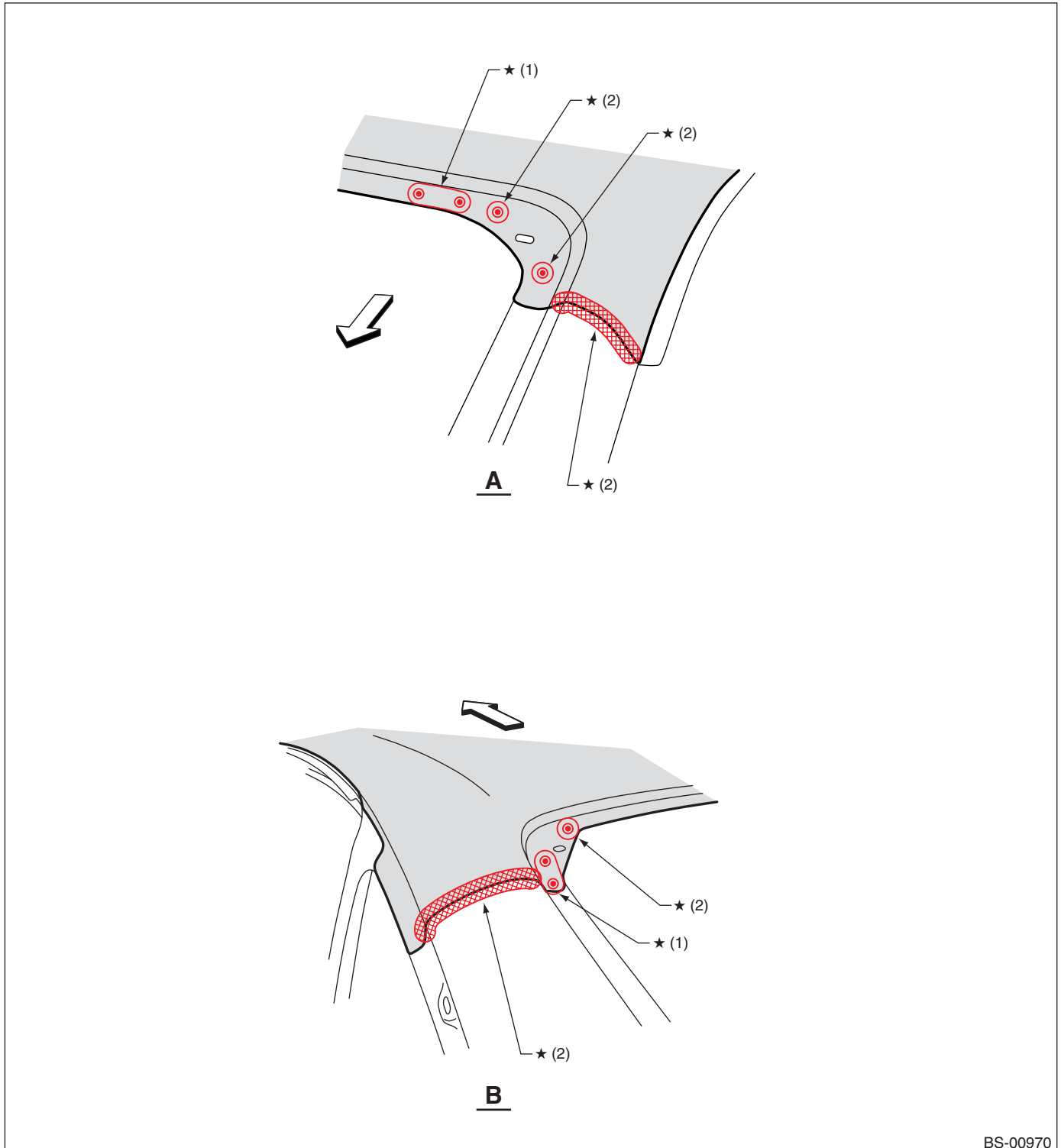
- (5) 1 point (top · 1)
- (6) 3 points (top · 1)
- (7) 4 points (top · 1)

- (8) 5 points (top · 1)
- (9) 6 points (top · 1)
- (10) 2 points (top · 1)

## Roof Panel / Sedan (total replacement)

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

### • Views



BS-00970

(1) 2 points (top · 1)

(2) 1 point (top · 1)

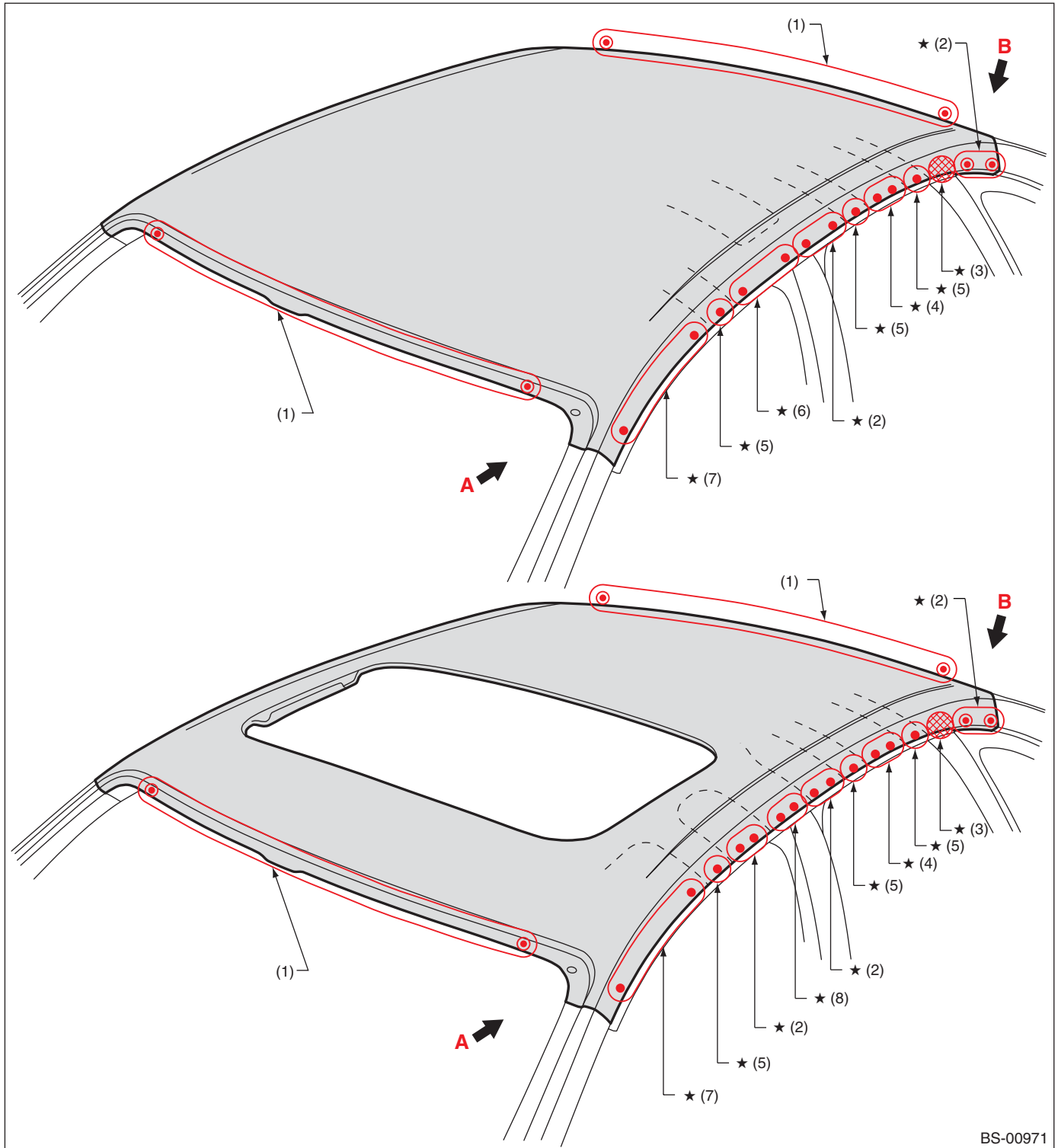
For locations marked by ★, the welding method, the number of welding points, and the rough cutting dimensions are the same on the left and the right.

# Roof Panel / Sedan (total replacement)

## B: INSTALLATION

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

### • Overall view



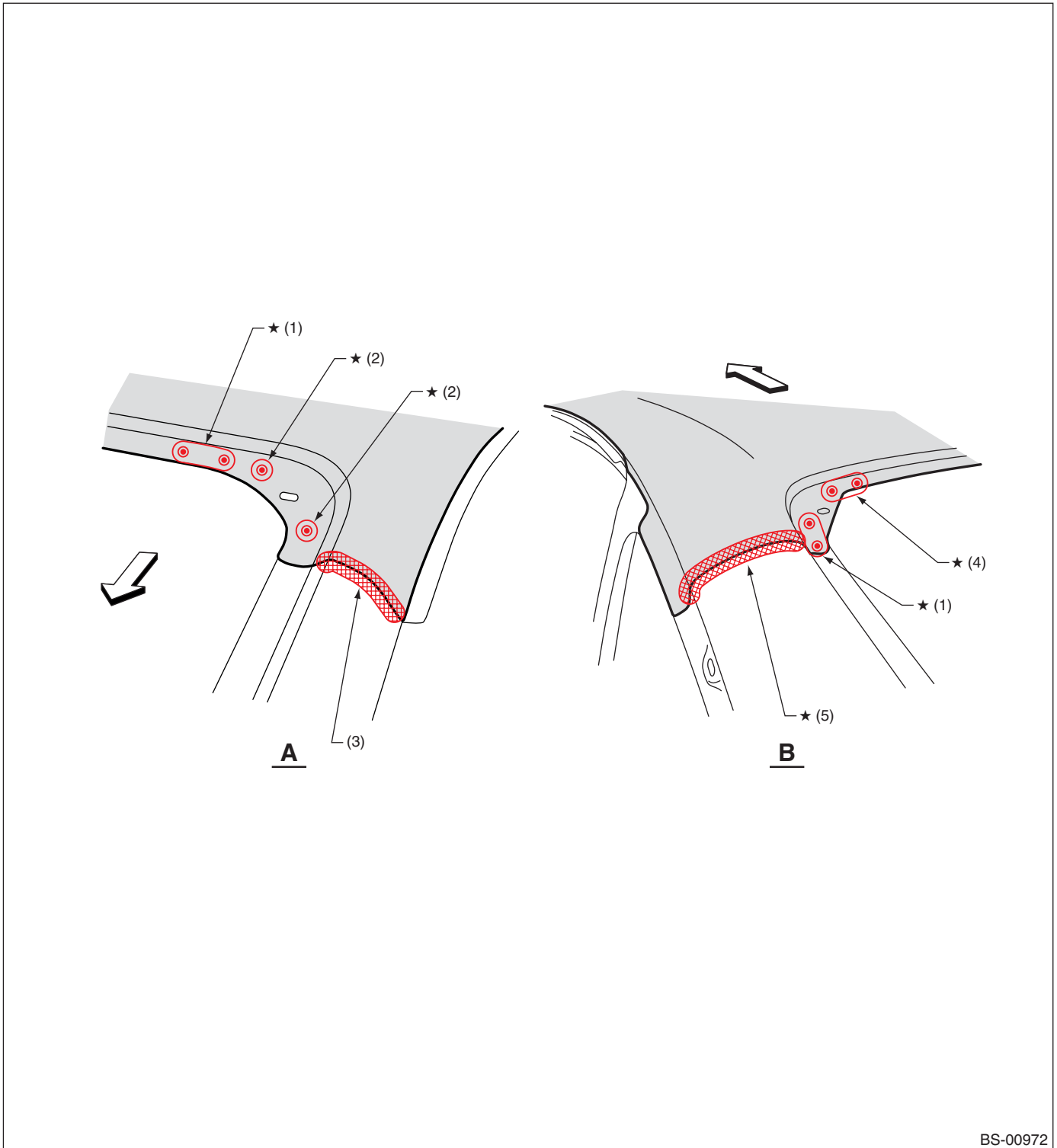
BS-00971

- |                         |              |              |
|-------------------------|--------------|--------------|
| (1) 20 points           | (4) 3 points | (7) 8 points |
| (2) 5 points            | (5) 1 point  | (8) 2 points |
| (3) 1 point (10 mm × 1) | (6) 6 points |              |

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

# Roof Panel / Sedan (total replacement)

## • Views



BS-00972

(1) 3 points  
(2) 1 point

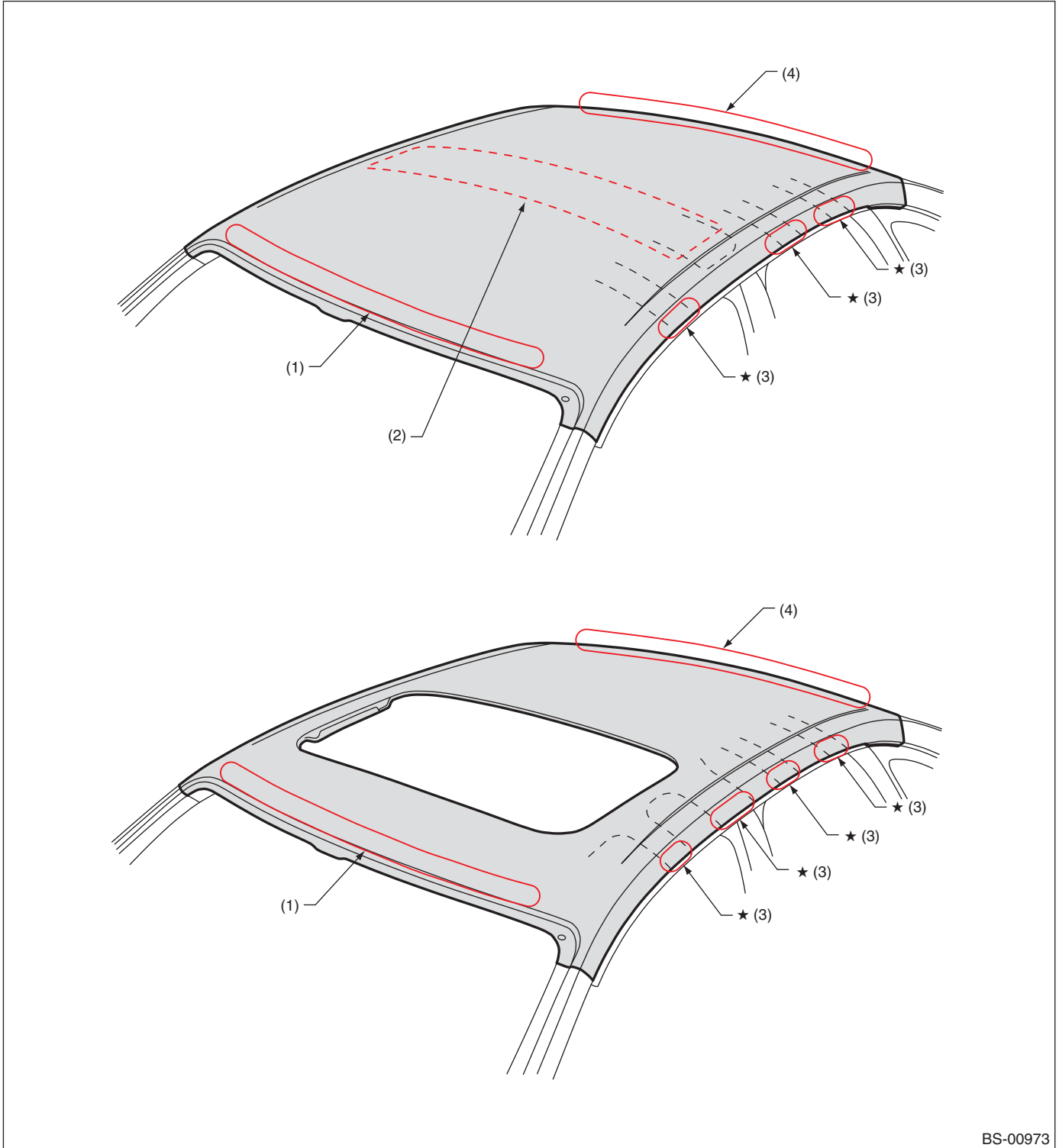
(3) 1 point (60 mm × 1)  
(4) 2 points

(5) 1 point (130 mm × 1)

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

# Roof Panel / Sedan (total replacement)

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



BS-00973

(1) 9 points  
(2) 17 points

(3) 3 points

(4) 11 points