1. Foreword

A: USE OF THIS MANUAL

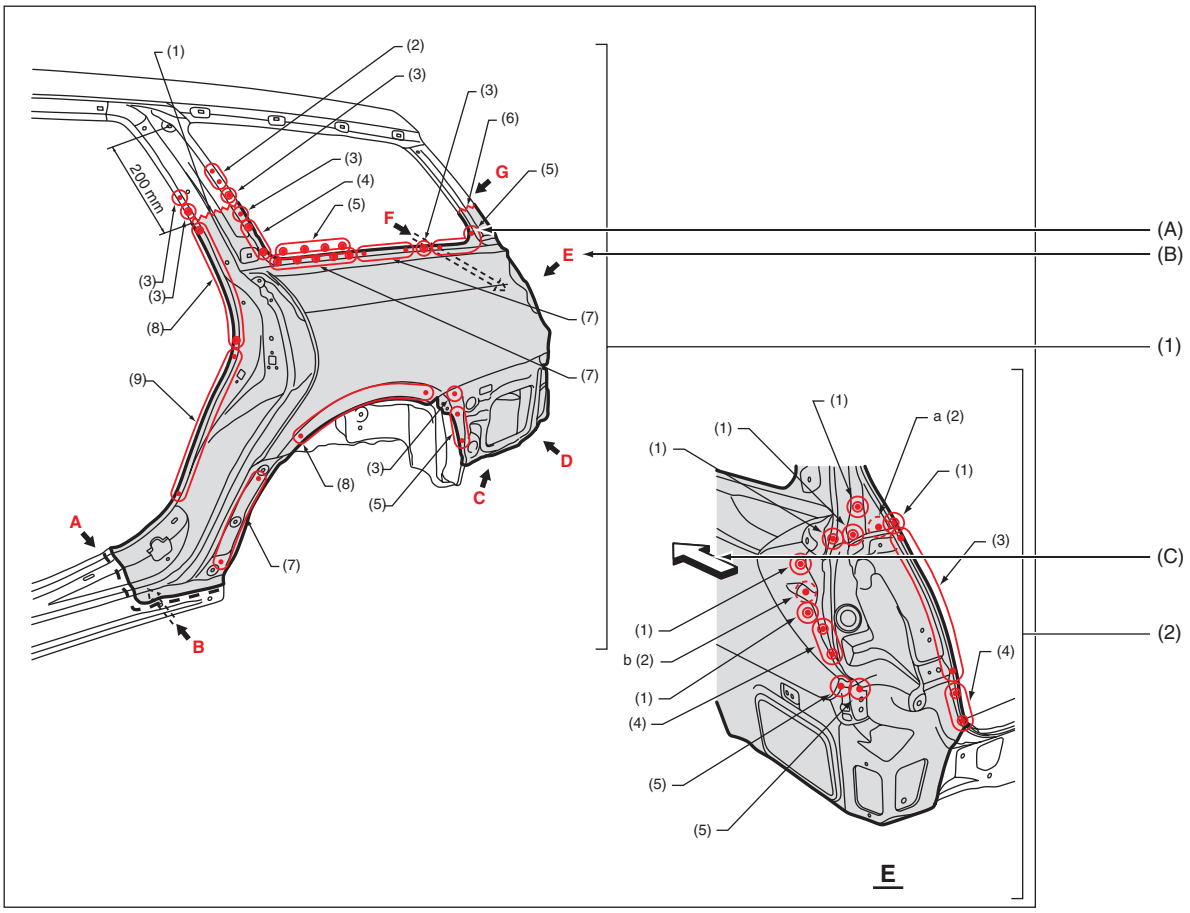
This manual explains important points for removal and installation of parts per location.

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) Rough cutting (130 mm)
(2) 2 points (outside · 1)
(3) 1 point (outside · 1)
(4) 3 points (outside · 1)
(5) 4 points (outside · 1)
(6) Rough cutting (170 mm)
(7) 5 points (outside · 1)
(8) 8 points (outside · 1)
(9) 12 points (outside · 1)
(10) 1 point (outside · 2)
(11) 1 point (outside · 1), hidden hit point
(12) 9 points (outside · 1)
(13) 2 points (outside · 2)

· Rear quarter removal condition
· Detach the hidden hit point between the rear door catcher bracket and side sill reinforcement.
· When replacing the D-pillar, there are two weld locations a and b (hidden hit point).

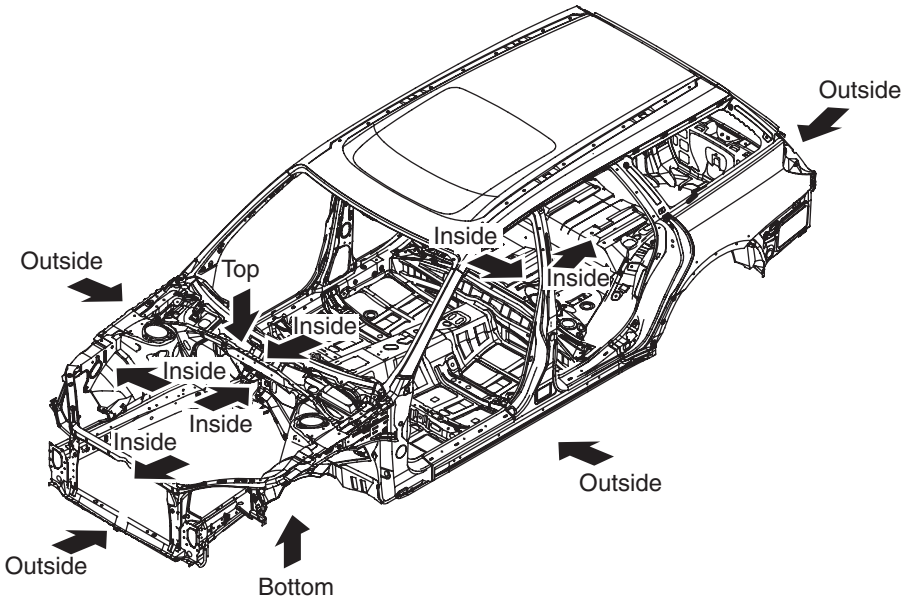
BS-00649

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

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

2. REMOVAL DIRECTION

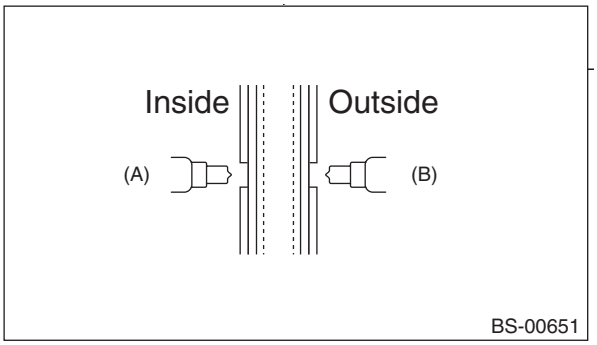
Areas are divided into four groups of inside, outside, top, and bottom, and these directions are defined as shown in the following figure.



3. NUMBER OF PANELS TO BE DRILLED

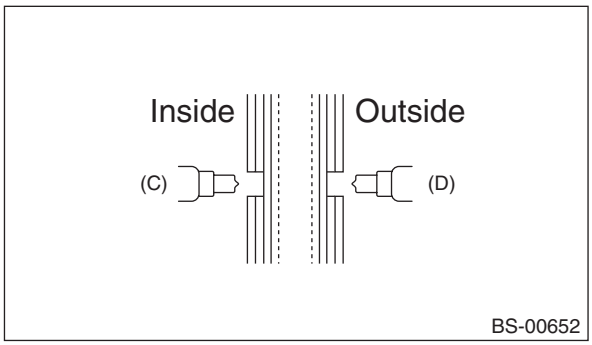
Depending on the number of panels, drilling is performed through one or two panels, and this is listed together with the removal direction.

(1) Drilling through one plate



(A) (Inside · 1)
(B) (Outside · 1)

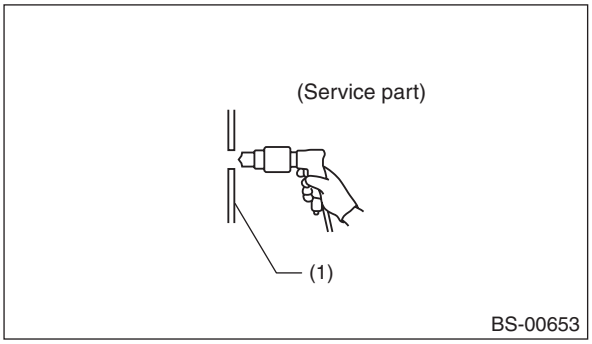
(2) Drilling through two plate



(C) (Inside · 2)
(D) (Outside · 2)

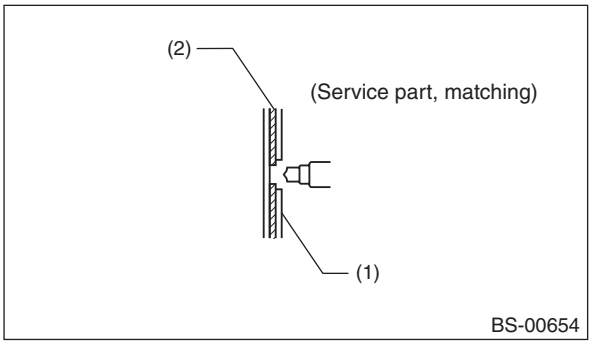
4. HOLE DRILLING FOR PLUG WELDING

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



(A) Service part

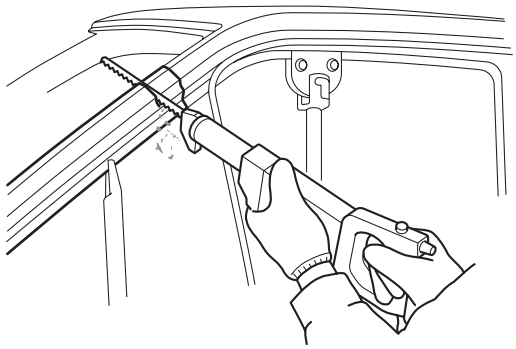
(2) Drilling of holes on service parts for plug welding, to match the holes on the vehicle side



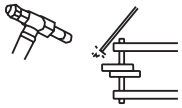
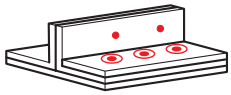
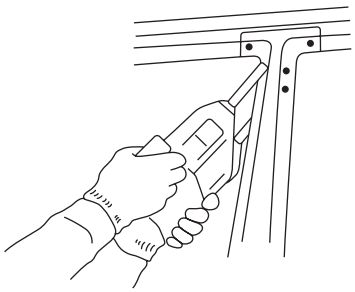
(1) Service part
(2) Vehicle side

5. MEANING OF SYMBOLS

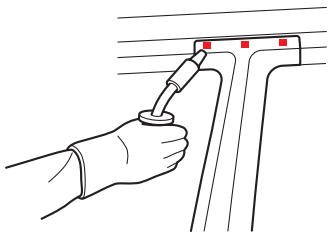
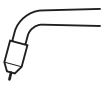
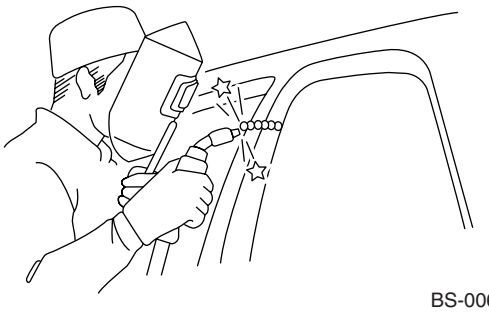
- **Cutting**

BS-00352	 BS-00267

- **Spot welding**

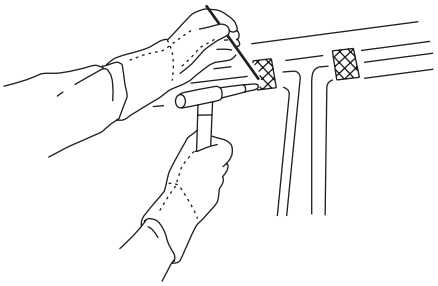
Two overlapping parts	 BS-00655	 BS-00656	 BS-00657	 BS-00658
Three overlapping parts	 BS-00659	 BS-00660		

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

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

- **Brazing**

BS-00667

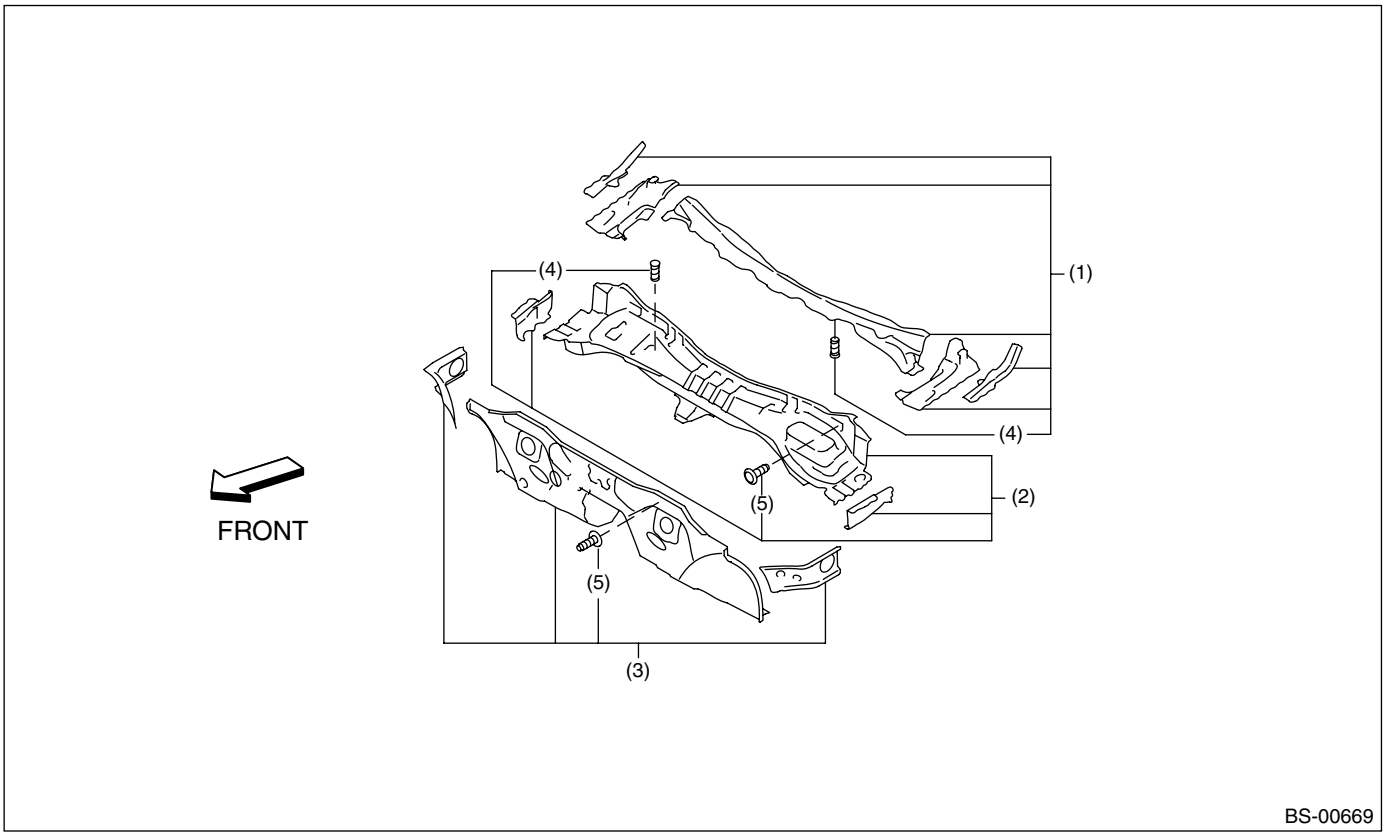


BS-00668

2. Panel Components

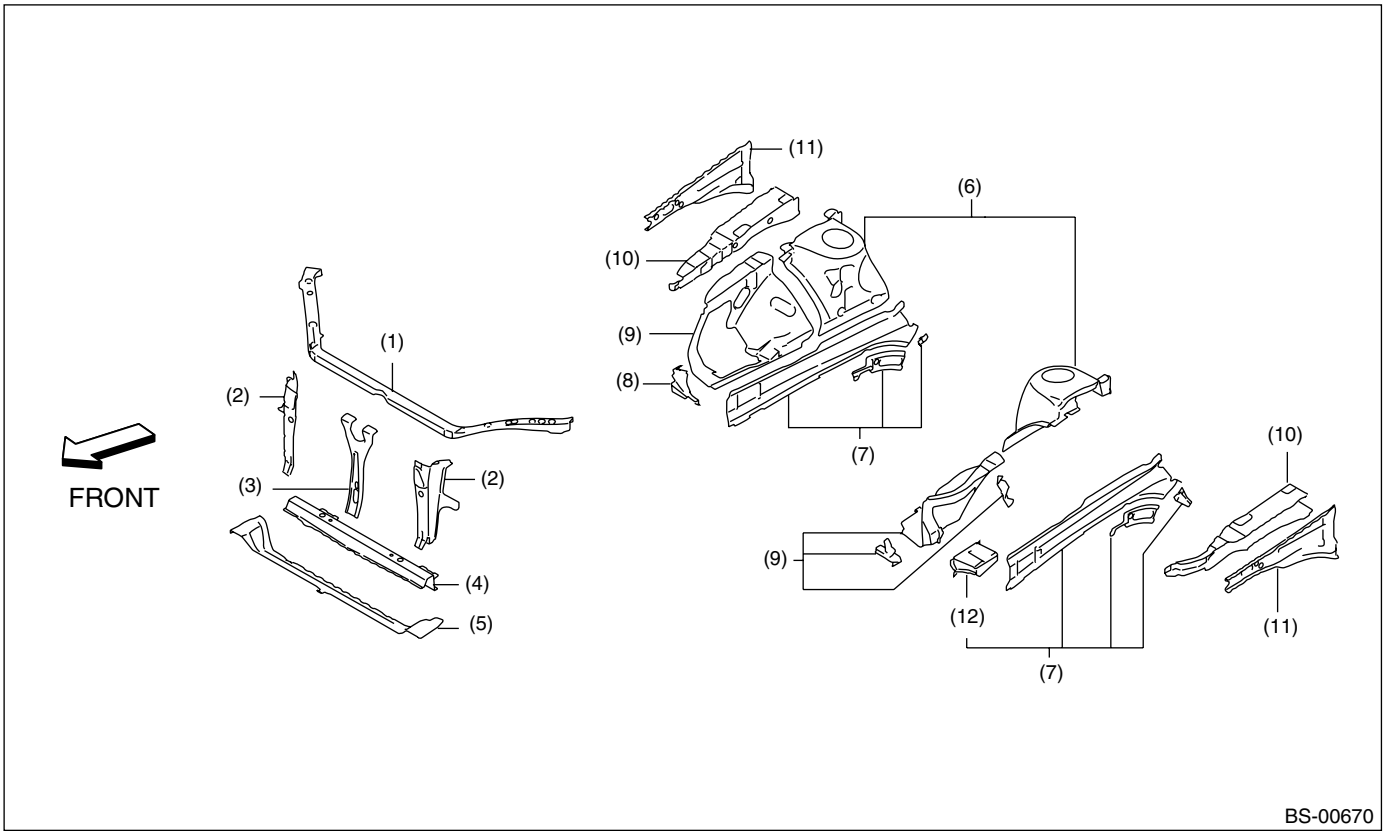
A: COMPONENTS

1. TOE BOARD & FRONT PANEL



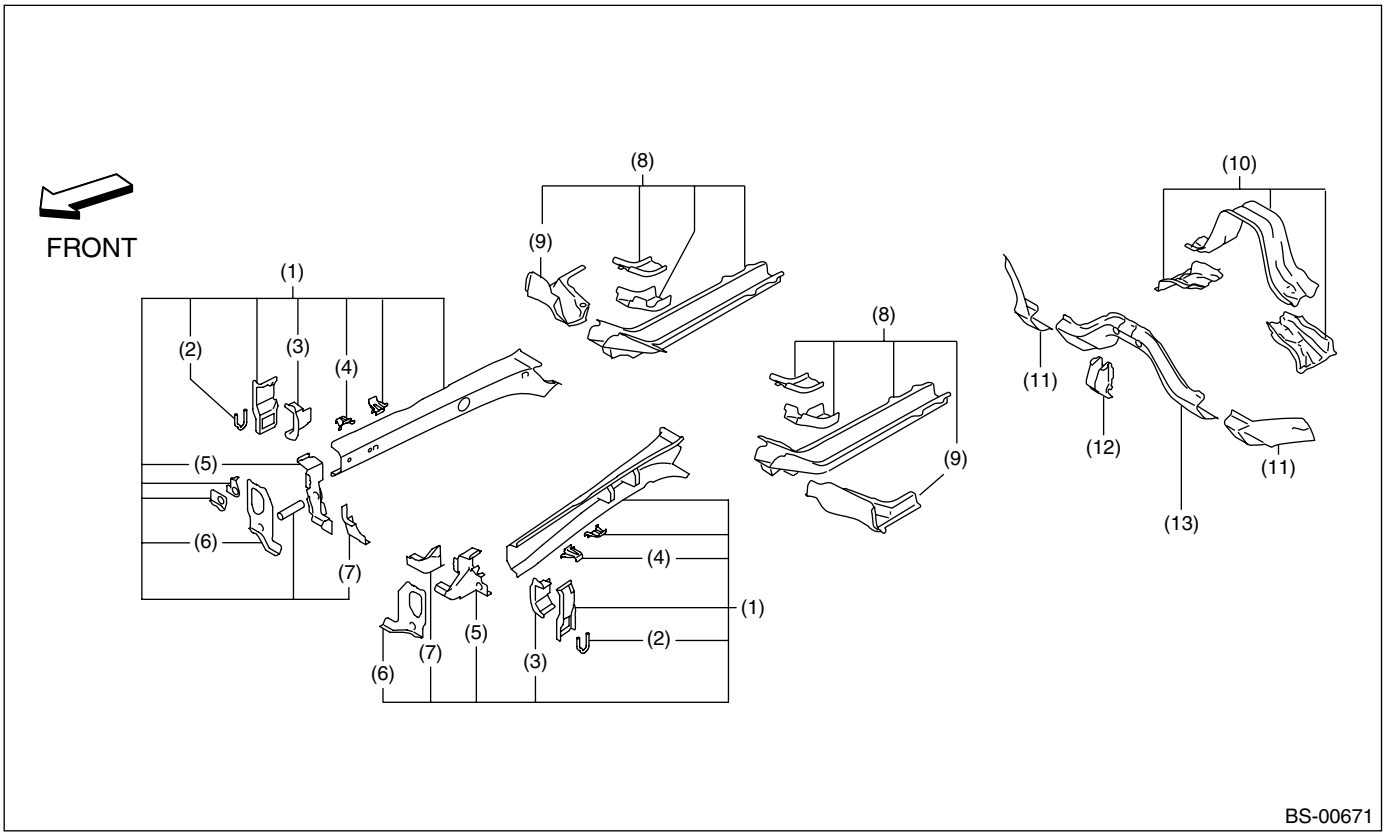
(1) Front panel
(2) Duct
(3) Toe board
(4) Stud bolt
(5) Stud bolt

2. RADIATOR PANEL & FRONT WHEEL APRON



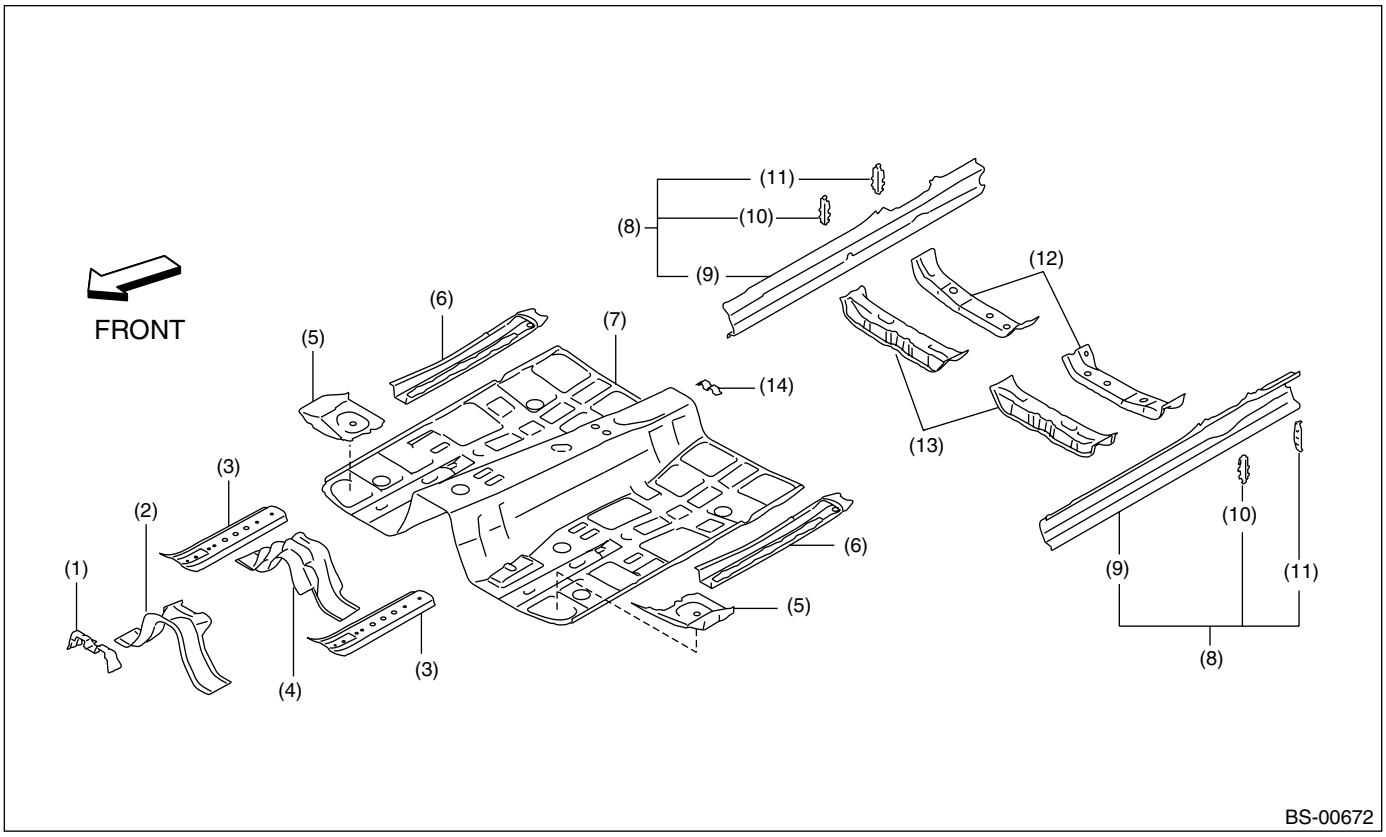
(1) Upper frame
(2) Radiator side panel
(3) Hood lock stay
(4) Lower frame A
(5) Lower frame B
(6) Front suspension bracket
(7) Closing plate
(8) Fender bracket
(9) Front wheel apron
(10) Front wheel apron upper
(11) Side upper frame
(12) Gusset battery

3. FRONT SIDE FRAME



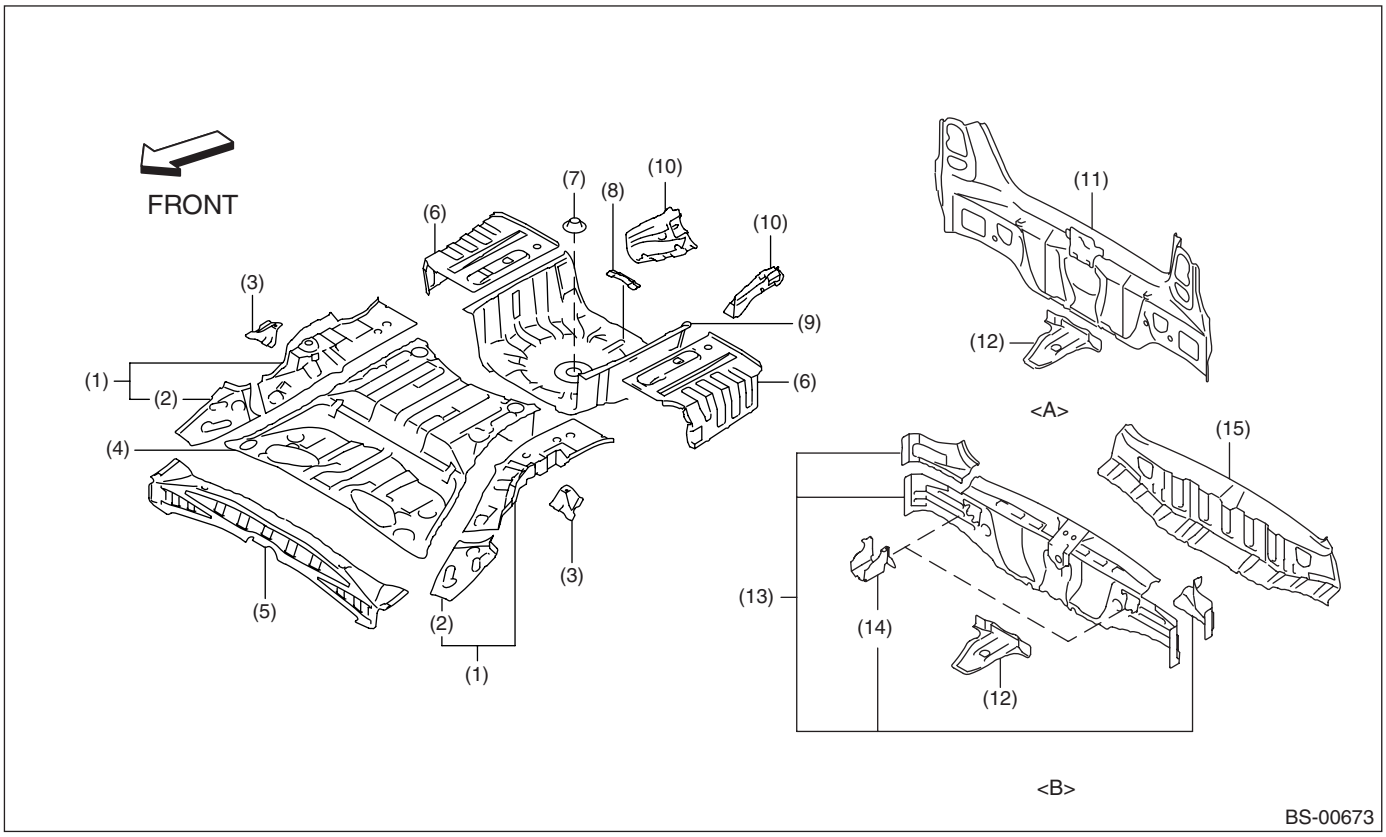
(1) Front side frame front
(2) Tie-down hook
(3) Bumper bracket front
(4) Separator B
(5) Front gusset
(6) Front plate
(7) Front gusset C
(8) Front side frame rear
(9) Toe board lower reinforcement
(10) Front floor crossmember
(11) Toe board crossmember side
(12) Pitching stopper bracket
(13) Toe board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

4. FRONT FLOOR PANEL



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

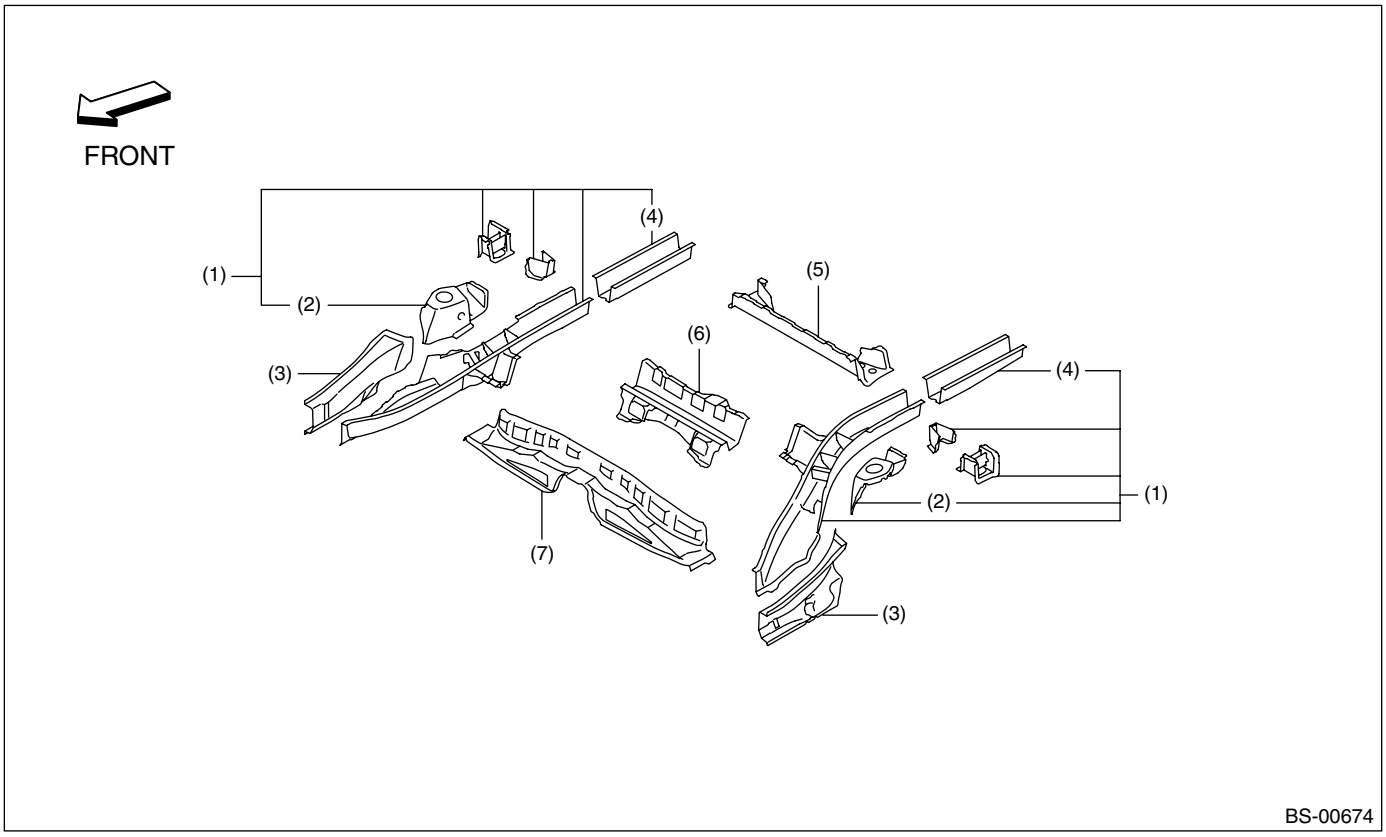
5. REAR FLOOR PANEL & REAR SKIRT



(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

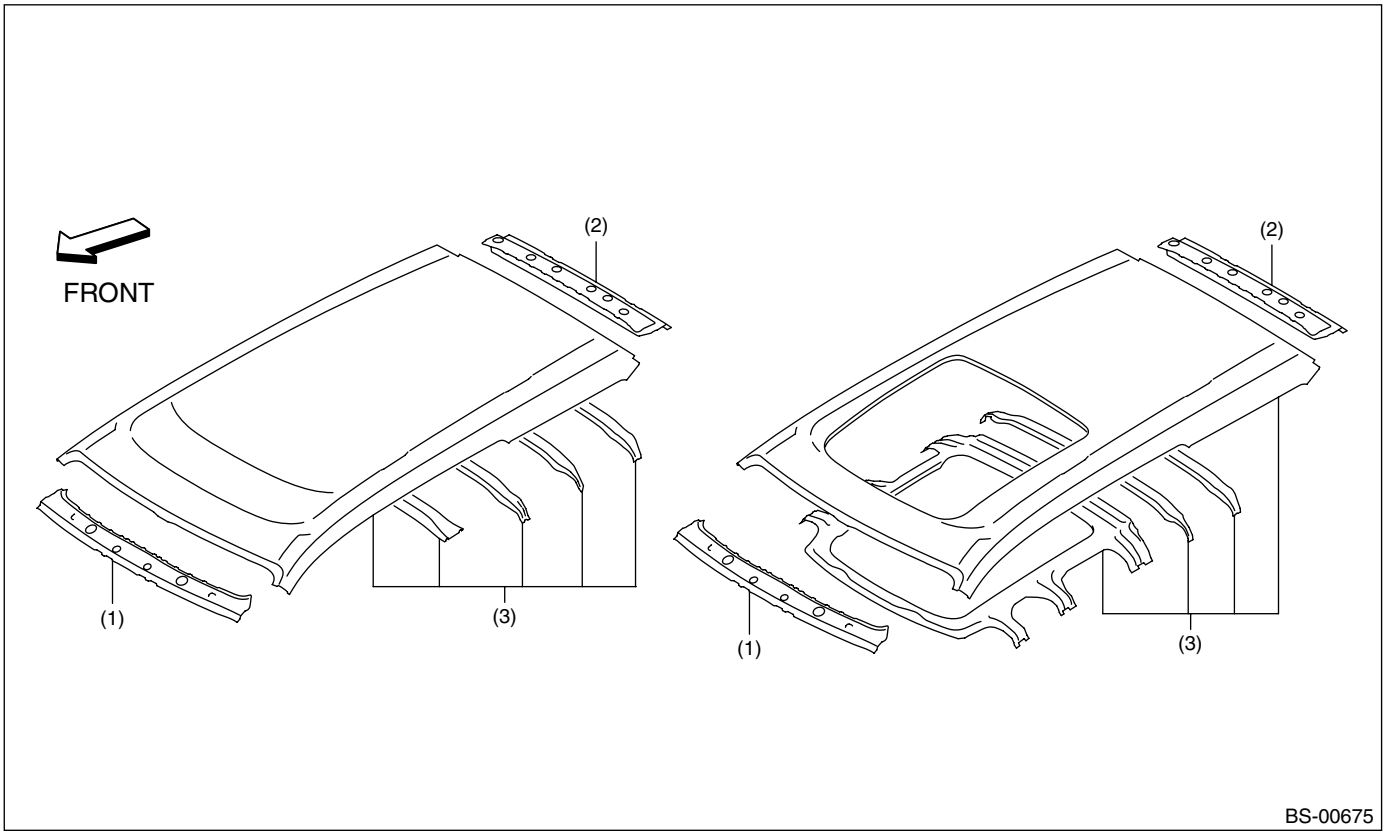
6. REAR FLOOR SIDE FRAME



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

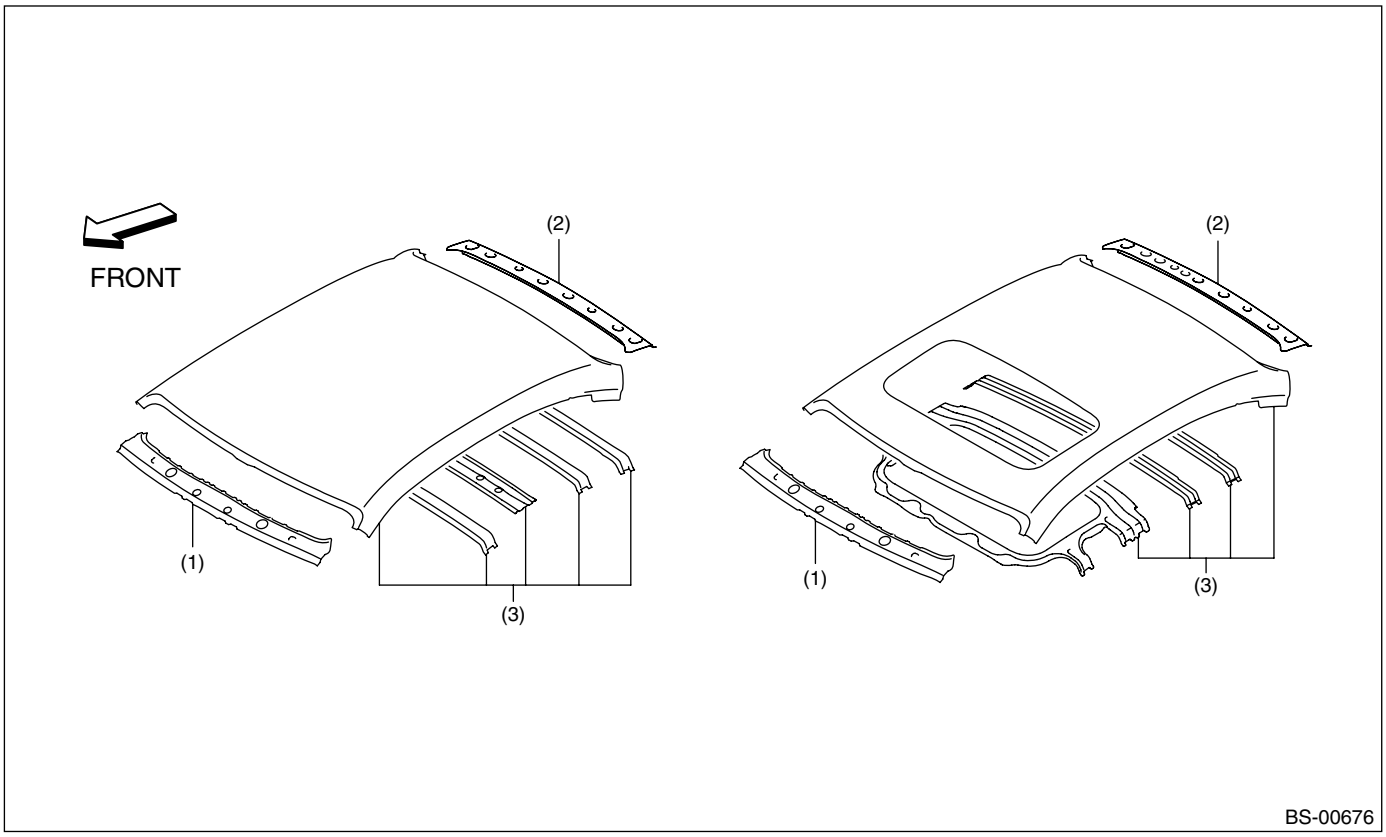
7. ROOF

- **Wagon**



(1) Front roof rail
(2) Rear roof rail
(3) Roof panel

- **Sedan**

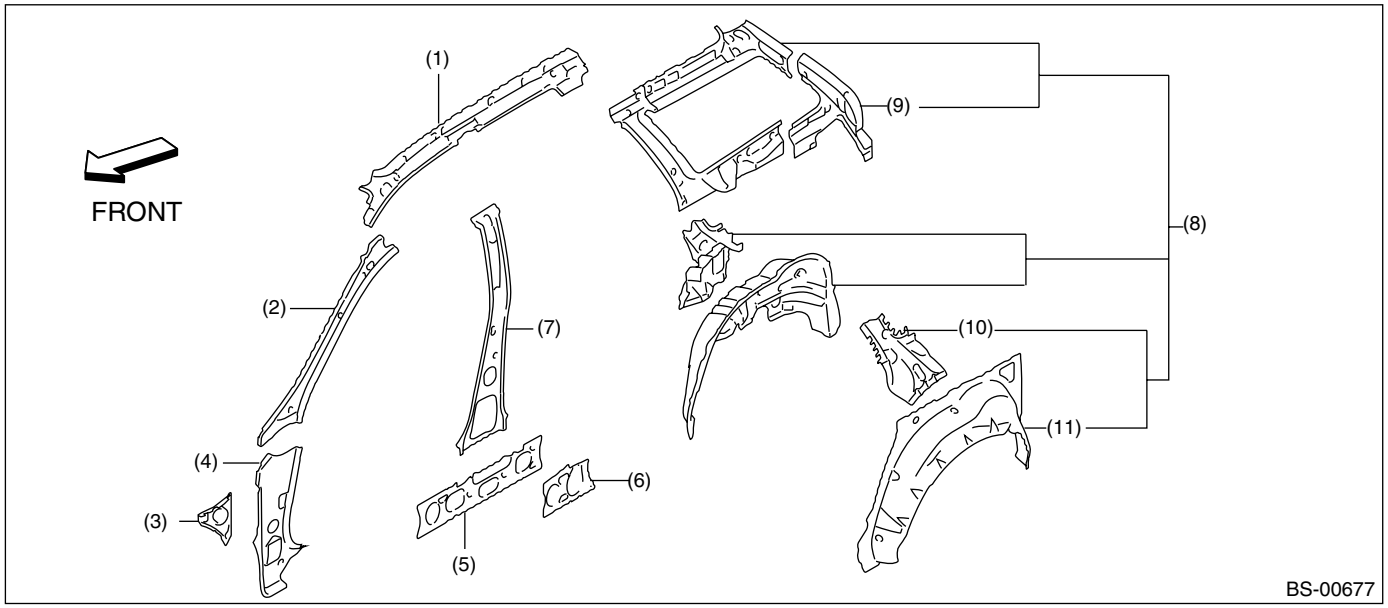


(1) Front roof rail
(2) Rear roof rail
(3) Roof panel

8. SIDE PANEL

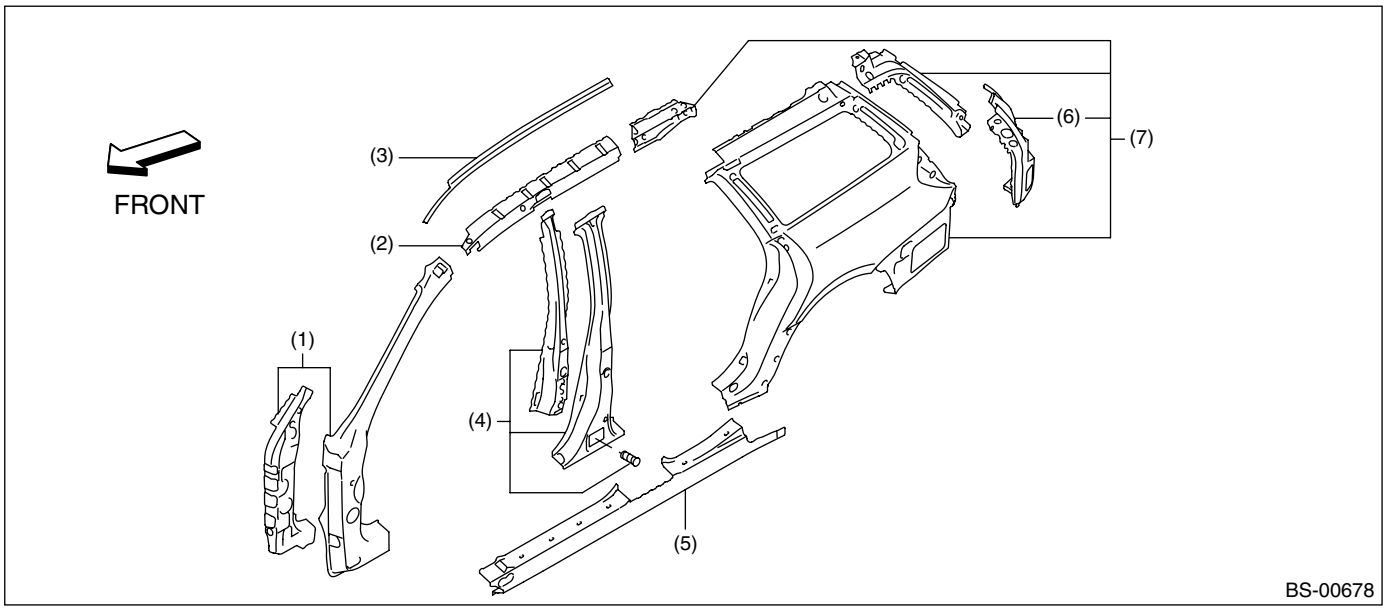
- **Wagon**

1) Inner panel



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

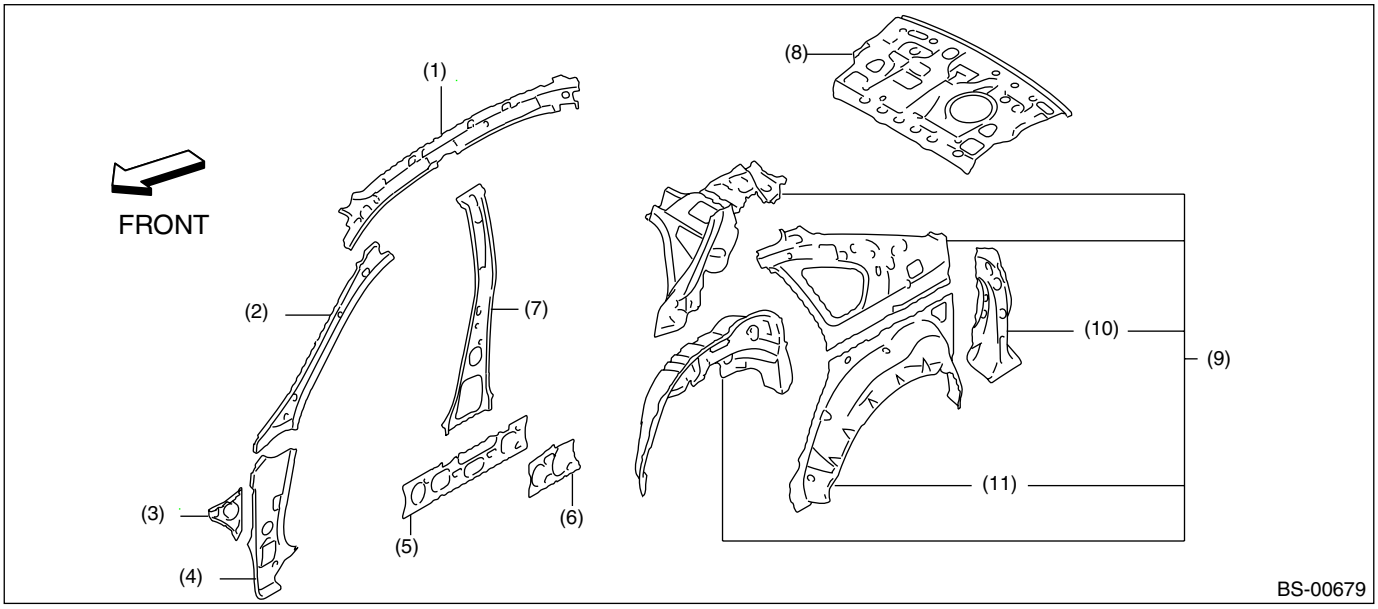
2) Outer panel



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

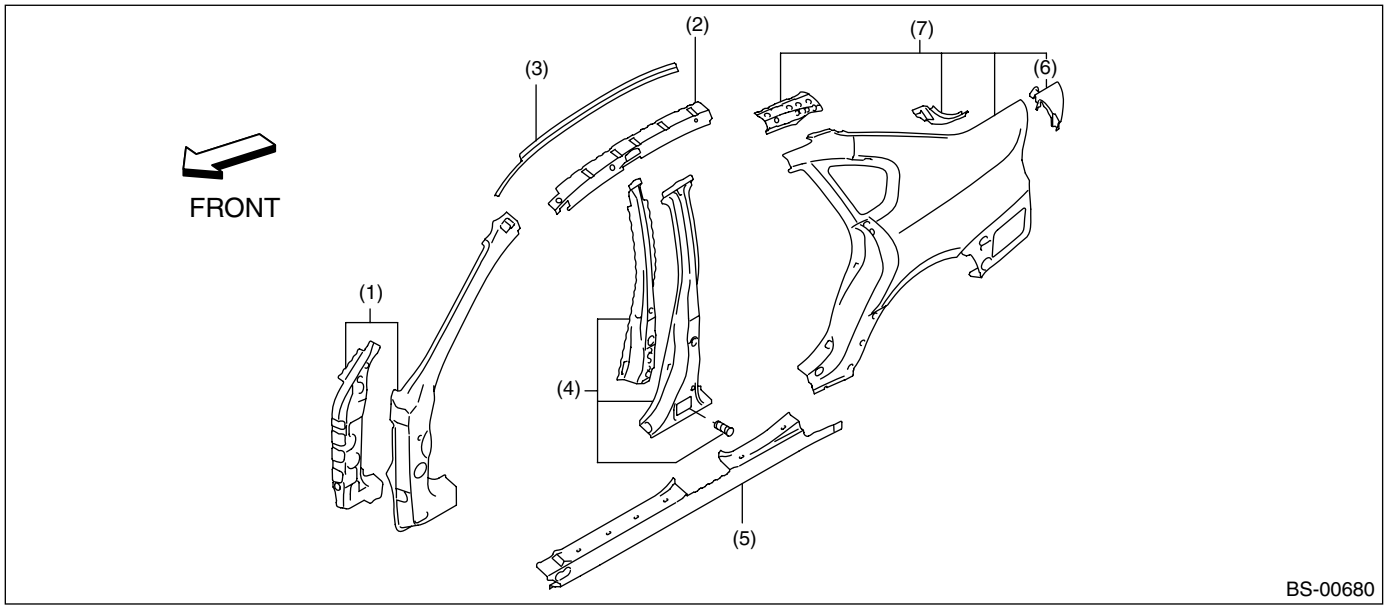
- **Sedan**

1) Inner panel



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

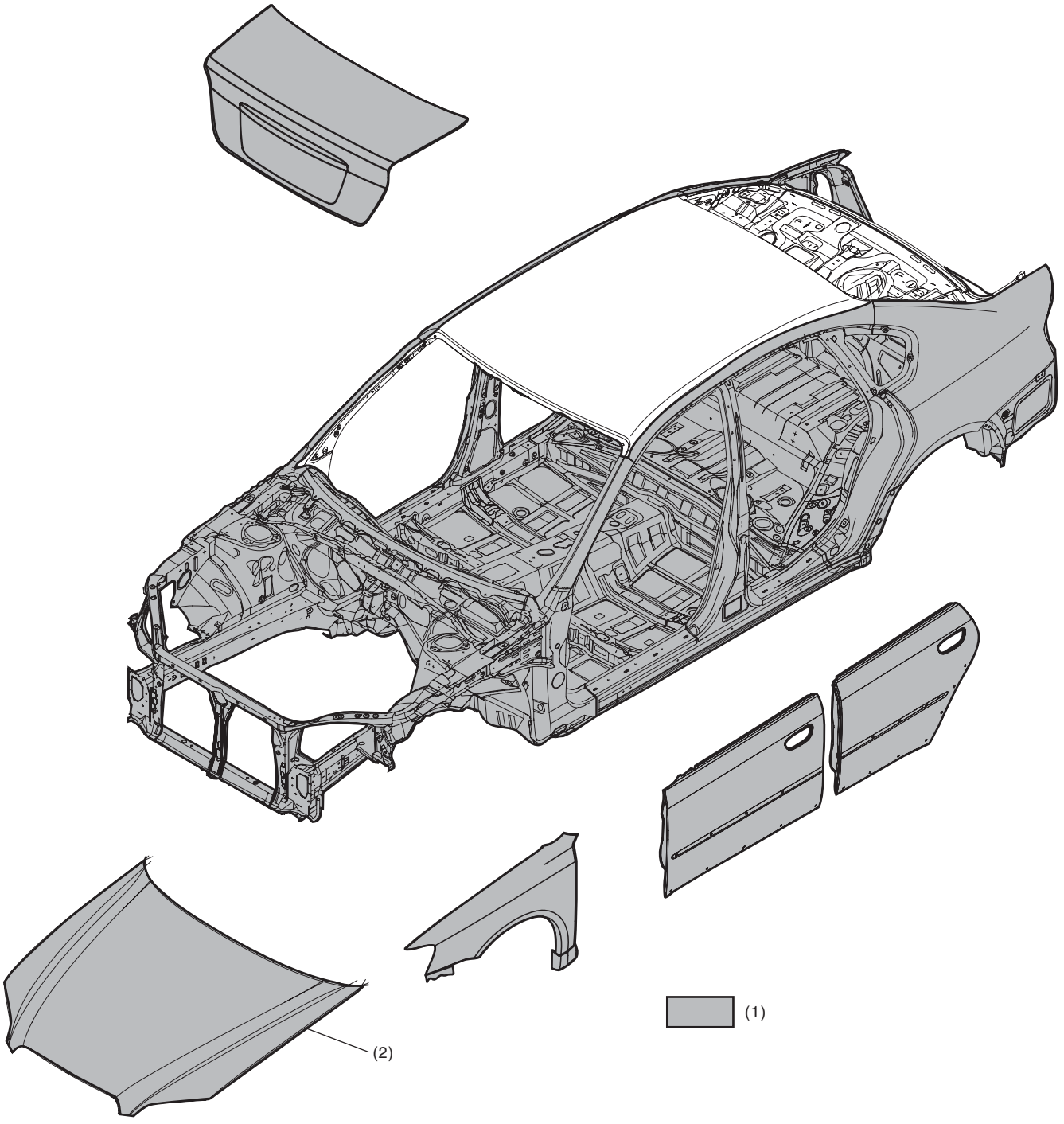
2) Outer panel



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

3. Galvanized Sheet Metal

A: SPECIFICATION



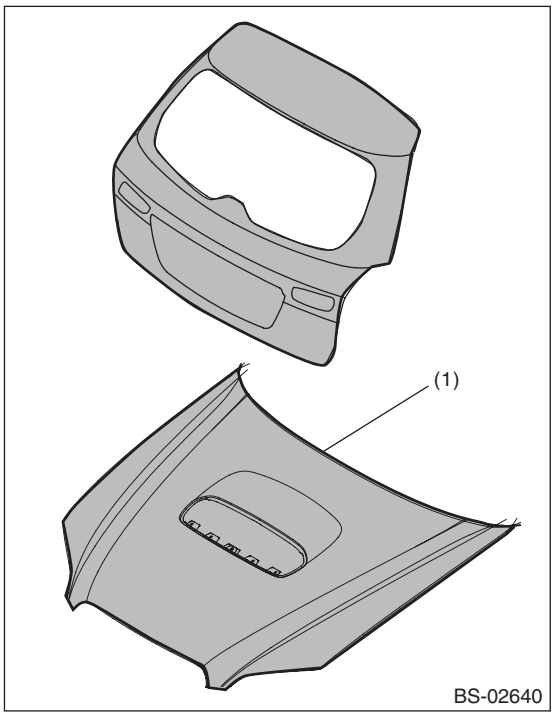
BS-02639

(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

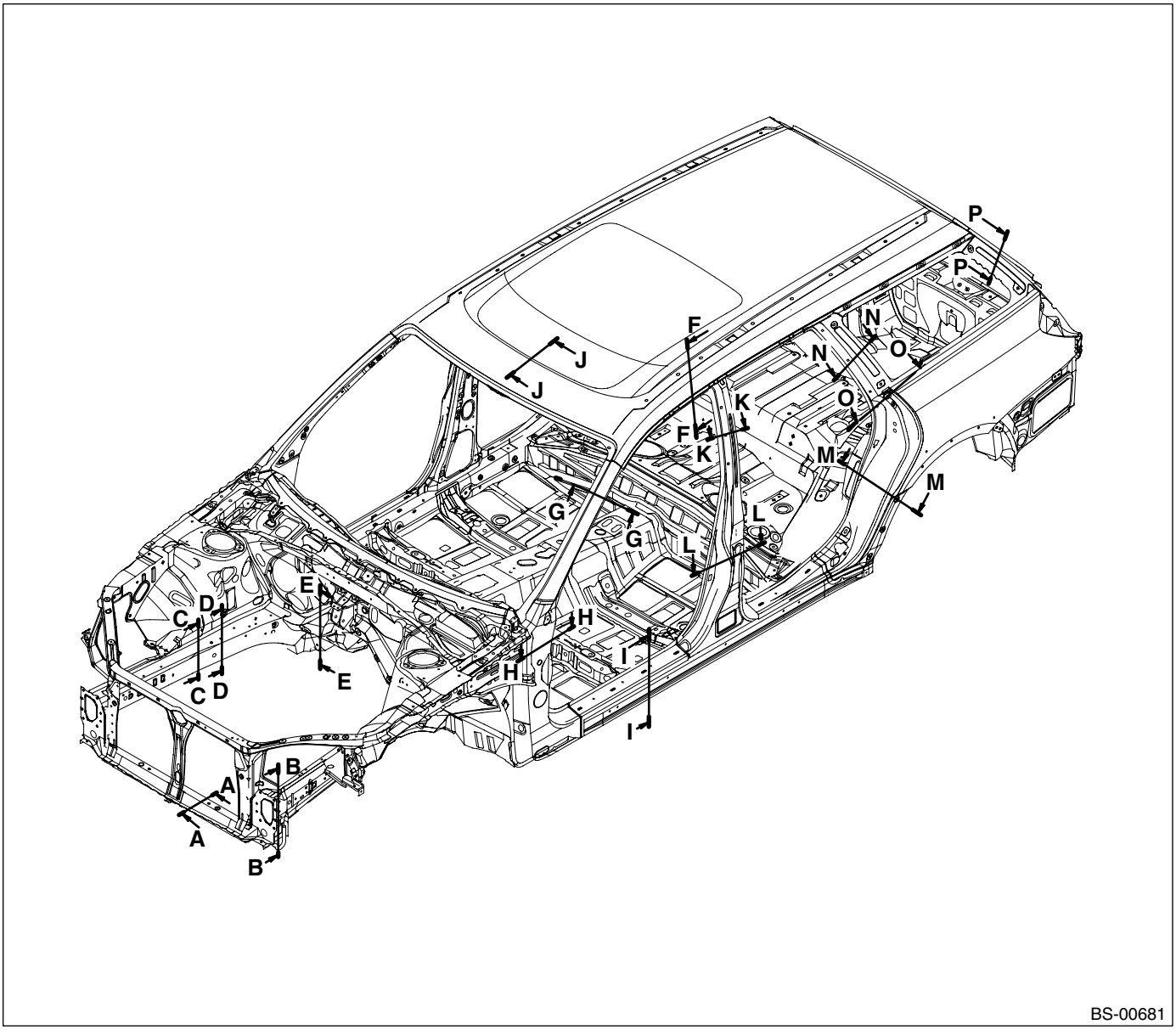


(1) Hoods for vehicles other than the OUTBACK are aluminum sheet metal

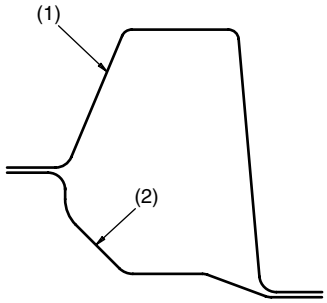
5. Body Construction

A: SPECIFICATION

- **Wagon / sedan common parts**



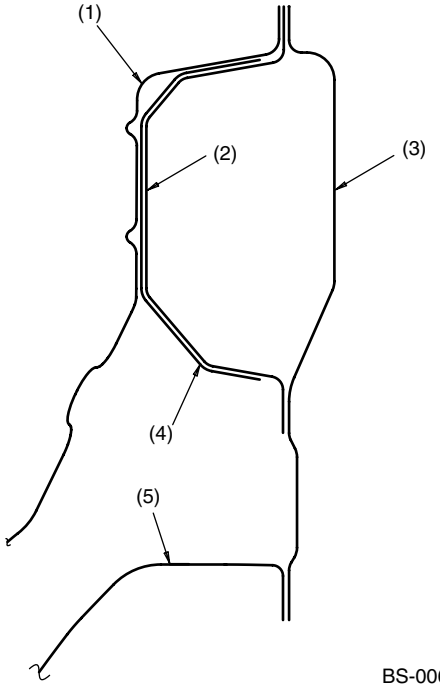
Cross section A — A



BS-00682

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

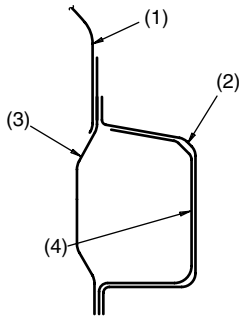
Cross section B — B



BS-00683

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

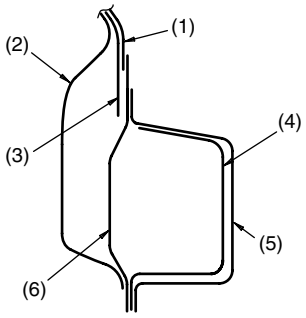
Cross section C — C



BS-00684

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

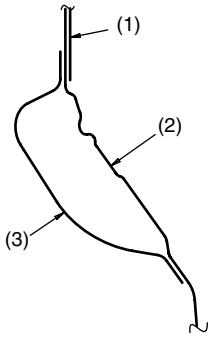
Cross section D — D



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

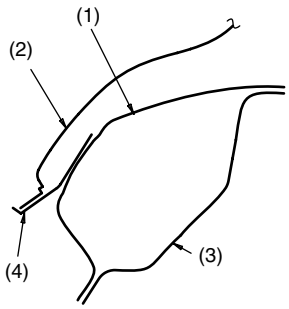
Cross section E — E



BS-00686

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

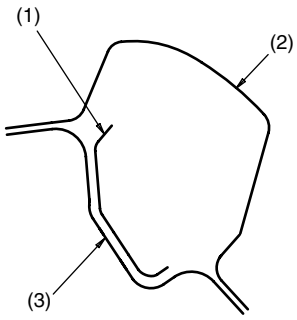
Cross section F — F



BS-00687

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

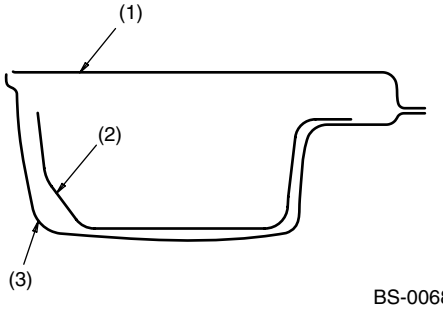
Cross section G — G



BS-00688

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

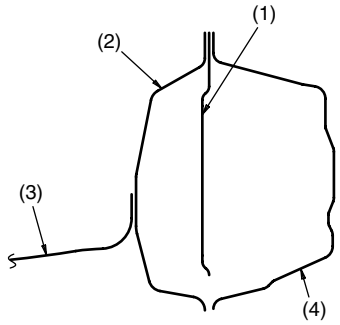
Cross section H — H



BS-00689

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

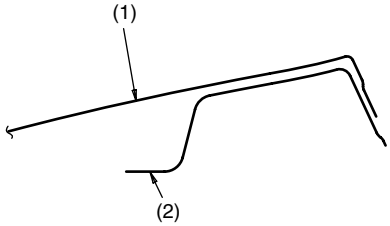
Cross section I — I



BS-00690

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

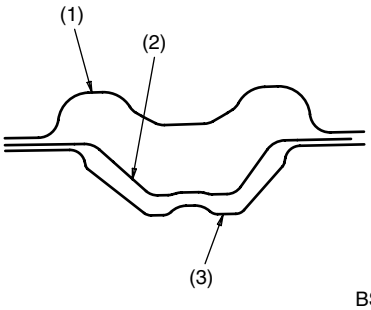
Cross section J — J



BS-00691

(1) Roof panel
(2) Sunroof frame front

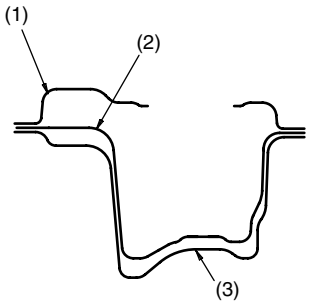
Cross section K — K



BS-00692

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

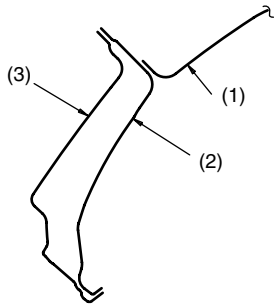
Cross section L — L



BS-00693

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

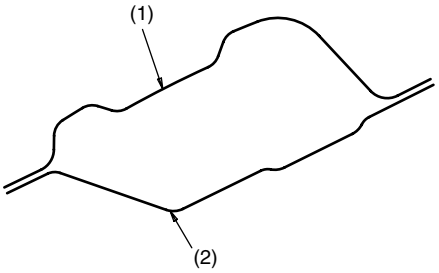
Cross section M — M



BS-00694

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

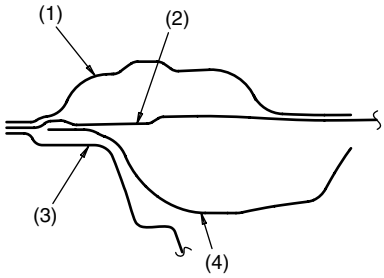
Cross section N — N



BS-00695

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

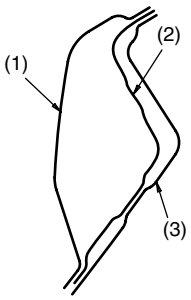
Cross section O — O



BS-00696

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

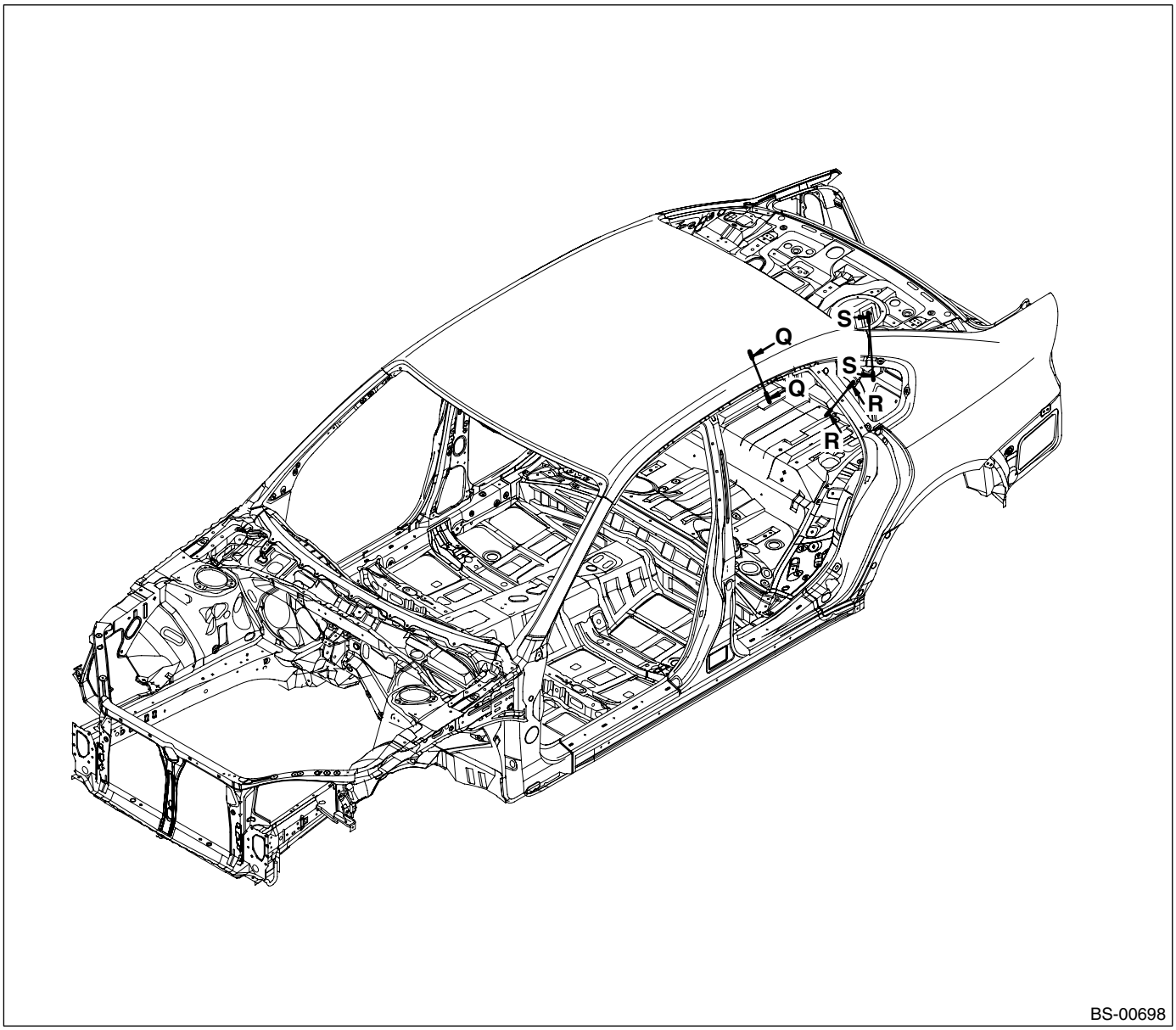
Cross section P — P



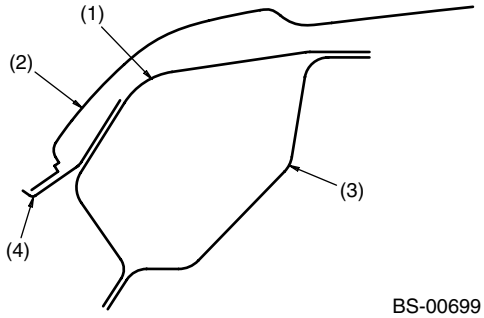
BS-00697

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

- **Sedan-only parts**



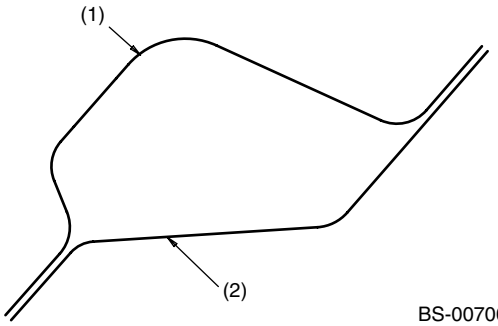
Cross section Q — Q



BS-00699

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

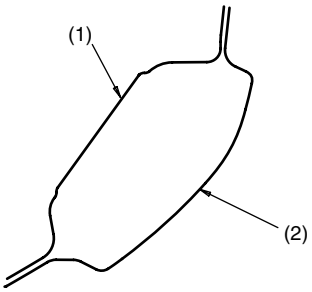
Cross section R — R



BS-00700

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

Cross section S — S

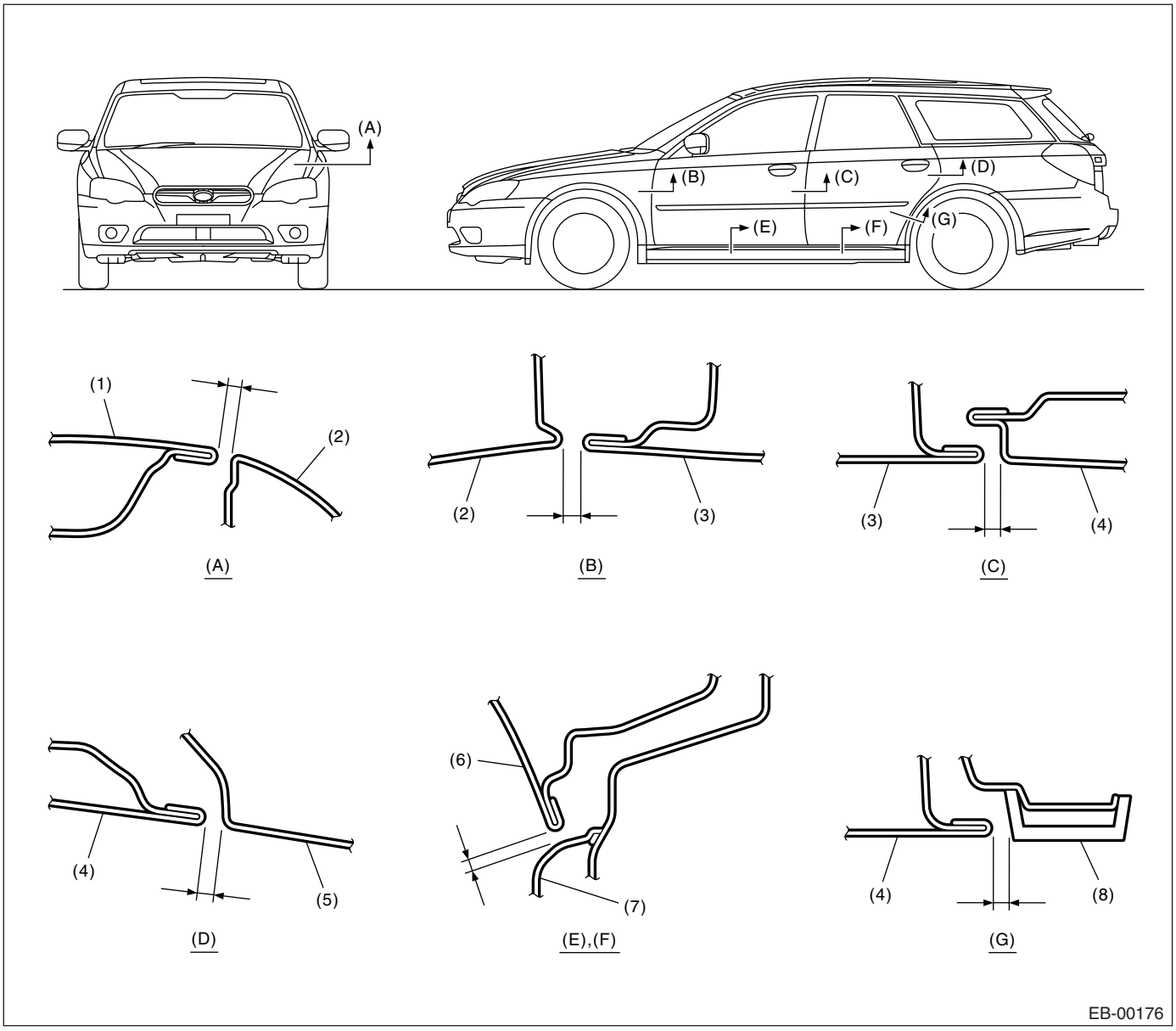


BS-00701

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

6. Gauge Values for Fitting

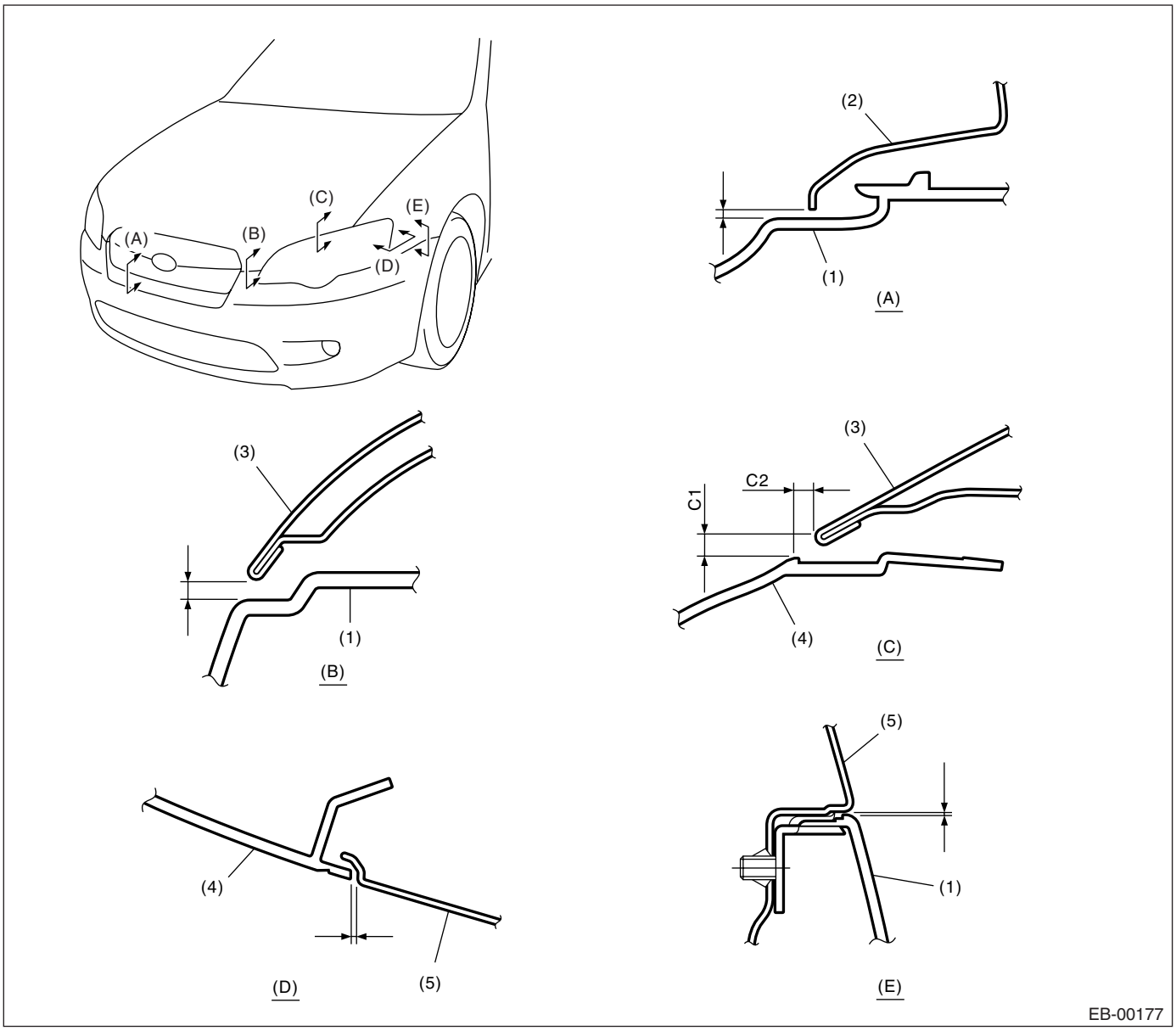
1. SIDE



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

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)

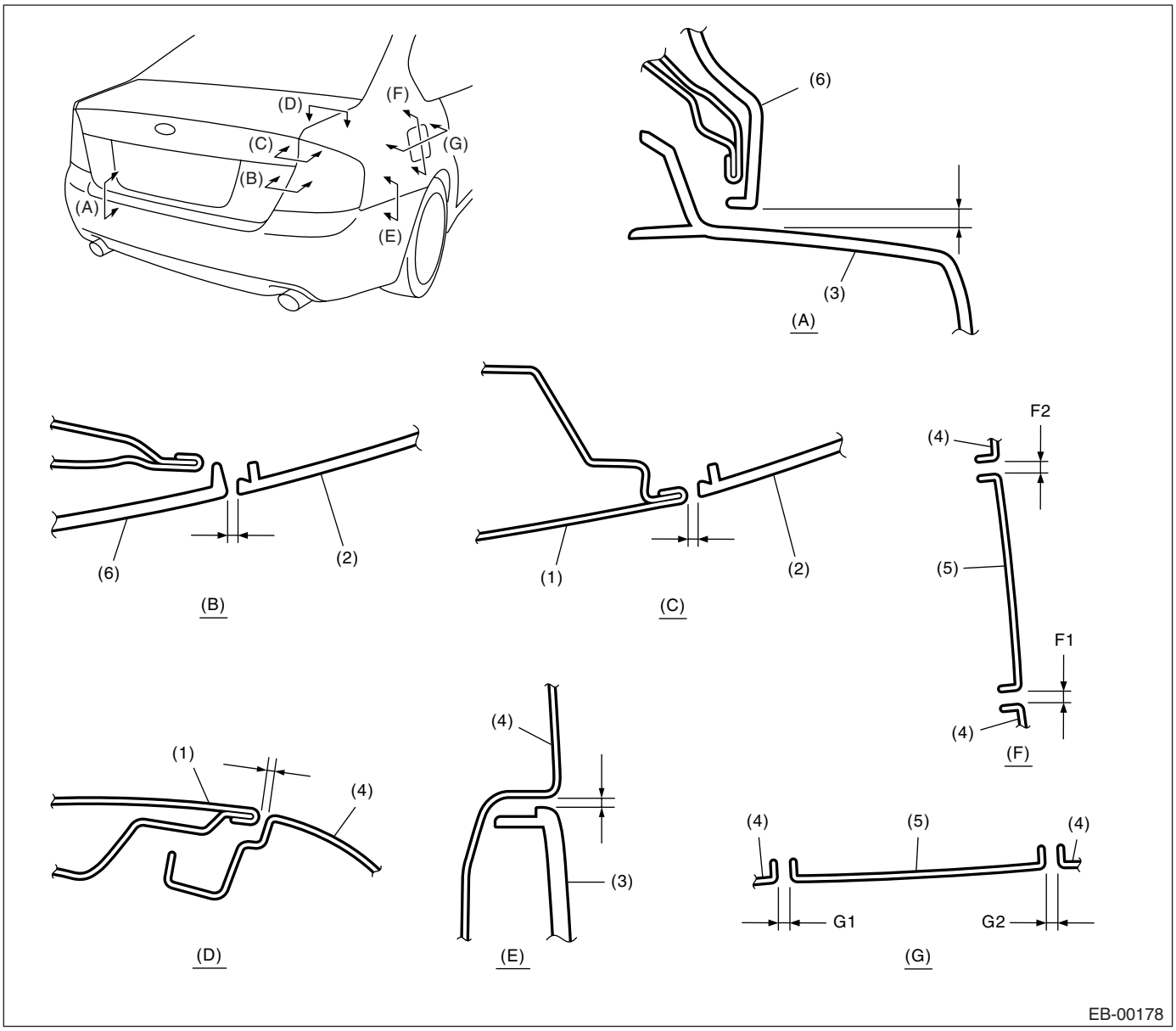
2. FRONT



(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)

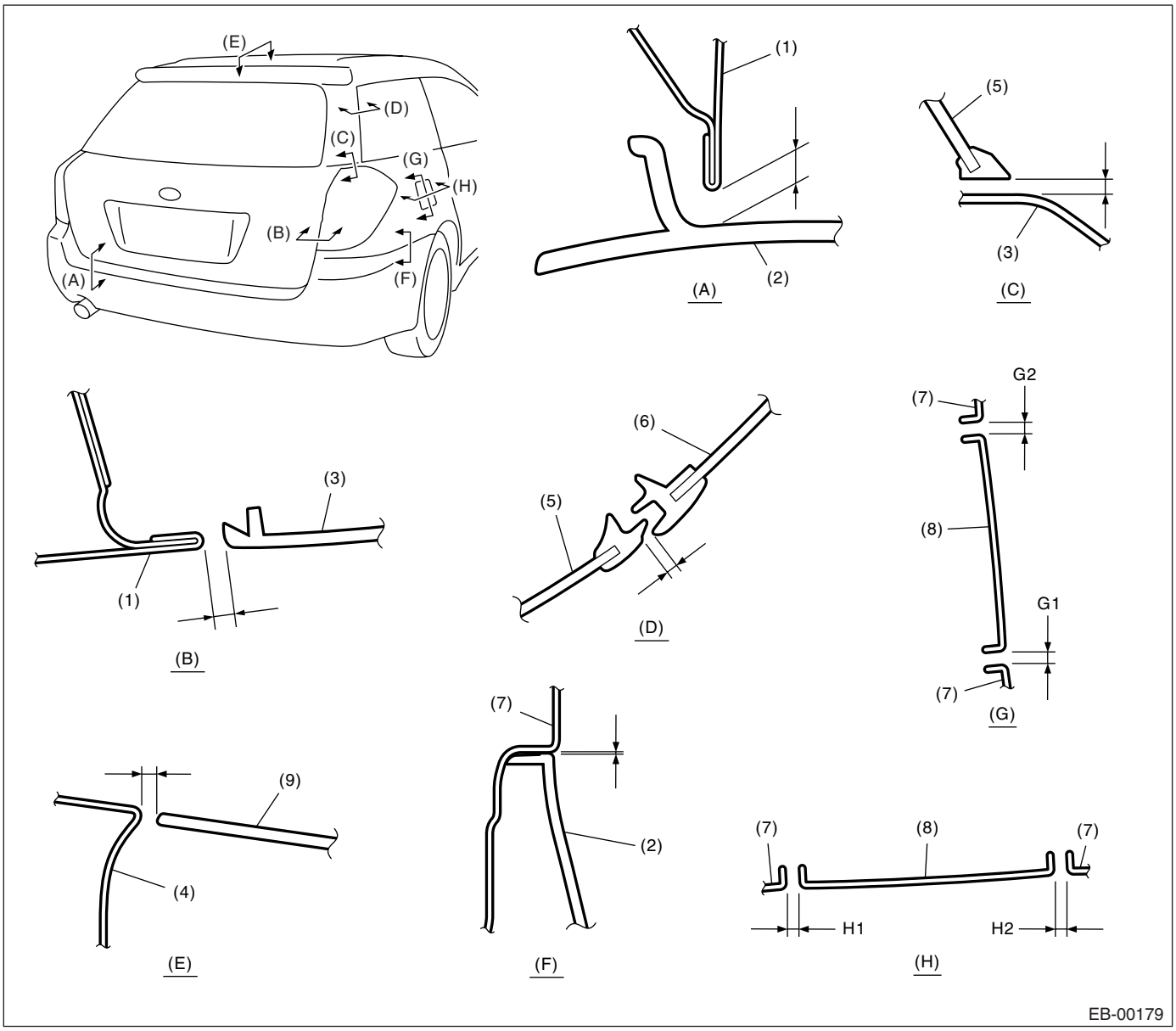
3. REAR (SEDAN MODEL)



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

4. REAR (WAGON MODEL)

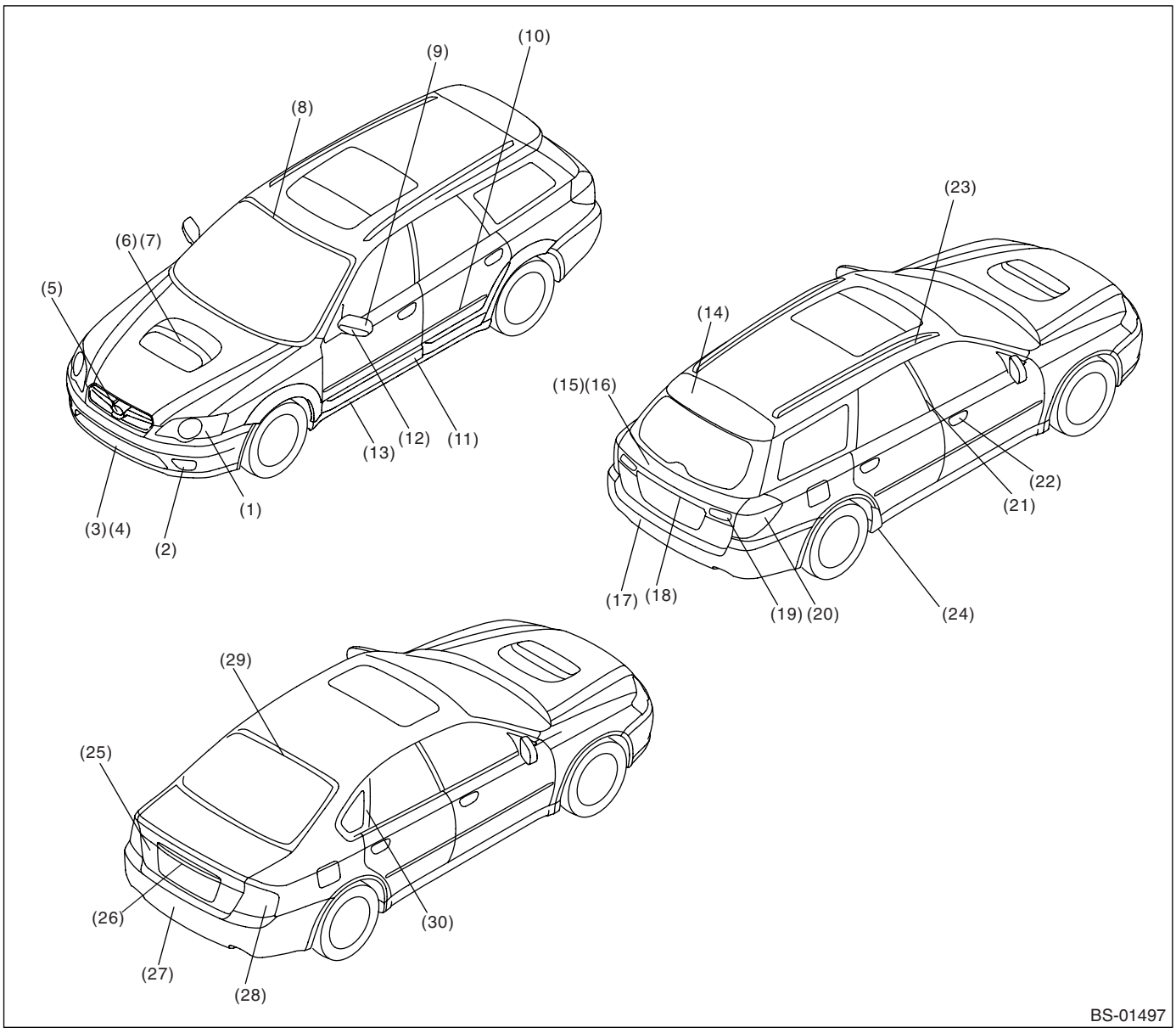


(1) Rear gate panel
(2) Rear bumper
(3) Rear combination light
(4) Roof panel
(5) Rear gate glass
(6) Rear quarter glass
(7) Rear fender panel
(8) Fuel filler flap lid
(9) Roof spoiler

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

7. Plastic Parts and Materials

A: SPECIFICATION



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

- **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	Body	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

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

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)

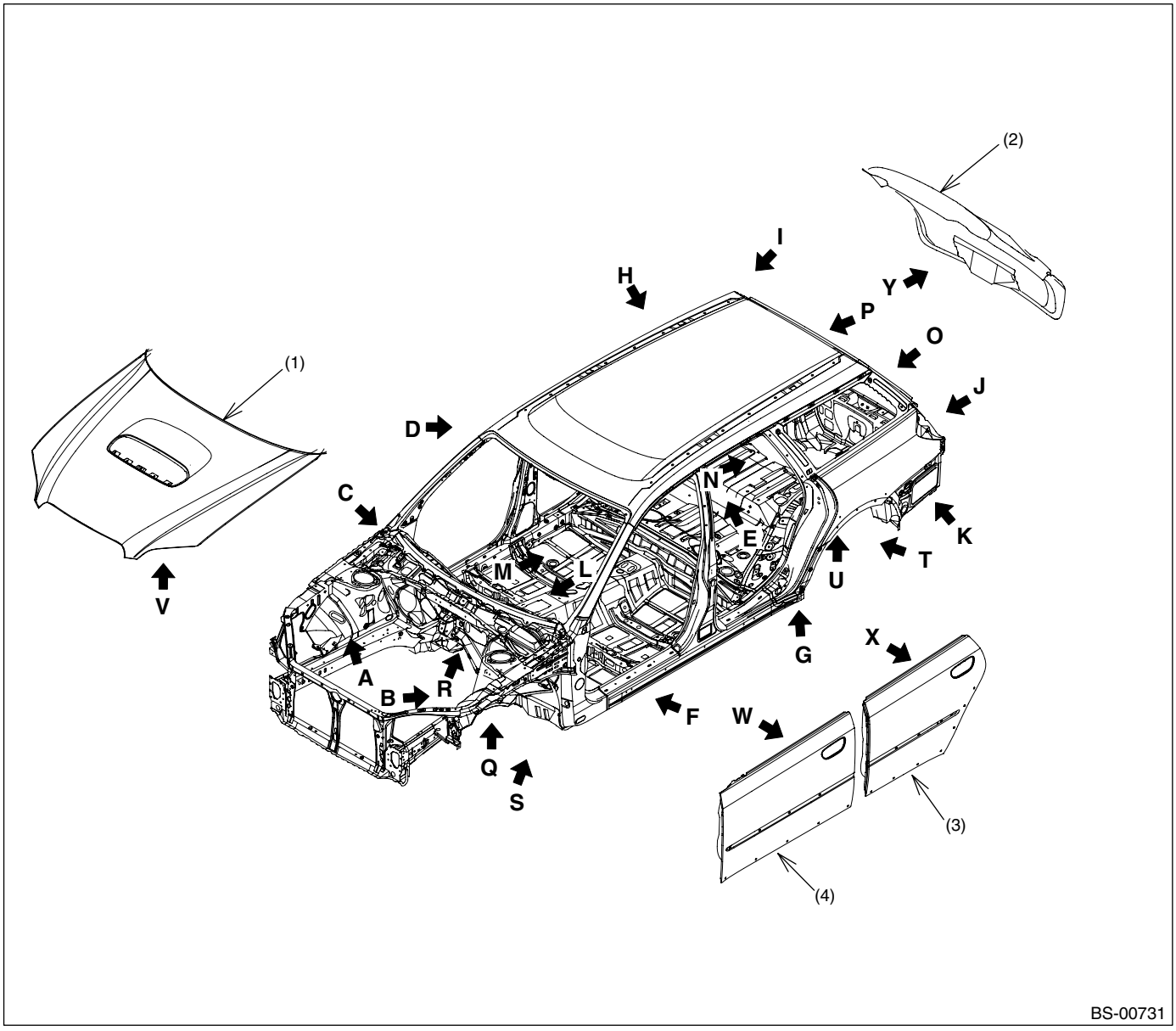
9. Body Sealing

A: SPECIFICATION

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

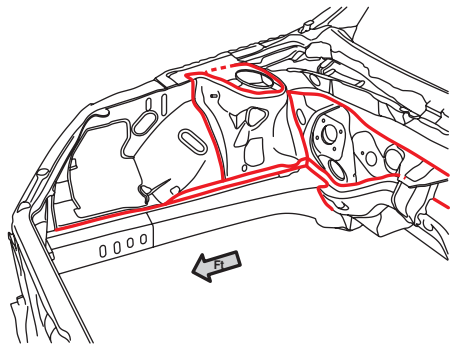
: Sealer application location

- **Common parts for wagon and sedan**



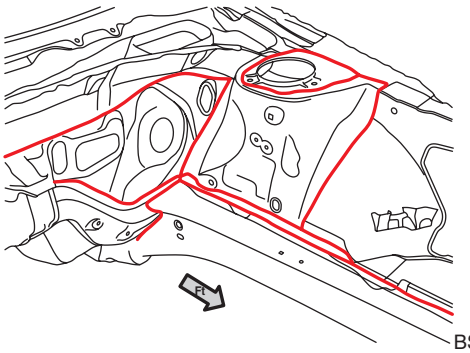
(1) Front hood
(2) Rear gate
(3) Rear door
(4) Front door

View A



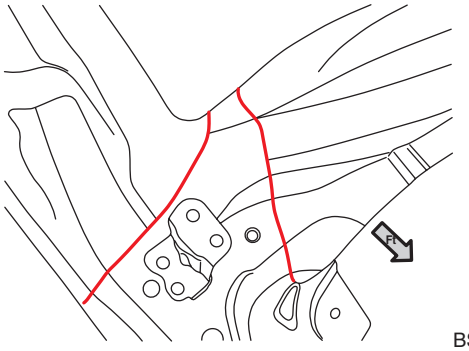
BS-00732

View B



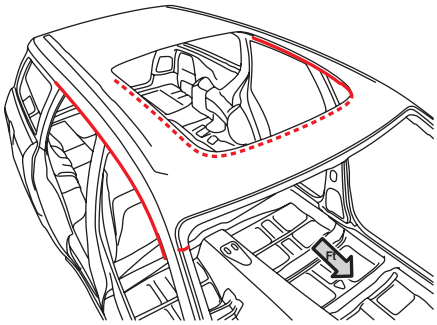
BS-00733

View C



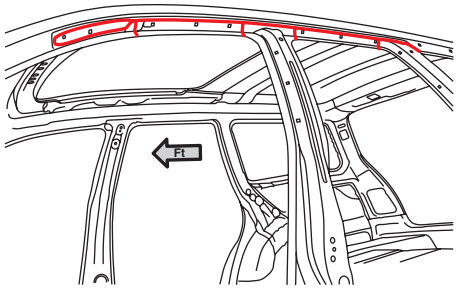
BS-00734

View D



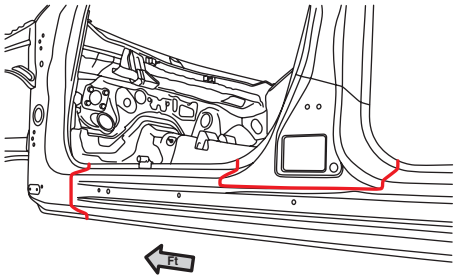
BS-00735

View E



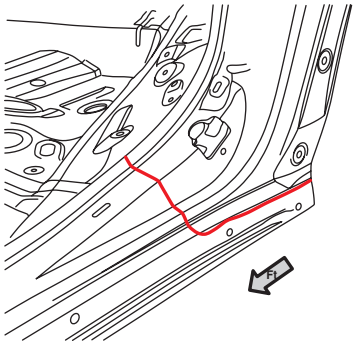
BS-00736

View F



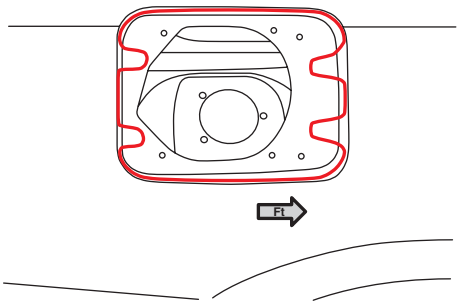
BS-00737

View G



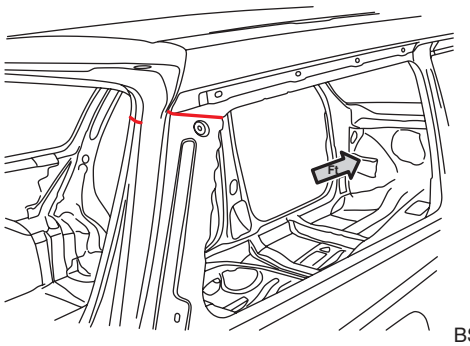
BS-00738

View H



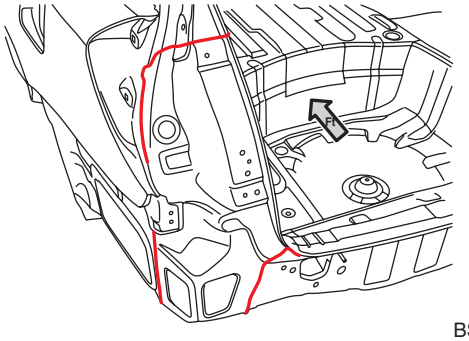
BS-00739

View I



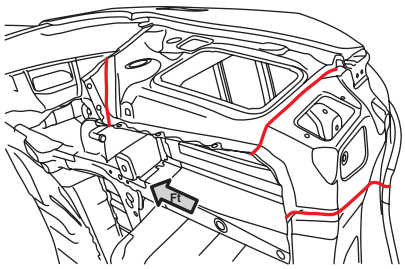
BS-00740

View J



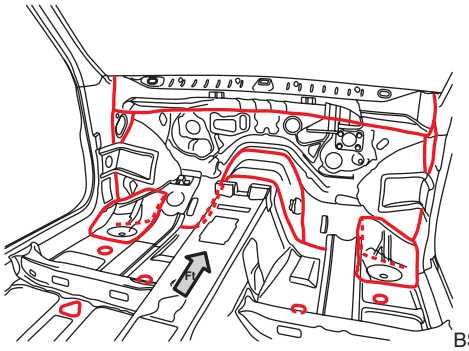
BS-00741

View K



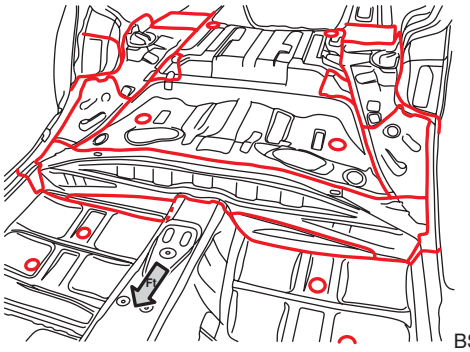
BS-00742

View L



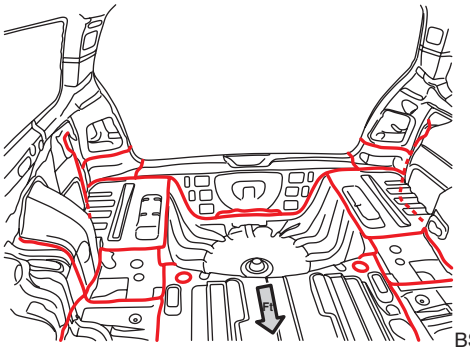
BS-00743

View M



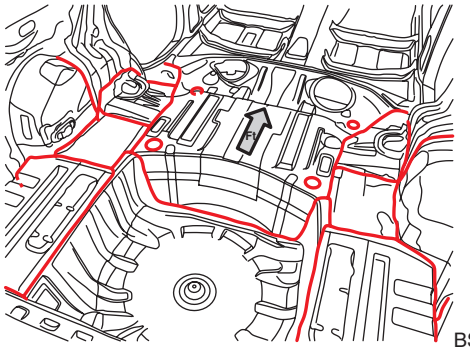
BS-00744

View N



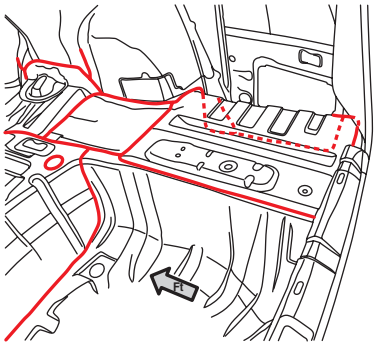
BS-00745

View O



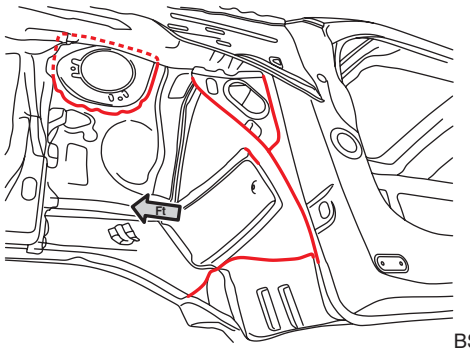
BS-00746

View P



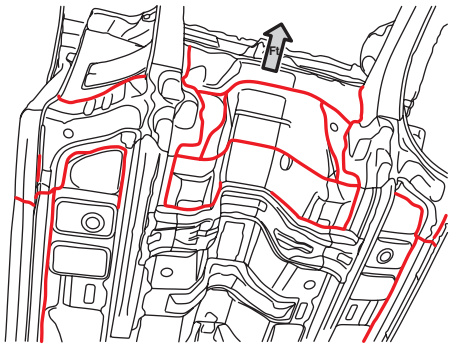
BS-00747

View Q



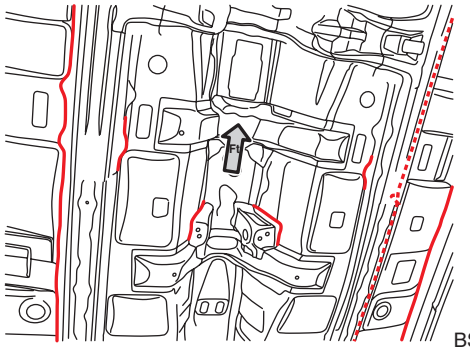
BS-00748

View R



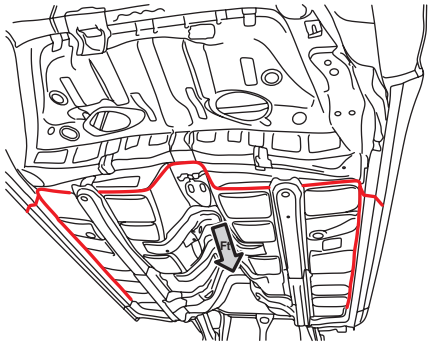
BS-00749

View S



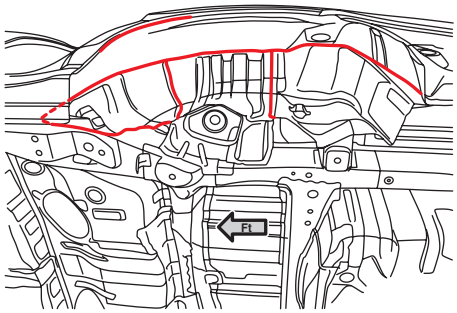
BS-00750

View T



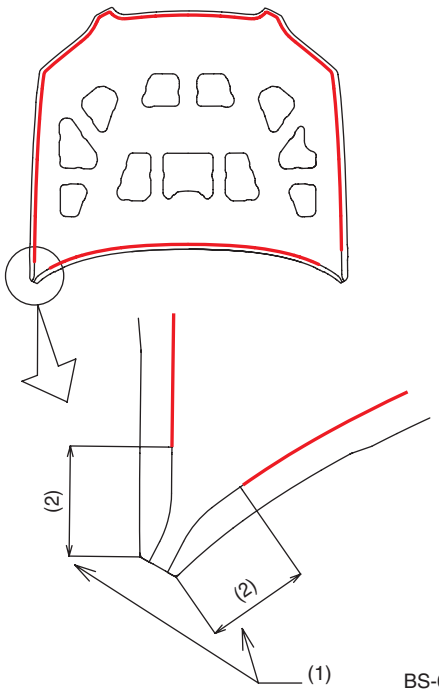
BS-00751

View U



BS-00752

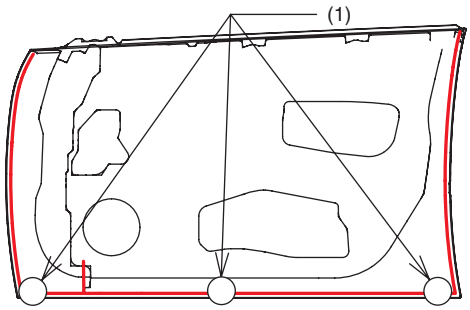
View V



BS-02513

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

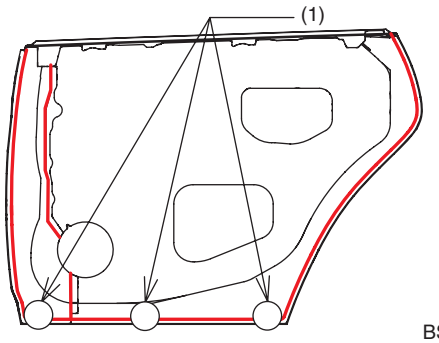
View W



BS-00754

(1) Do not block the water drain holes.

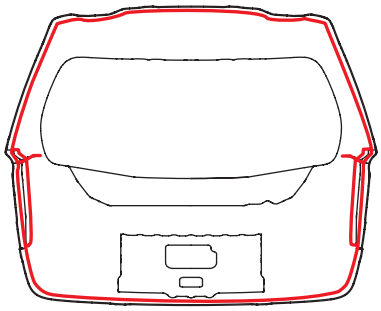
View X



BS-00755

(1) Do not block the water drain holes.

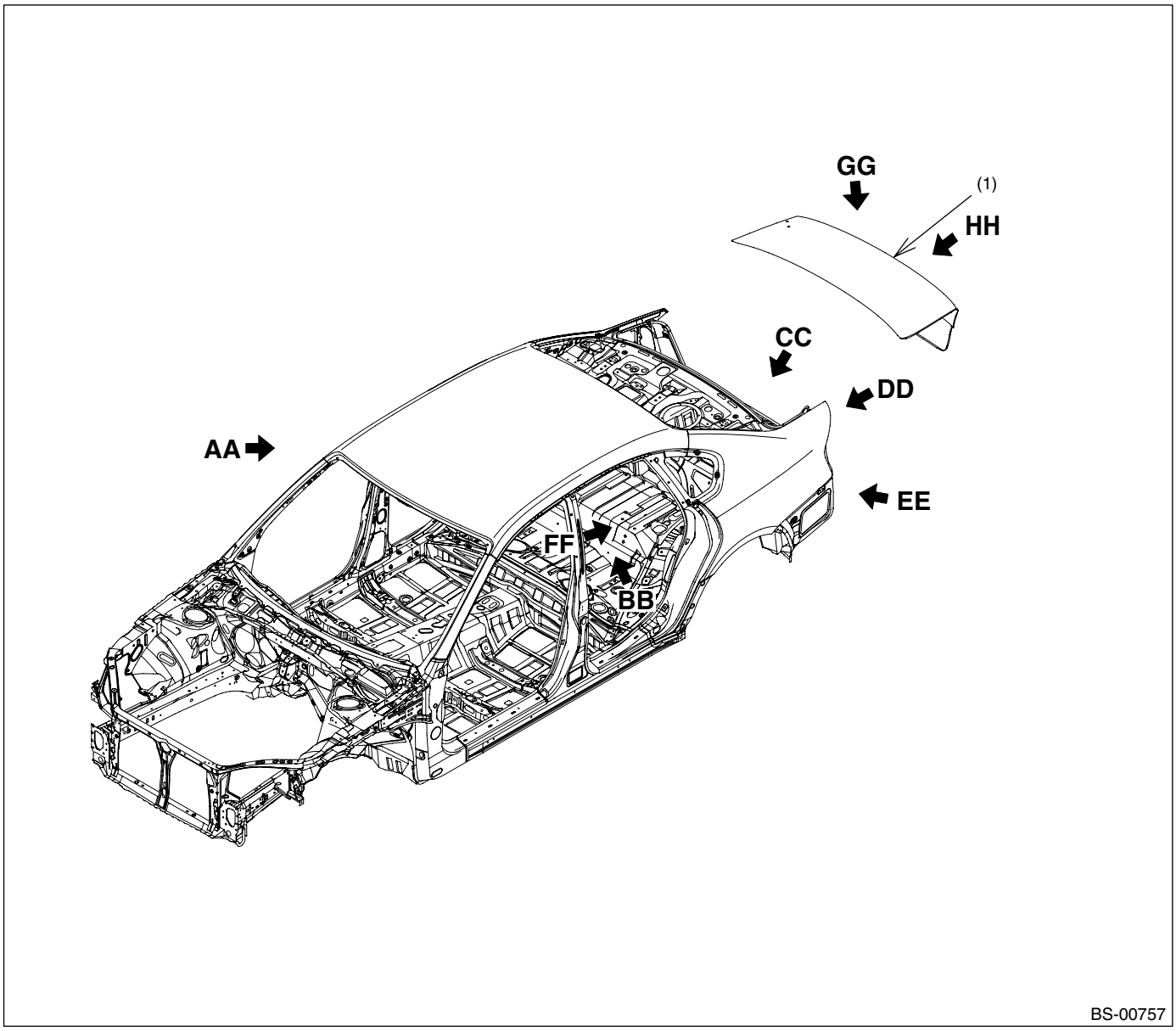
View Y



BS-00756

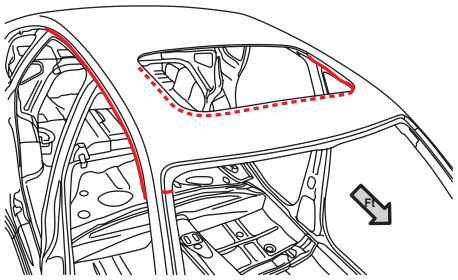
CAUTION:
Sealer already has been applied to hood, door and rear gate in replacement condition.

- **Sedan-only parts**



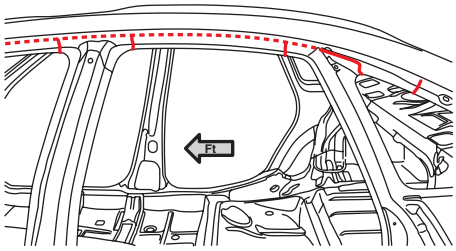
(1) Trunk

View AA



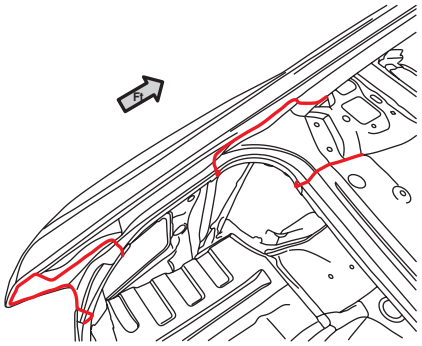
BS-00758

View BB



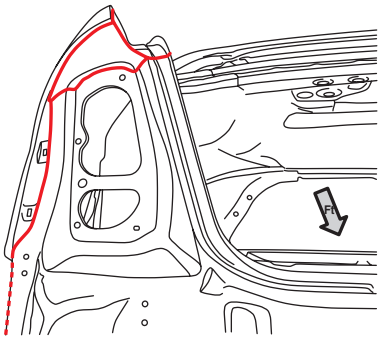
BS-00759

View CC



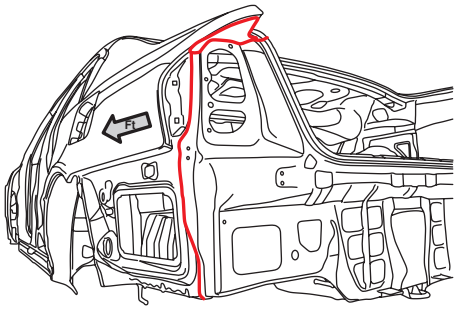
BS-00760

View DD



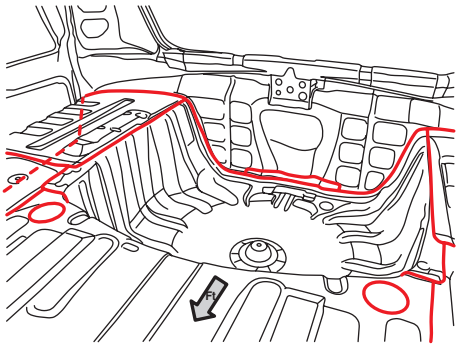
BS-00761

View EE



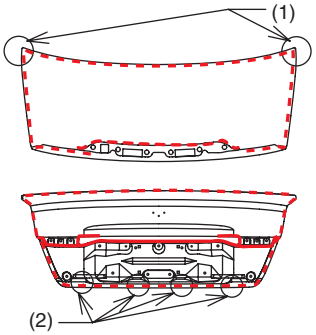
BS-00762

View FF



BS-00763

View GG
View HH



BS-00764

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

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

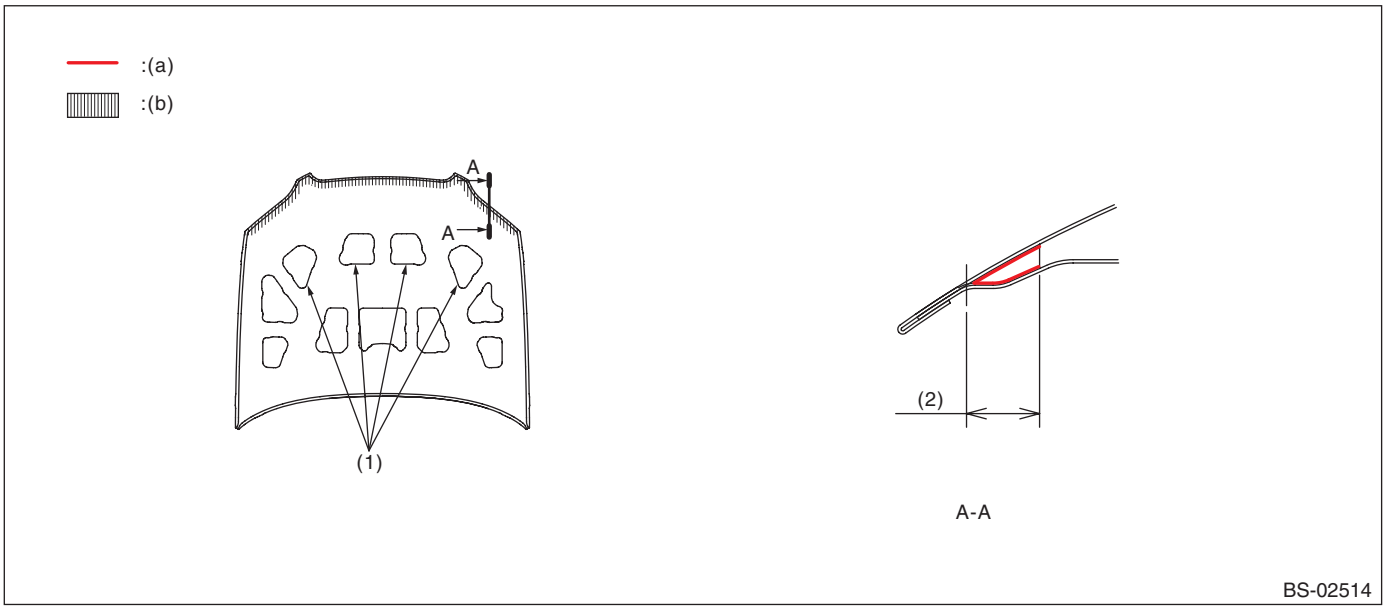
10.Anticorrosion Wax

A: SPECIFICATION

Used material:

Rust-stop aerosol (K0877YA015)

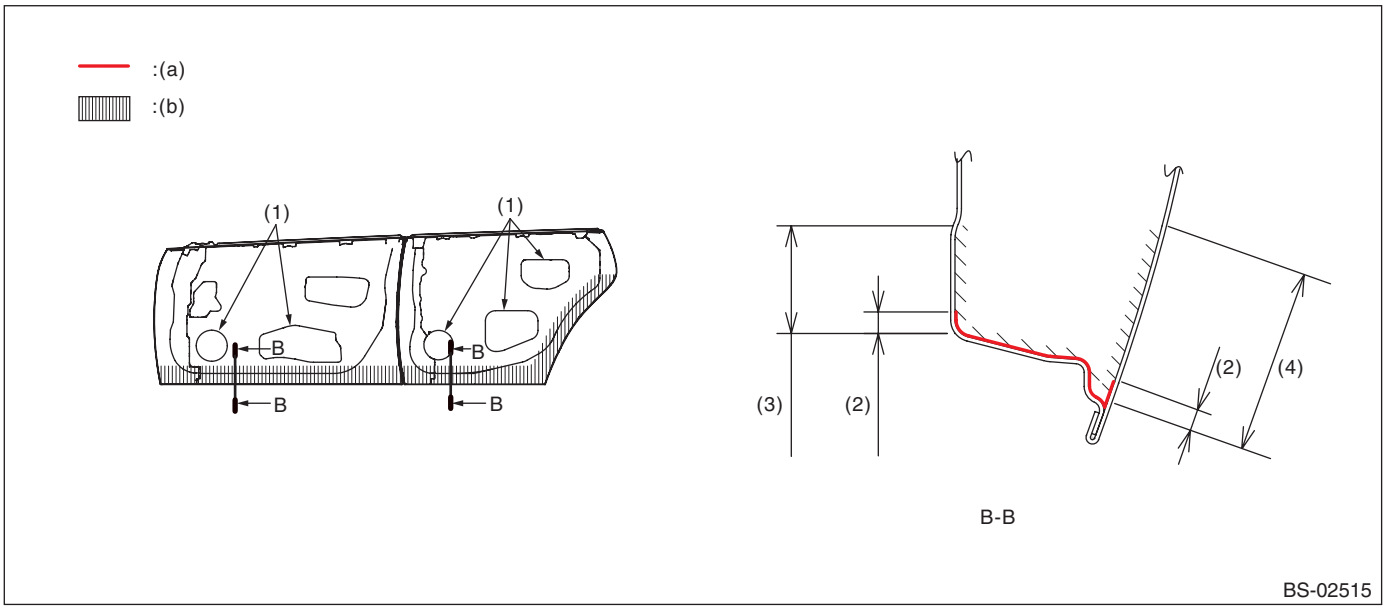
- Front hood



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

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

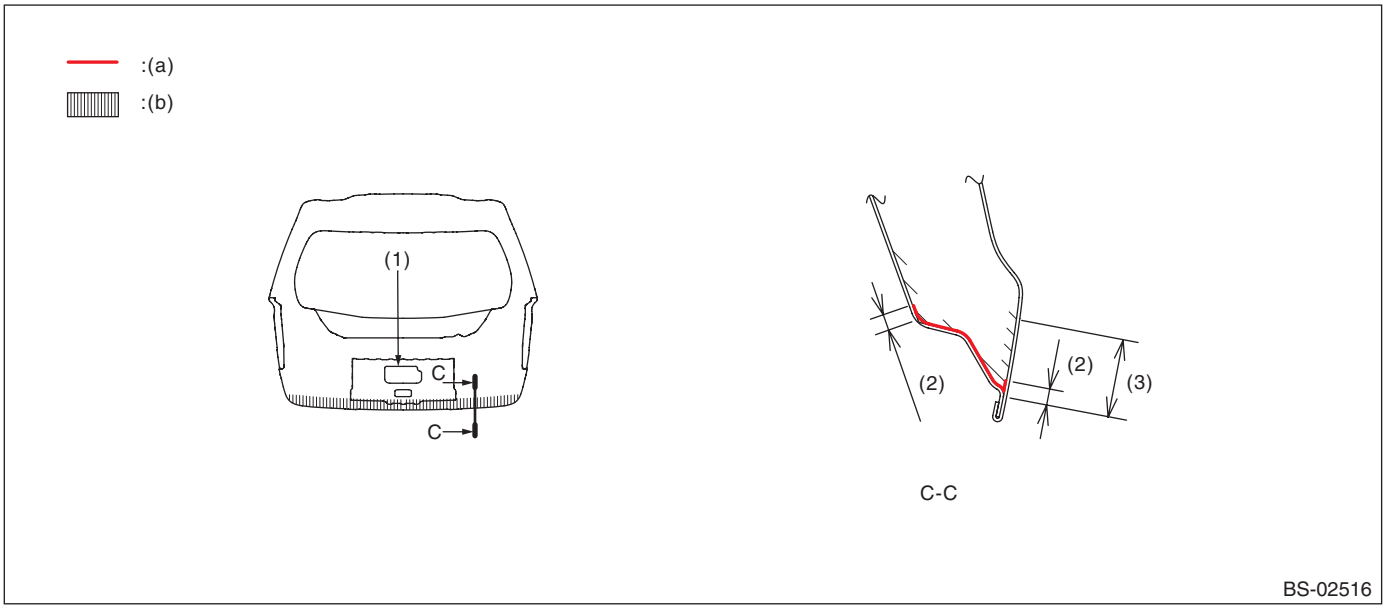
- Door (Front, rear)



(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)

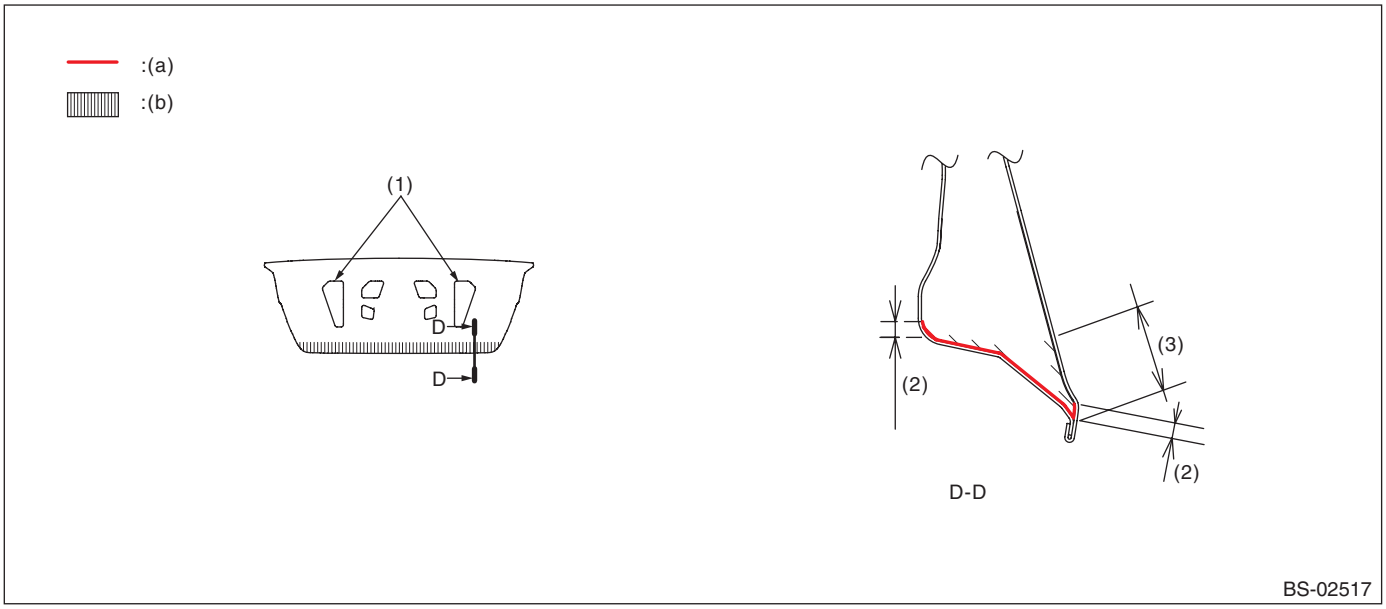
- Rear gate



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

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

- Trunk

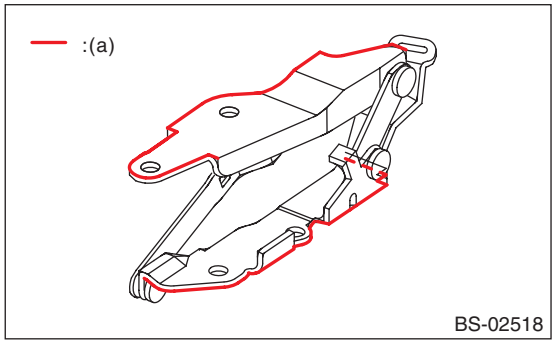


(a) Application thickness: 50 µm or more (b) Application area

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

- Front hood hinge

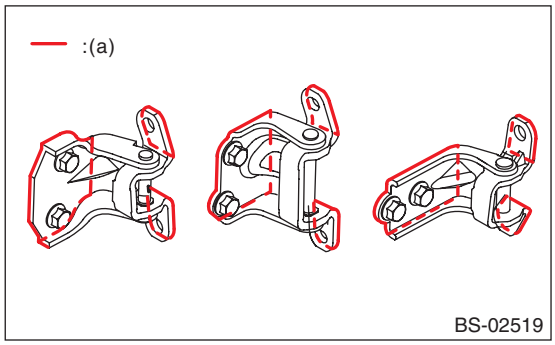
Apply around the installation outer circumference (indicated range) at two locations on the left and right.



(a) Application thickness: 15 µm or more

- Door hinge

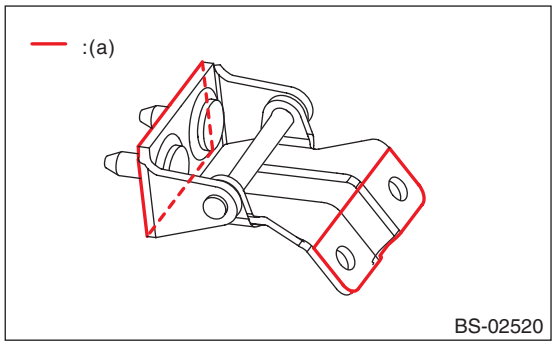
Apply to the installation outer circumference at two locations at the top and bottom (eight locations in all).



(a) Application thickness: 15 µm or more

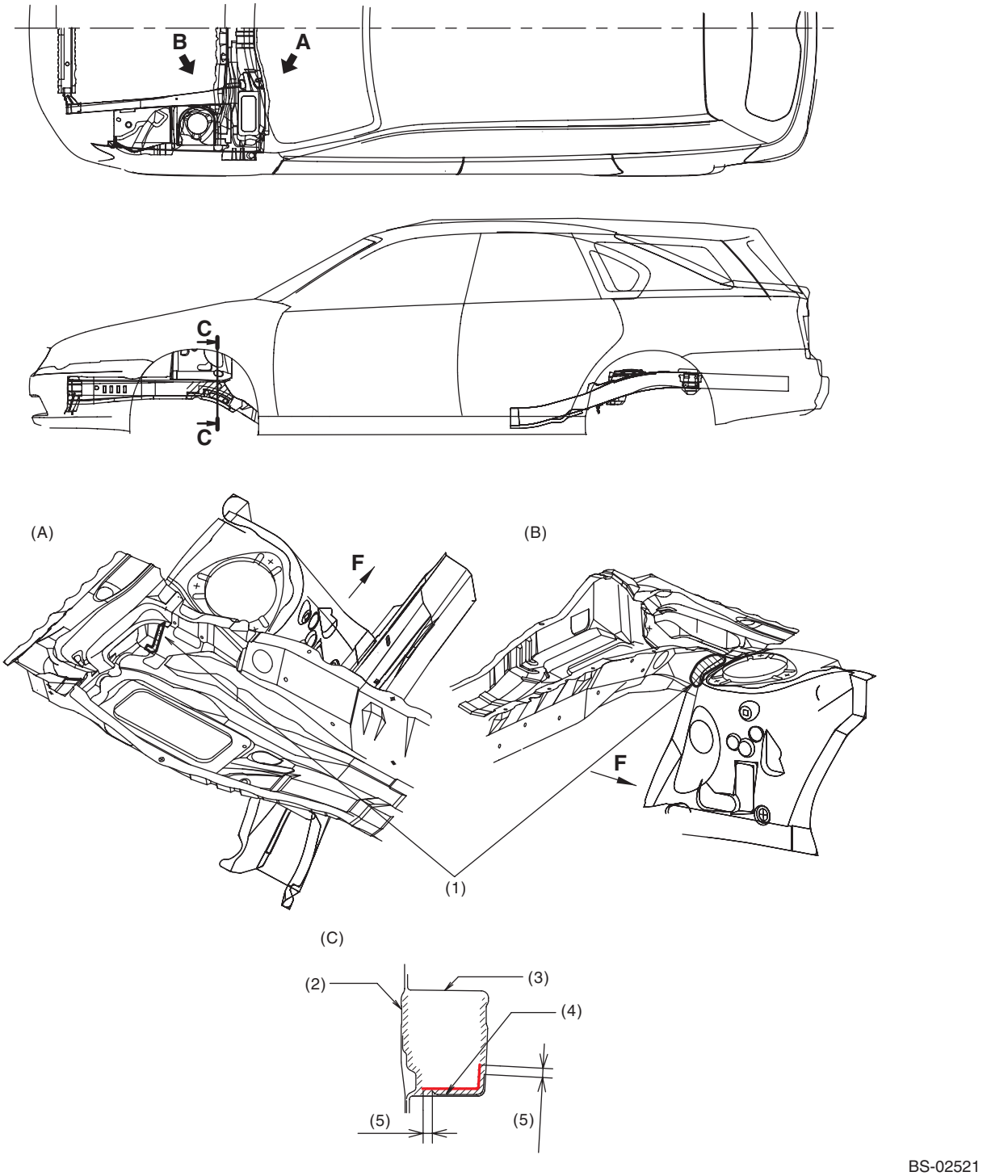
- Rear gate hinge

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



(a) Application thickness: 15 µm or more

- 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 μm or more)

(2) Closing plate

(3) Front side frame front

(4) Reinforcement

(5) 10 mm (0.39 in)

11.Undercoat

A: SPECIFICATION

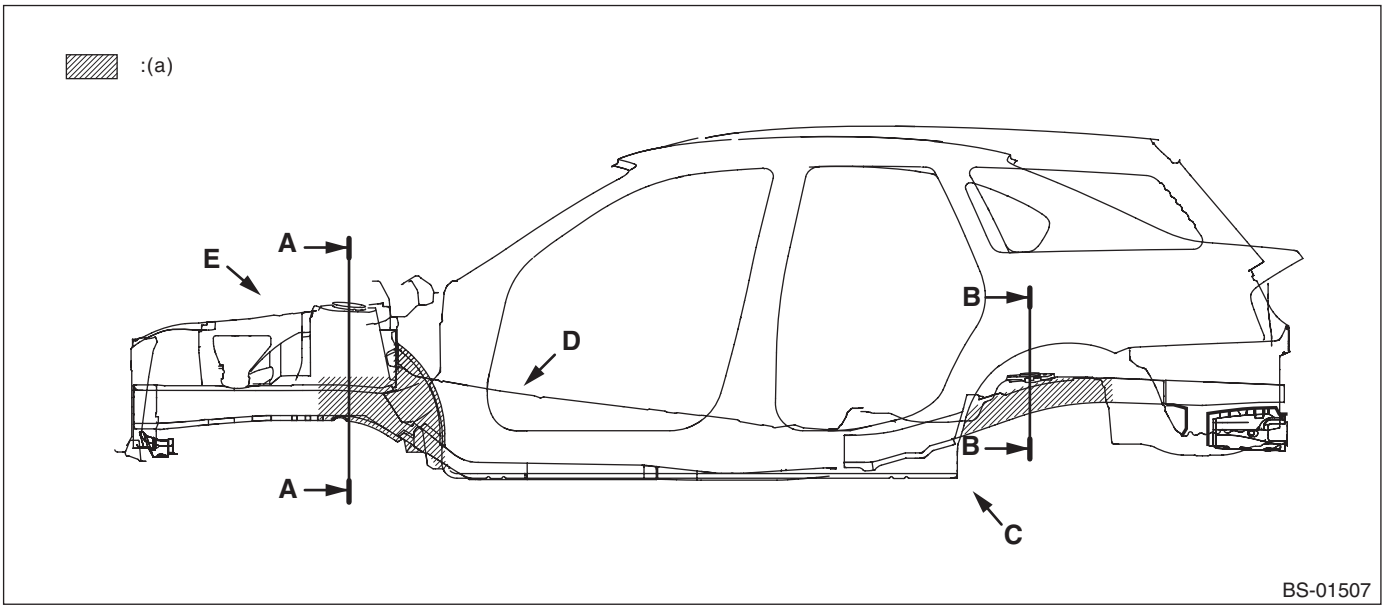
Repair material:
THREE BOND 6115

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.

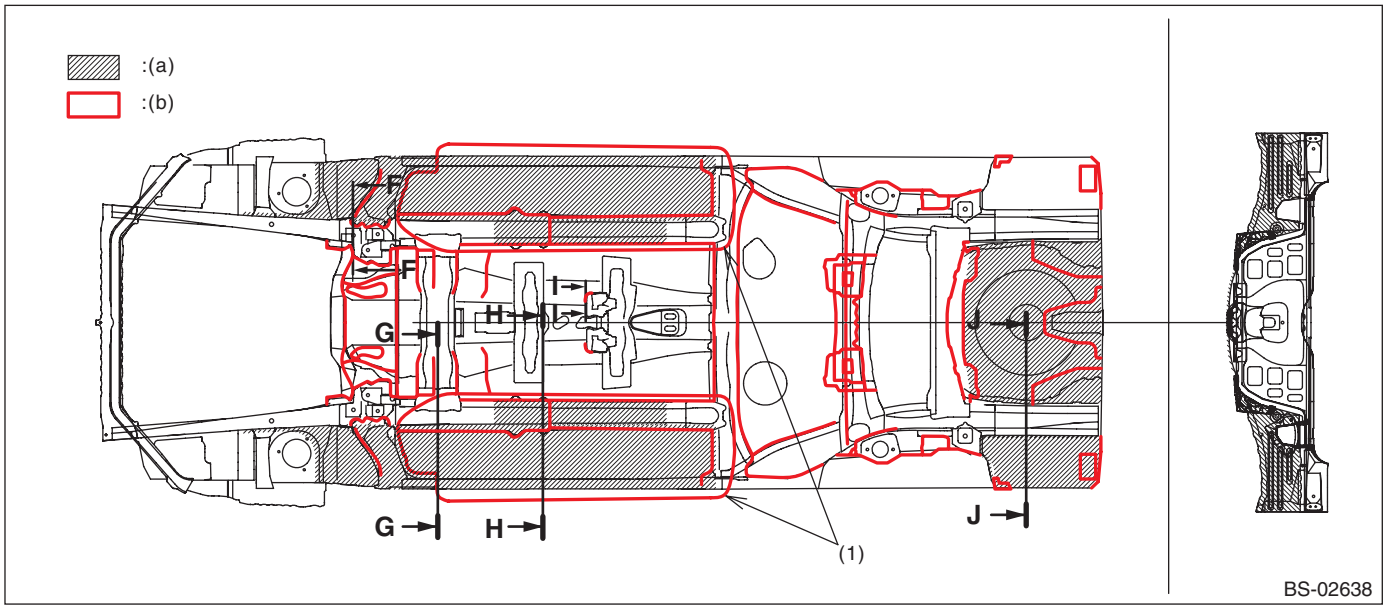
3) Application area
 and : Undercoat application location

- Side view



(a) Undercoat application location

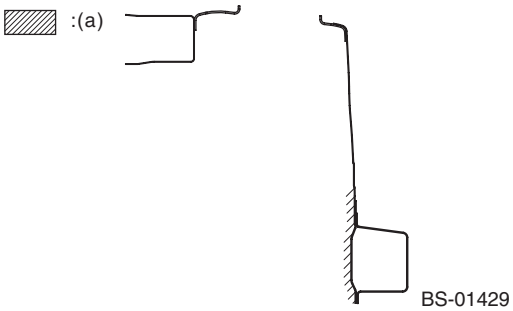
- Bottom view/1



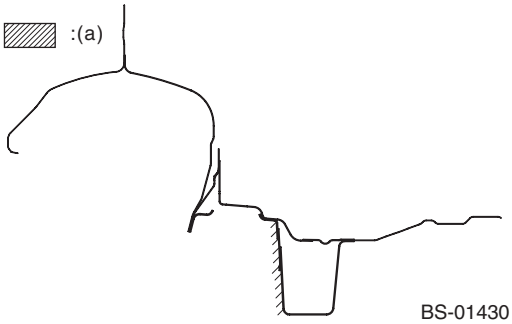
(1) Undercoat is not required in this area for vehicles equipped with an undercover.

(a), (b) Undercoat application location

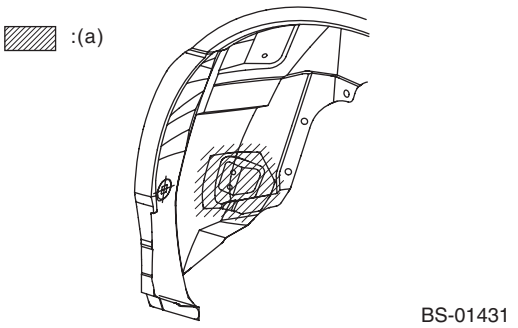
Cross section A — A



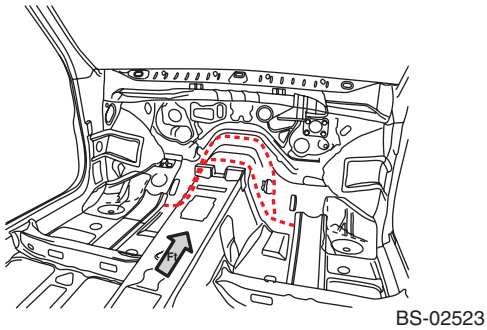
Cross section B — B



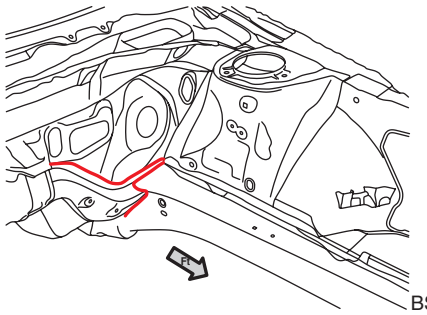
View C



View D

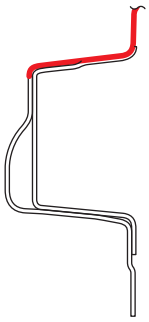


View E



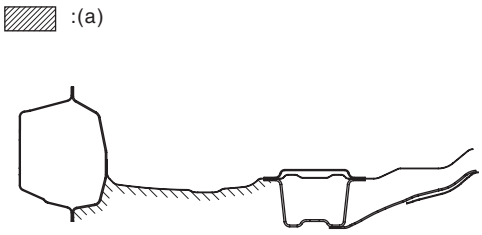
BS-02524

Cross section F — F



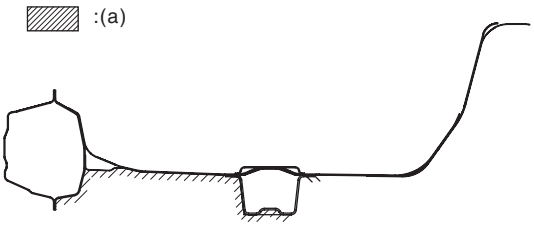
BS-02525

Cross section G — G (rotated 90°)



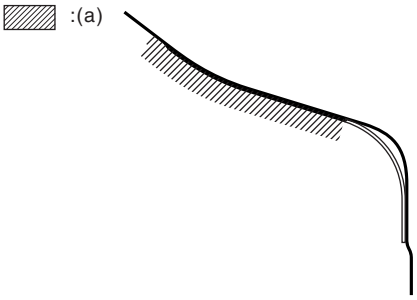
BS-01432

Cross section C — C (rotated 90°)



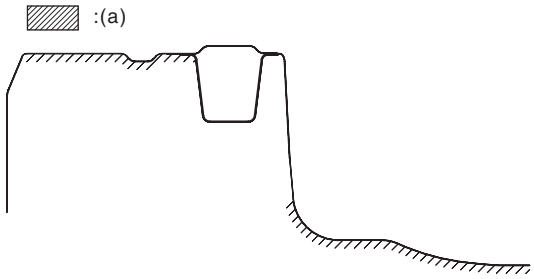
BS-01433

Cross section I — I



BS-01512

Cross section J — J (rotated 90°)



BS-01434

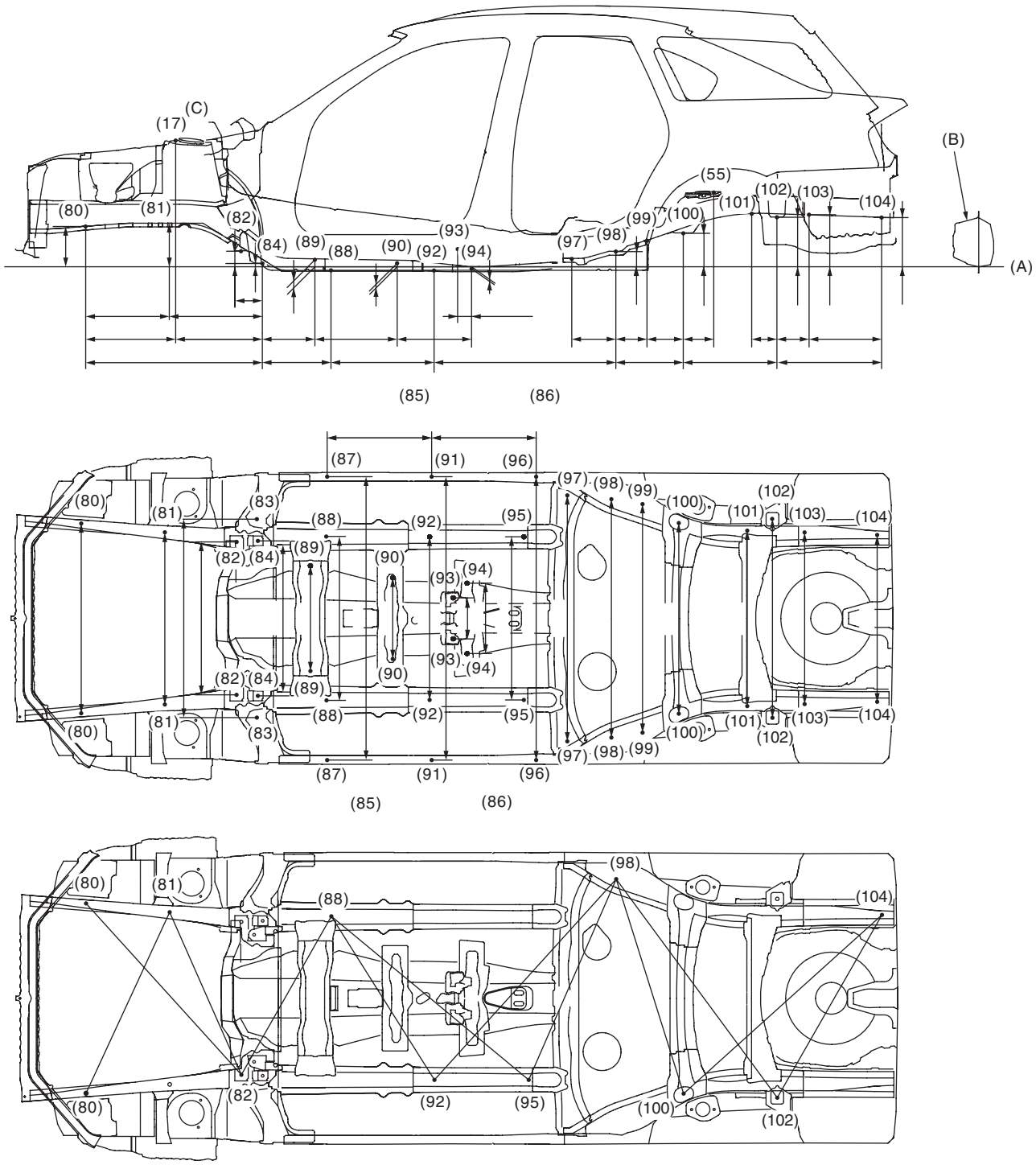
(a) Undercoat application location

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.

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

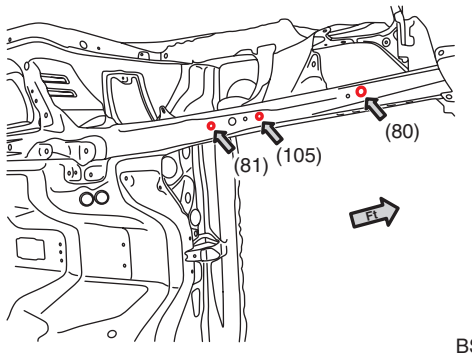
(C) Upper face

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

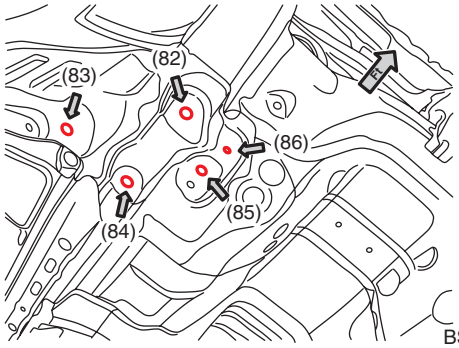
Measurement point	Datum dimension mm (in)
Datum line — (80)	198 (7.80)
Datum line — (81)	212 (8.35)
Datum line — (82)	77 (3.03)
Datum line — (84)	17(0.07)
Datum line — (89)	(4AT, MT) 35 (1.38) (5AT) 56 (2.20)
Datum line — (90)	18 (0.71)
Datum line — (94)	–9 (–0.35)
Datum line — (98)	75 (2.95)
Datum line — (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)

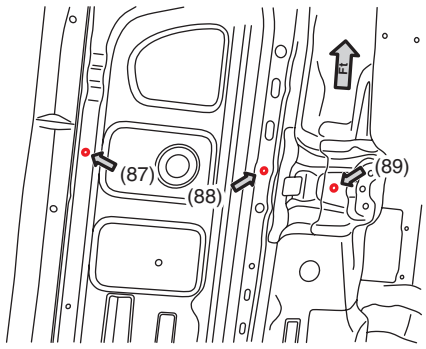
Measurement point	Datum dimension/projected reference dimensions mm (in)
(80) RH — (82) LH	1,135 (44.68)/1,128 (44.41)
(80) LH — (81) RH	973 (38.31)/973 (38.31)
(81) RH — (82) LH	877 (34.53)/867 (34.13)
(82) LH — (88) LH	894 (35.20)/889 (35.00)
(88) RH — (92) LH	943 (37.13)/943 (37.13)
(88) RH — (95) 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)



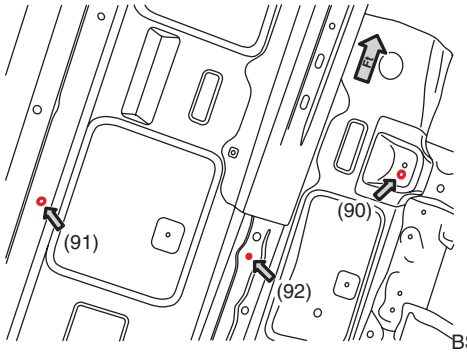
BS-02526



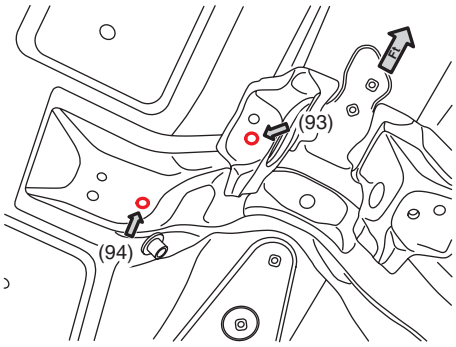
BS-02527



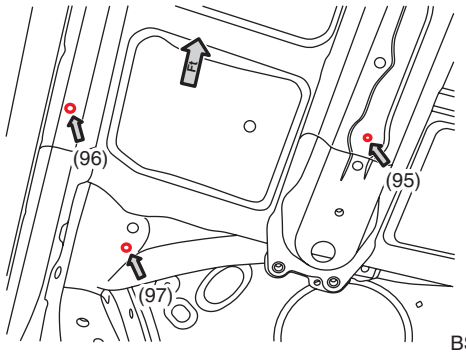
BS-02528



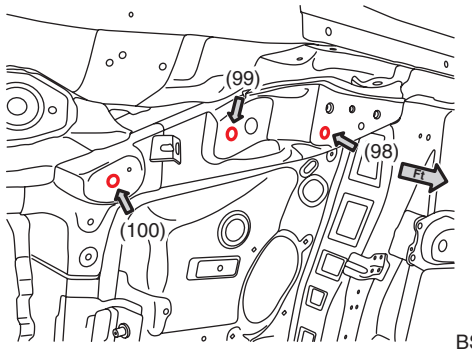
BS-02529



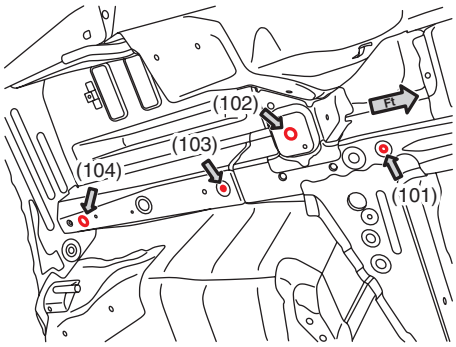
BS-02530



BS-02531



BS-02532

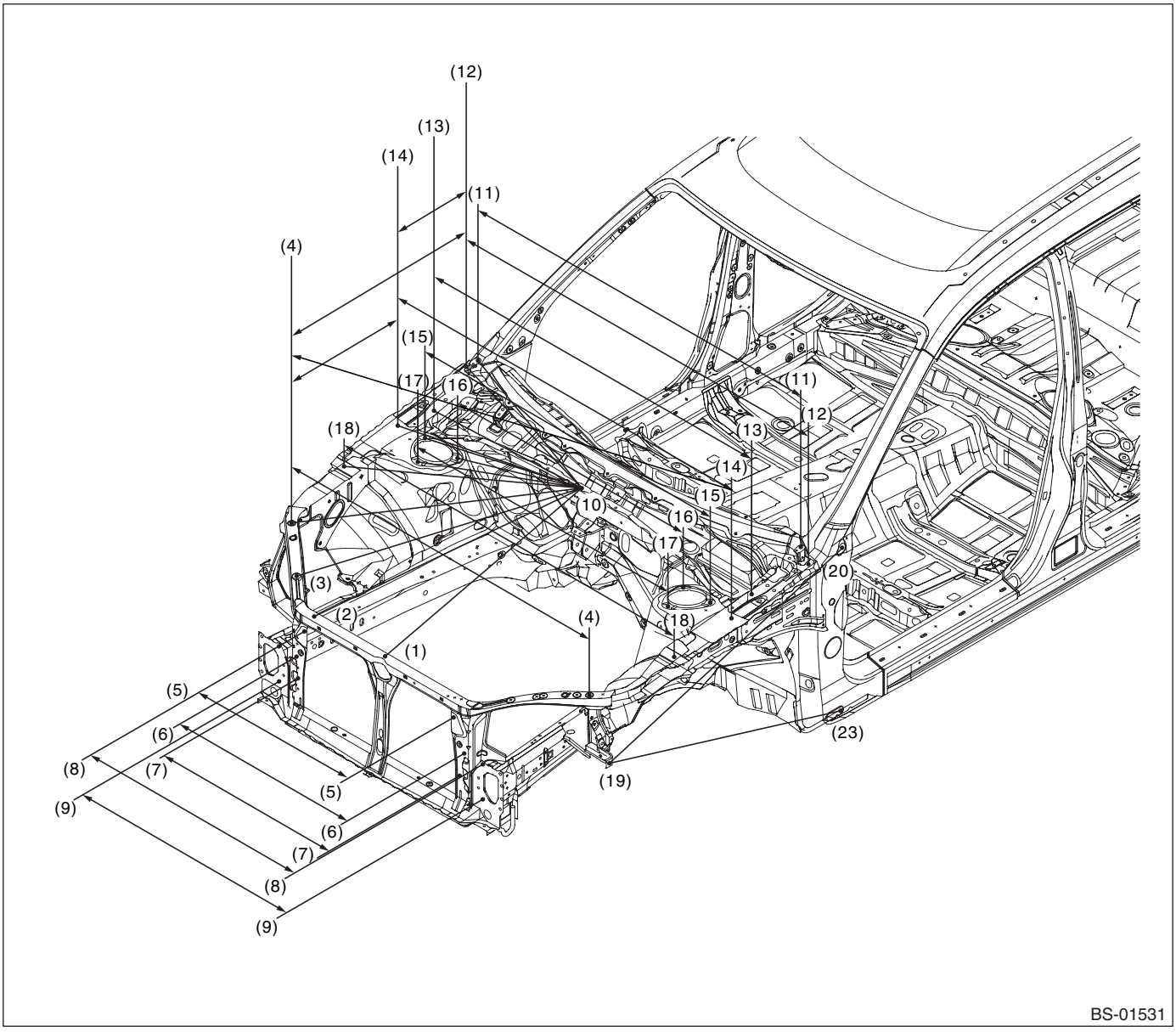


BS-02533

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.)

2. FRONT STRUCTURE

- Common for wagon, sedan

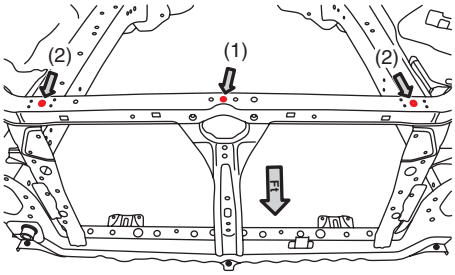


(1) Repair locator hole (body center)
(2) Radiator mounting hole
(3) Headlight mounting hole (symmetrical)
(4) Reinforcement fender mounting hole (symmetrical)
(5) A/C condenser mounting hole (symmetrical)
(6) Beam corner side mounting hole (symmetrical)
(7) Heat insulation cover mounting hole (symmetrical)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

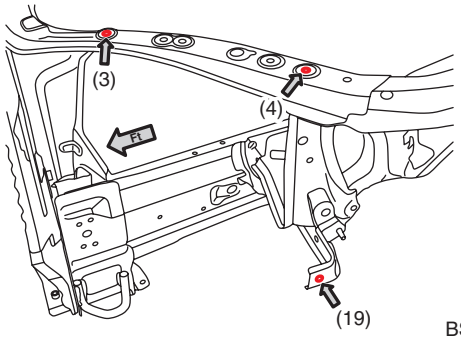
Measurement point	Datum dimension mm (in)
(1) — (10)	893 (35.16)
(2) — (10)	948 (37.32)
(3) — (10)	934 (36.77)
(4) — (10)	918 (36.14)
(4) — (4)	1,314 (51.73)
(4) — (12)	882 (34.72)
(4) — (14)	557 (21.93)
(4) RH — (14) LH	1,498 (58.98)
(4) LH — (14) RH	1,498 (58.98)
(5) — (5)	658 (25.91)
(6) — (6)	740 (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:

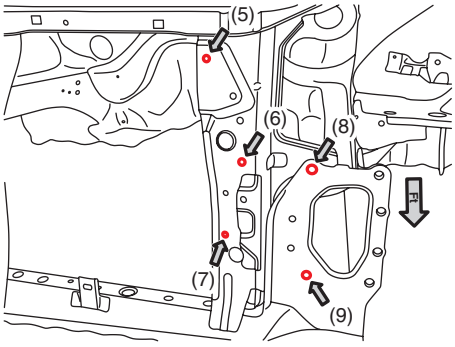
- The reference points (1) and (10) are at the body center, while the other points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



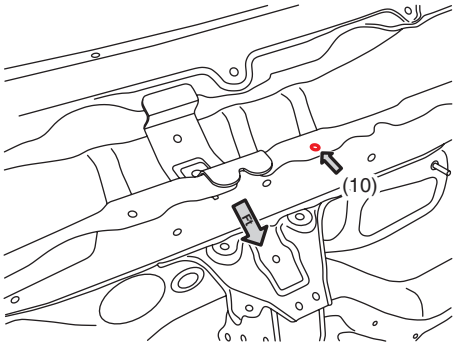
BS-02534



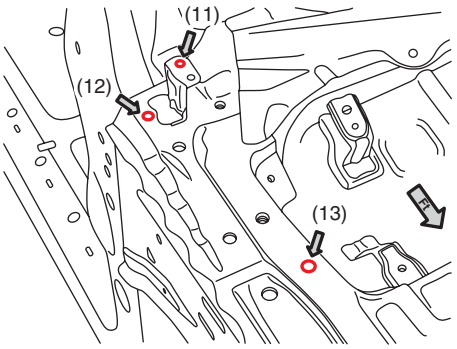
BS-02535



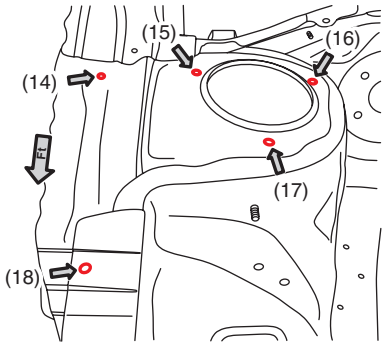
BS-02536



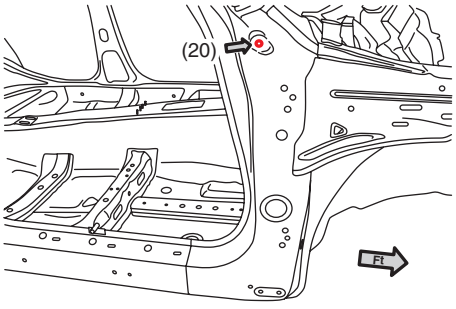
BS-02537



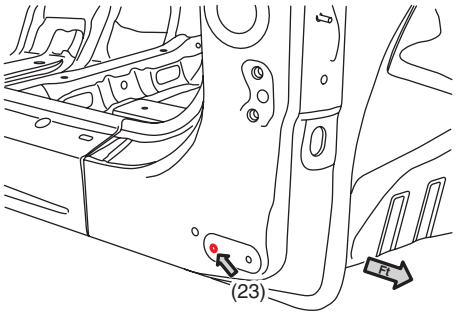
BS-02538



BS-02539



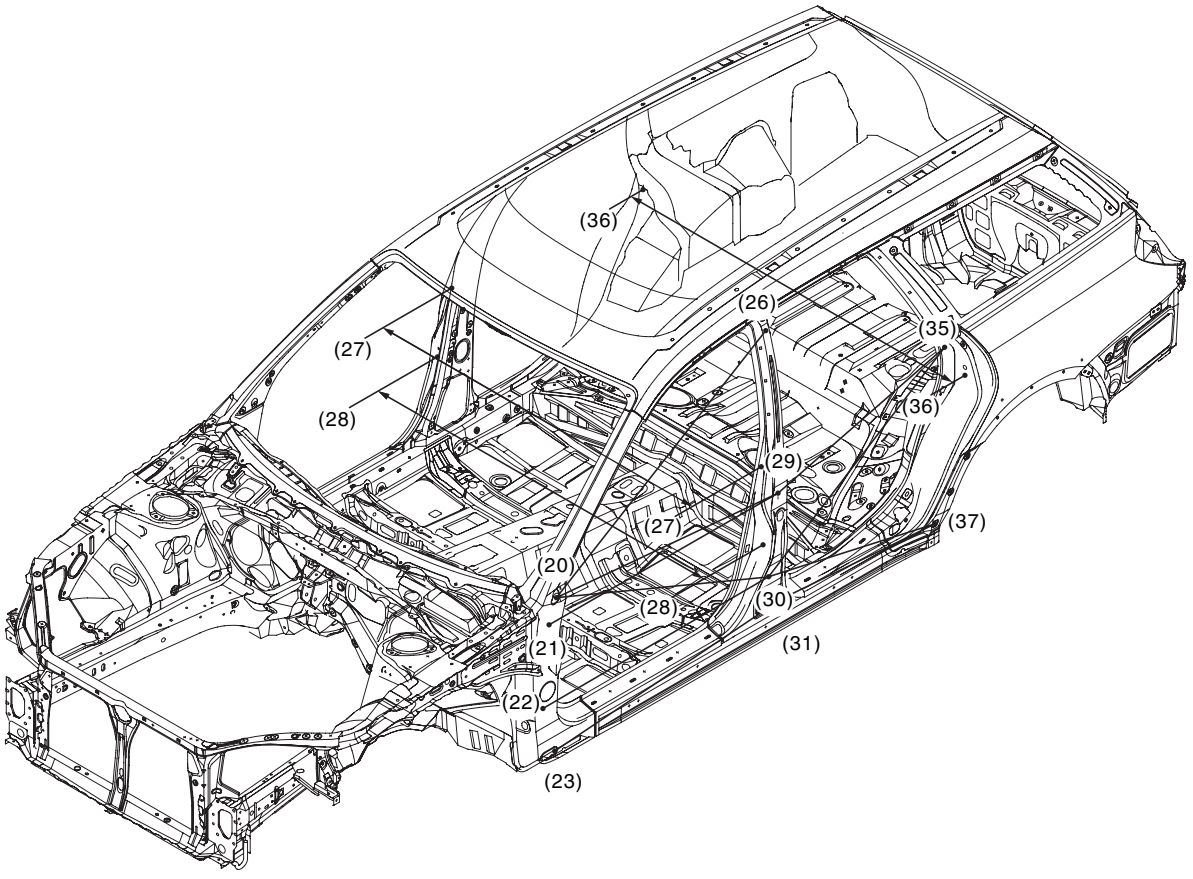
BS-02540



BS-02541

3. INSIDE

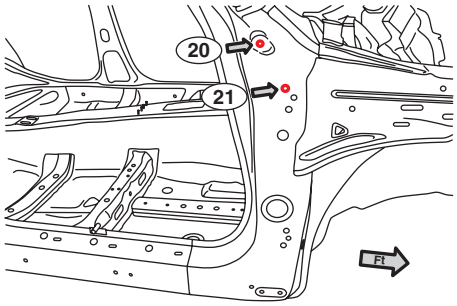
- Common for wagon and sedan, 1



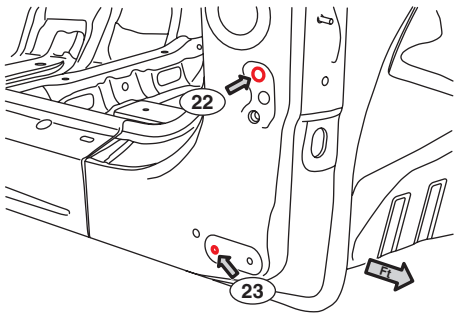
(20) Fender mounting hole (symmetrical)
(21) Front door hinge upper mounting hole (symmetrical), upper side
(22) Front door hinge lower mounting hole (symmetrical), upper side
(23) Fender mounting hole (symmetrical)
(26) Gauge hole (symmetrical)
(27) Weatherstrip mounting hole (symmetrical)
(28) Front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

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)

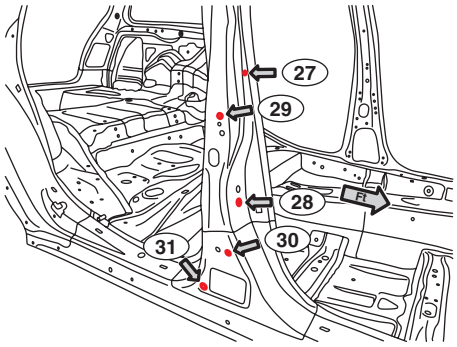
NOTE:
- All reference points are left-right symmetrical.
- The dimensions between the reference points are the actual dimensions.



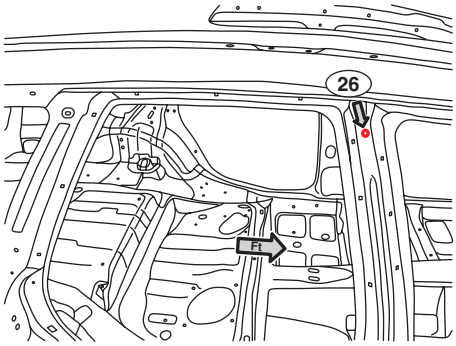
BS-00808



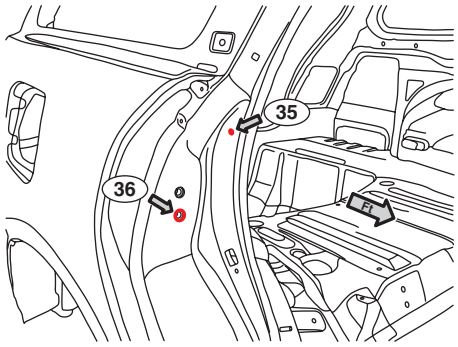
BS-00809



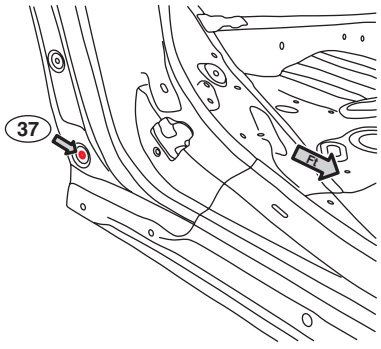
BS-00810



BS-00811

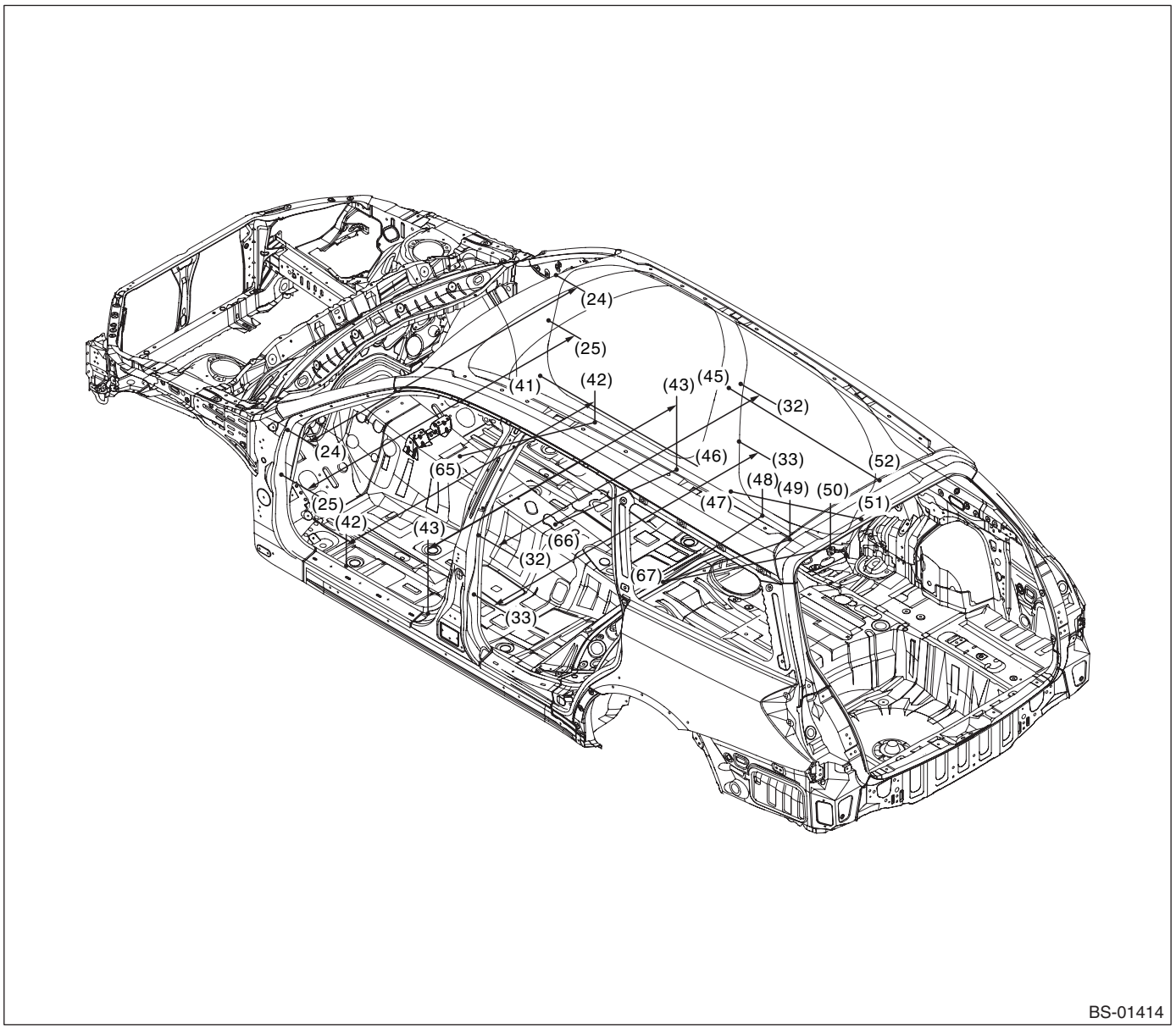


BS-00812



BS-00813

- Common for wagon and sedan, 2



(24) Weatherstrip mounting hole (symmetrical)

(25) Front door checker mounting hole (symmetrical)

(32) Weatherstrip mounting hole (symmetrical)

(33) Rear door checker mounting hole (symmetrical)

(41) Side sill cover mounting hole (symmetrical)

(42) Harness clip mounting hole (symmetrical)

(43) Harness clip mounting hole (symmetrical)

(45) Trim clip mounting hole (symmetrical)

(46) Trim clip mounting hole (symmetrical)

(47) Harness clip mounting hole (symmetrical)

(48) Harness clip mounting hole (symmetrical)

(50) Side sill cover mounting hole (symmetrical)

(51) Gauge hole (symmetrical)

(52) Trim clip mounting hole (symmetrical)

(65) Airbag unit mounting hole (body center)

(66) Hand brake mounting hole (body center)

(67) Floor mat mounting hole (body center)

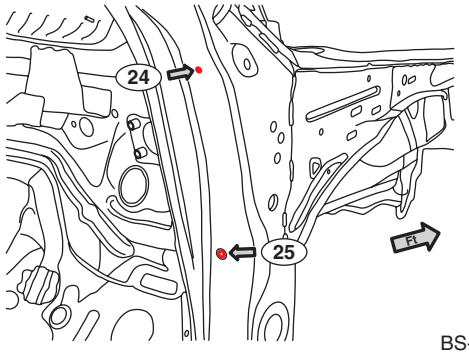
Body Reference Points

Unit: mm

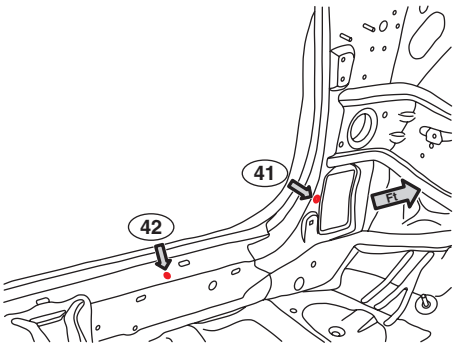
Measurement point	Datum dimension	Measurement point	Datum dimension
24 — 24	1482	43 — 43	1373
25 — 25	1476	43 — 66	693
32 — 32	1448	45 — 52	838
33 — 33	1464	47 — 51	740
41 — 46	863	48 — 67	711
42 — 42	1373	49 — 67	649
42 — 65	706	50 — 67	704

NOTE:

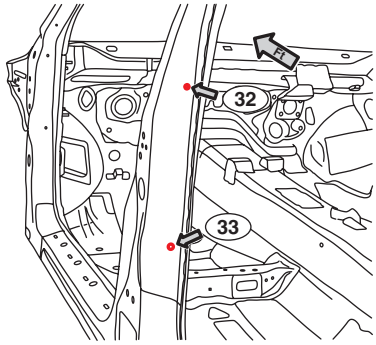
- The reference points 65, 66 and 67 are at the body center, while the other points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



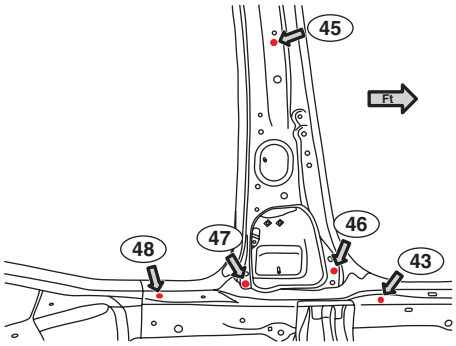
BS-00815



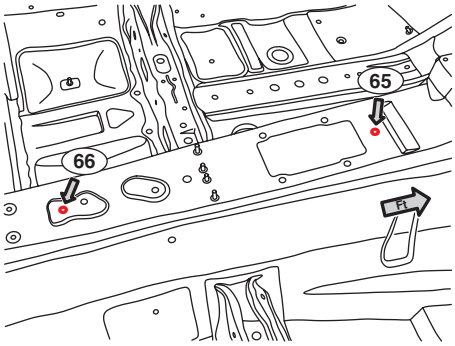
BS-00816



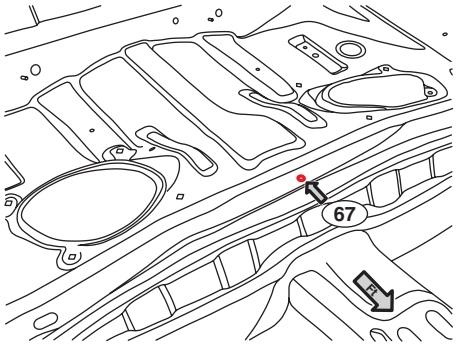
BS-00817



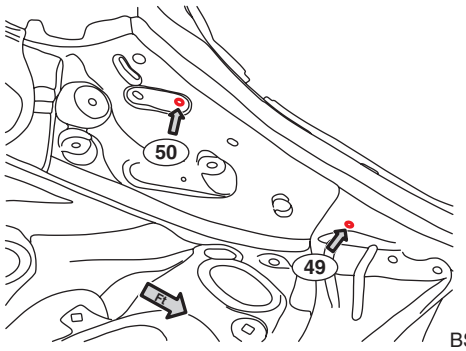
BS-00818



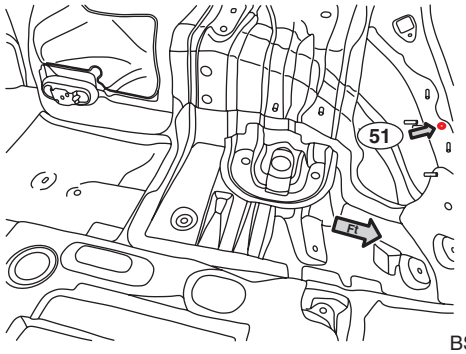
BS-00819



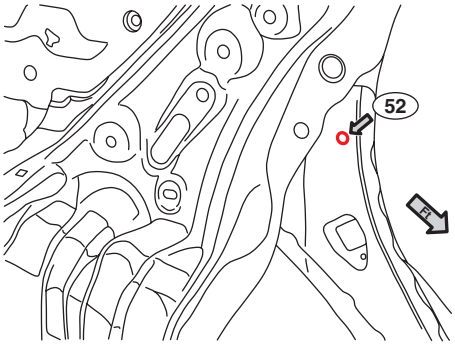
BS-00820



BS-00821

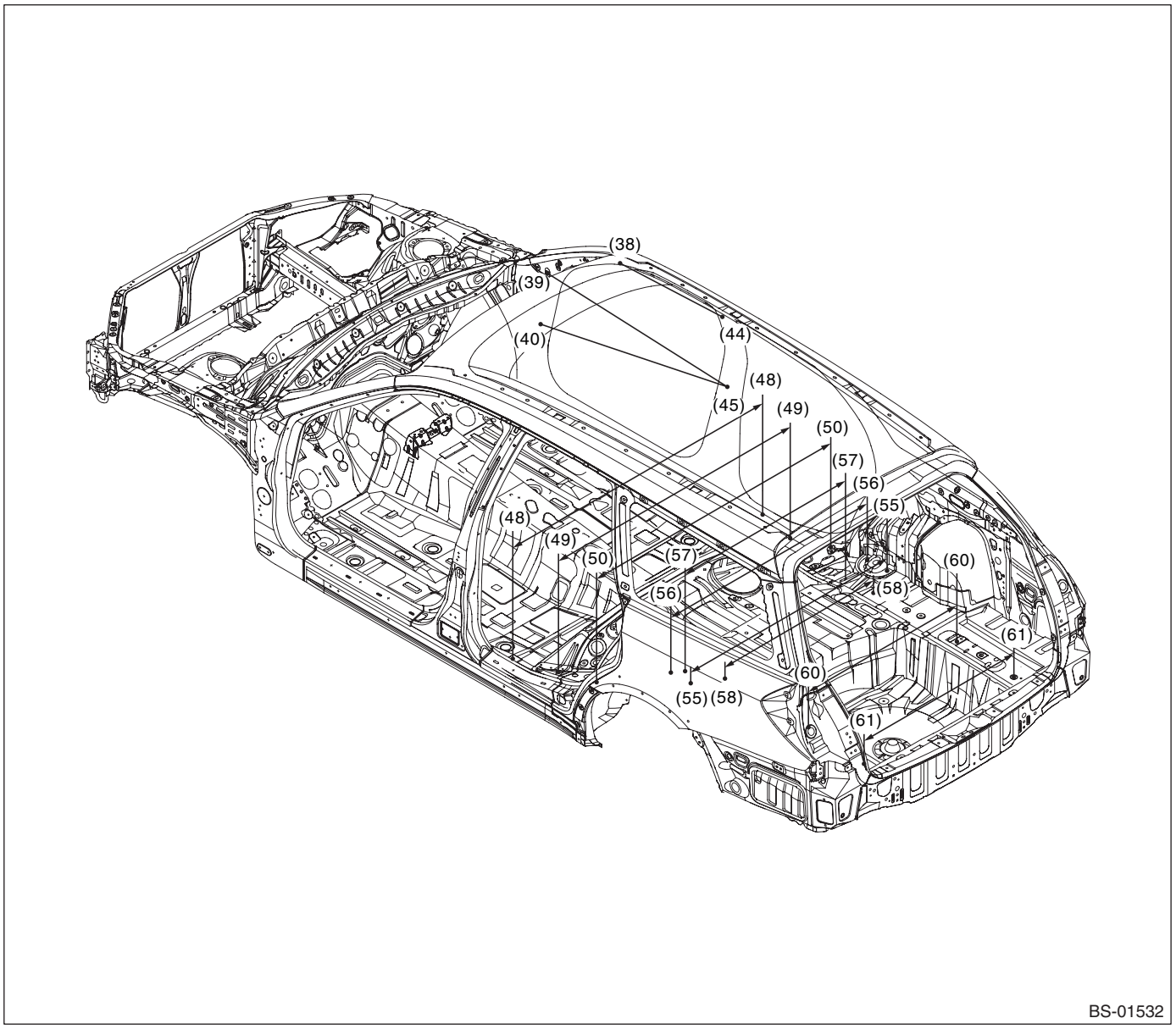


BS-00822



BS-00823

- Common for wagon and sedan, 3



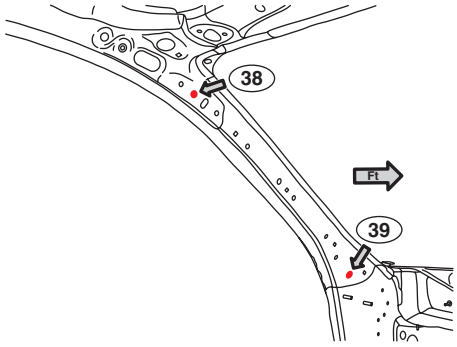
(38) Trim clip mounting hole (symmetrical)
(39) ED hole (symmetrical)
(40) Hood lock lever area stop hole (symmetrical)
(44) Trim clip mounting hole (symmetrical)
(45) Trim clip mounting hole (symmetrical)
(48) Harness clip mounting hole (symmetrical)
(49) Harness clip mounting hole (symmetrical)
(50)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

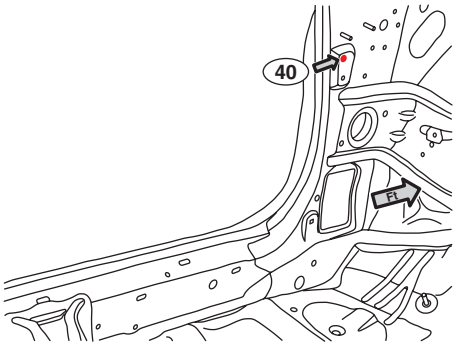
Measurement point	Datum dimension mm (in)
(55) — (55)	1,084 (42.68)
(56) — (56)	1,090 (42.91)
(57) — (57)	886 (34.88)
(58) — (58)	820 (32.28)
(60) — (60)	820 (32.28)
(61) — (61)	840 (33.07)

Body Reference Points

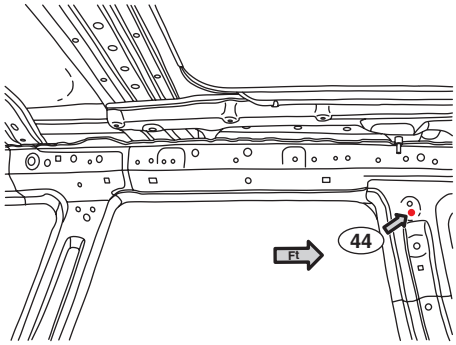
NOTE:
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



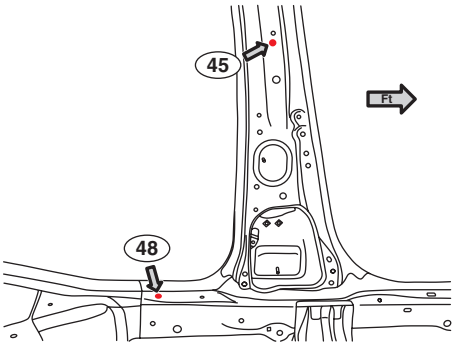
BS-00825



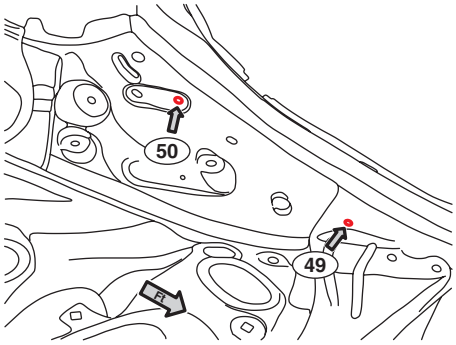
BS-00826



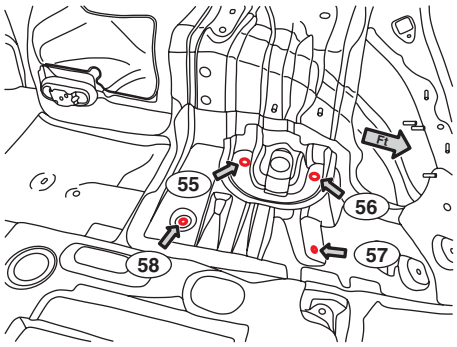
BS-00827



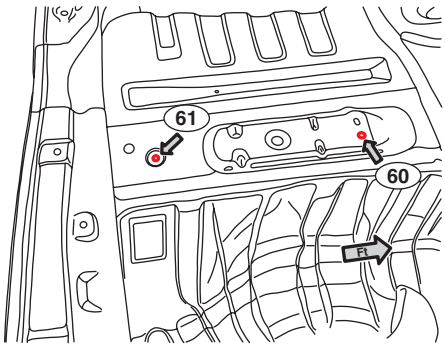
BS-00828



BS-00829



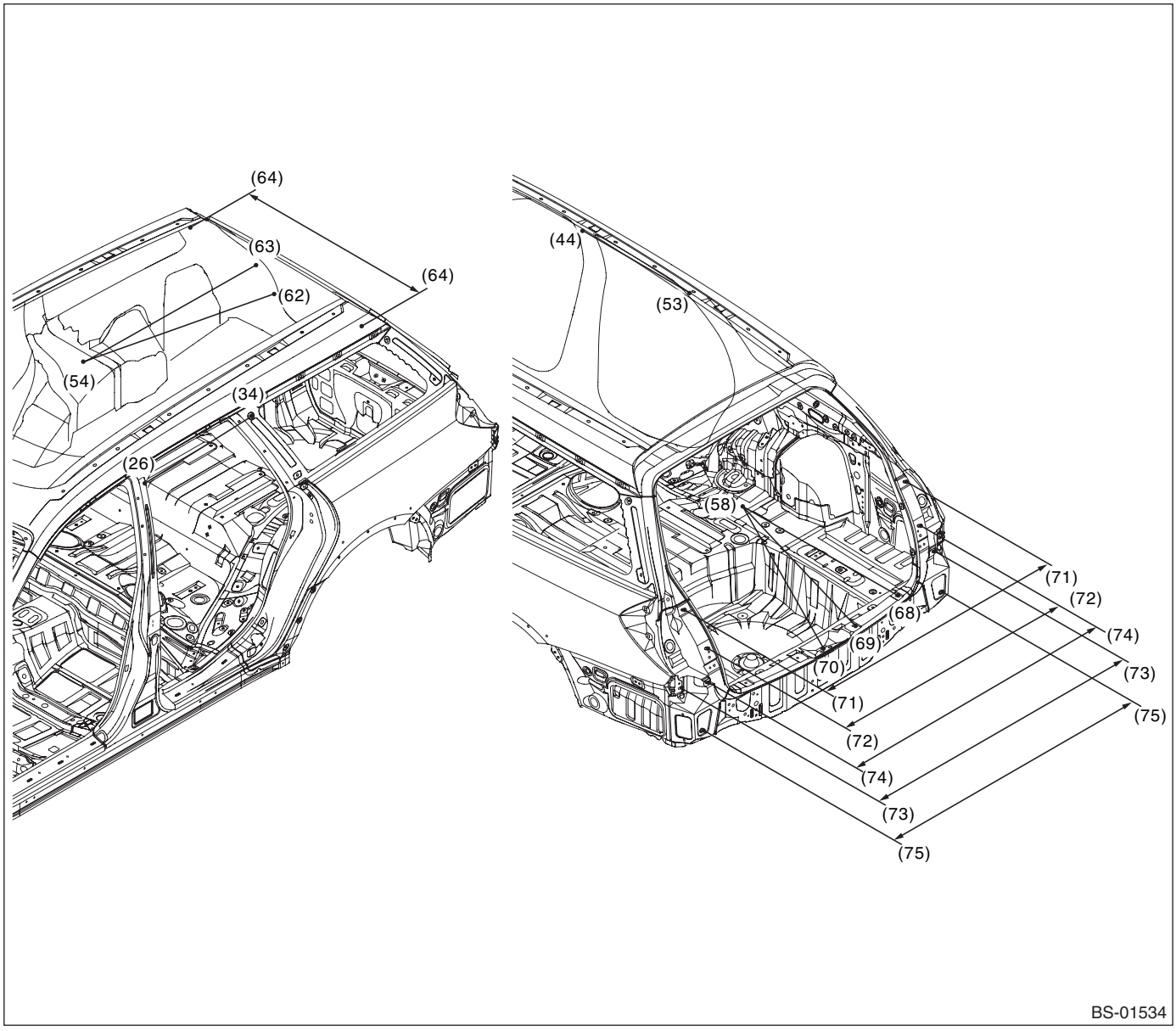
BS-01521



BS-00831

4. REAR *S906337a1404*

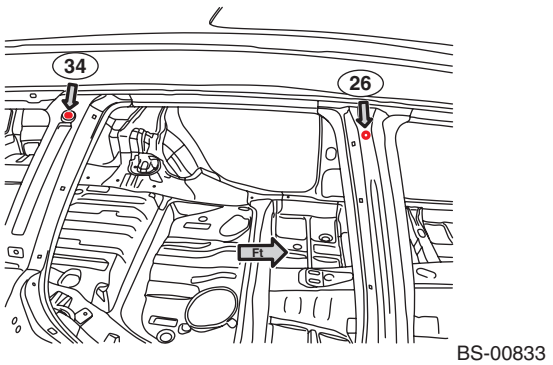
- Wagon only



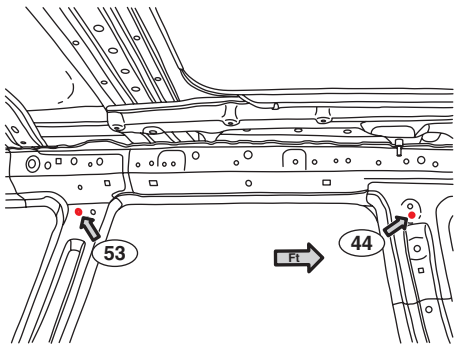
(26) Gauge hole (symmetrical)
(34) Rear quarter glass mounting hole (symmetrical)
(44) Trim clip mounting hole (symmetrical)
(53) Trim clip mounting hole (symmetrical)
(54) Rear seat striker mounting hole (symmetrical)
(58) Gauge hole (symmetrical)
(62) Trim clip mounting hole (symmetrical)
(63) Trim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

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)

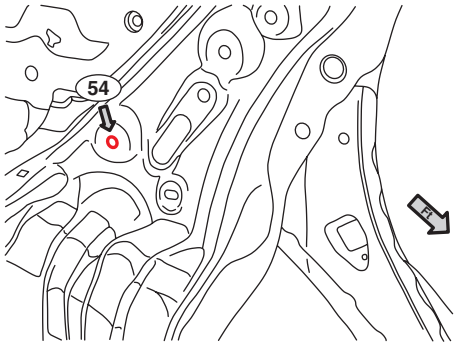
NOTE:
- The reference point (70) is at the body center, while the other points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



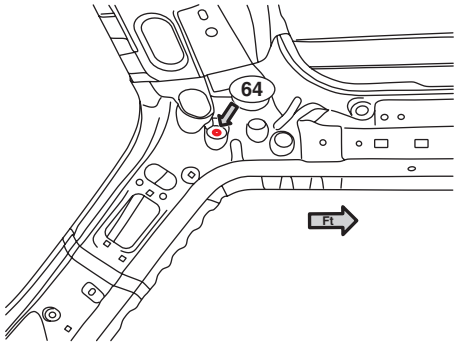
BS-00833



BS-00834

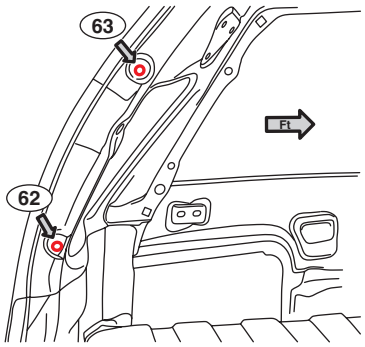


BS-00835

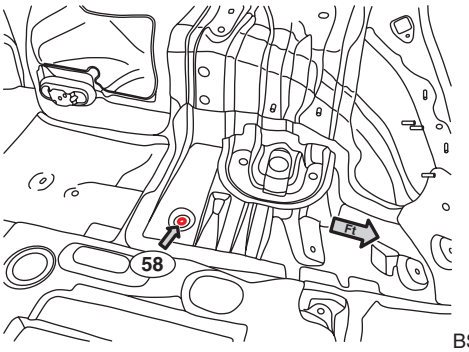


BS-00836

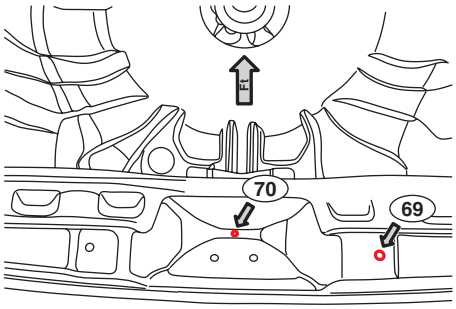
Body Reference Points



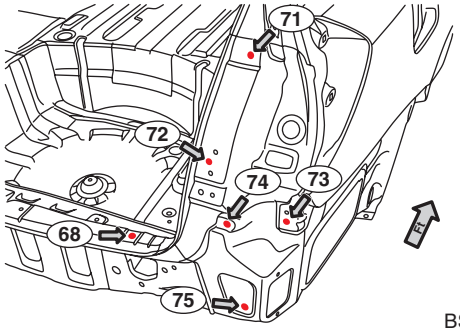
BS-00837



BS-01522

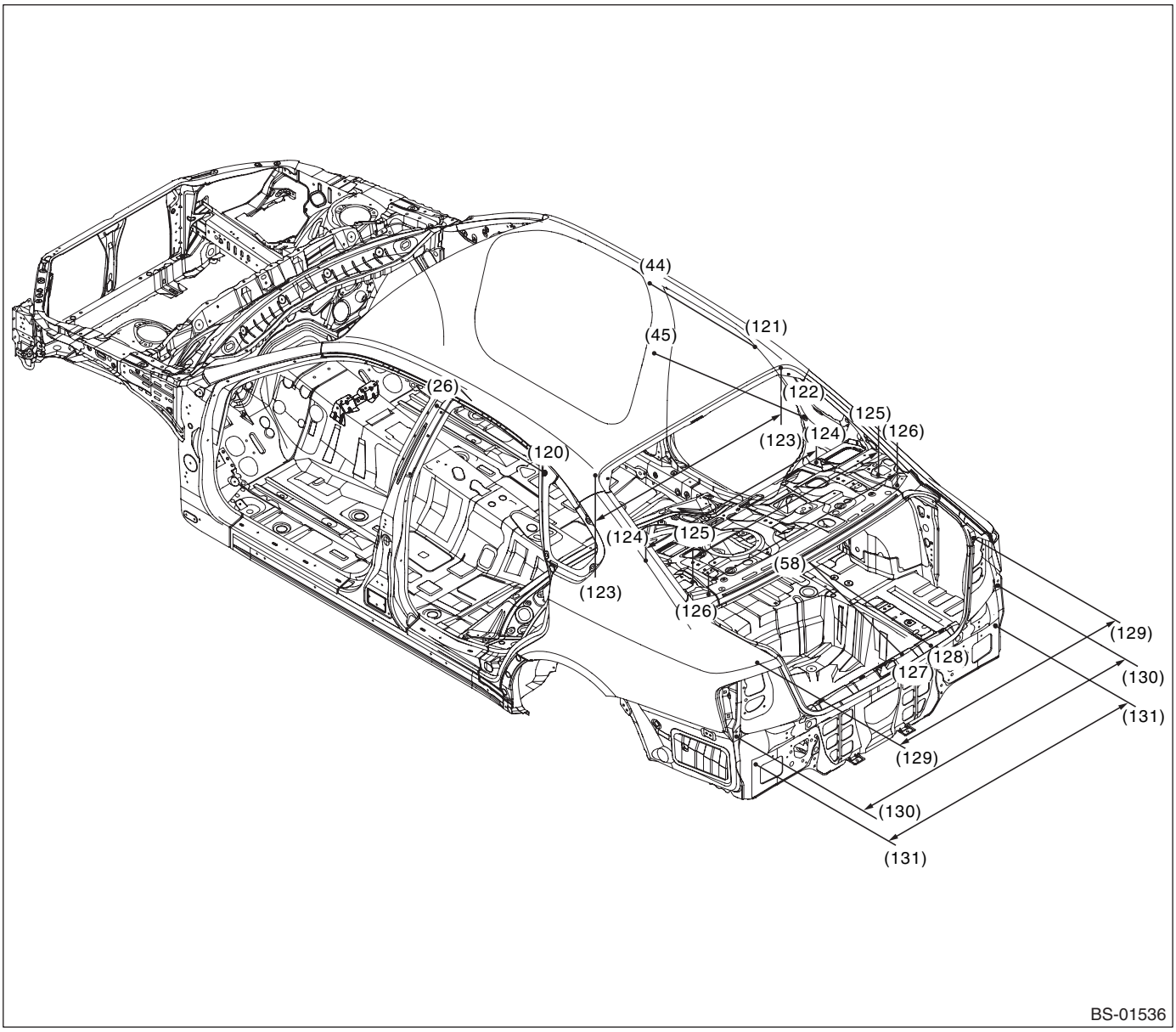


BS-00839



BS-00840

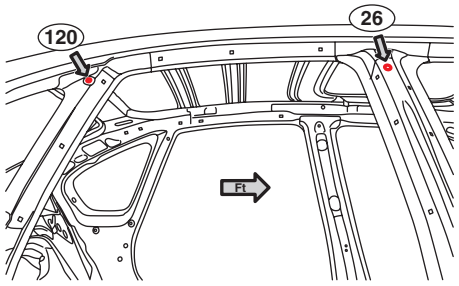
- Sedan only



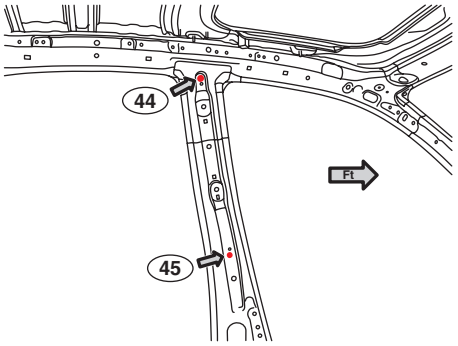
(26) Gauge hole (symmetrical)
(44) Trim clip mounting hole (symmetrical)
(45) Trim clip mounting hole (symmetrical)
(58) Gauge hole (symmetrical)
(120) Six light glass mounting hole (symmetrical)
(121) Trim clip mounting hole (symmetrical)
(122) Trim clip mounting hole (symmetrical)
(123) Sunroof drain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

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)

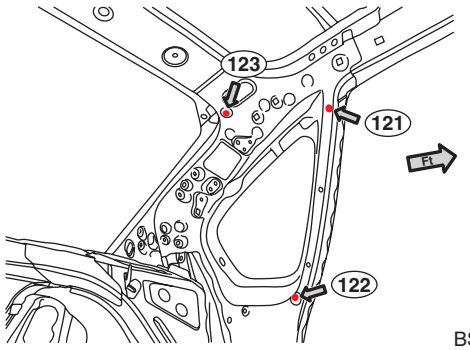
NOTE:
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



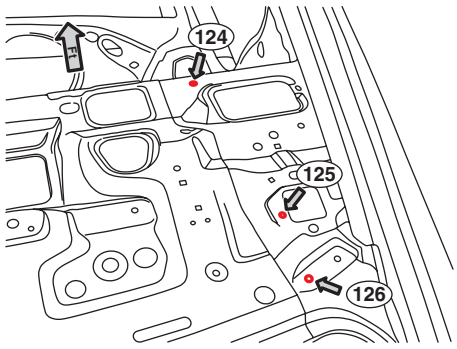
BS-00842



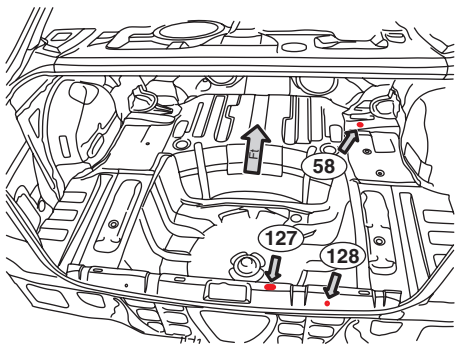
BS-00843



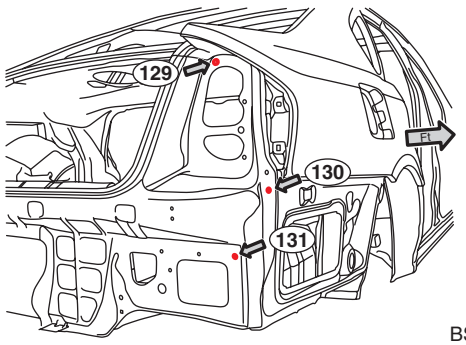
BS-00844



BS-00845

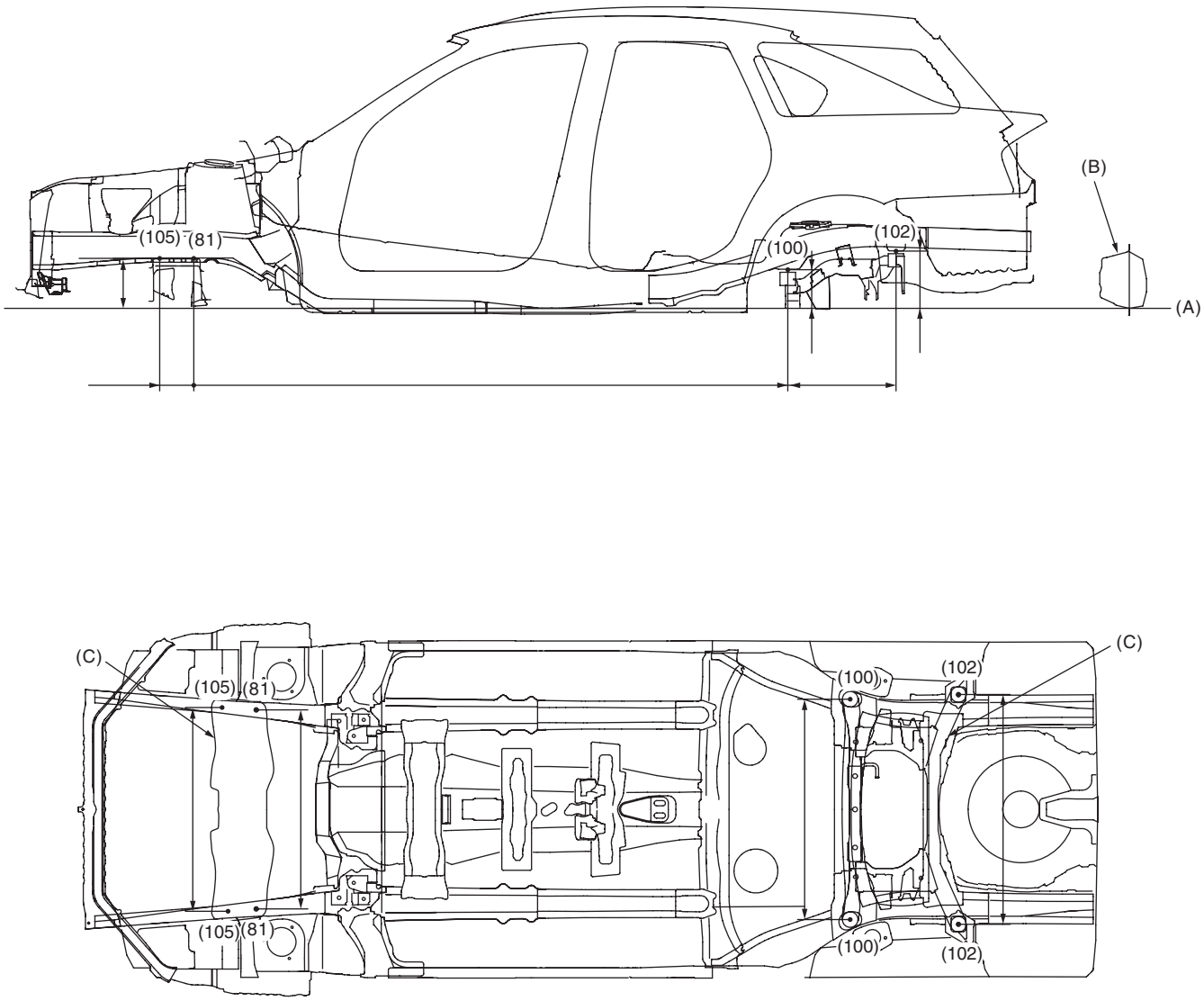


BS-01523



BS-00847

5. SUSPENSION MOUNT



BS-01418

(A) Standard line

(B) Side sill

(C) Crossmember

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

(100) Rear suspension crossmember mounting hole (symmetrical)

(102) Rear suspension crossmember mounting hole (symmetrical)

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

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:

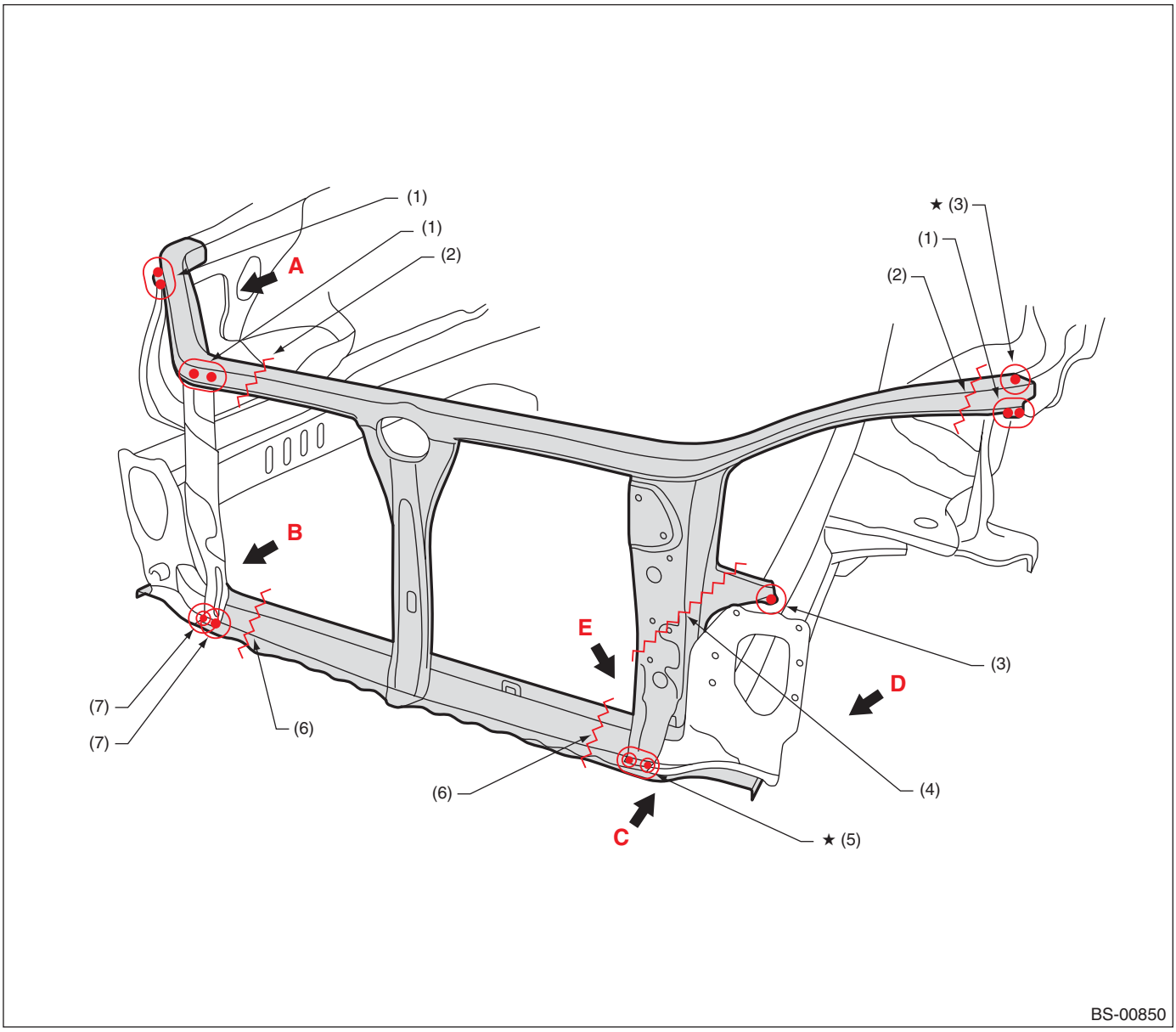
- Longitudinal dimensions are projected dimensions.
- Height dimensions are the vertical distances from the gauge point on the assumed horizontal line through the side sill flange joint (bending angle point).

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

13.Radiator Panel (total replacement)

A: REMOVAL

- **Overall view**

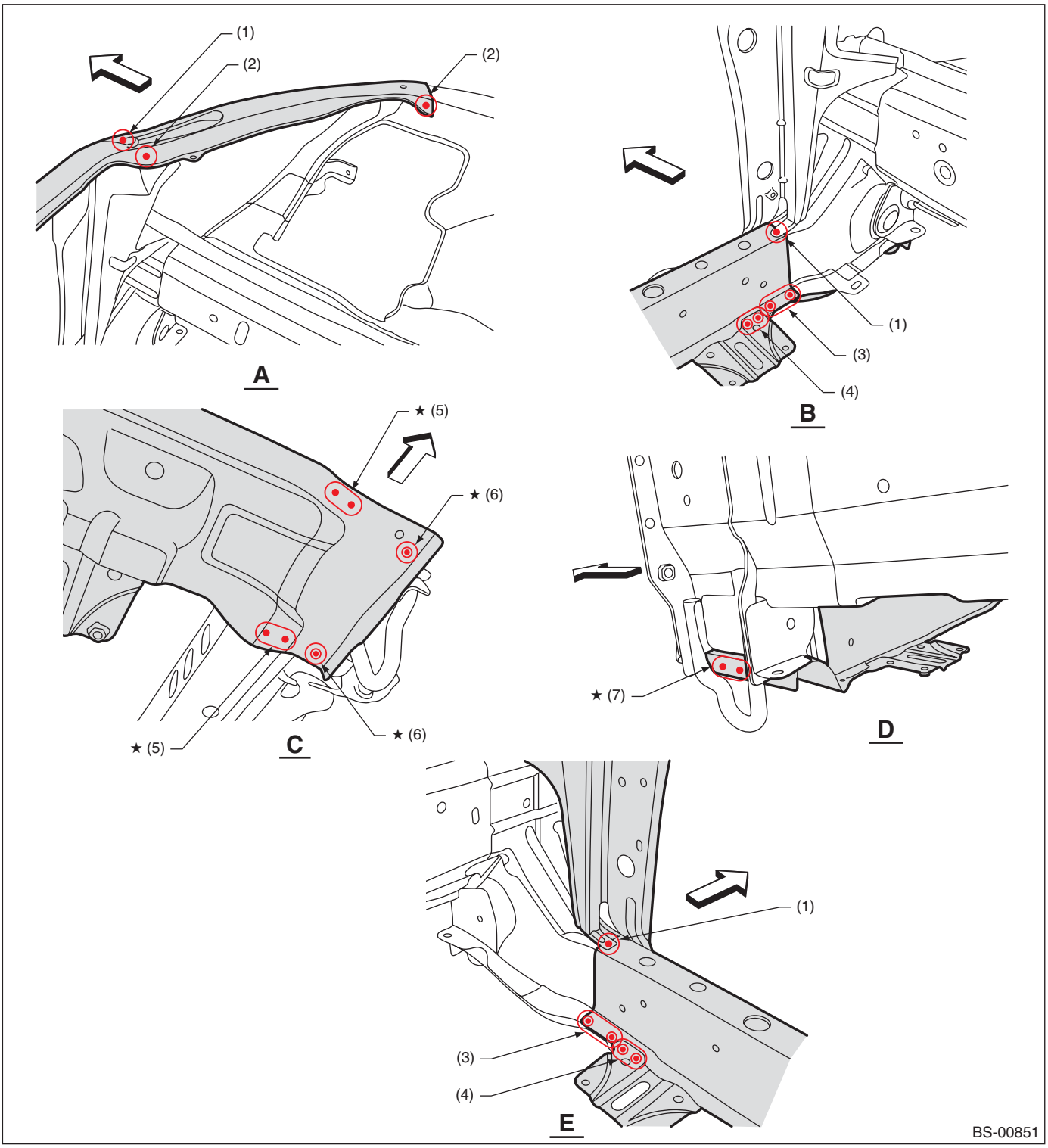


(1) 2 points (outside · 1)
(2) Rough cutting (80 mm) to make removal easier
(3) 1 point (top · 1)
(4) Rough cutting (140 mm) to make removal easier
(5) 2 points (top · 1, bottom · 1)
(6) Rough cutting (190 mm) to make removal easier
(7) 1 point (outside · 1)

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)

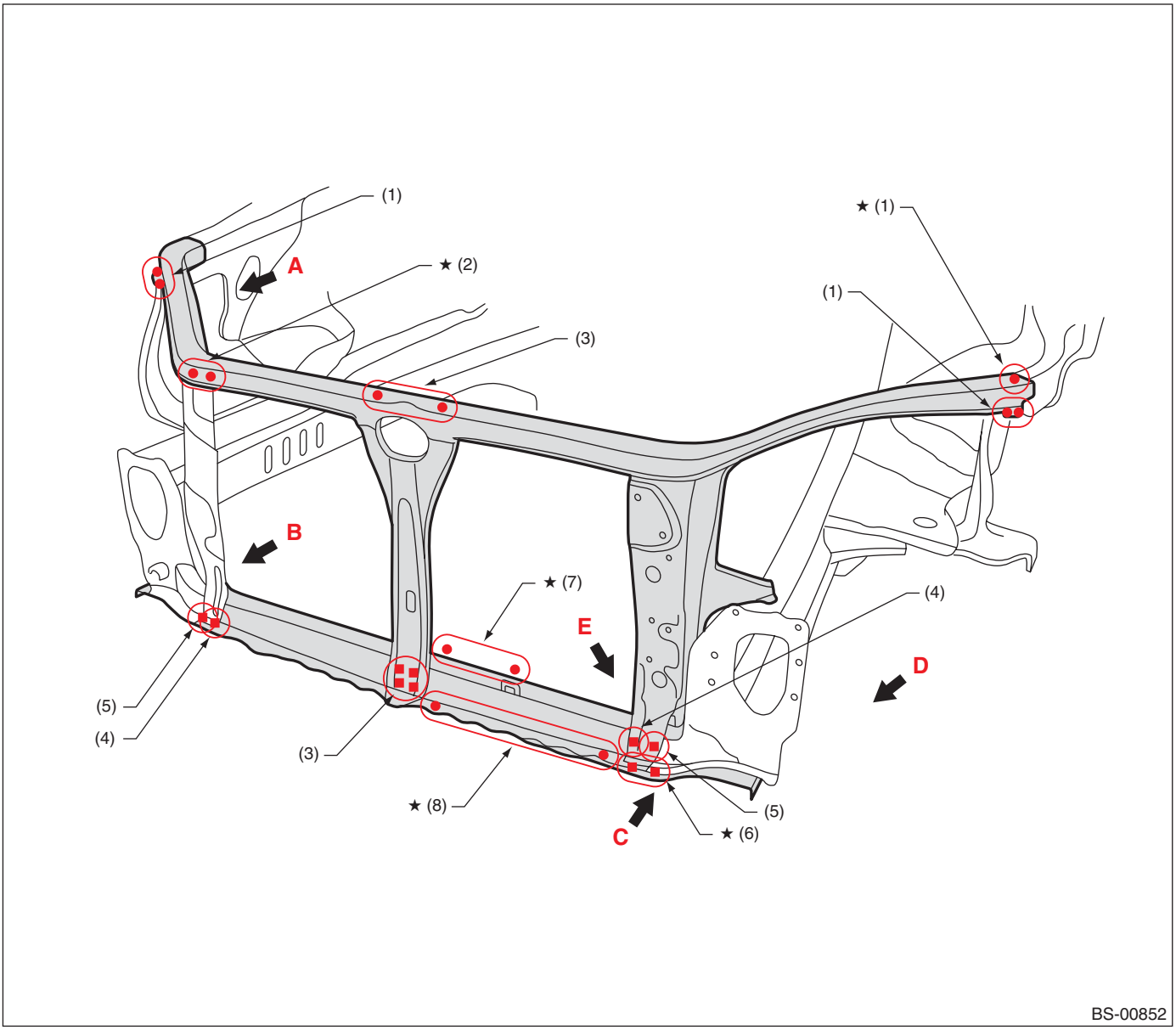
- **Views**



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

B: INSTALLATION

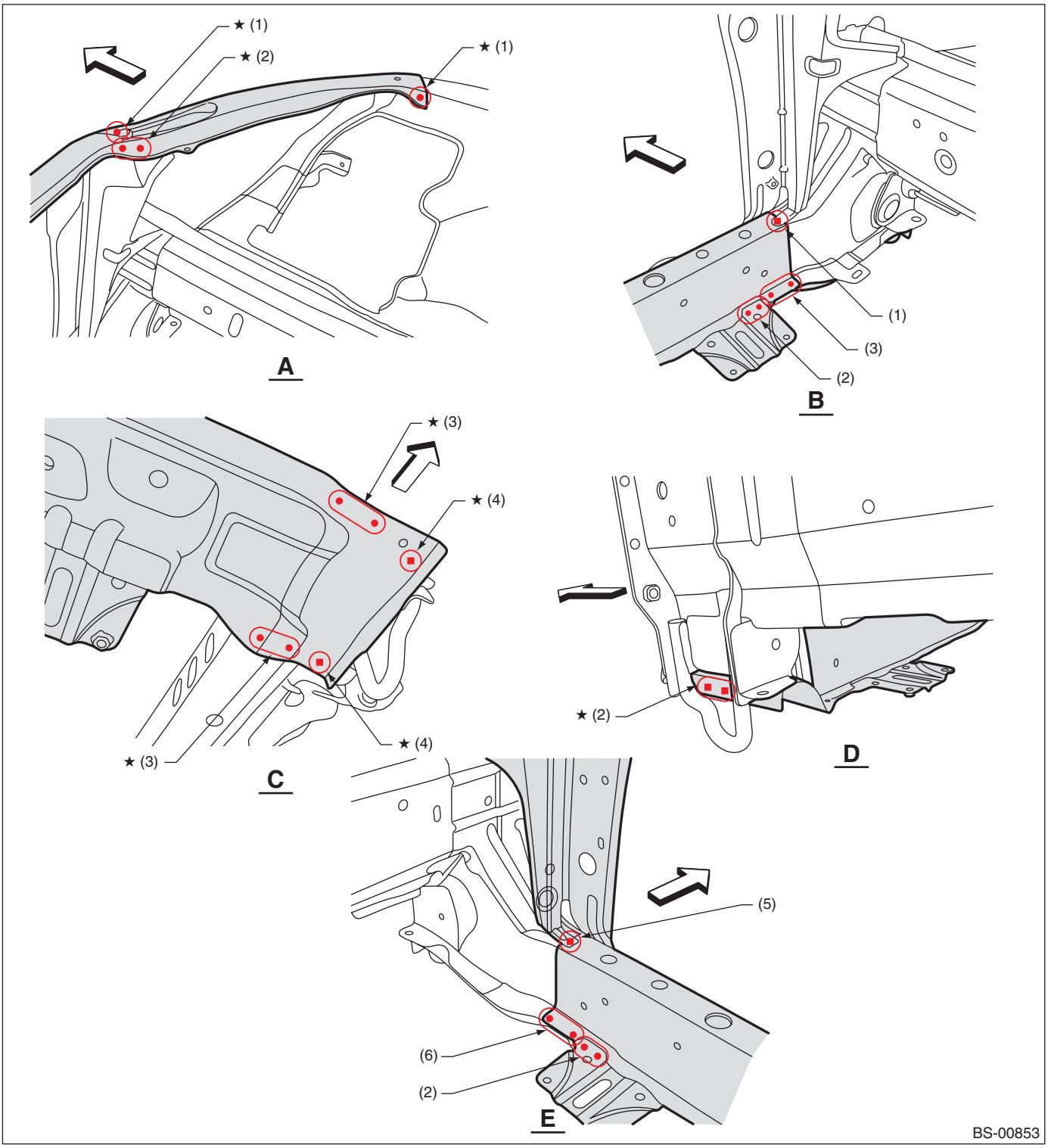
- **Overall view**



(1)	2 points	(5)	1 point (service · matching)	(7)	5 points
(2)	3 points	(6)	2 points (service · both surface plug)	(8)	10 points
(3)	4 points				
(4)	1 point				

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

- **Views**

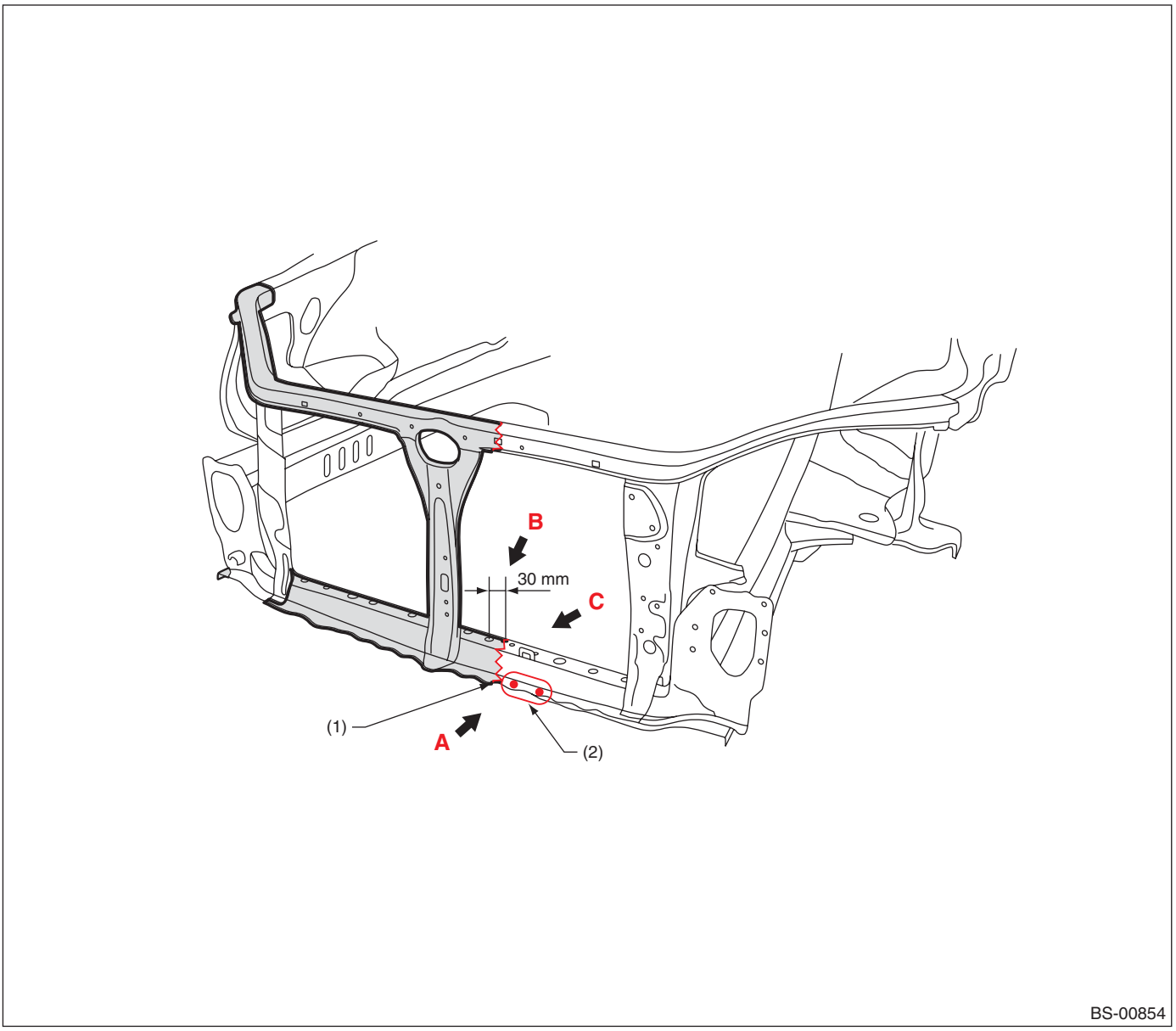


(1) 1 point
(2) 2 points
(3) 3 points
(4) 1 point (service)
(5) 1 point (service · matching)
(6) 4 points

14.Radiator Panel (partial replacement)

A: REMOVAL

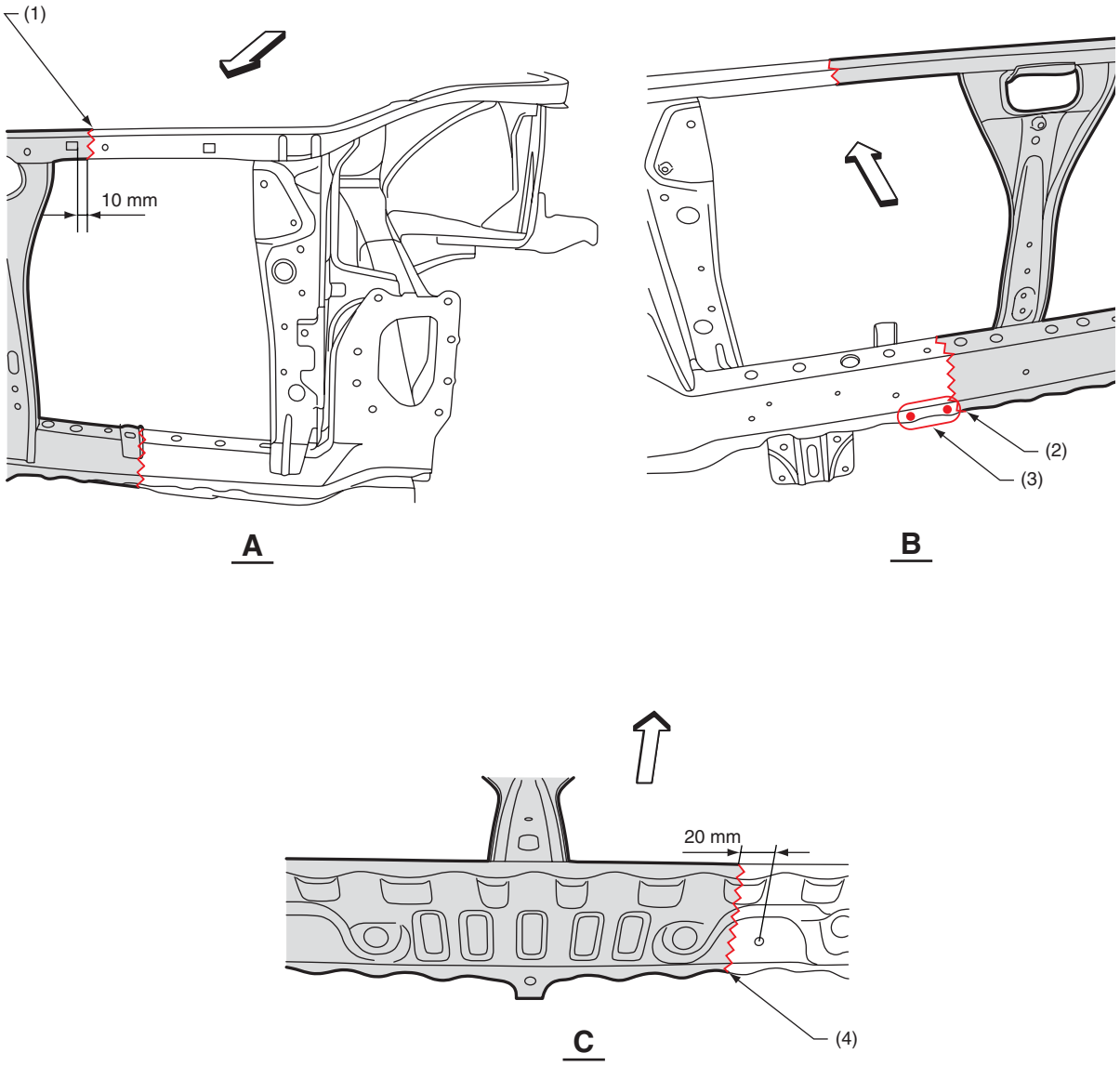
- **Overall view**



(1) Rough cutting (280 mm) to make removal easier

(2) 3 points (top · 1)

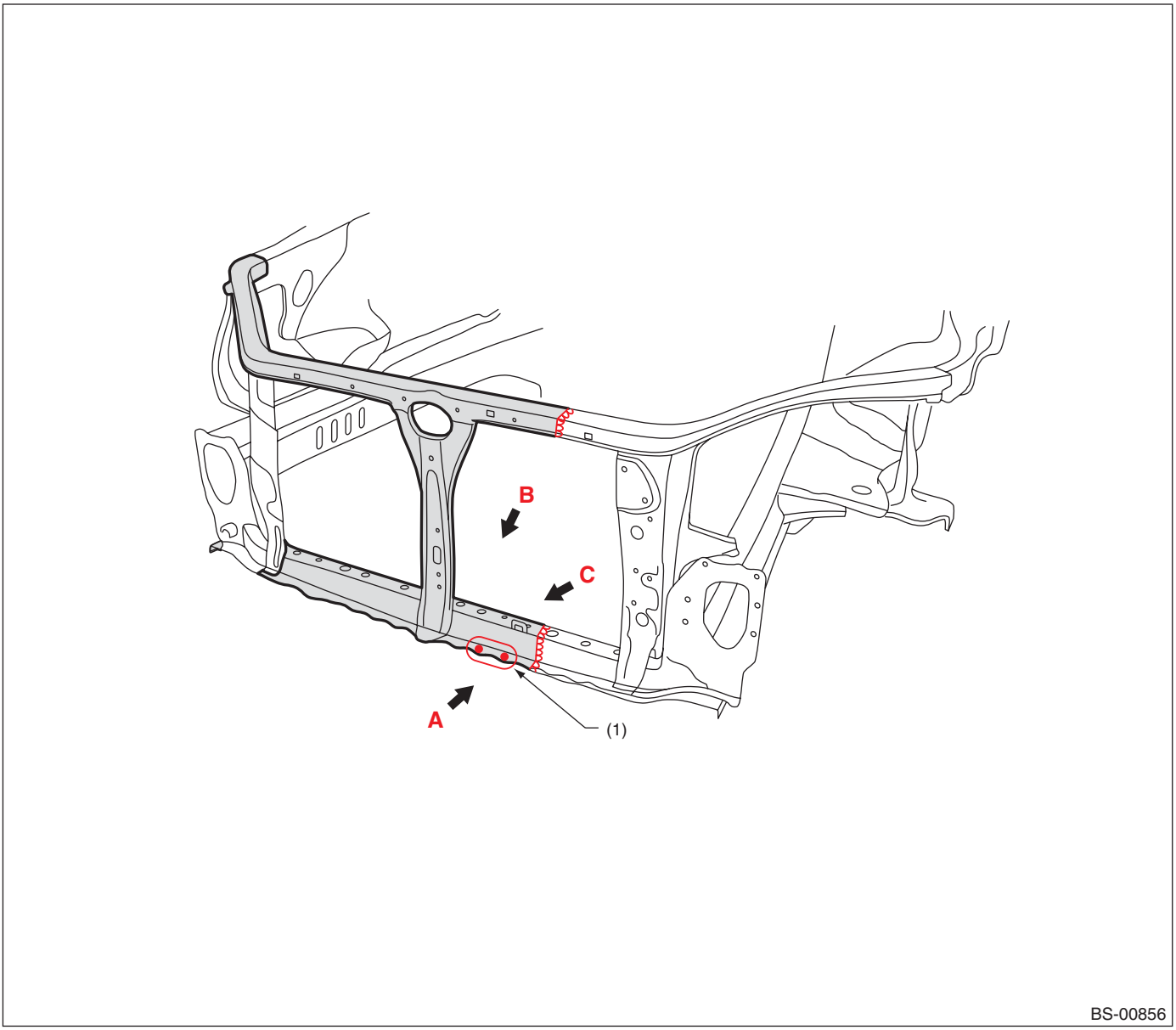
- **Views**



(1) Rough cutting (80 mm) to make removal easier
(2) Rough cutting
(3) 2 points
(4) Rough cutting (110 mm) to make removal easier

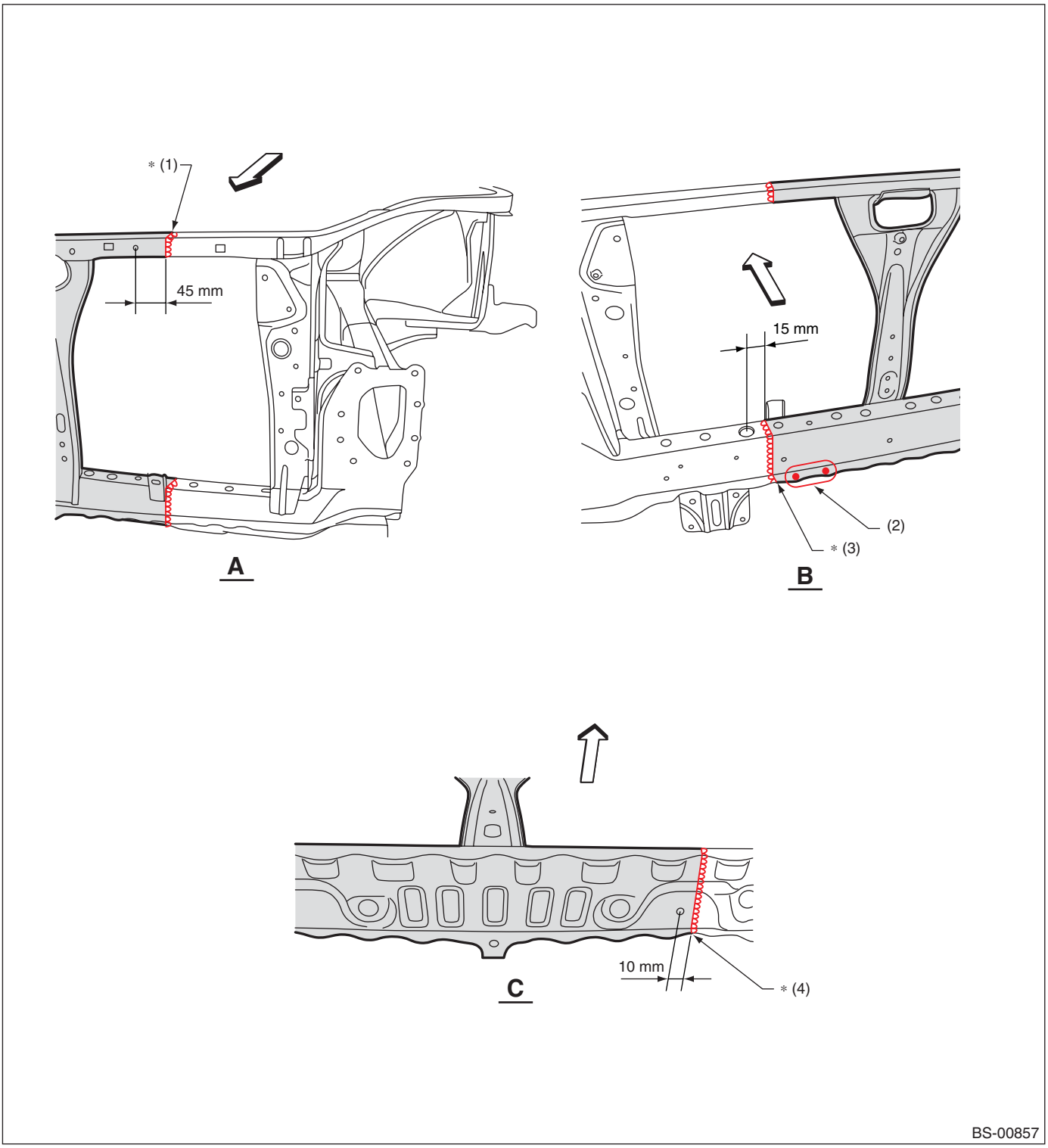
B: INSTALLATION

- **Overall view**



(1) 4 points

- **Views**



(1) 1 point (both face plug) (80 mm)
(2) 3 points
(3) 1 point (180 mm)
(4) 1 point (110 mm)

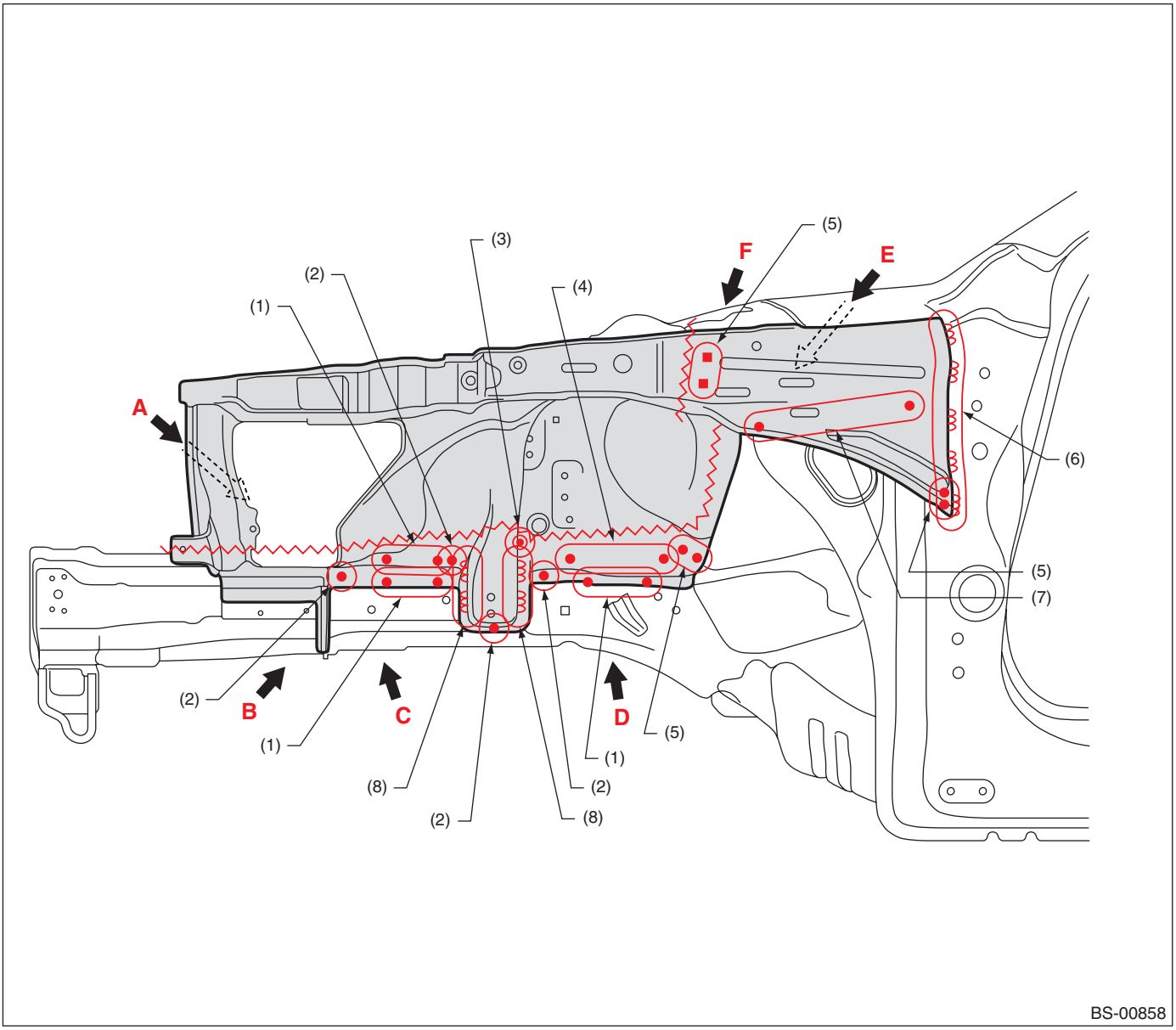
For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

15.Front Wheel Apron (total replacement)

A: REMOVAL

1) Radiator panel removal condition

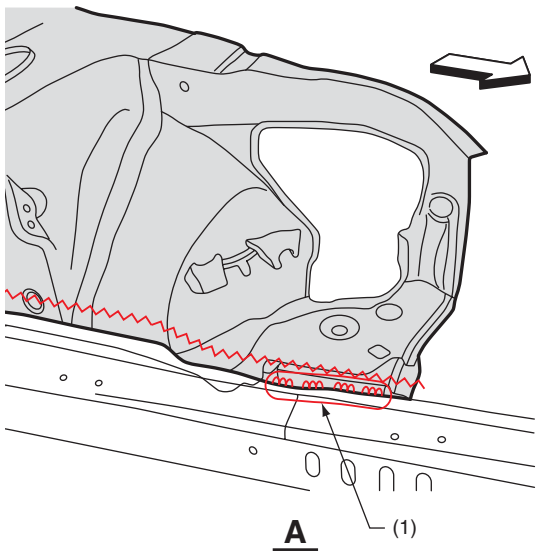
- **Overall view**

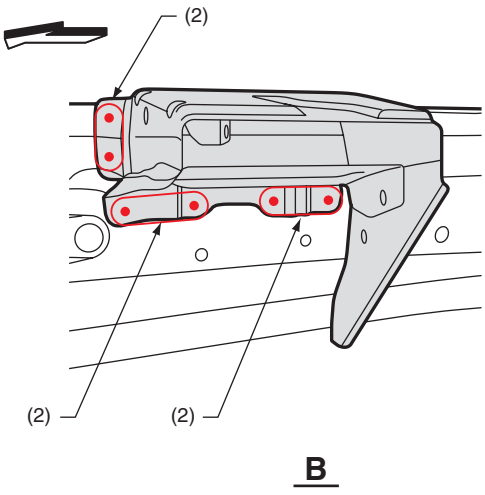


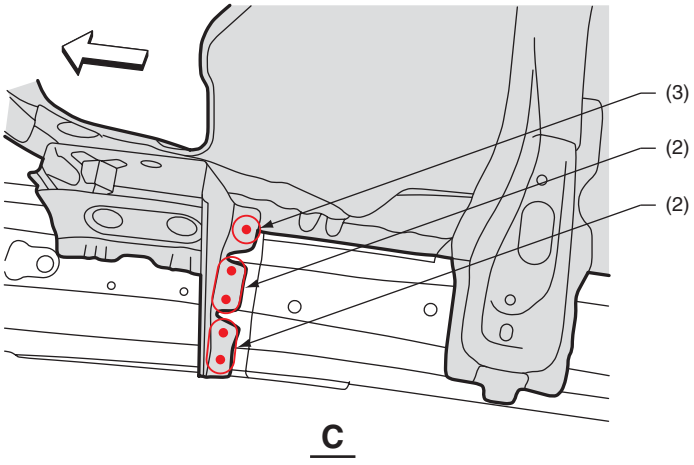
(1) 3 points (outside · 1)
(2) 1 point (outside · 1)
(3) 1 point (outside · 2)
(4) 6 points (outside · 1)
(5) 2 points (outside · 1)
(6) 5 points (outside · 1, belt sander)
(7) 7 points (outside · 1)
(8) 2 points (outside · 1, belt sander)

Front Wheel Apron (total replacement)

- **Views 1**





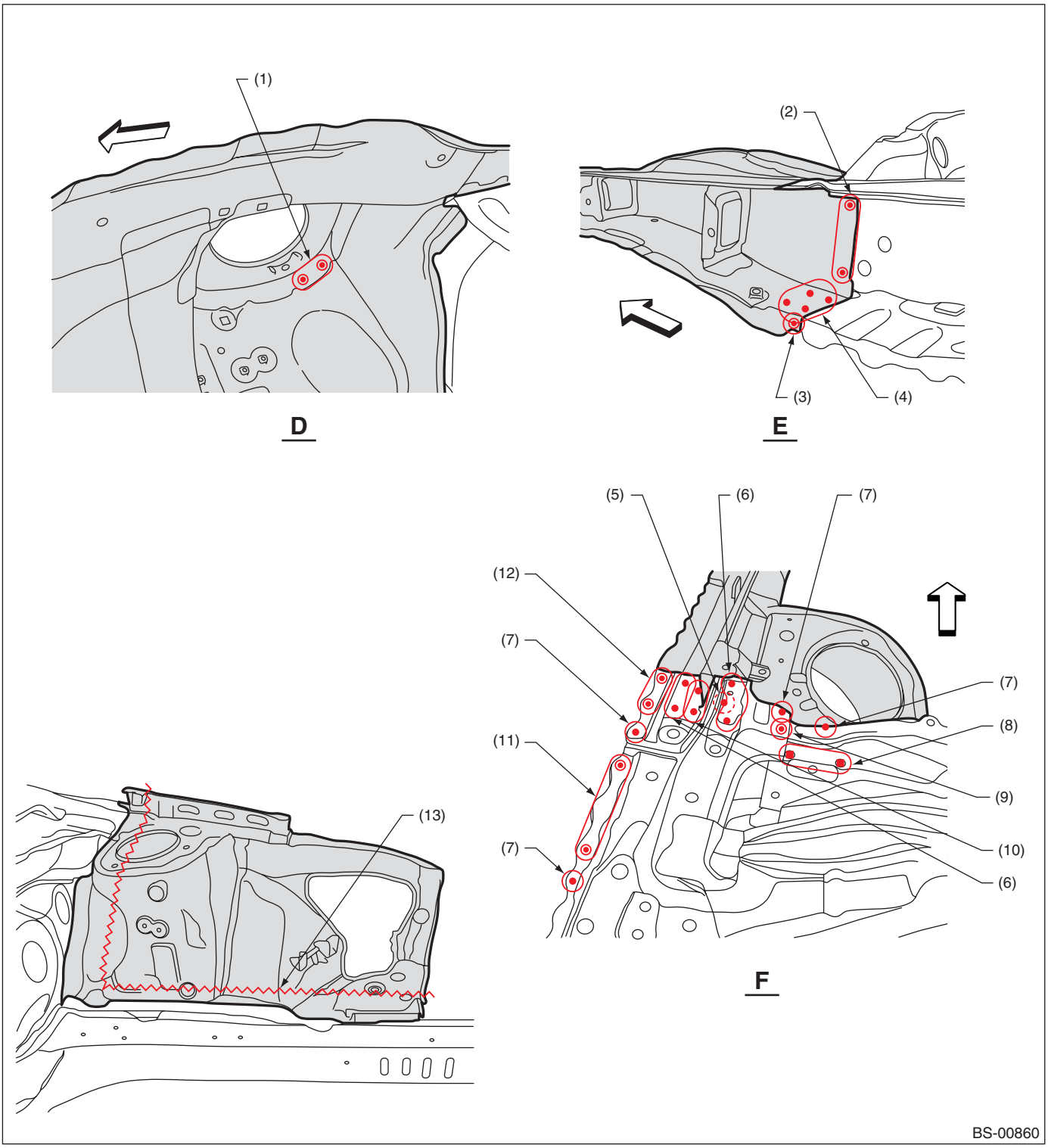


BS-00859

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

Front Wheel Apron (total replacement)

- **Views 2**

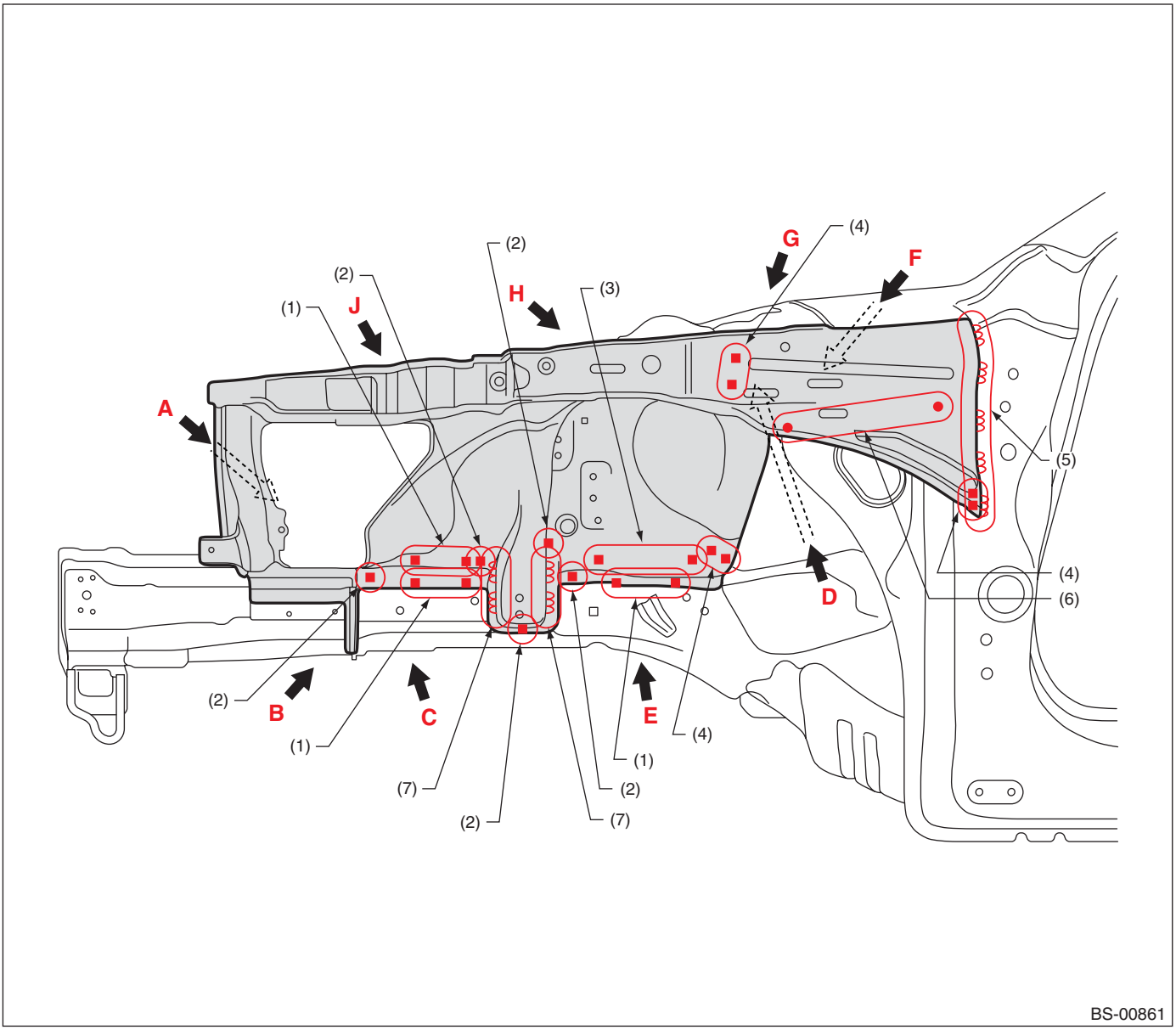


(1) 2 points (inside · 2, belt sander)
(2) 3 points (outside · 2)
(3) 1 point (outside · 1)
(4) 4 points (bottom · 1)
(5) 1 point (inside · 1, belt sander)
★ hidden hit point
(6) 3 points (top · 1)
(7) 1 point (top · 1)
(8) 2 point plug weld
(9) 1 point (top · 2)
(10) 2 points (top · 1)
(11) 3 points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

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

B: INSTALLATION

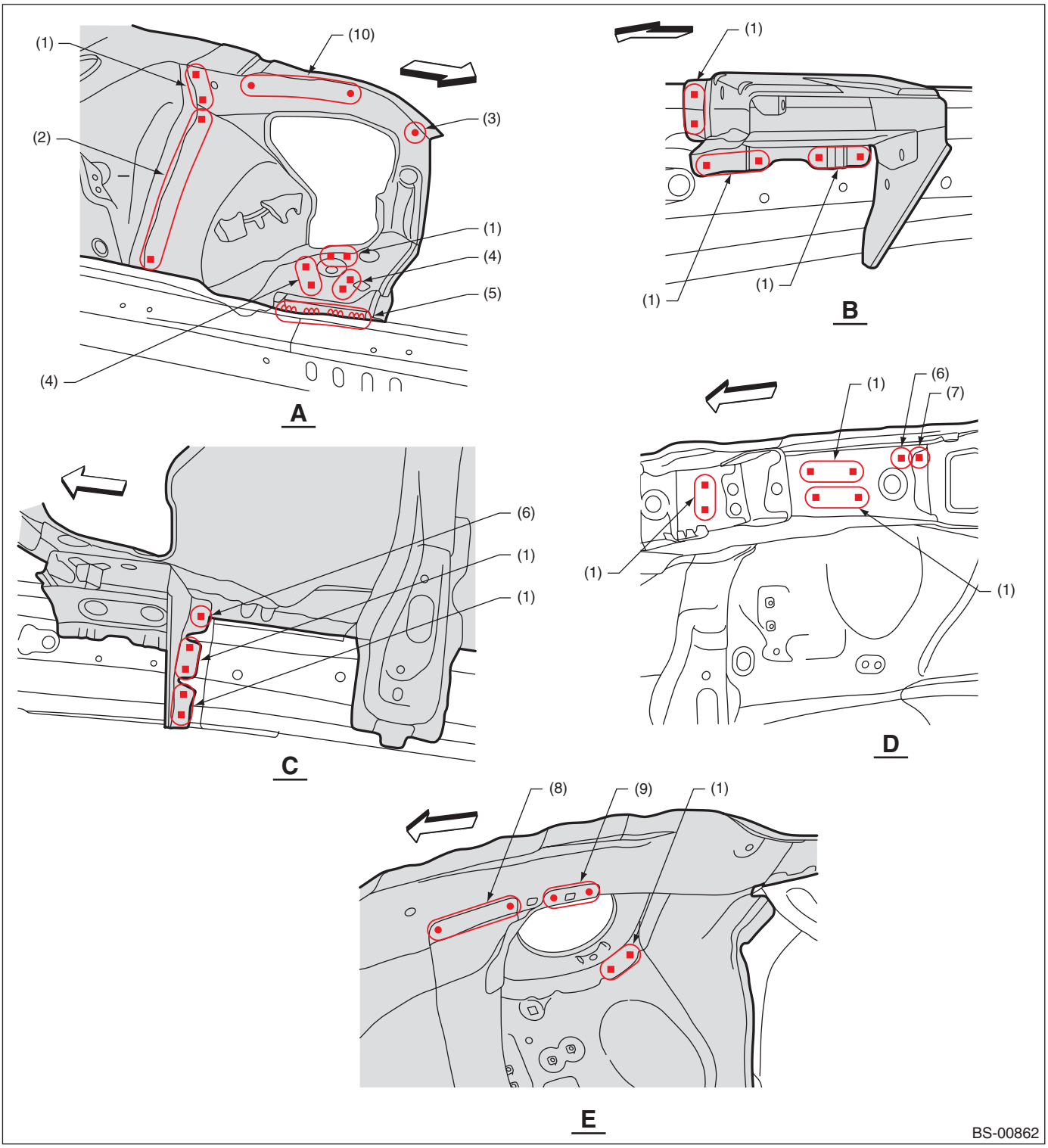
- **Overall view**



(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)

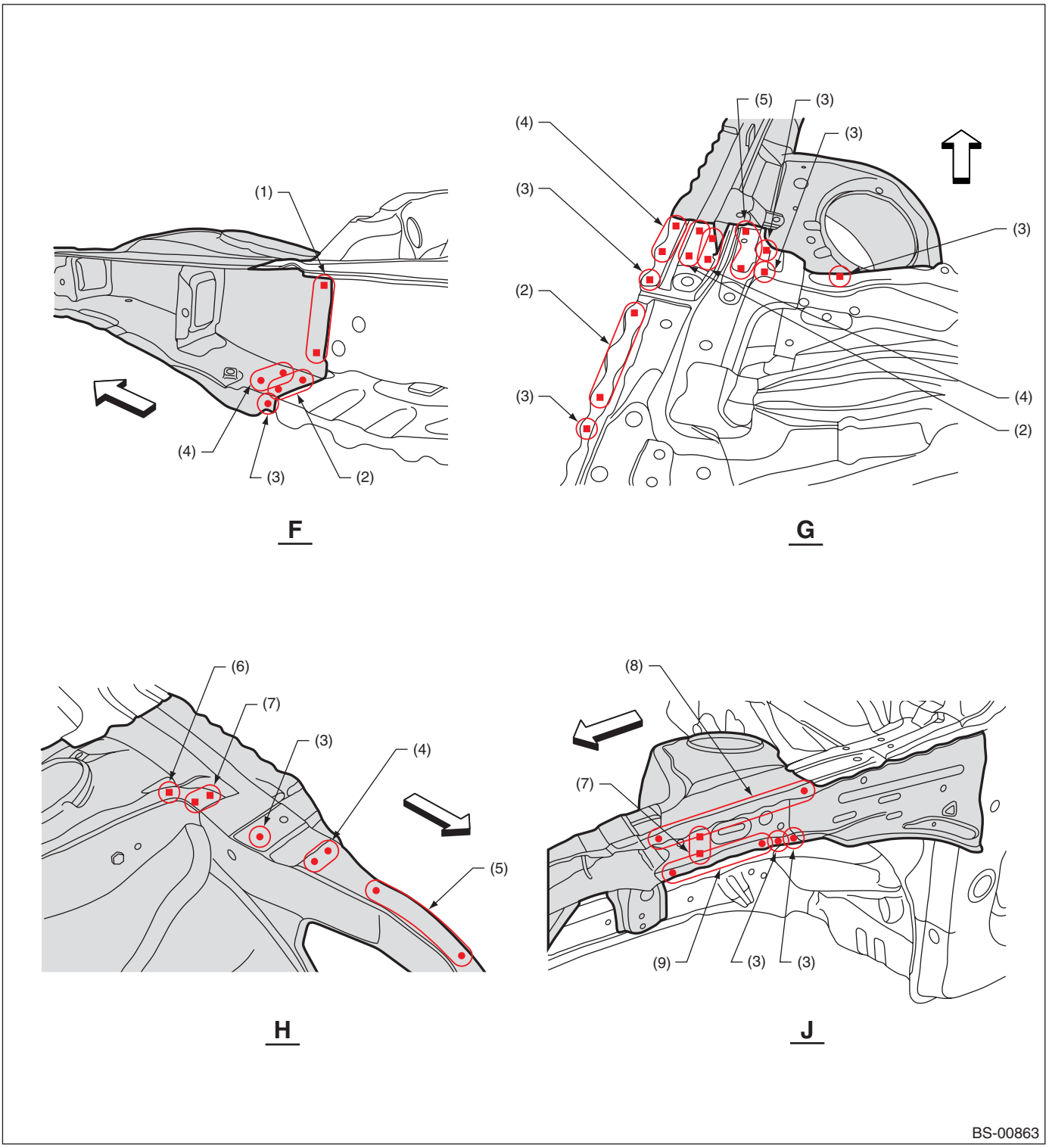
Front Wheel Apron (total replacement)

- **Views 1**



(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

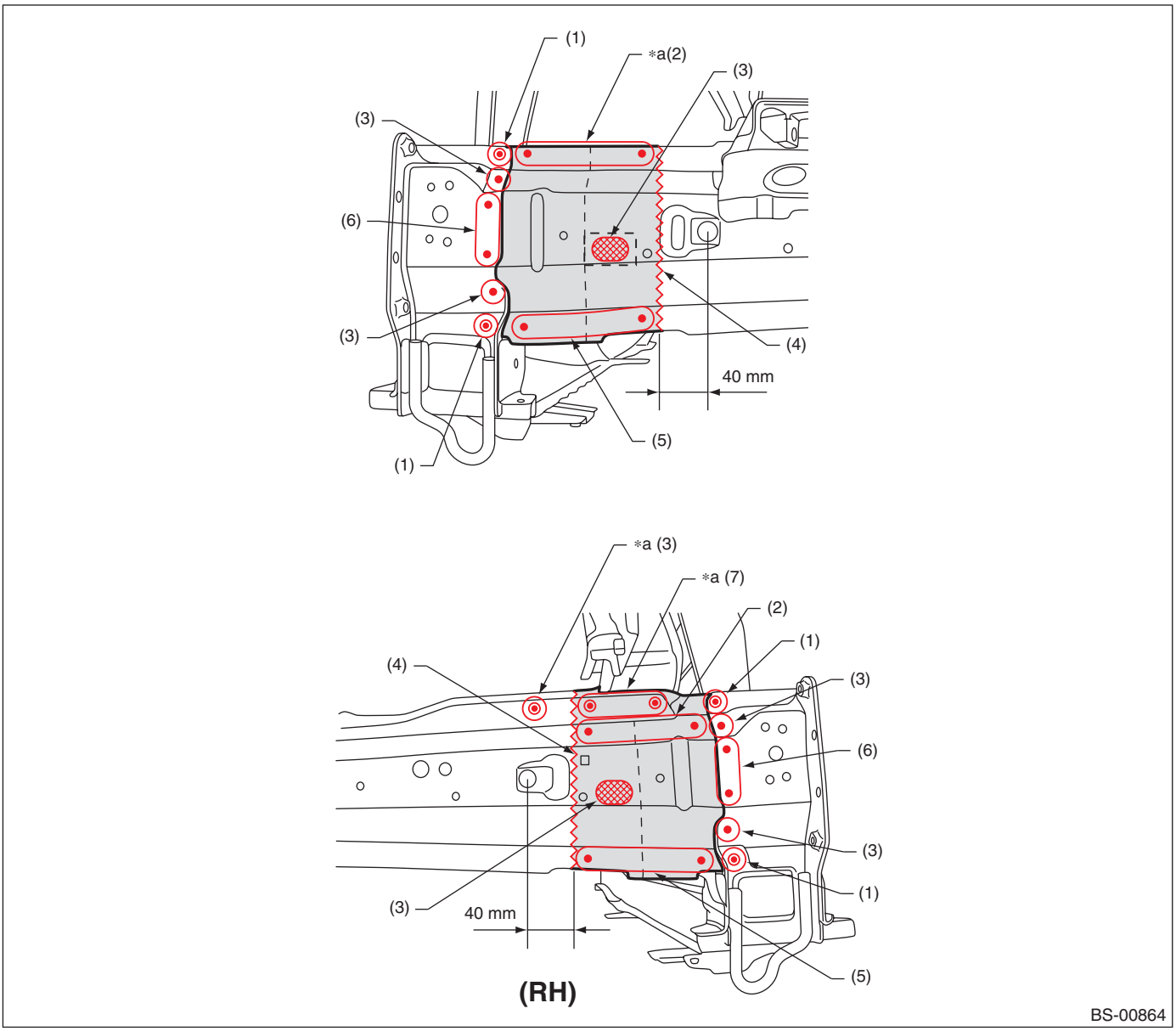
- **Views 2**



(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

16.Closing Plate (partial replacement)

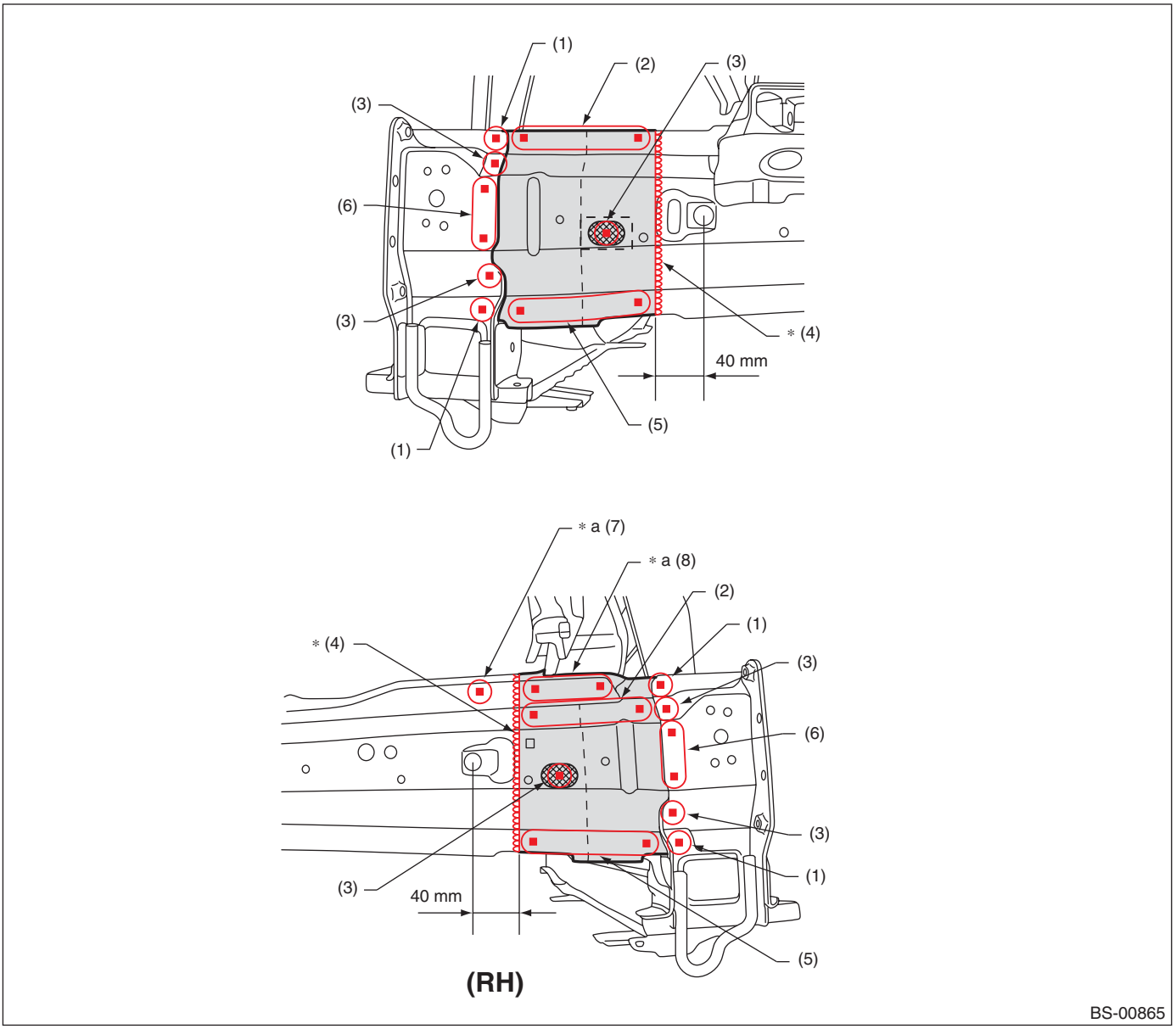
A: REMOVAL



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

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

B: INSTALLATION



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

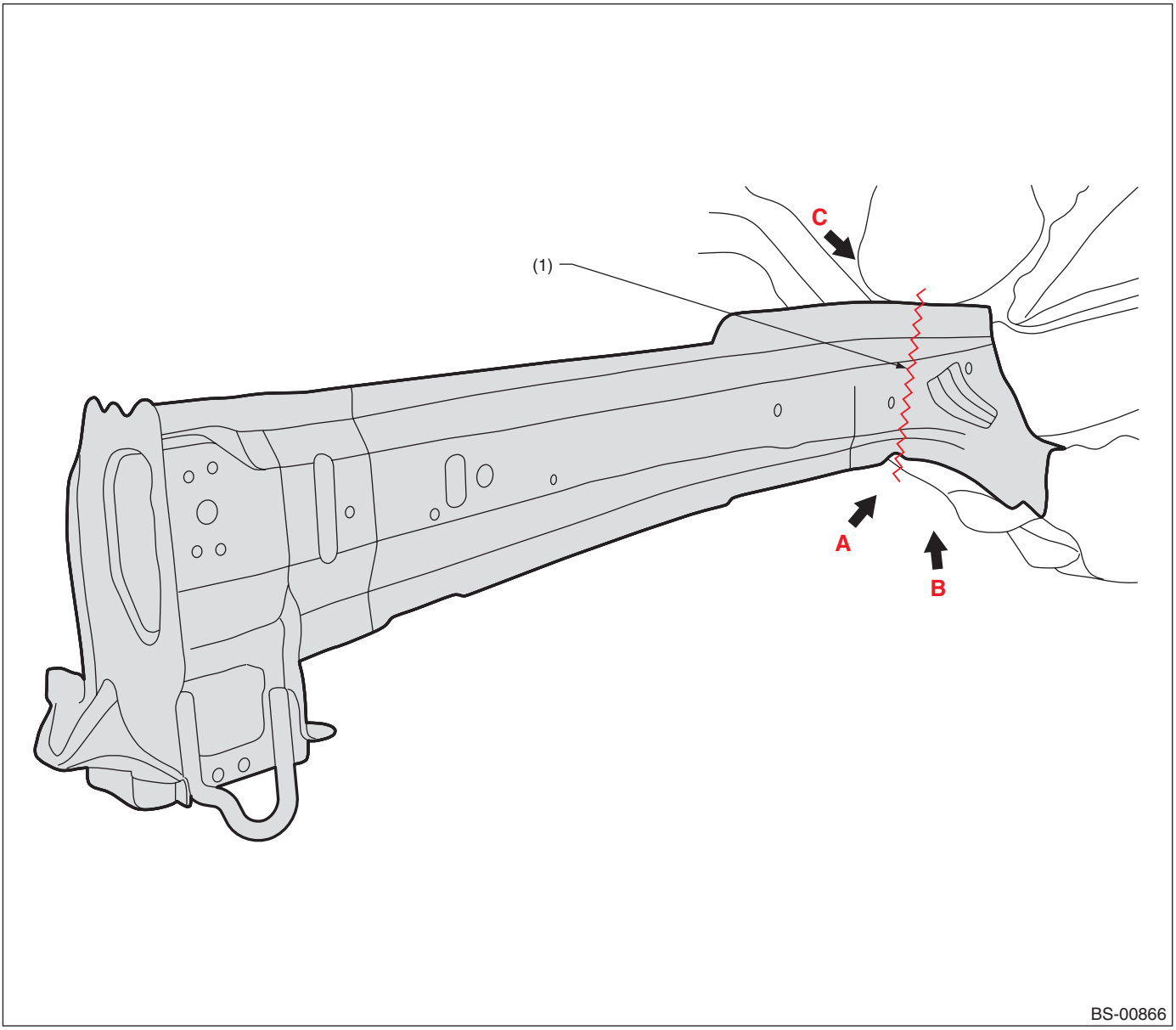
For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

17.Frame Side Front (partial replacement)

A: REMOVAL

1) Radiator panel and front wheel apron removal condition

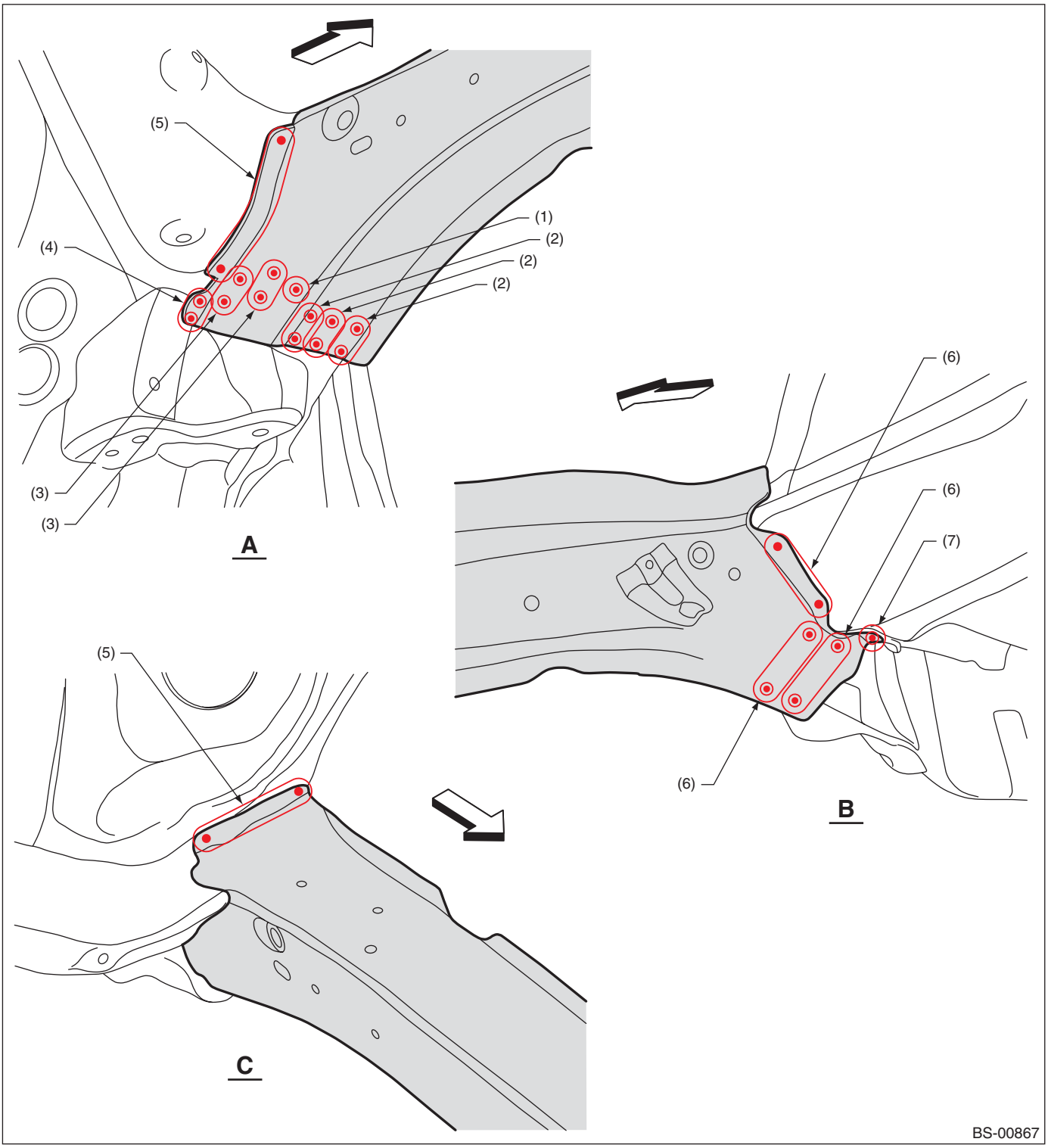
- **Overall view**



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

Frame Side Front (partial replacement)

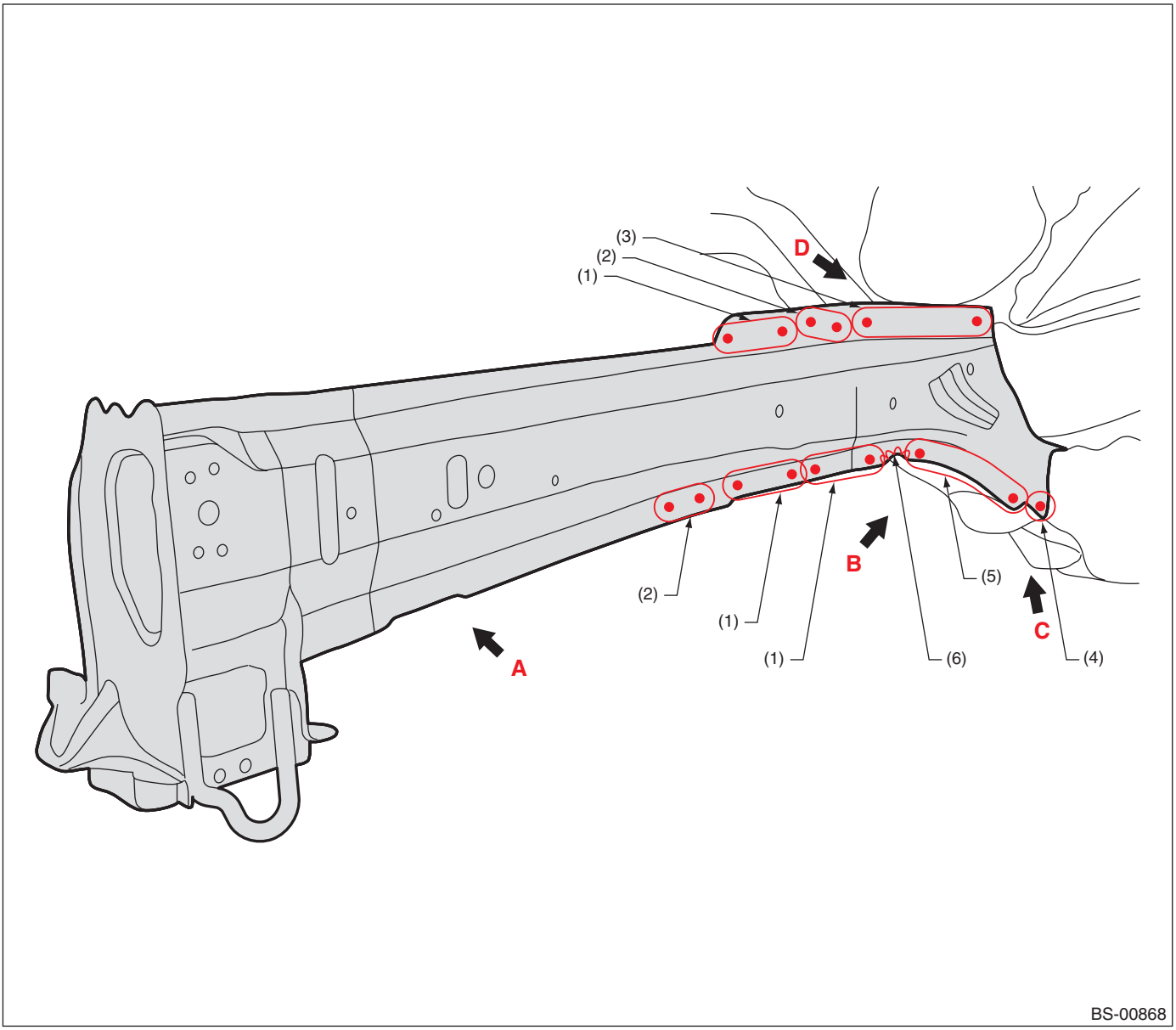
- **Views**



(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)

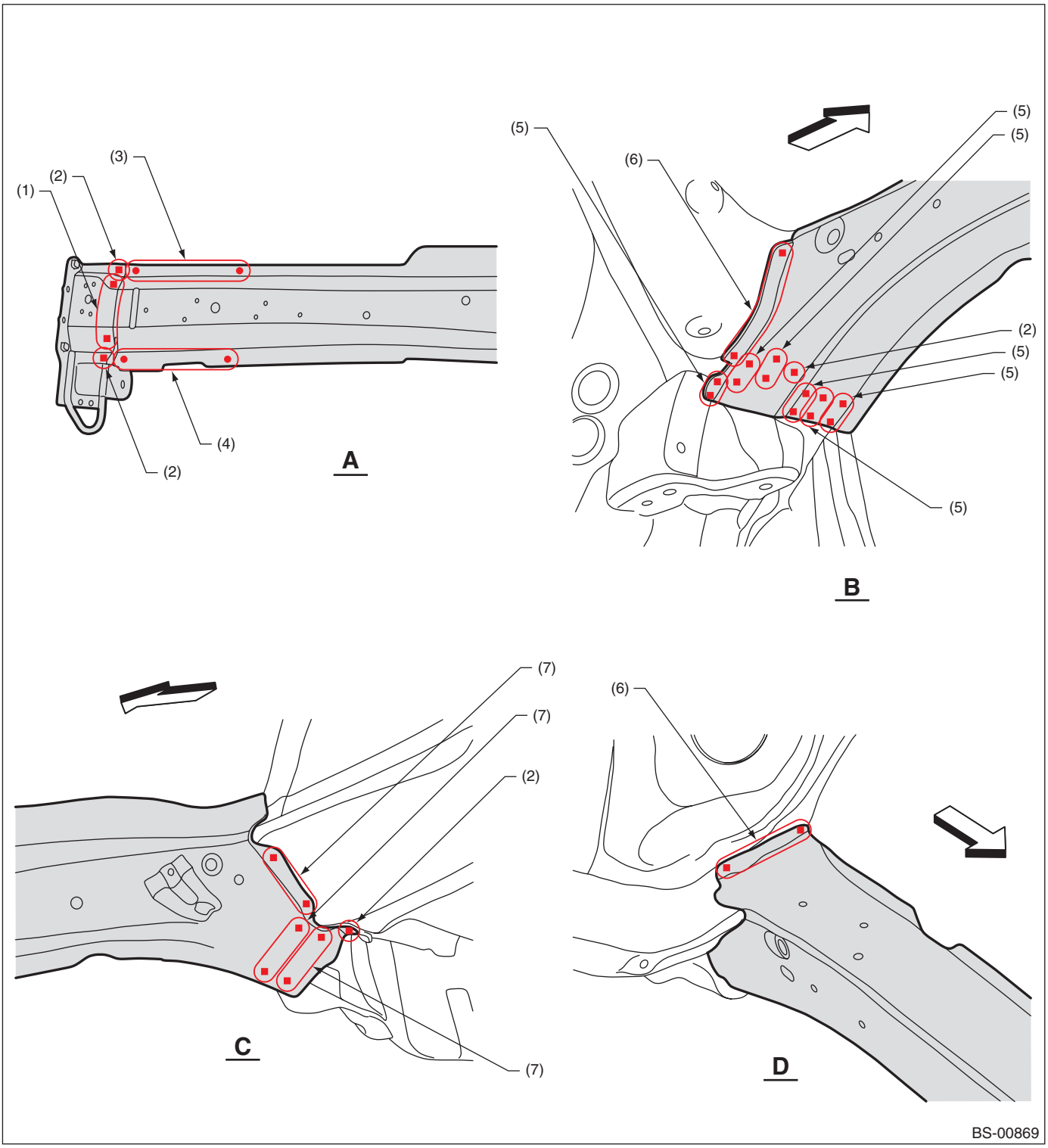
B: INSTALLATION

- **Overall view**



(1) 5 points
(2) 3 points
(3) 10 points
(4) 1 point
(5) 8 points
(6) 1 point (40 mm × 1)

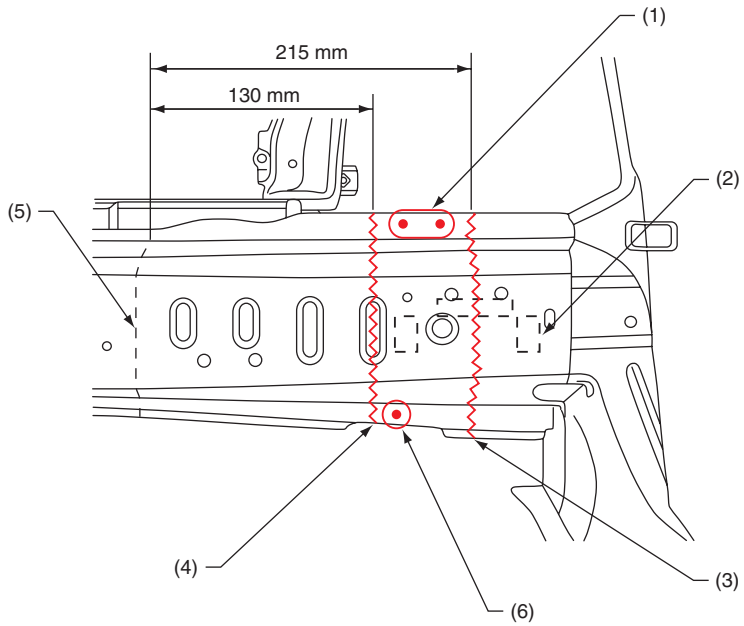
- **Views**



(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)

18.Front Side Frame (partial replacement)

A: REMOVAL

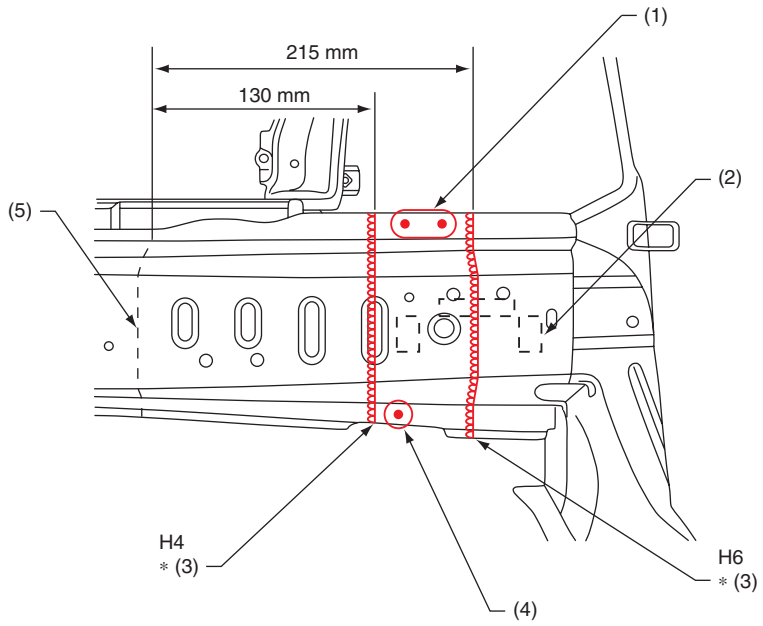


BS-00870

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

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

B: INSTALLATION



BS-00871

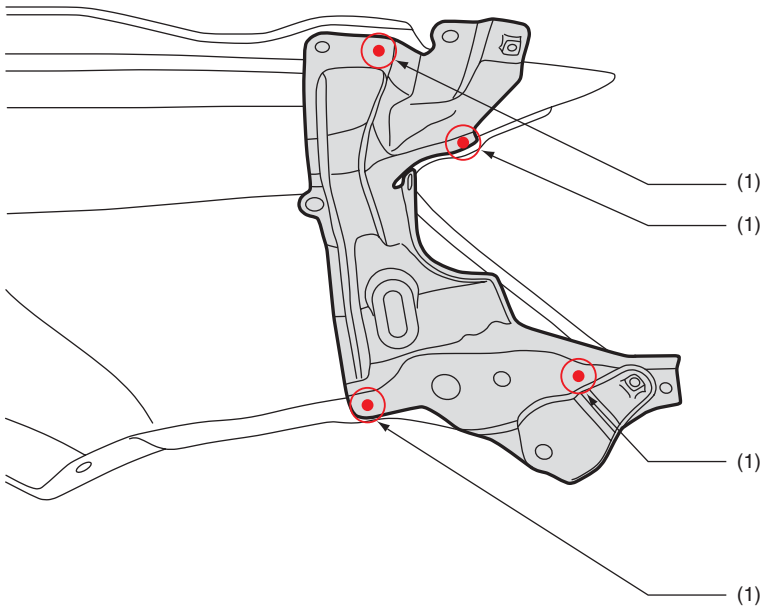
(1) 3 points (During H4 cutting)
(2) Separator bracket
(3) 1 point (230 mm)
(4) 2 points (During H4 cutting)
(5) Tailored line

- 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.

19.Front Fender Reinforcement (total replacement)

A: REMOVAL

1) Frame fender removal condition

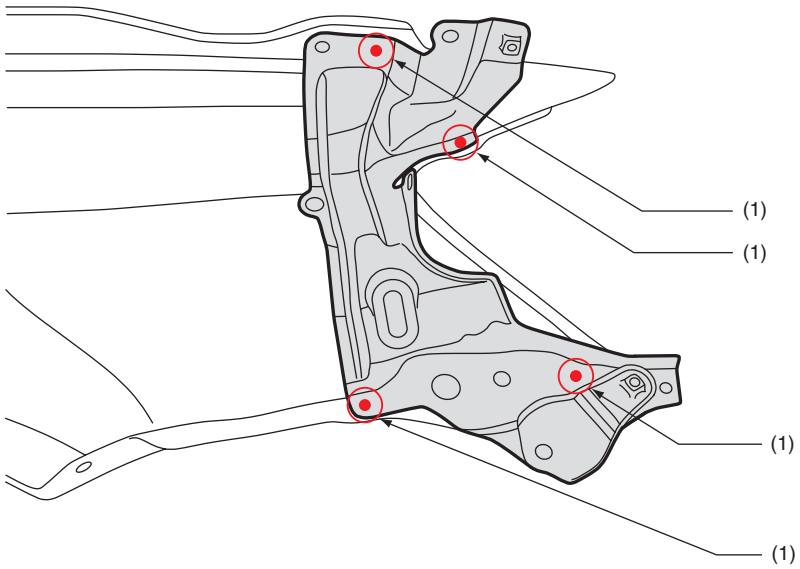


BS-00872

(1) 1 point (inside · 1)

Makes front fender tip repair easier.

B: INSTALLATION



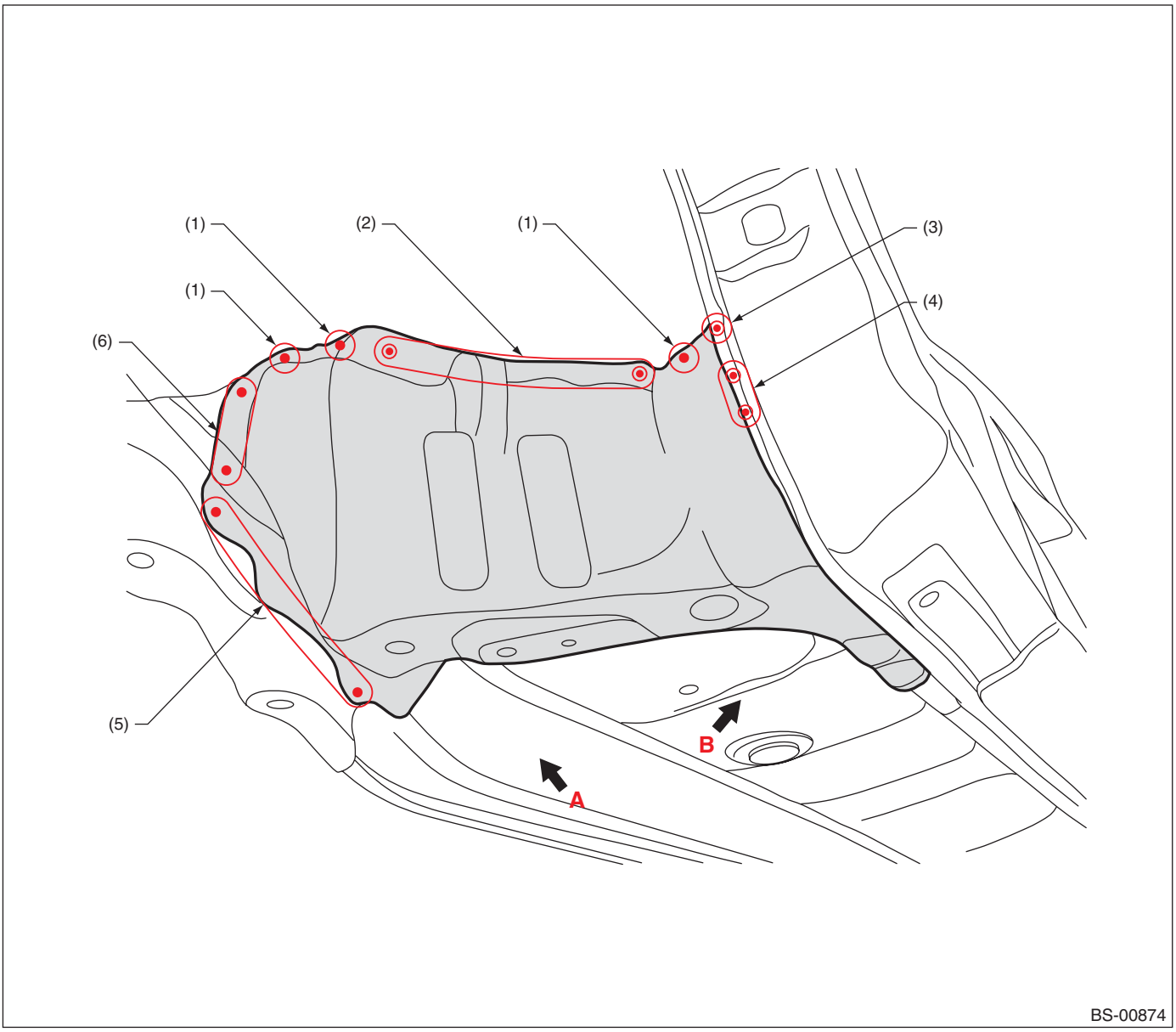
BS-00873

(1) 1 point

20.Reinforcement Toe Board (total replacement)

A: REMOVAL

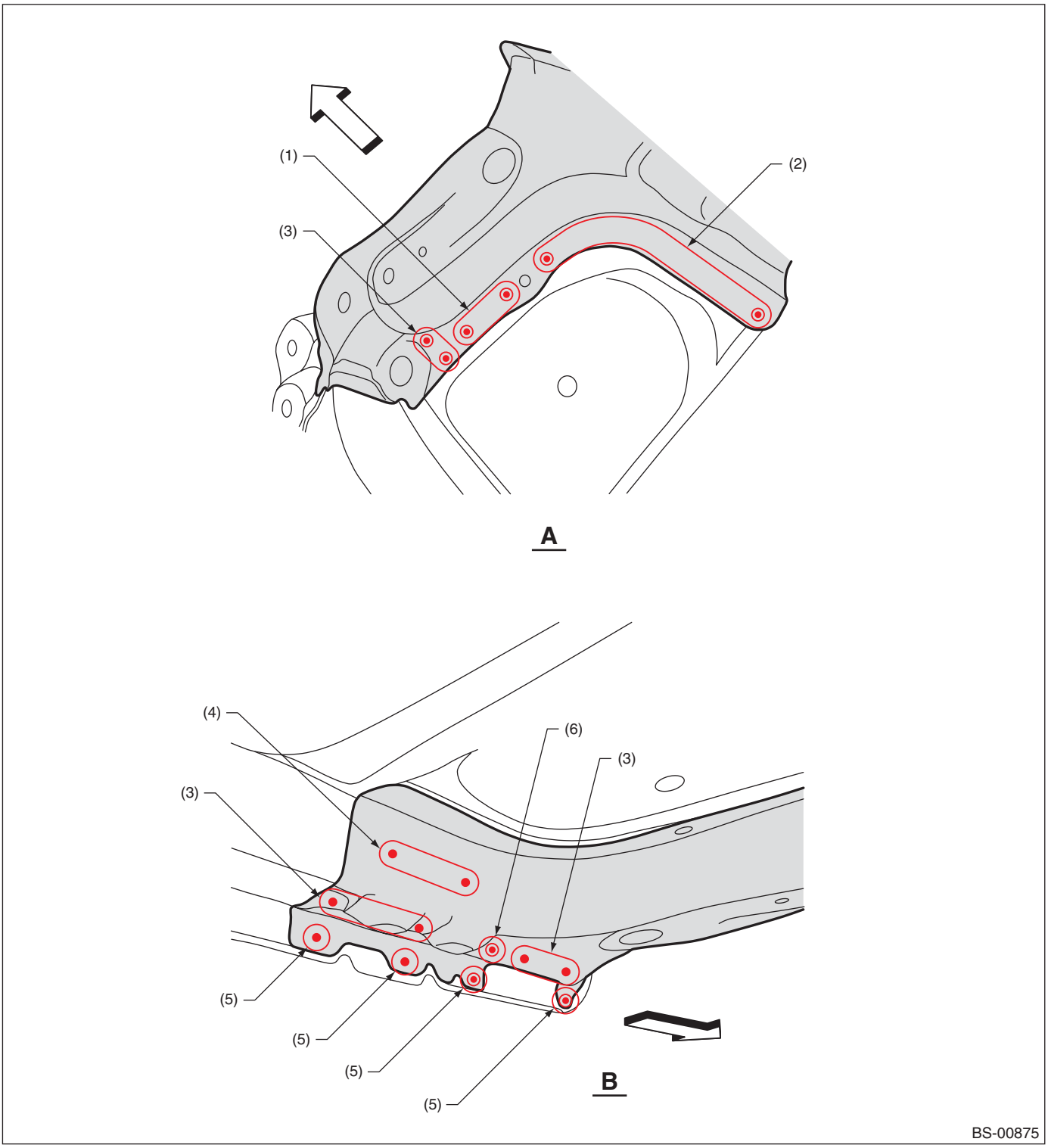
- **Overall view**



(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)

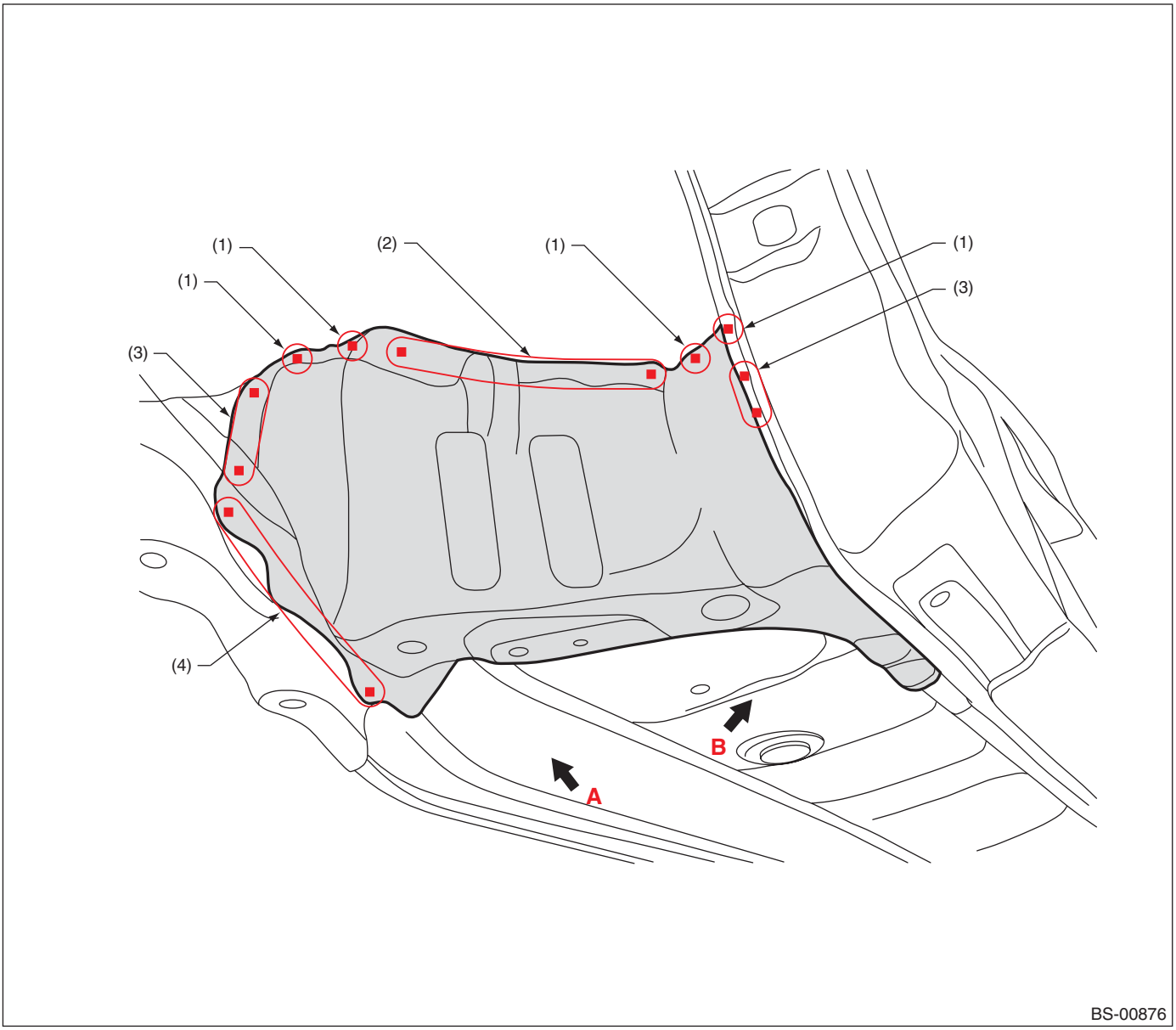
- **Views**



(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)

B: INSTALLATION

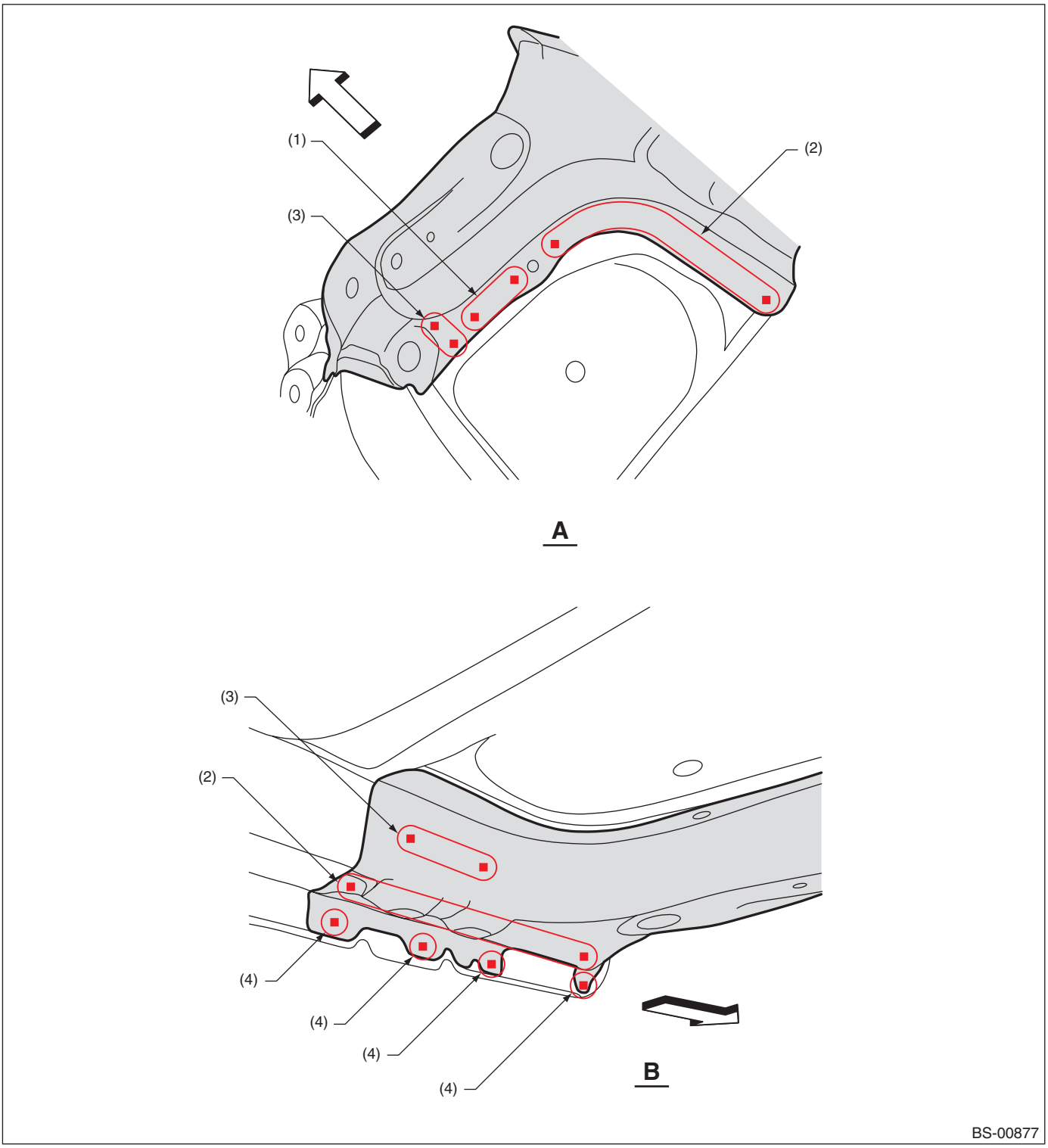
- **Overall view**



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

Reinforcement Toe Board (total replacement)

- **Views**



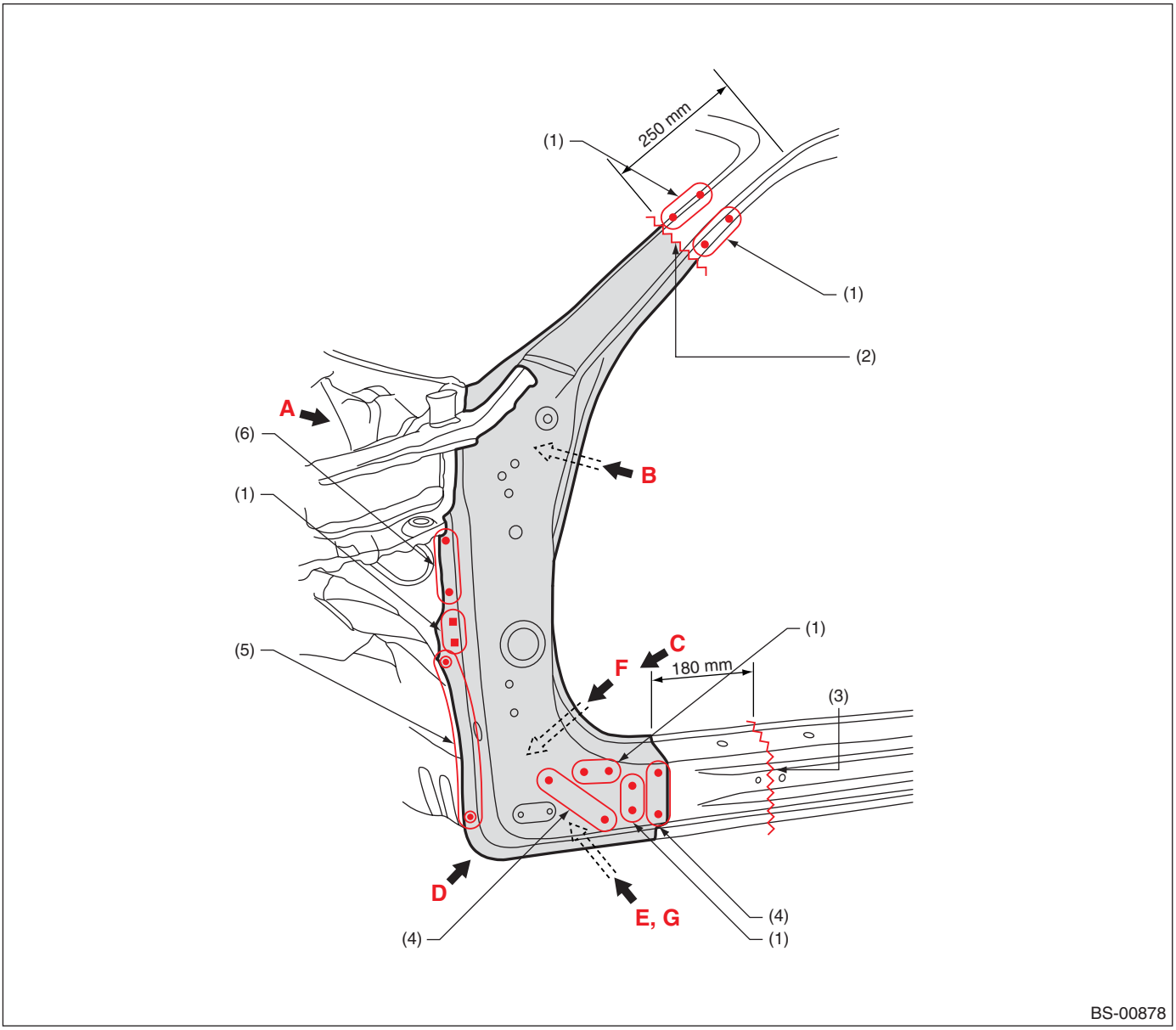
(1) 3 points (service)
(2) 5 points (service)
(3) 2 points (service)
(4) 1 point (service)

21.Front Pillar (partial replacement)

A: REMOVAL

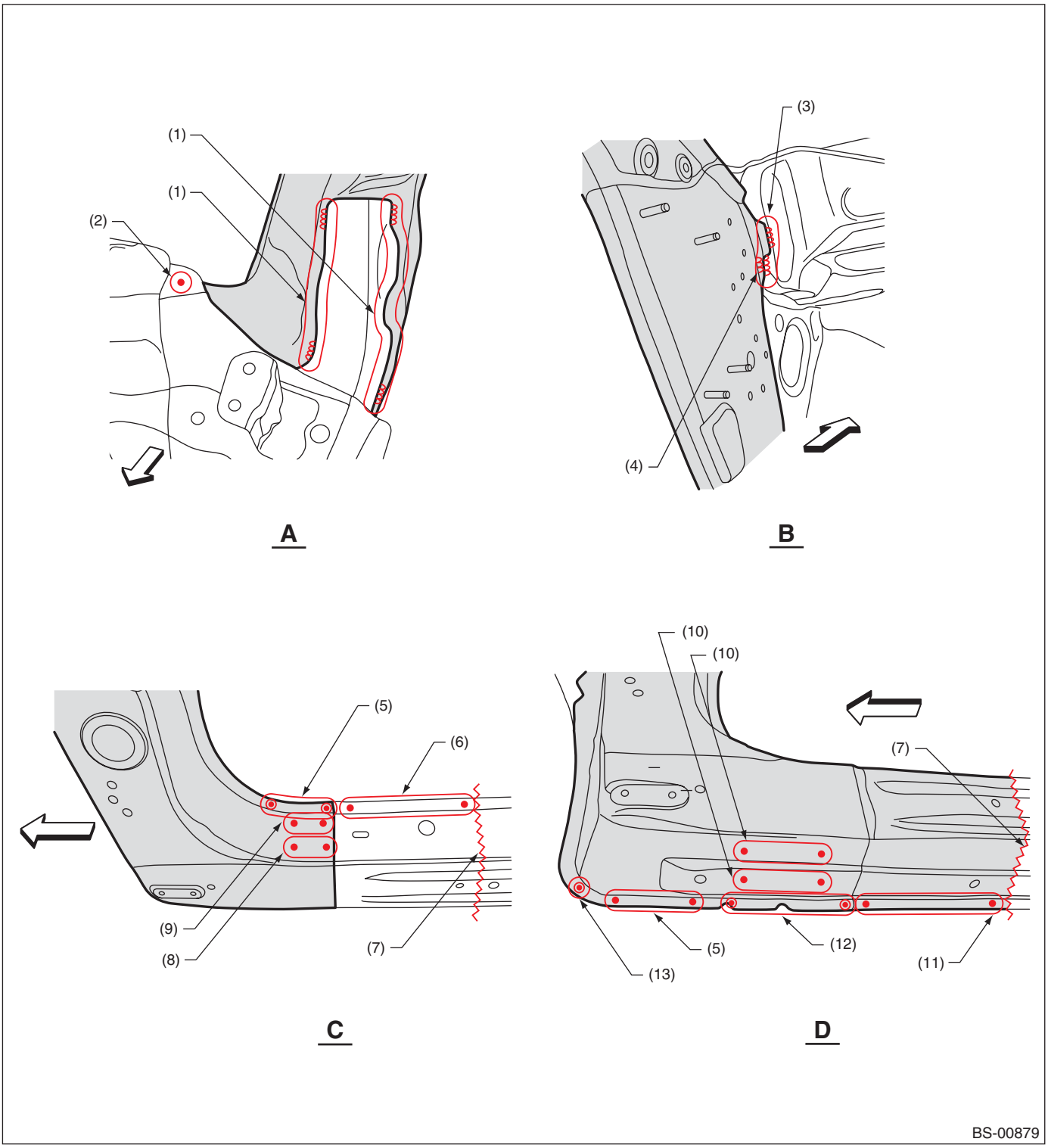
1) Frame side upper removal condition

- **Overall view**



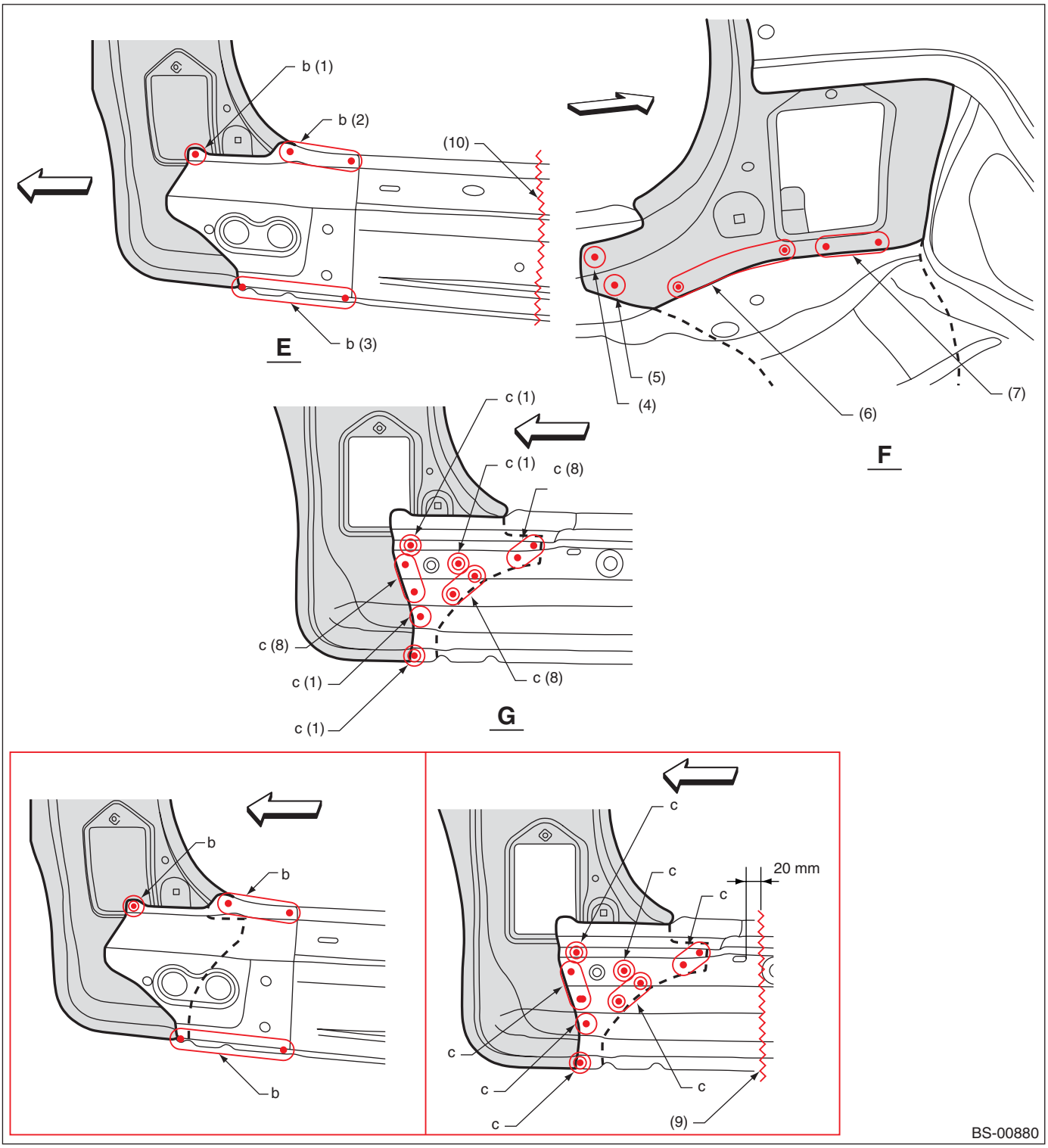
(1) 2 points (outside · 1)
(2) Rough cutting (250 mm)
(3) Cut (270 mm)
to make removal easier
Inner lower piller
(4) 3 points (outside · 1)
(5) 8 points (outside · 1)
(6) 4 points (outside · 1)

- **Views 1**



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

- **Views 2**

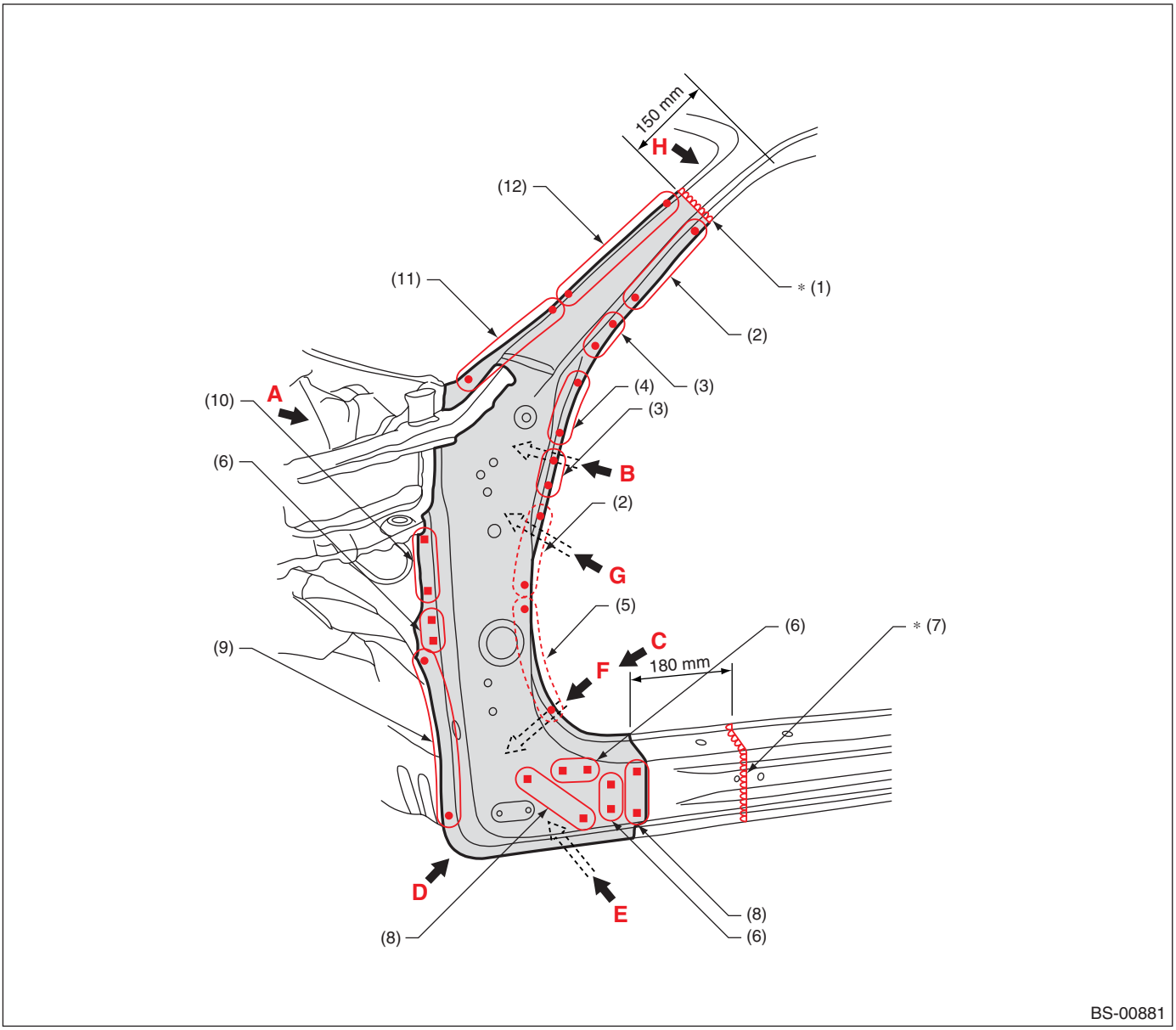


(1) 1 point (outside · 1)
(2) 3 points (outside · 1)
(3) 7 points (outside · 1)
(4) 1 point (top · 1)
(5) 1 point (inside · 1)
(6) 3 points (inside · 1)
(7) 2 points (inside · 1)
(8) 2 points (outside · 1)
(9) Cut (240 mm) to make work easier
(10) Cut

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.

B: INSTALLATION

- **Overall view**

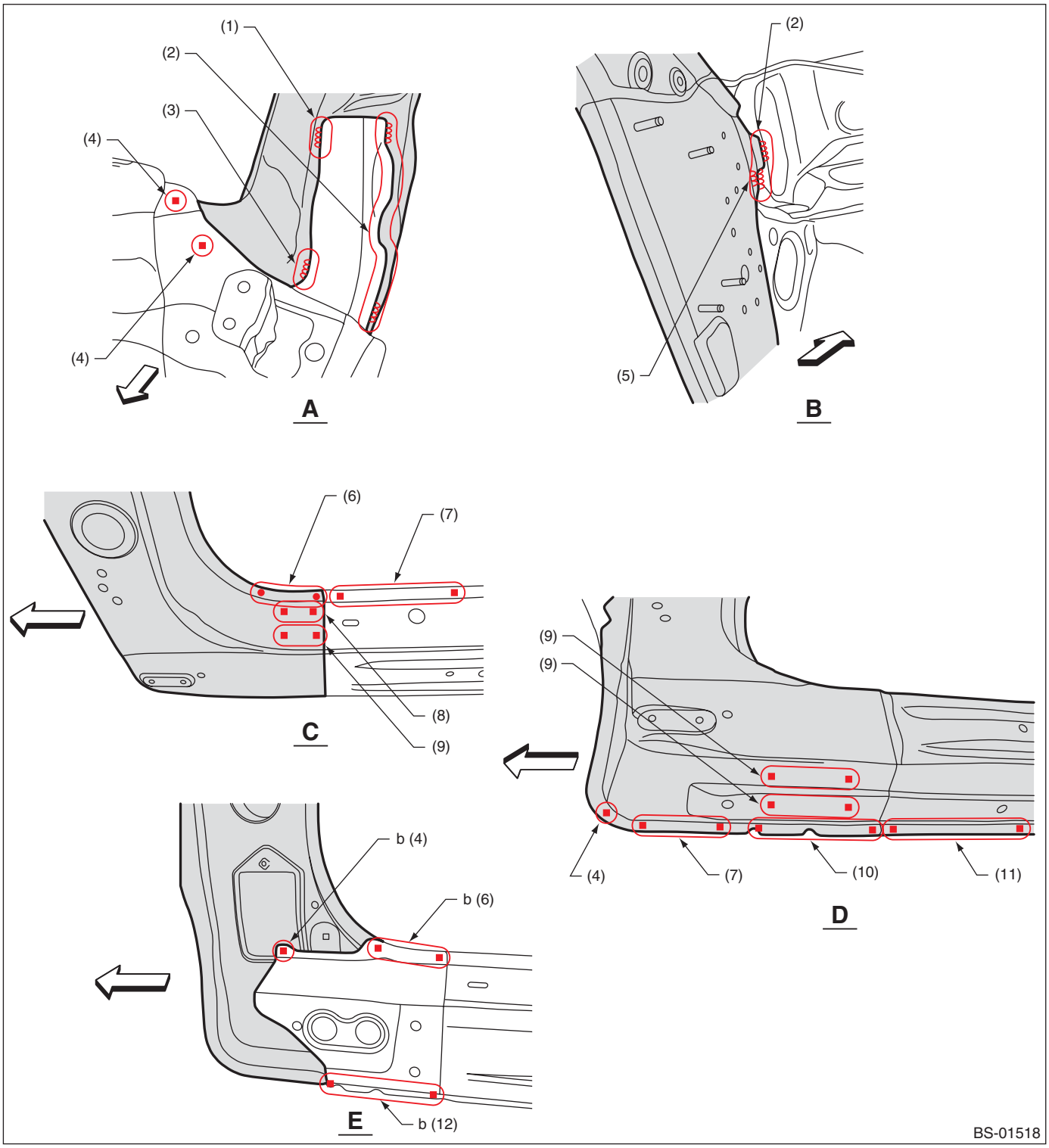


(1)	1 point (150 mm)	(5)	10 points	(9)	10 points (service)
(2)	5 points	(6)	2 points (service)	(10)	4 points (service)
(3)	2 points	(7)	1 point (270 mm)	(11)	7 points
(4)	3 points	(8)	3 points (service)	(12)	13 points

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.

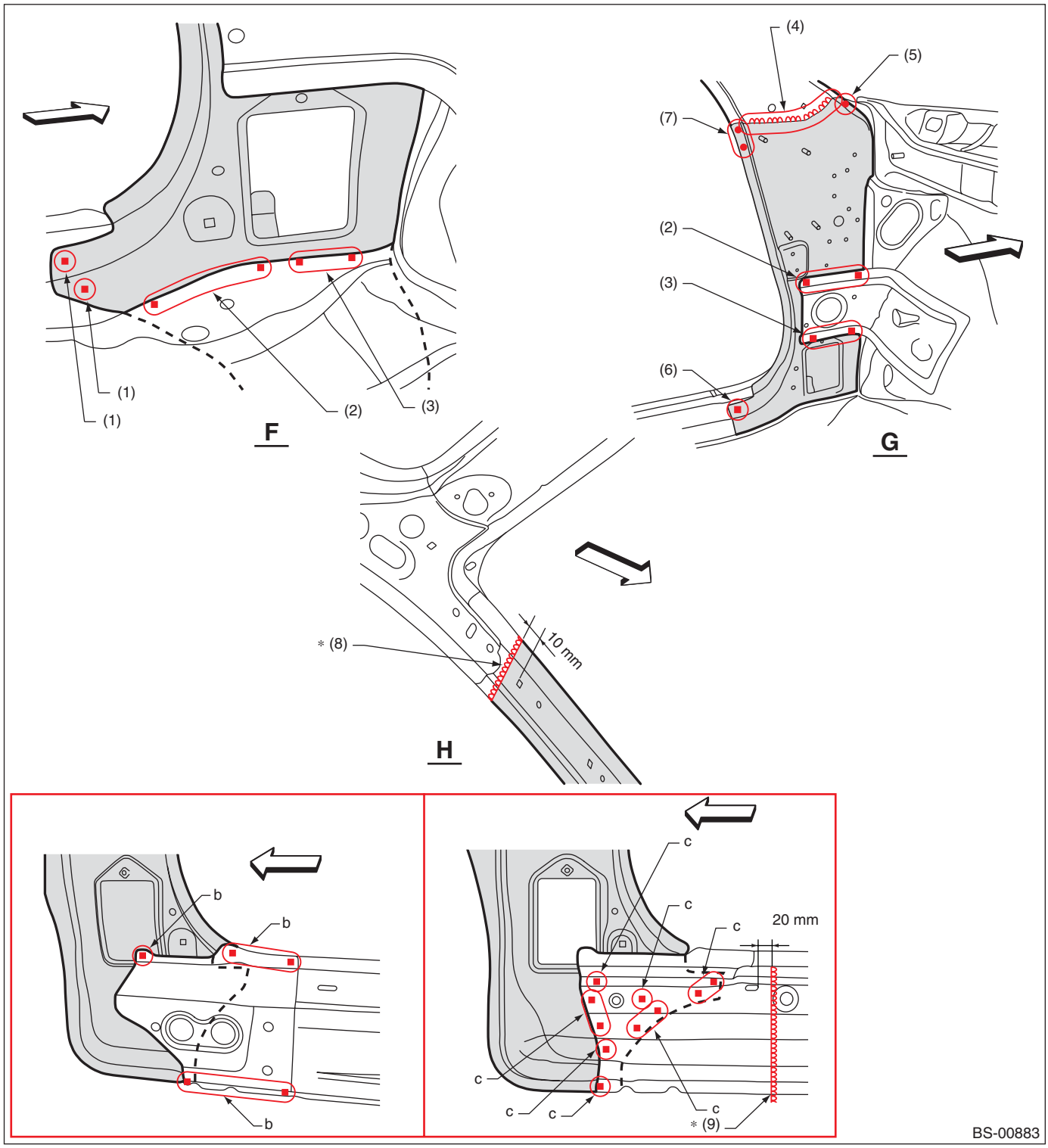
Front Pillar (partial replacement)

- **Views 1**



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

- **Views 2**



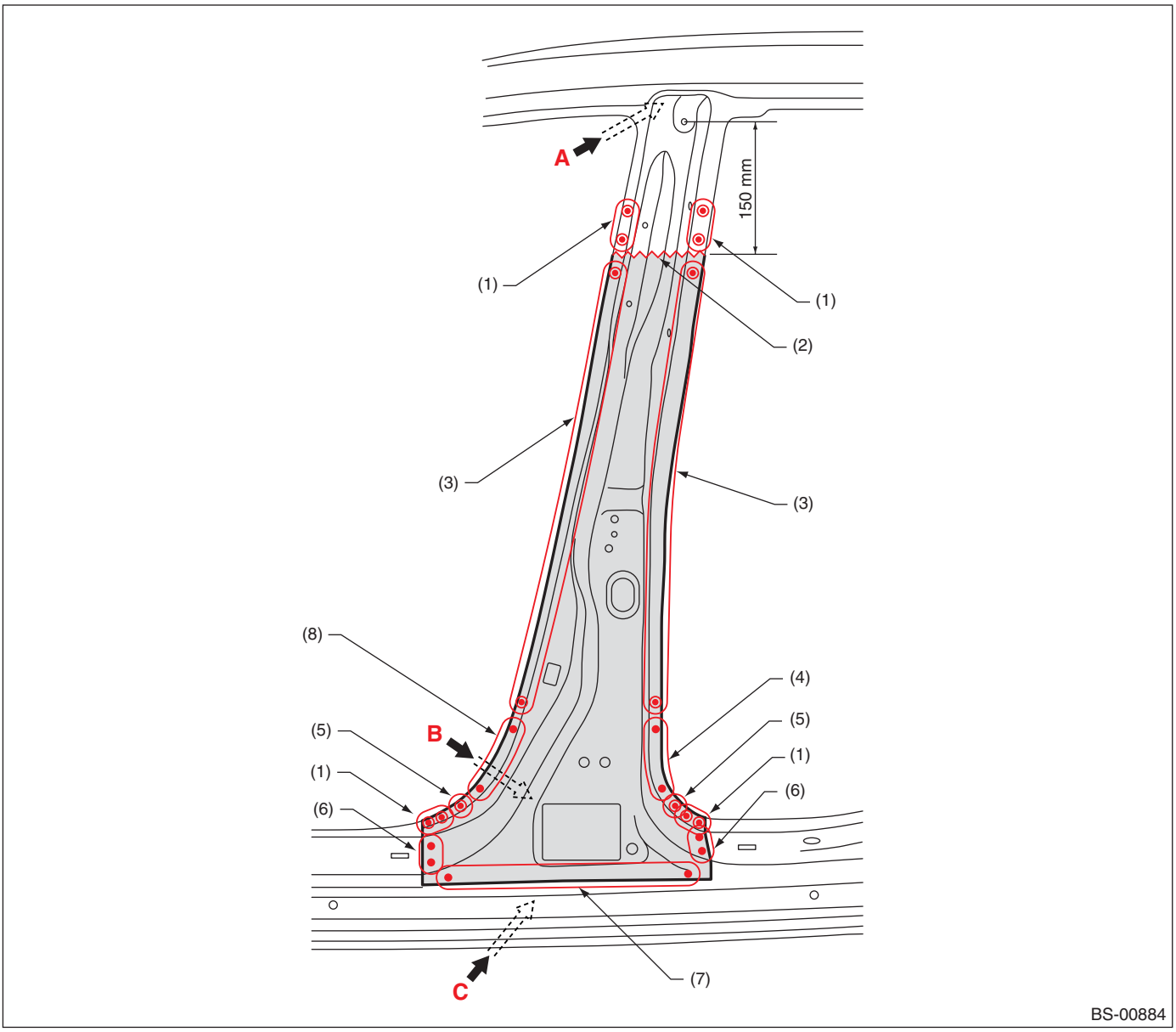
(1) 1 point
(2) 3 points
(3) 2 points
(4) 5 points (15 mm × 5)
(5) 1 point (service · matching)
(6) 1 point (service)
(7) 2 points (service)
(8) 1 point (100 mm)
(9) 1 point (240 mm)

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.

22.Center Pillar (partial replacement)

A: REMOVAL

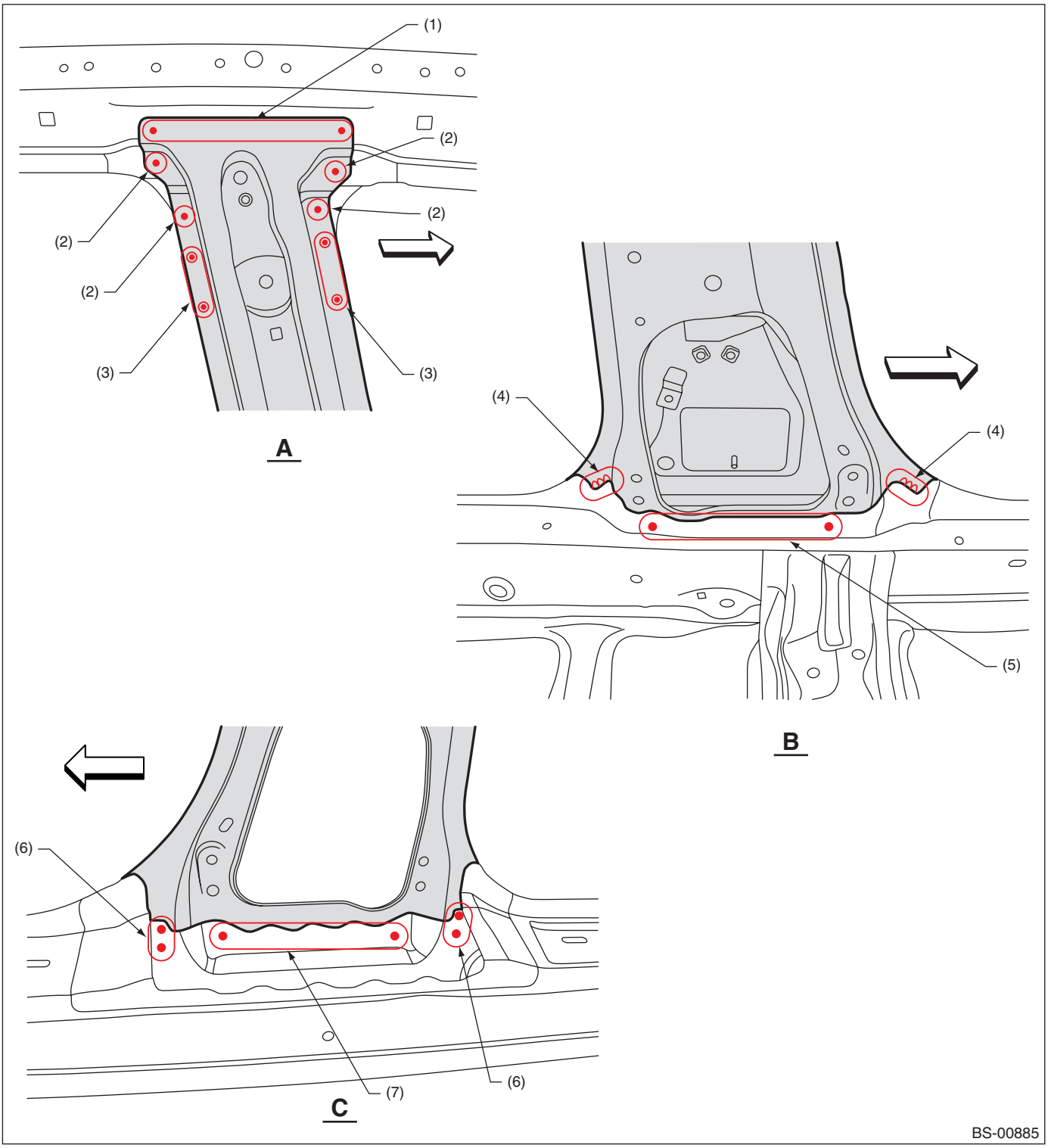
- **Overall view**



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

Center Pillar (partial replacement)

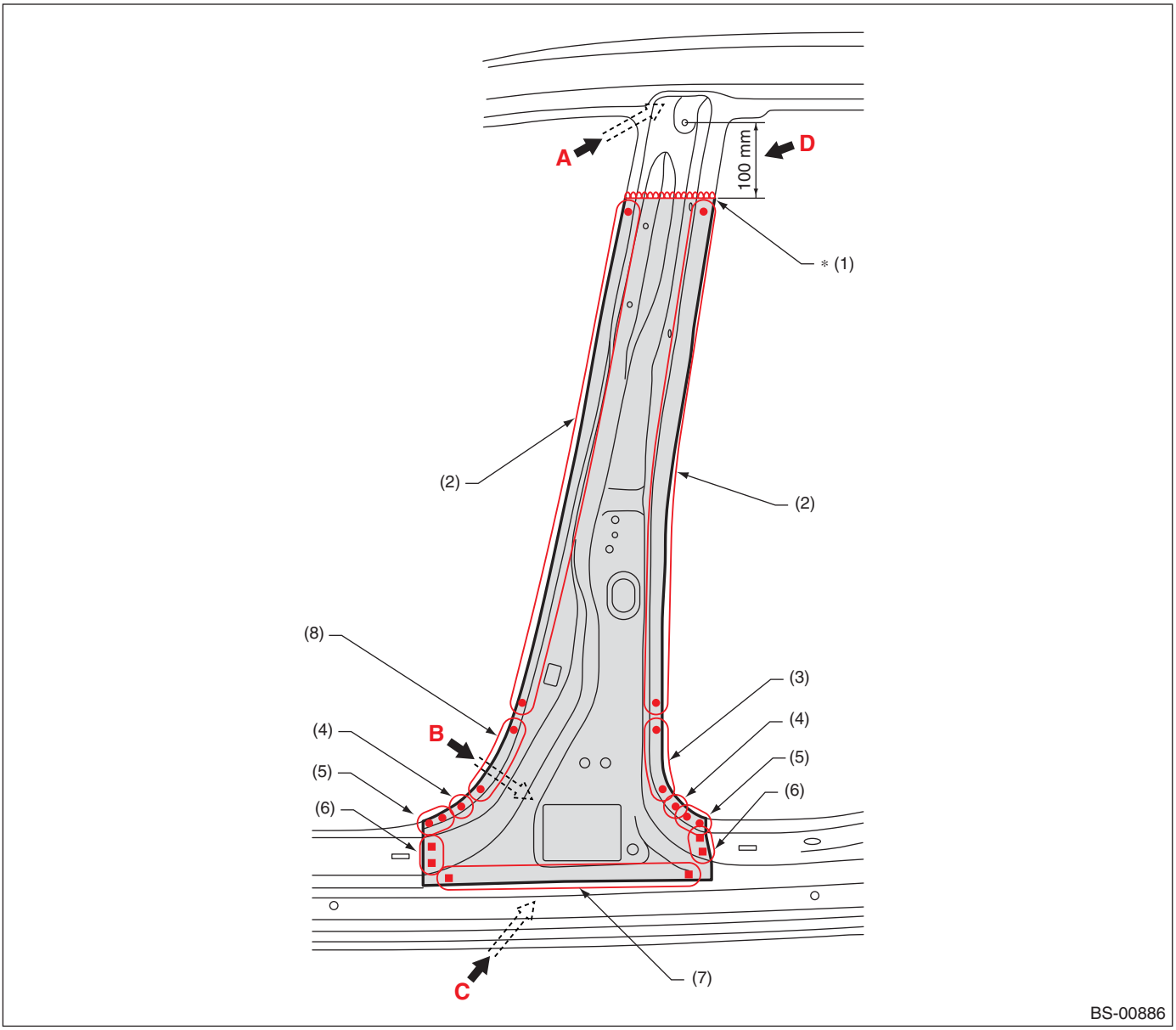
- **Views**



(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)

B: INSTALLATION

- **Overall view**

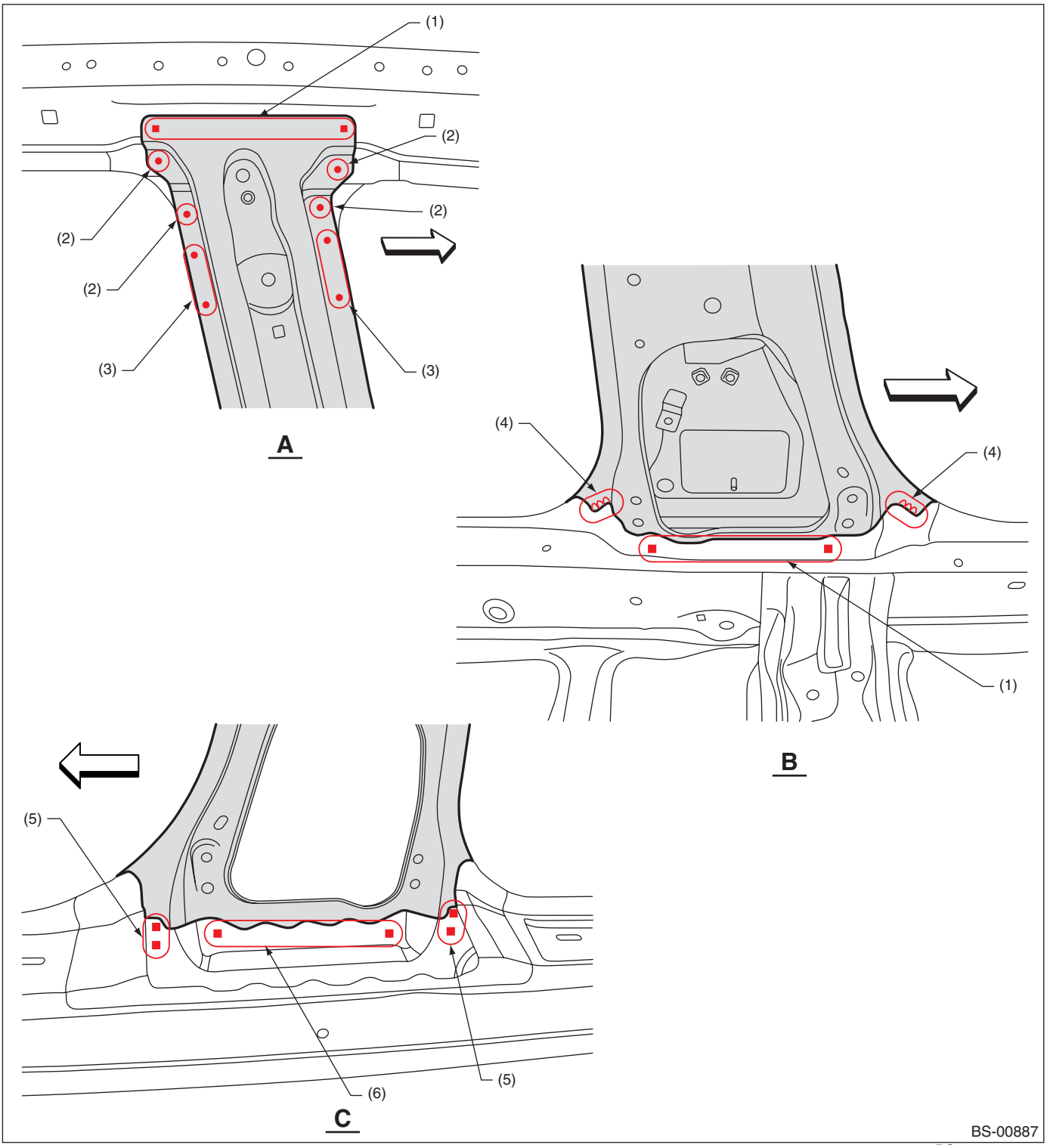


(1)	1 point (240 mm)	(4)	1 point	(7)	9 points (service)
(2)	19 points	(5)	3 points	(8)	5 points
(3)	6 points	(6)	2 points (service)		

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

Center Pillar (partial replacement)

- **Views**

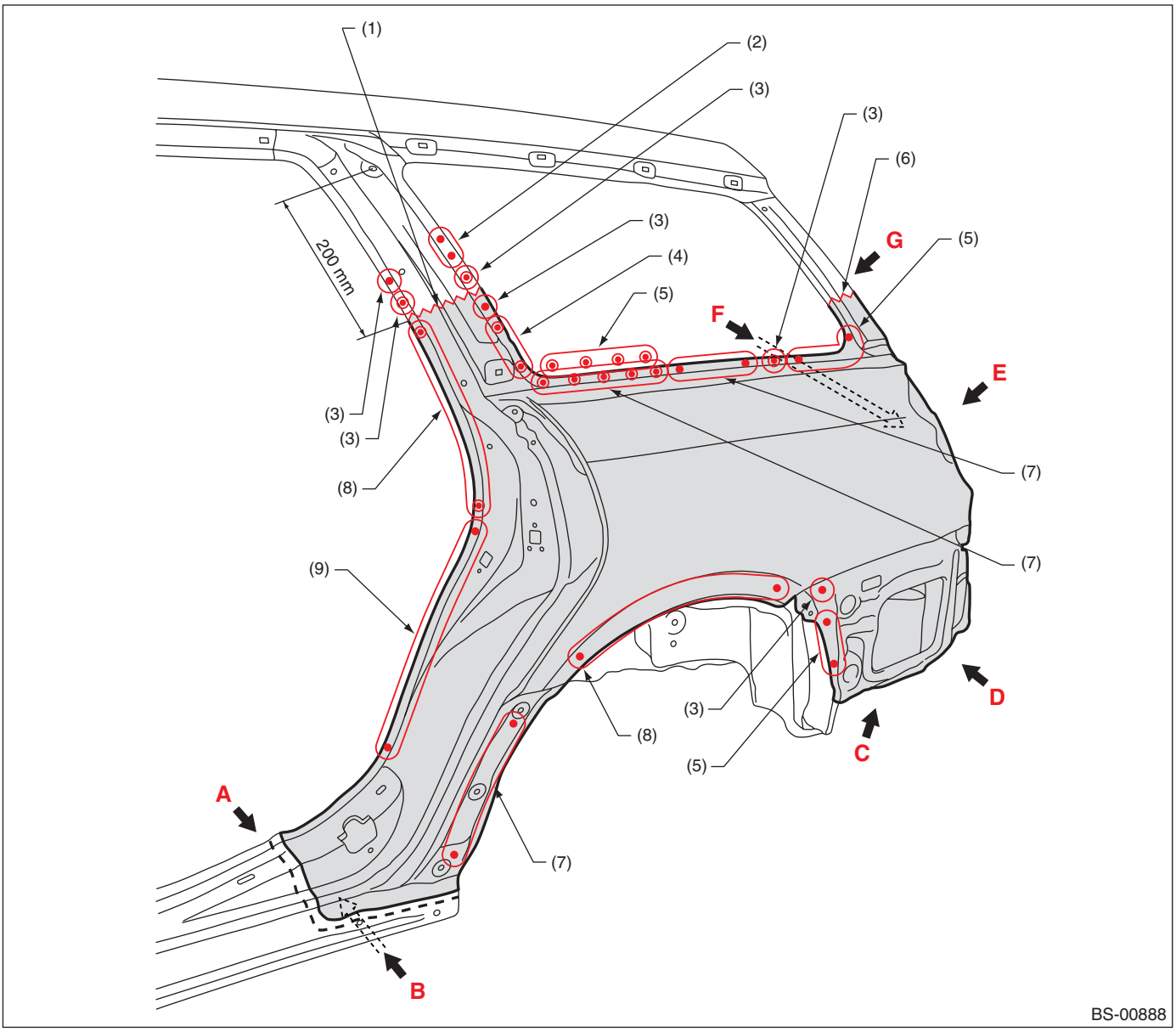


(1) 5 points (service)
(2) 1 point
(3) 3 points
(4) 1 point (15 mm)
(5) 2 points
(6) 5 points

23.Rear Quarter / Wagon (partial replacement)

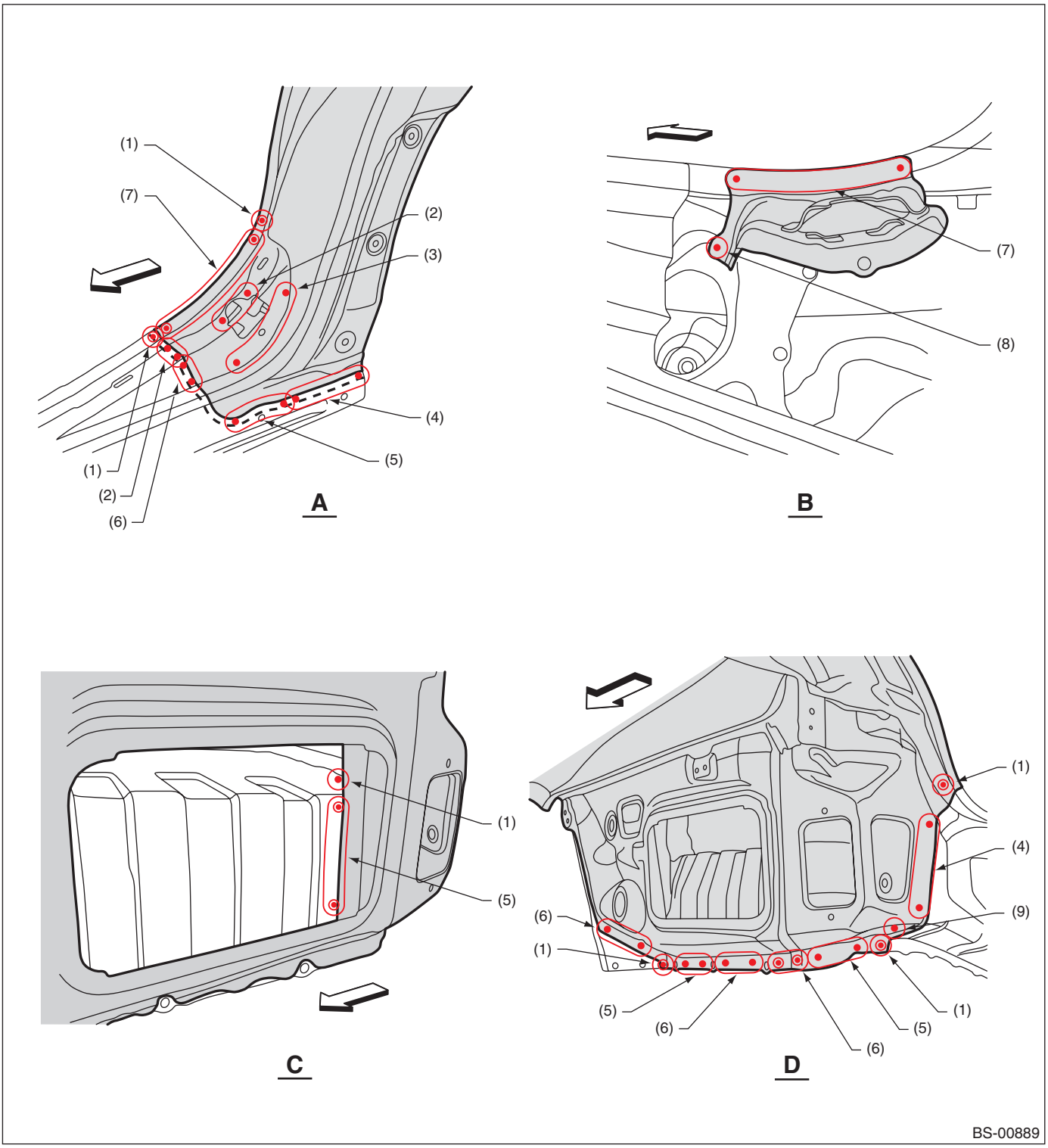
A: REMOVAL

- **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)

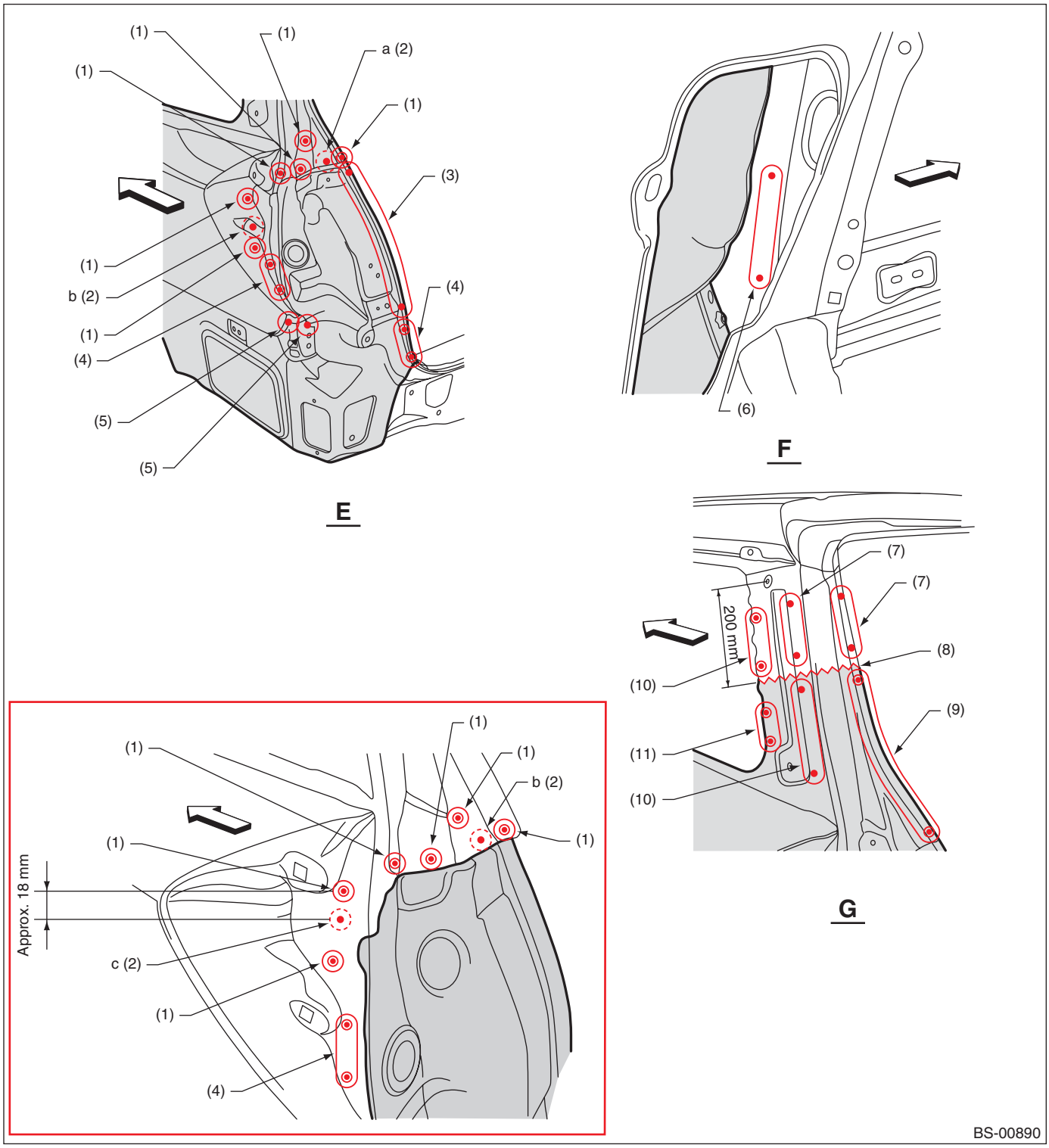
- **Views 1**



(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.

- **Views 2**

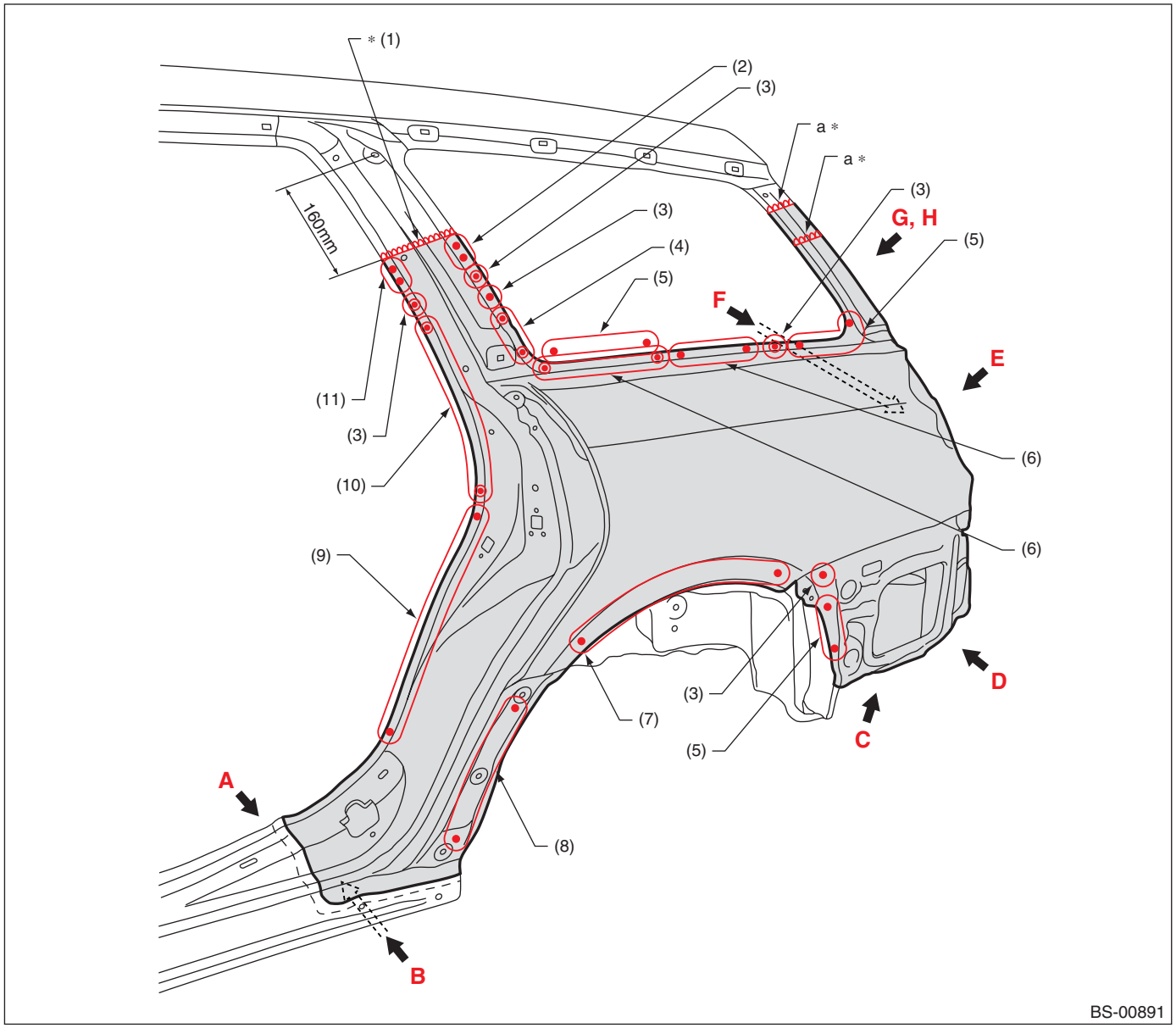


(1) 1 point (outside · 2)
(2) 1 point (outside · 1), hidden hit point
(3) 9 points (outside · 1)
(4) 2 points (outside · 2)
(5) 1 point (outside · 1)
(6) 3 points (inside · 1, belt sander)
(7) 3 points (outside · 1)
(8) Rough cutting (170 mm)
(9) 6 points (outside · 1)
(10) 4 points (outside · 1)
(11)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

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

B: INSTALLATION

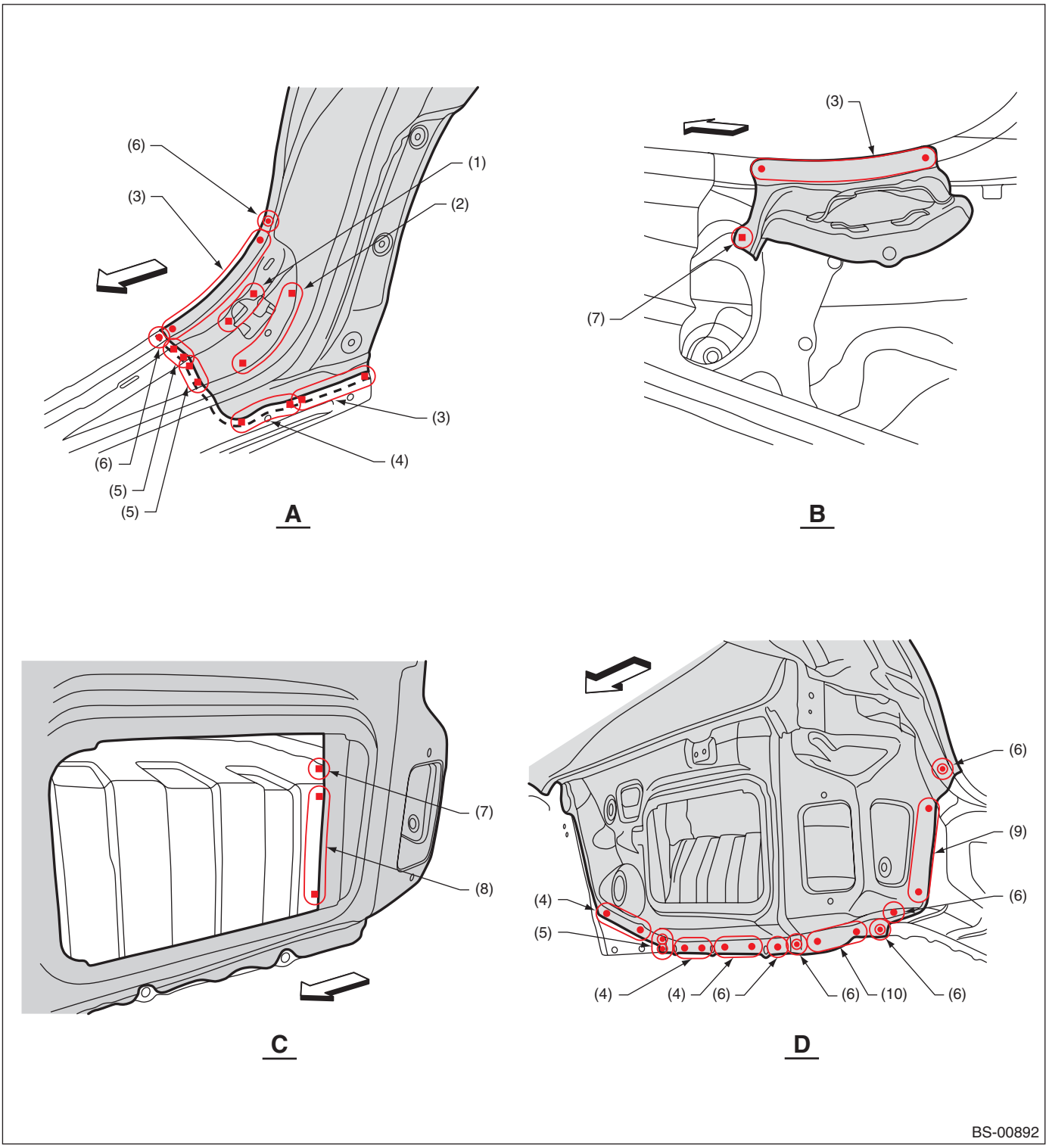
- **Overall view**



(1)	1 point (130 mm)	(5)	5 points	(9)	14 points
(2)	3 points	(6)	6 points	(10)	10 points
(3)	1 point	(7)	9 points	(11)	2 points
(4)	4 points	(8)	7 points		

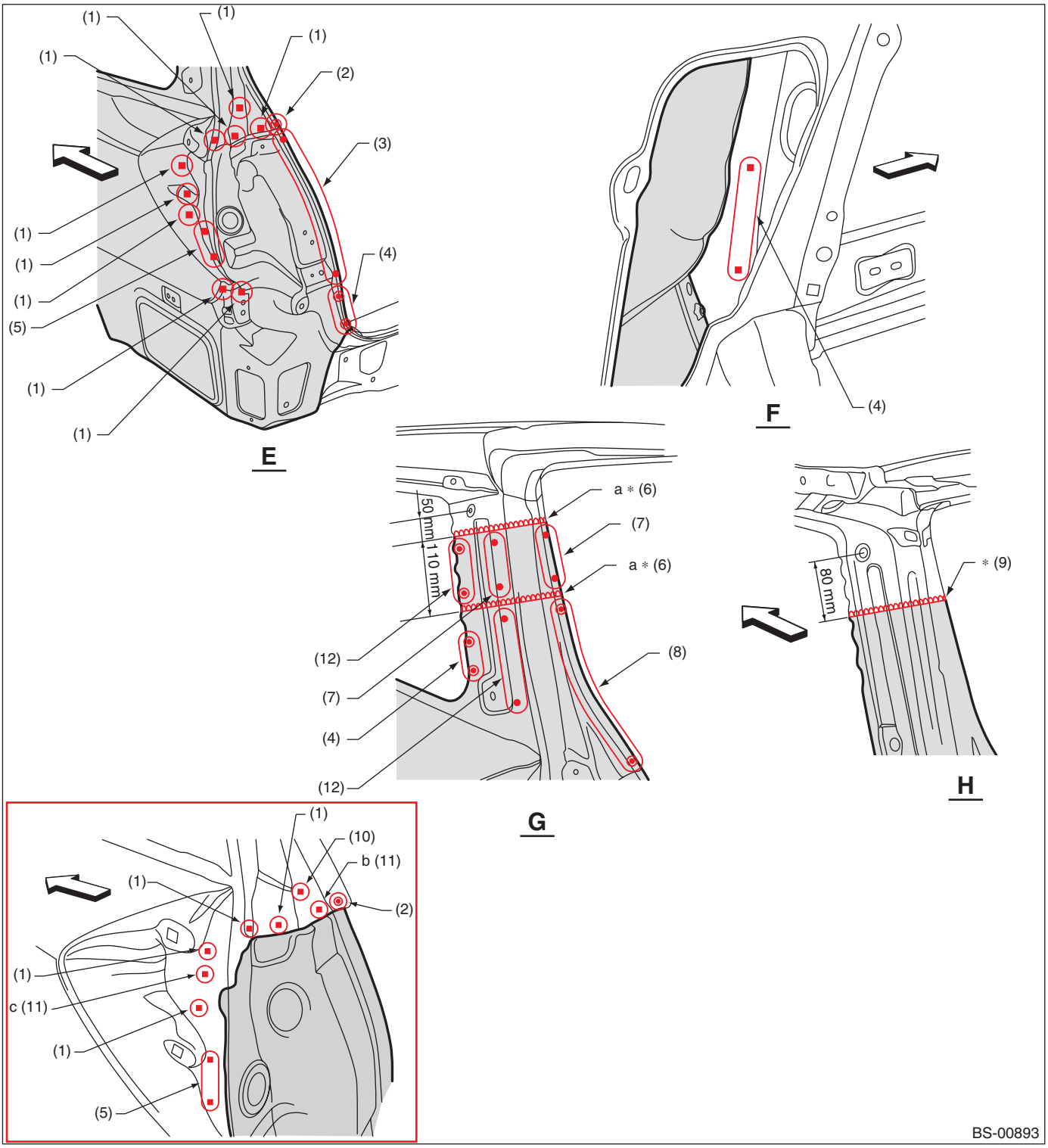
For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

- **Views 1**



(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

- **Views 2**



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

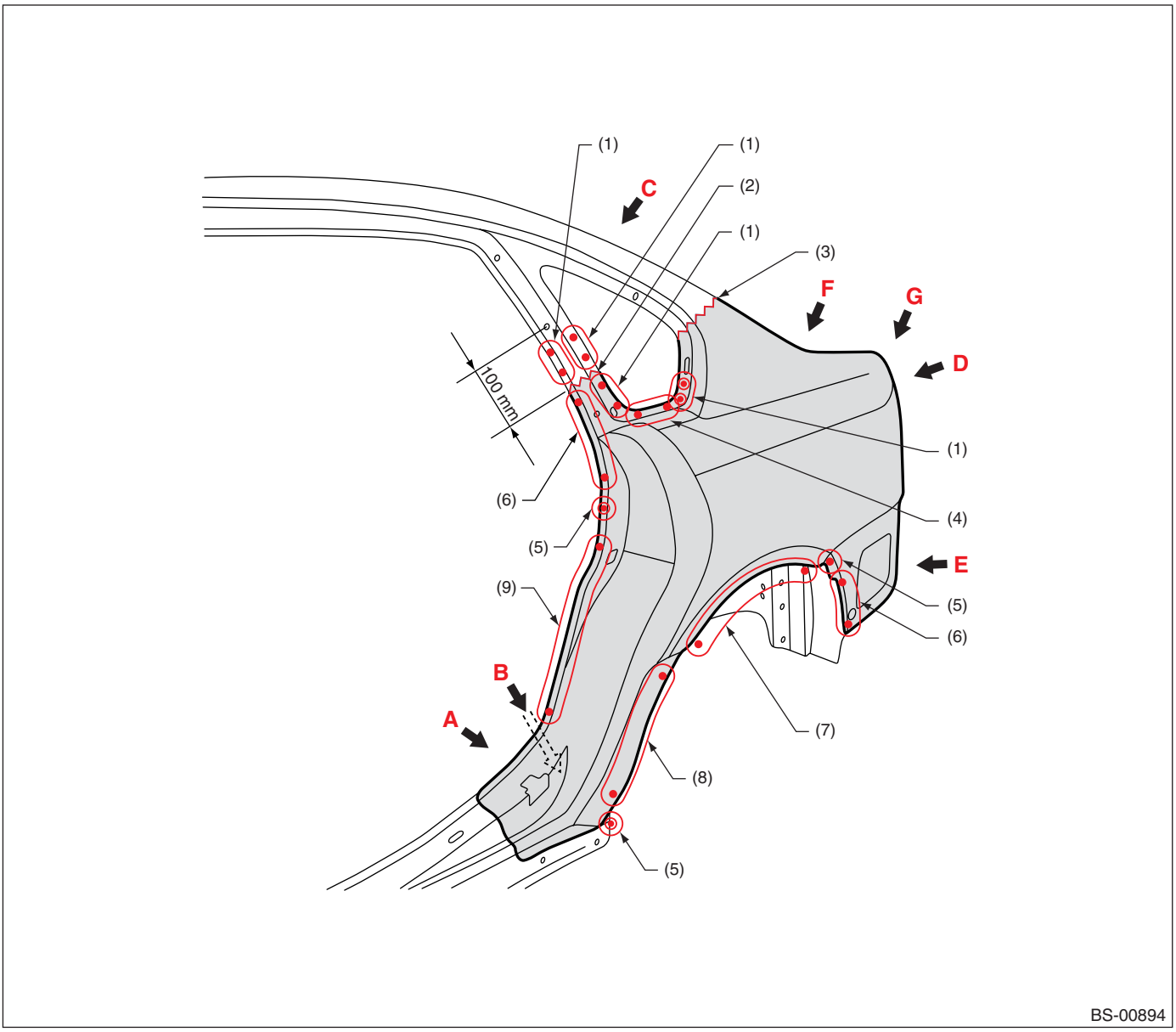
POINT: When replacing the D-pillar by itself, there are two weld locations b and c (hidden hit point).

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.

24.Rear Quarter / Sedan (partial replacement)

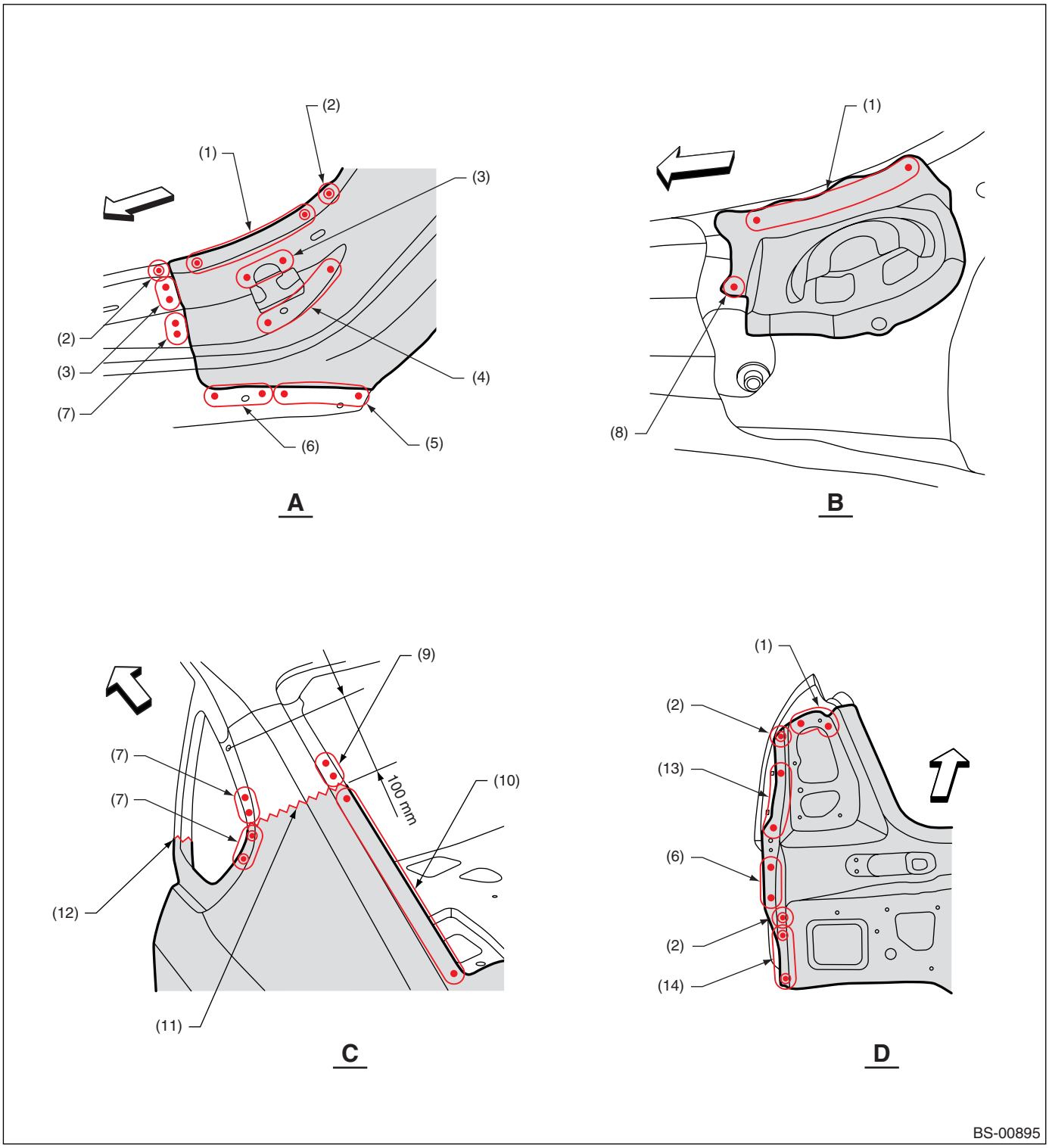
A: REMOVAL

- **Overall view**



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

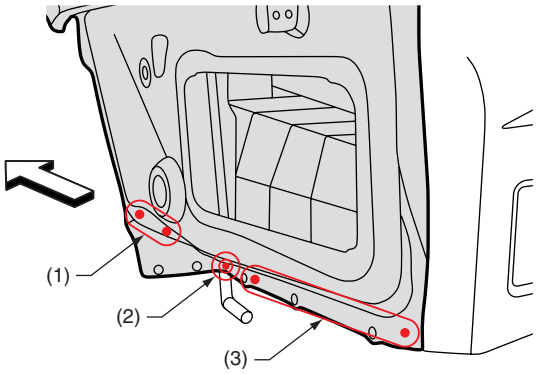
- **Views 1**



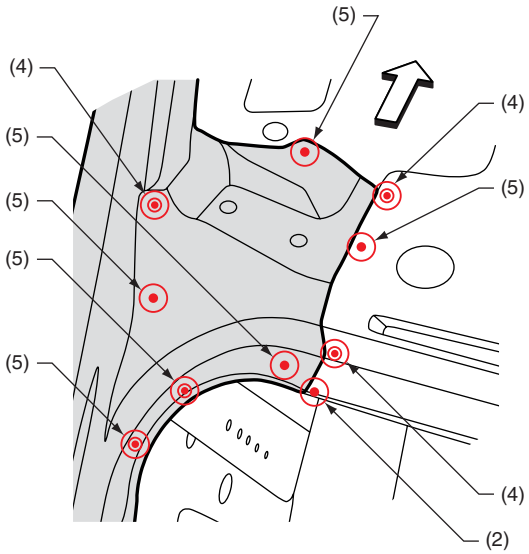
(1) 4 points (outside · 1)
(2) 1 point (outside · 1)
(3) 2 points (top · 1)
(4) 4 points (top · 1)
(5) 5 points (outside · 1)
(6) 3 points (outside · 1)
(7) 2 points (outside · 1)
(8) 1 point (outside · 1), hidden hit point
(9) 3 points (top · 1)
(10) 8 points (top · 1)
(11) Rough cutting (230 mm)
(12)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

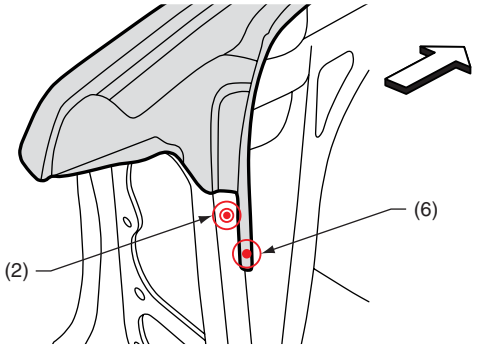
- **Views 2**



E



F



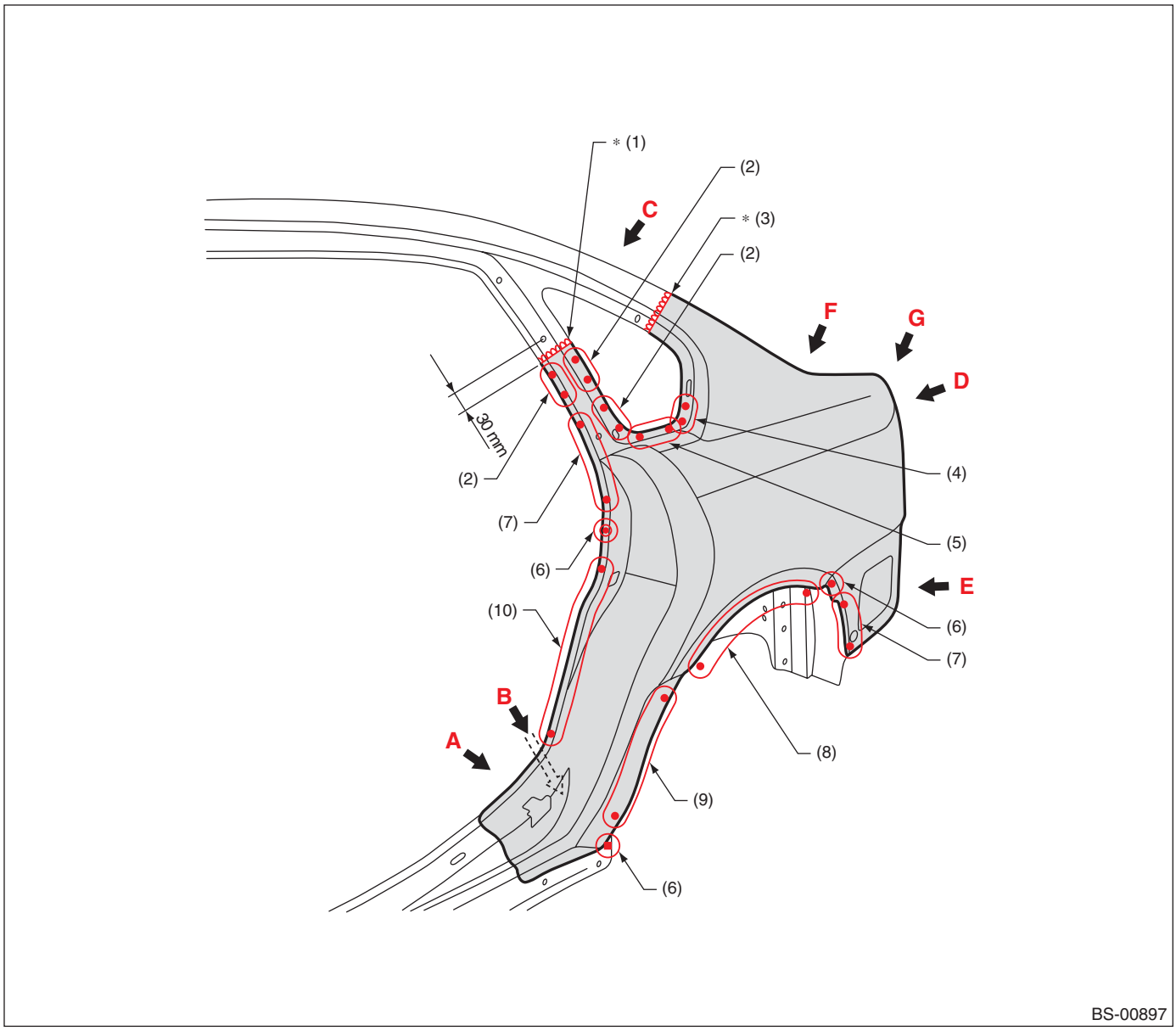
G

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)

B: INSTALLATION

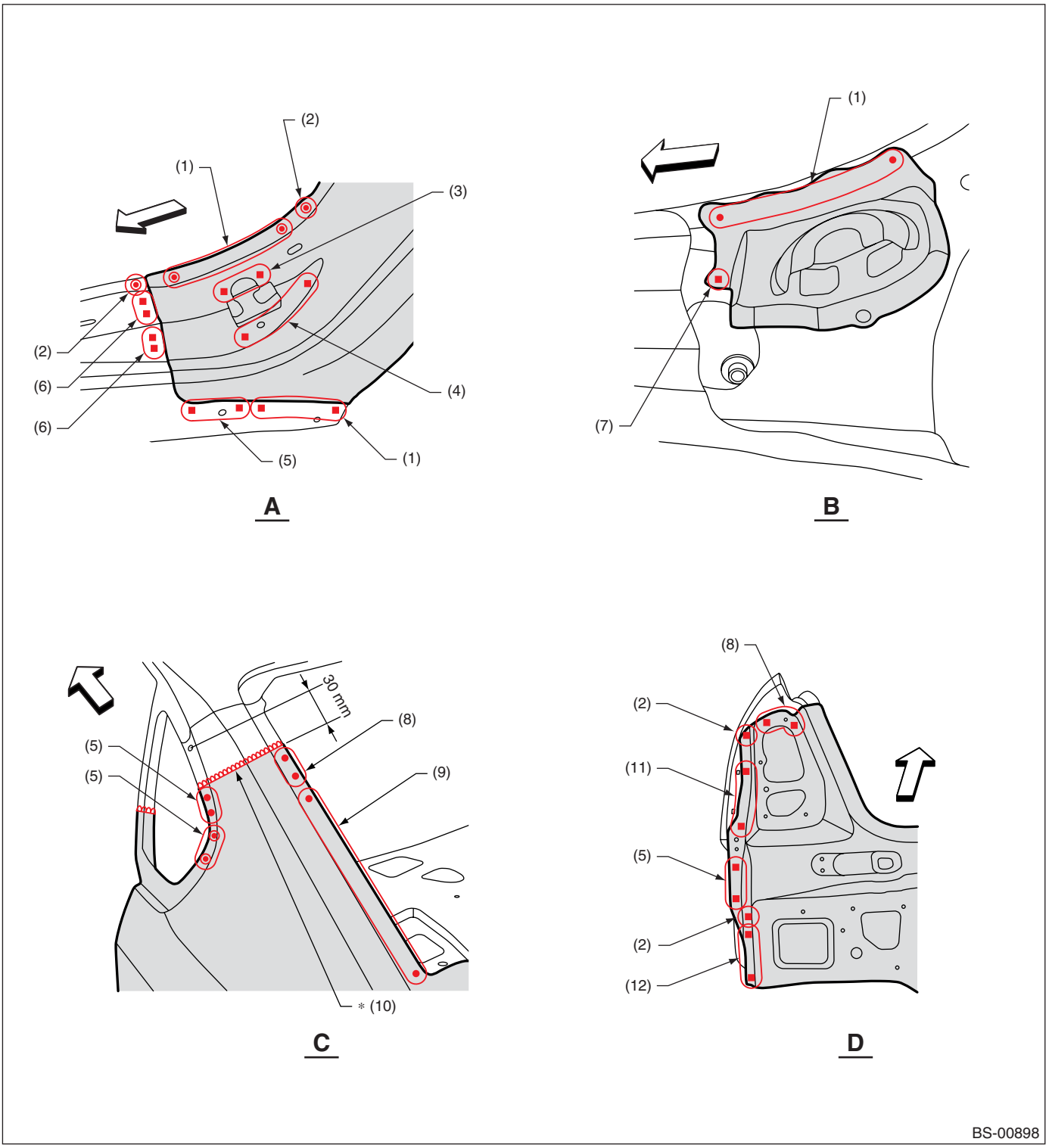
- **Overall view**



(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.

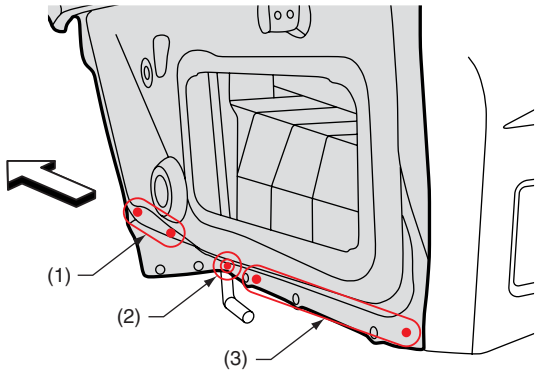
- **Views 1**



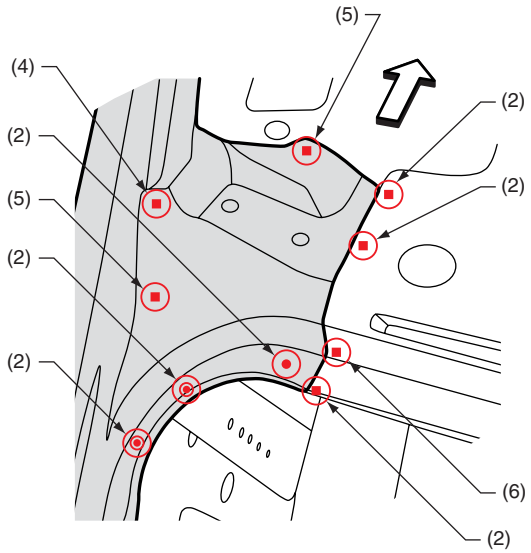
(1)	5 points	(5)	3 points	(9)	10 points
(2)	1 point	(6)	2 points	(10)	1 point (230 mm)
(3)	2 points (service)	(7)	1 point (service), hidden hit point	(11)	6 points
(4)	4 points (service)	(8)	4 points	(12)	4 points (matching)

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

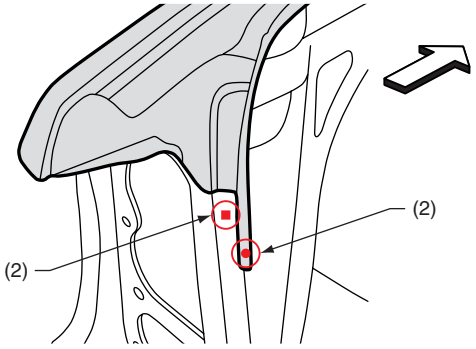
- **Views 2**



E



F



G

BS-00899

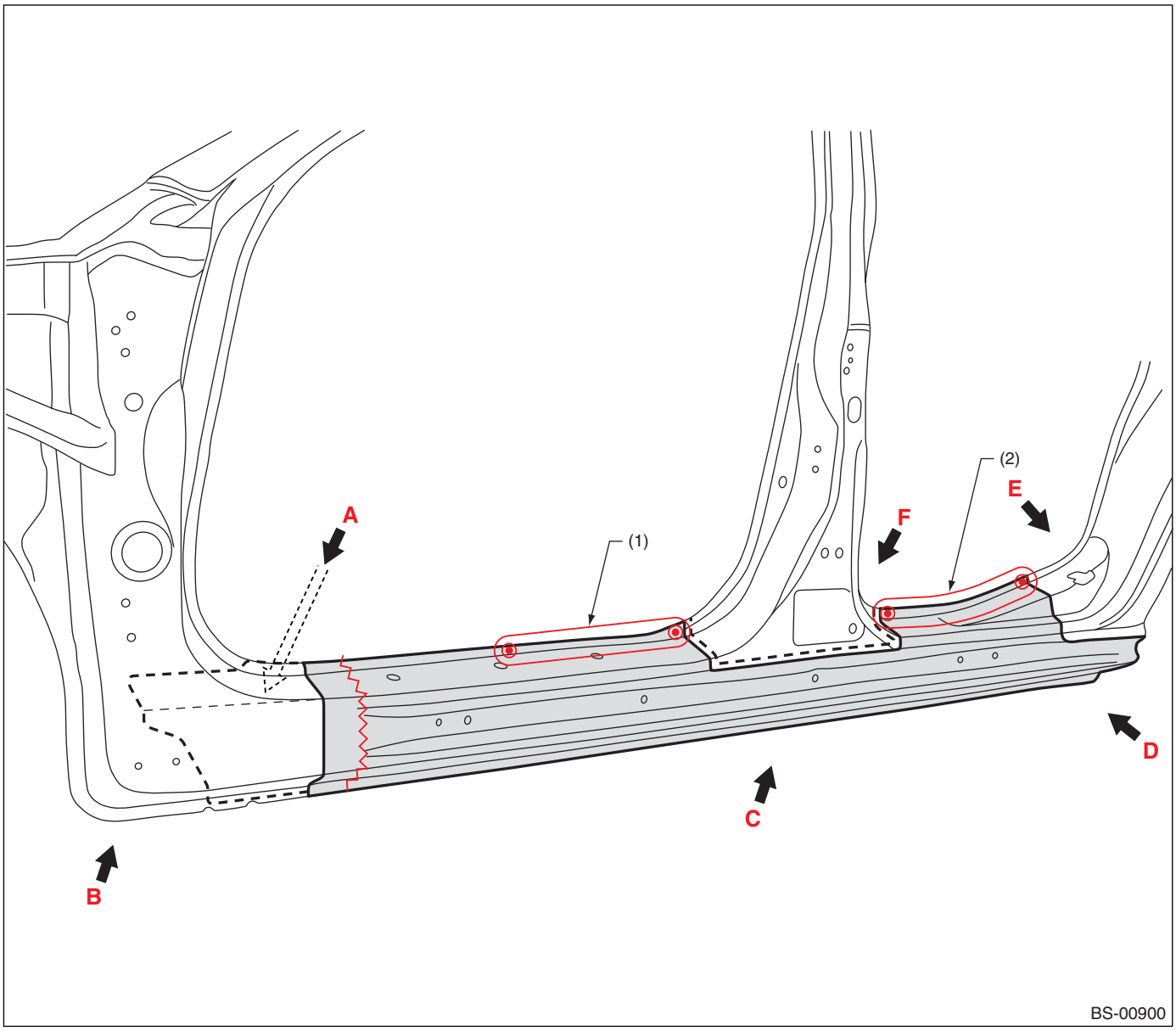
(1) 3 points
(2) 1 point
(3) 9 points
(4) 1 point (service · matching)
(5) 1 point (service)
(6) 1 point (matching)

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

25.Side Sill Outer (partial replacement)

A: REMOVAL

- **Overall view**

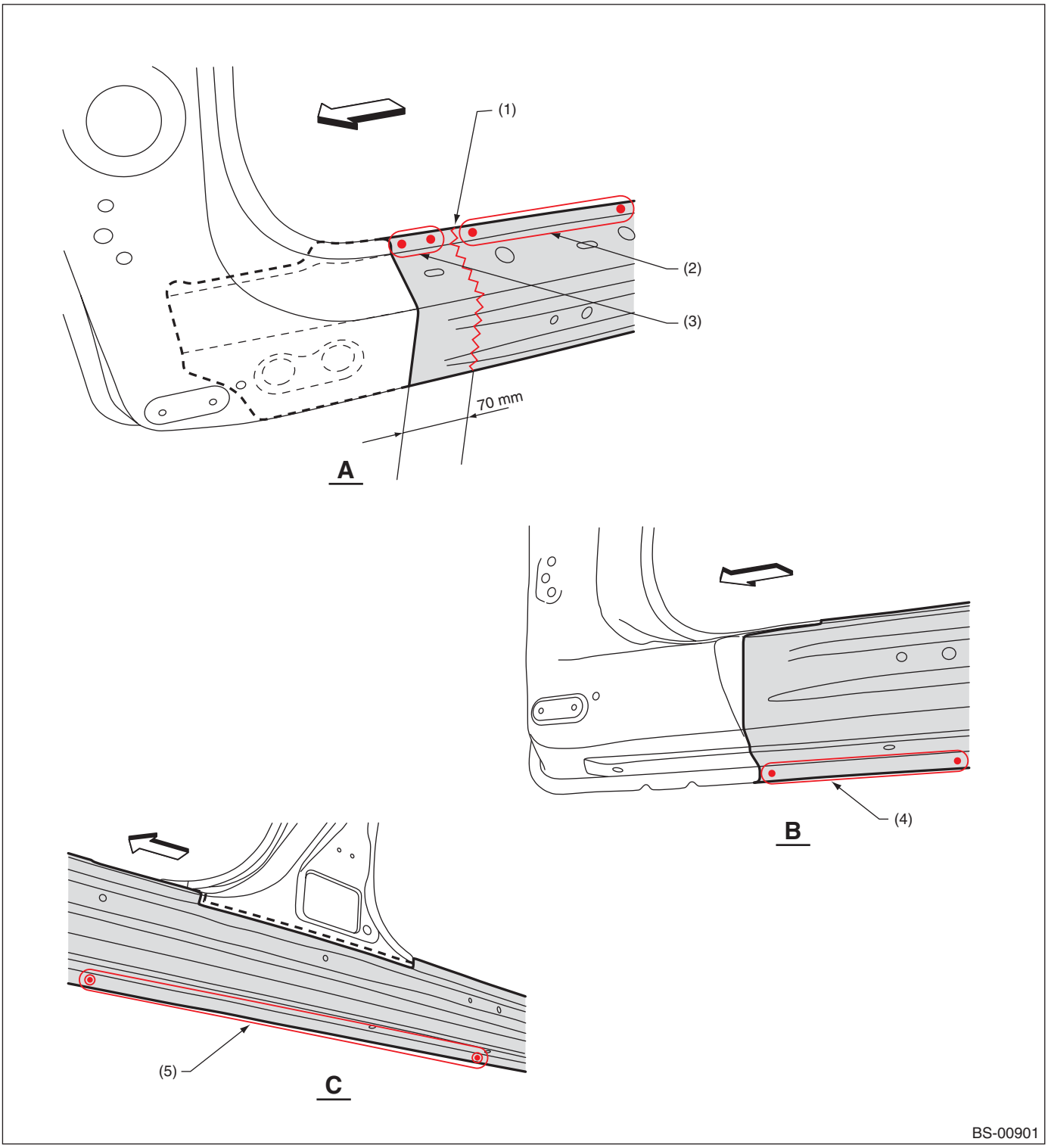


(1) 7 points (outside · 1)

(2) 13 points (outside · 1)

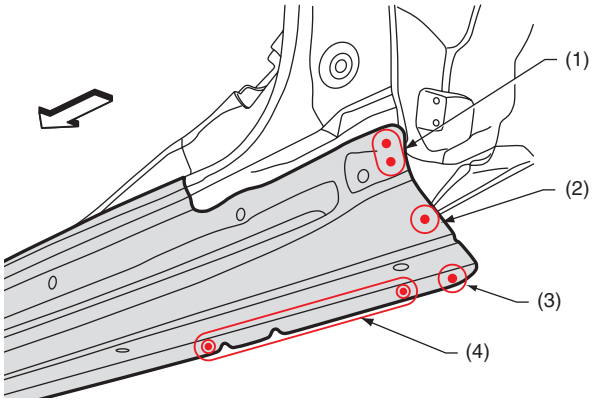
Side Sill Outer (partial replacement)

- **Views 1**

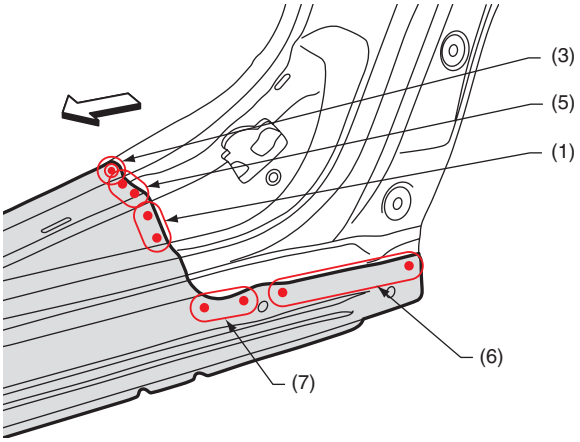


(1) Cut (270 mm)
(2) 6 points (outside · 1)
(3) 2 points (outside · 1)
(4) 9 points (outside · 1)
(5) 24 points (outside · 1)

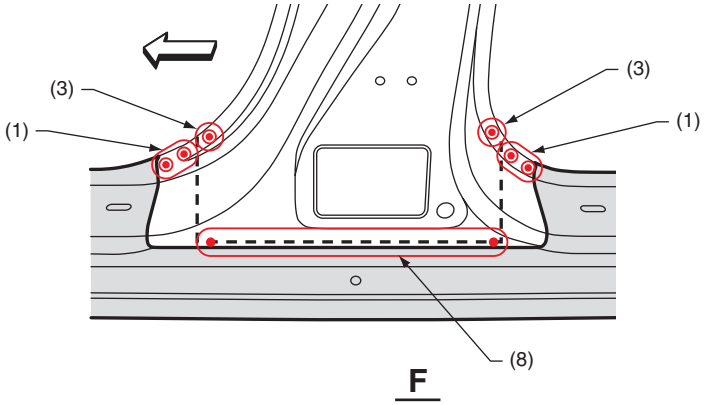
- The side sill outer is inside the front pillar
- (1) is to make work easier.



D



E



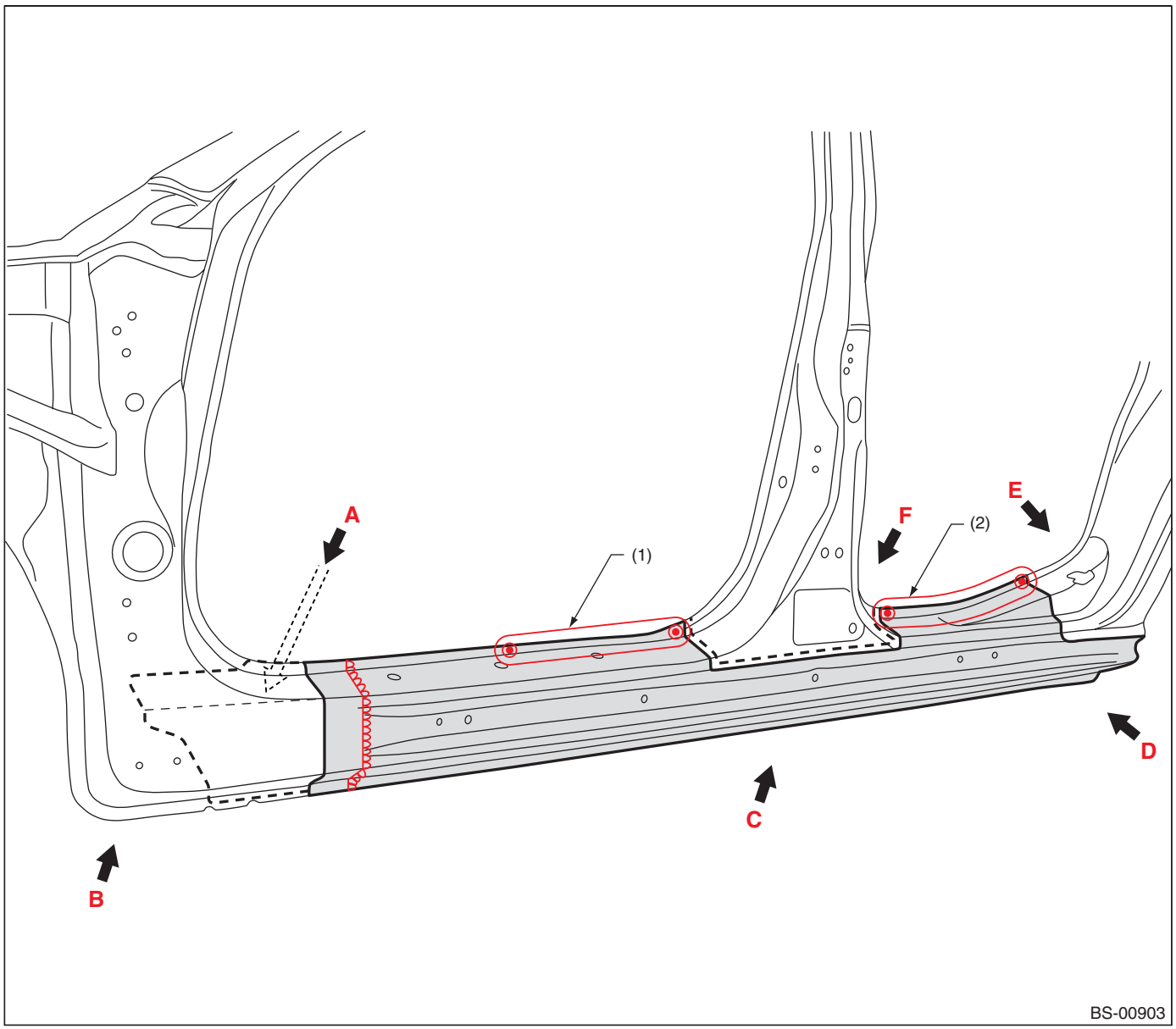
F

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)

B: INSTALLATION

- **Overall view**

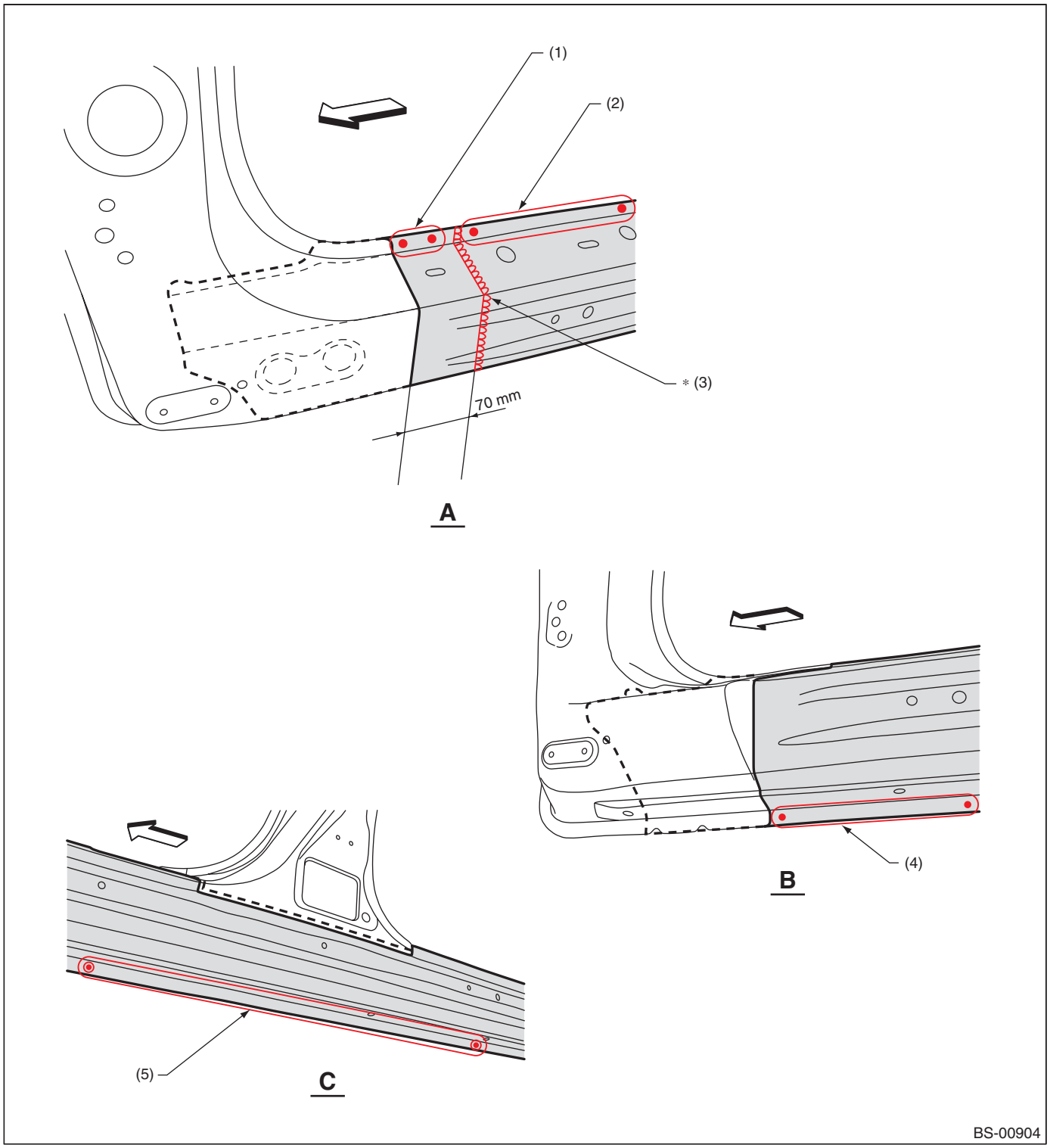


(1) 9 points (2) 16 points

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

Side Sill Outer (partial replacement)

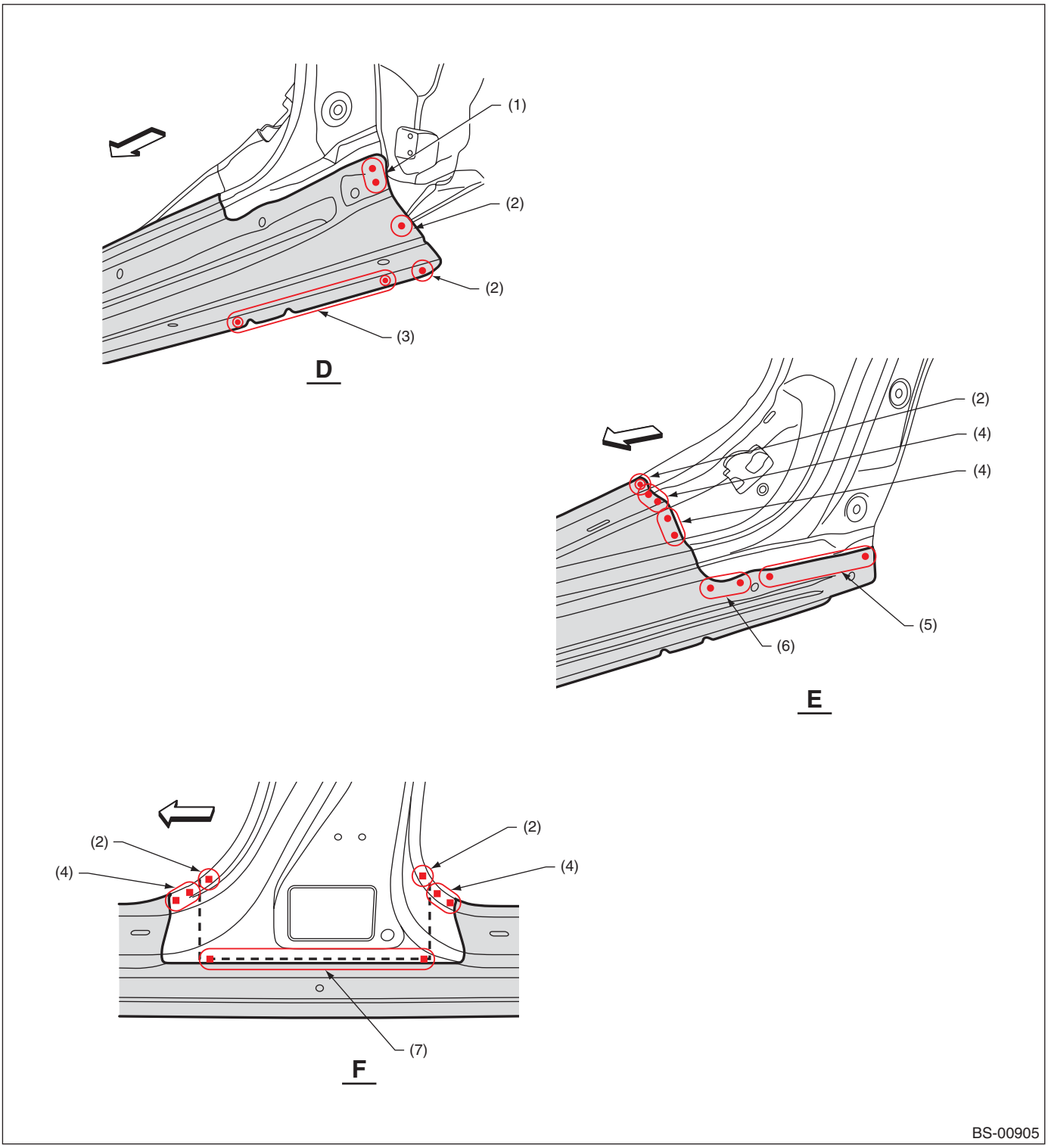
- **Views 1**



(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.

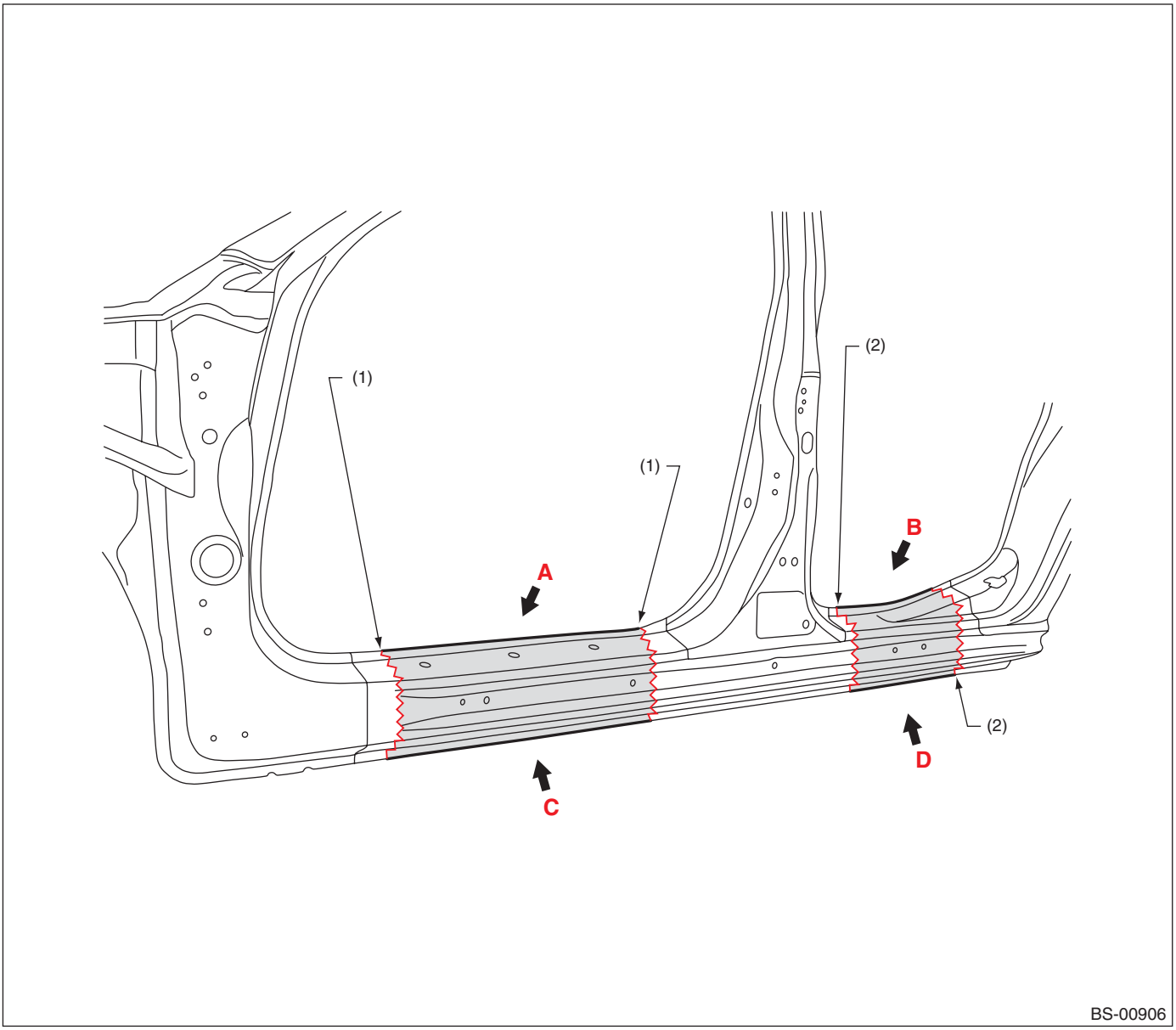
- **Views 2**



(1) 3 points
(2) 1 point
(3) 12 points
(4) 2 points
(5) 6 points
(6) 4 points
(7) 9 points

C: REMOVAL

- **Overall view**

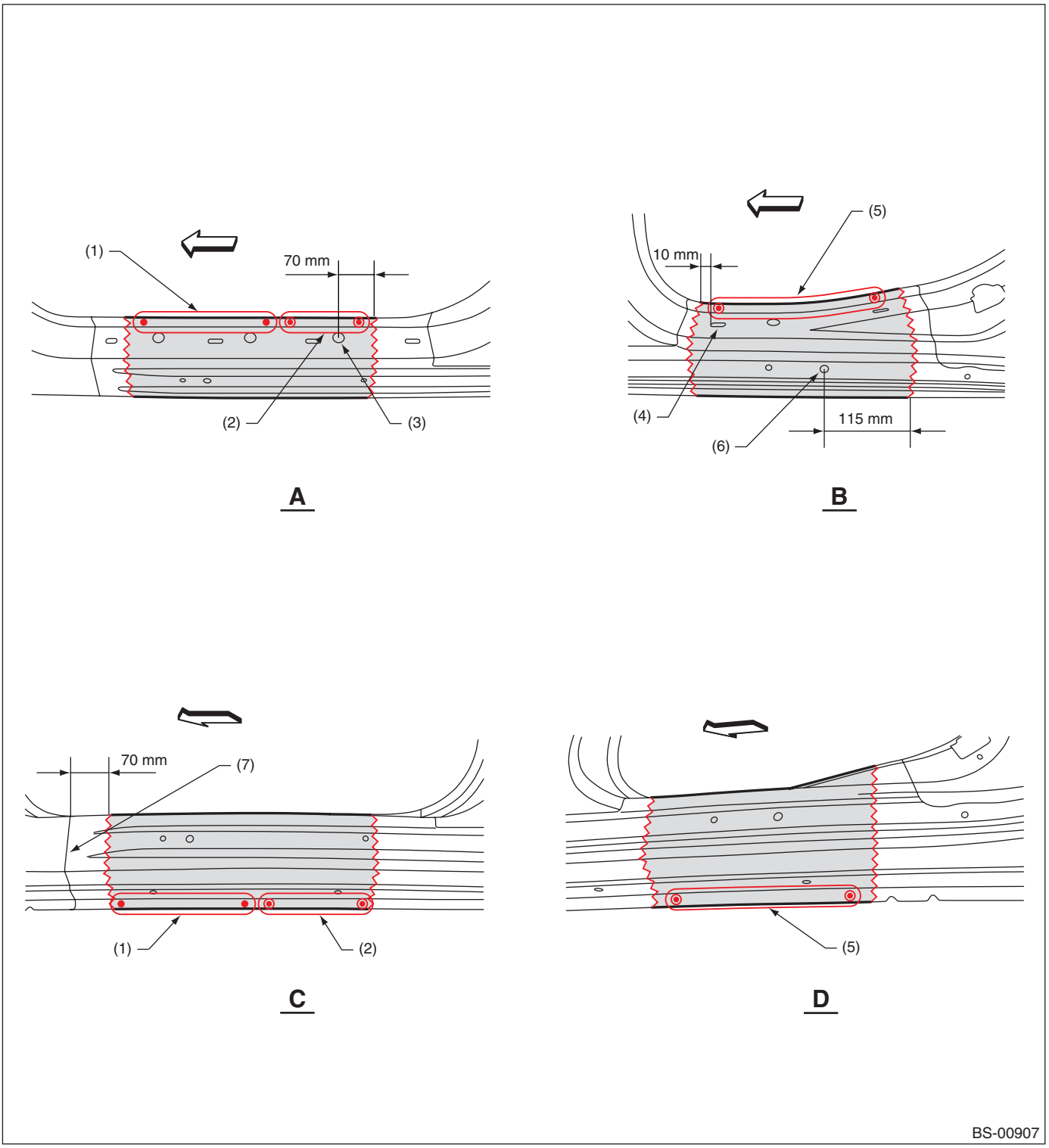


(1) Front cutting position (270 mm) (for butt welding)

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

Side Sill Outer (partial replacement)

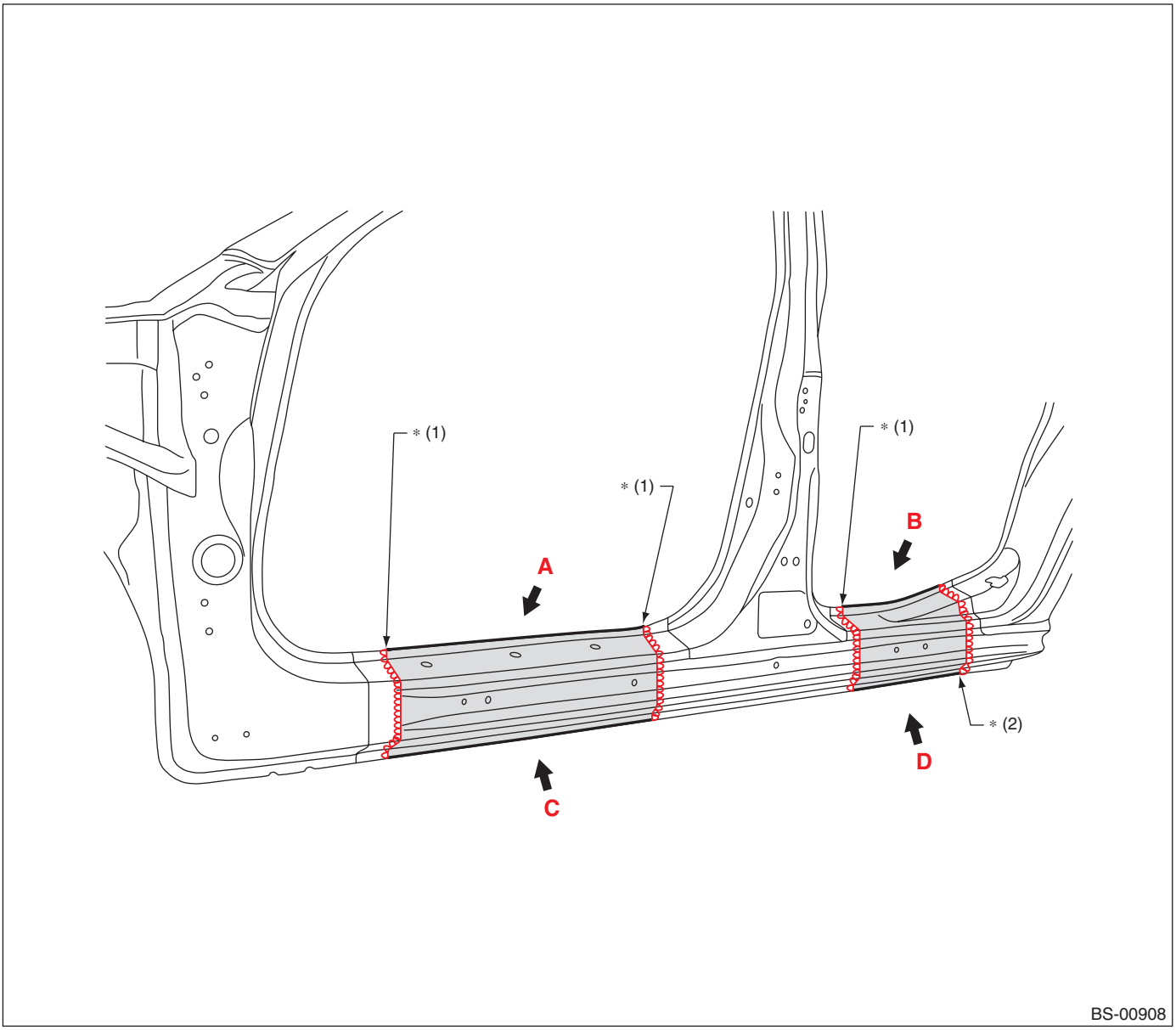
- **Views**



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

D: INSTALLATION

- **Overall view**

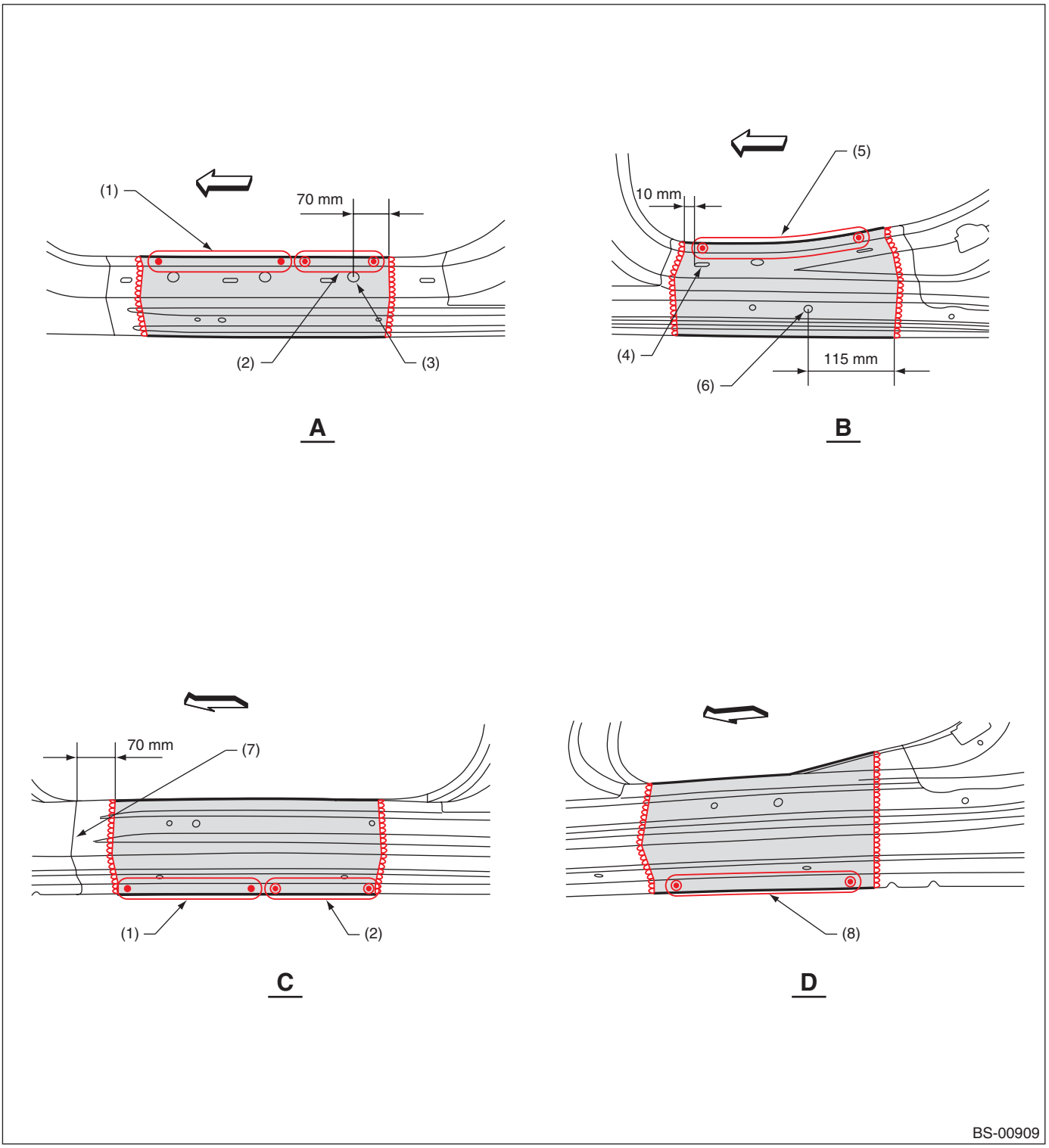


(1) 1 point (270 mm) (butt welding) (2) 1 point (300 mm) (butt welding)

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

Side Sill Outer (partial replacement)

- **Views**

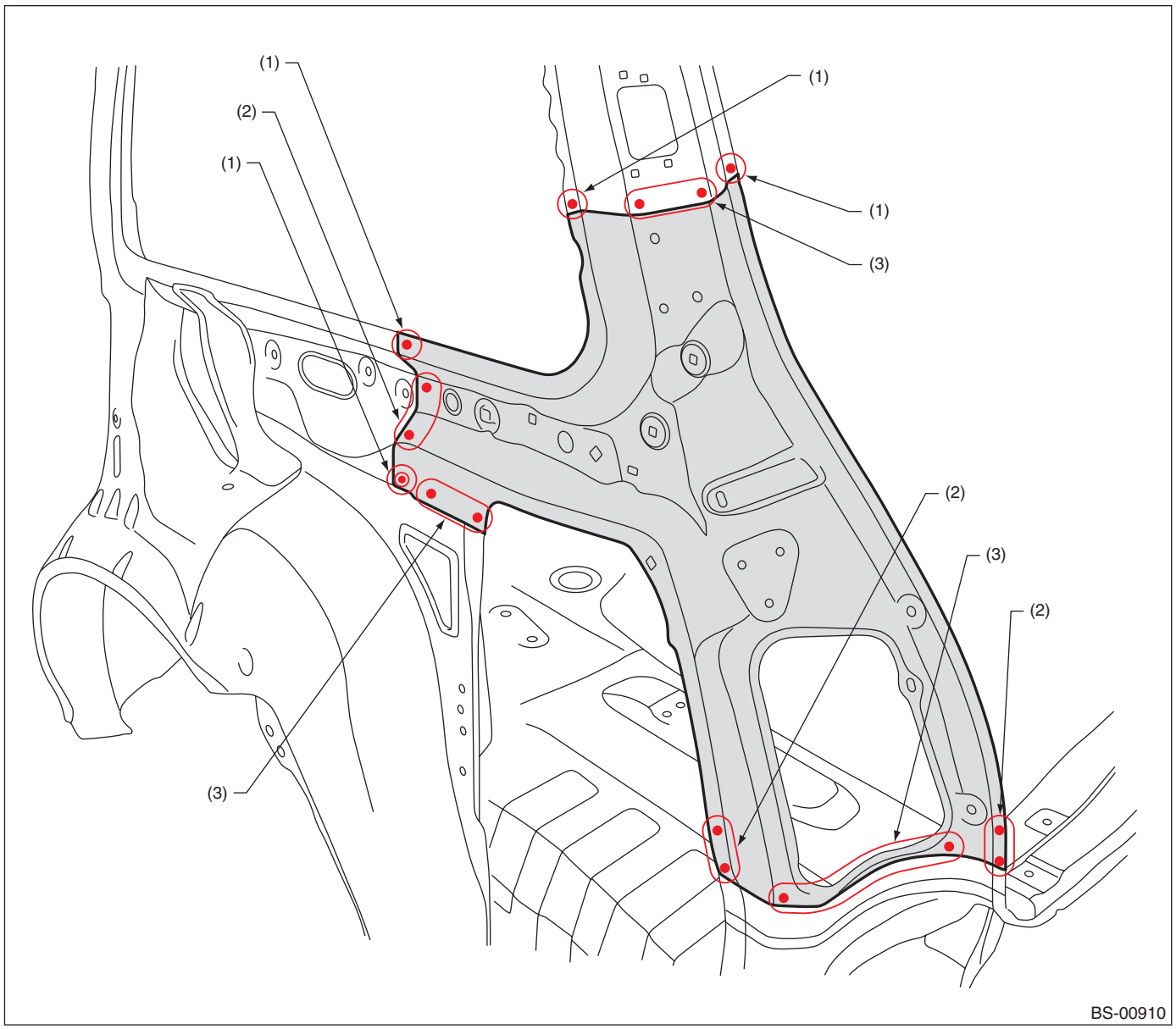


(1) 9 points
(2) 7 points
(3) 20 mm dia. hole
(4) 8 × 25 elongated hole
(5) 14 points
(6) 12 mm dia. hole
(7) Front pillar
(8) 13 points

26.Rear Quarter Upper / Wagon (total replacement)

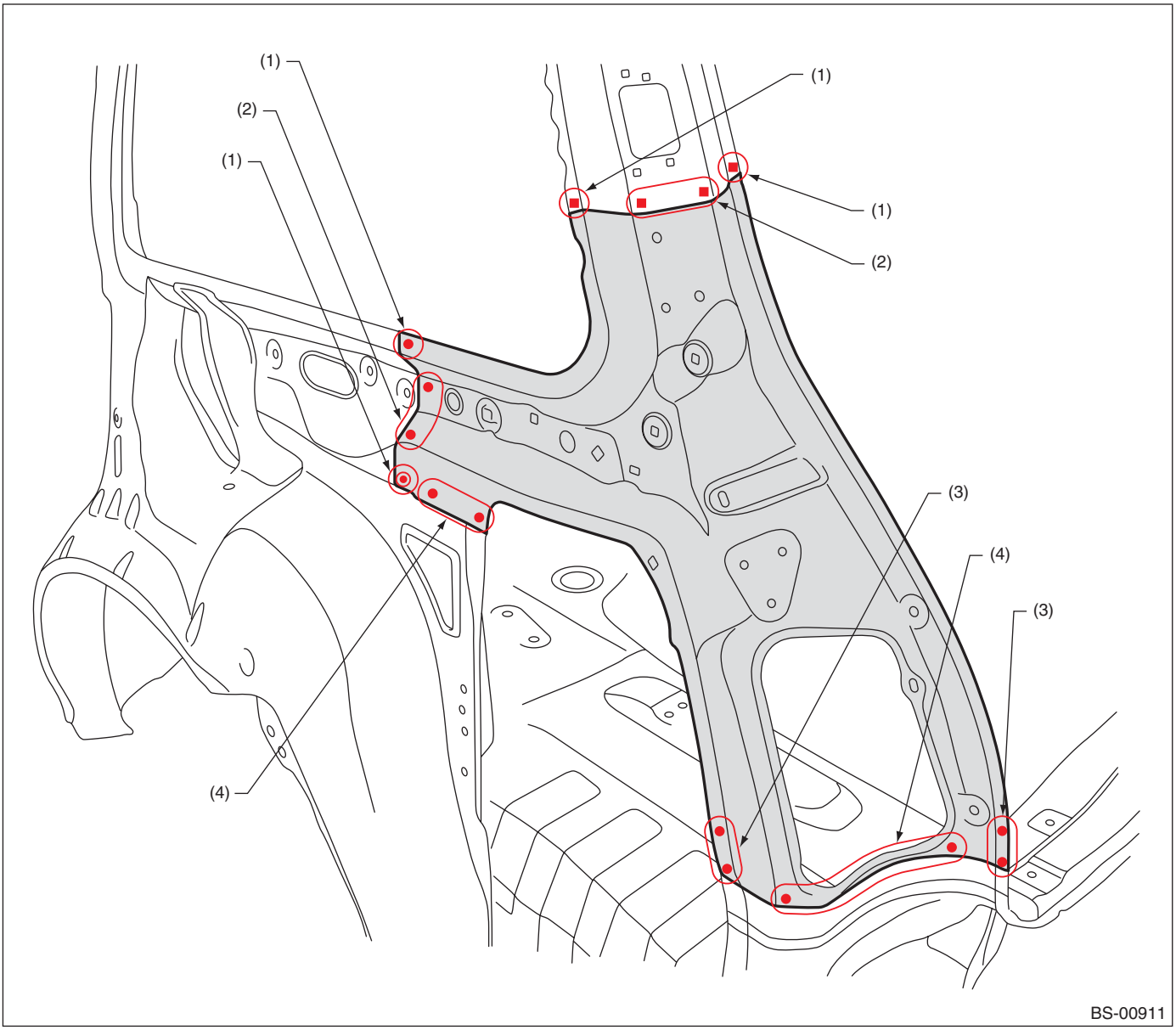
A: REMOVAL

1) Rear quarter and reinforcement D-pillar removed condition



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

B: INSTALLATION



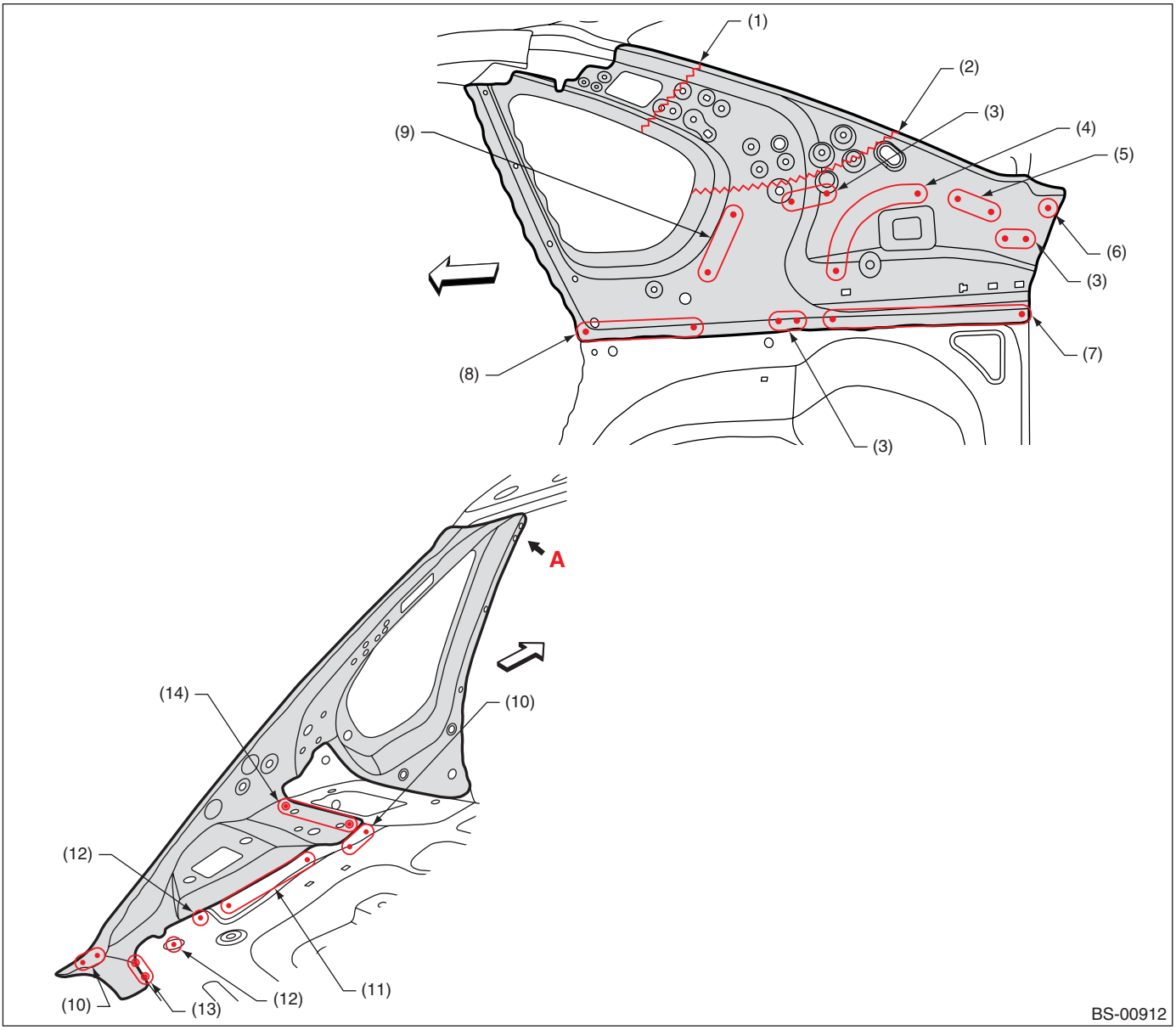
(1) 1 point
(2) 3 points
(3) 2 points
(4) 4 points

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

A: REMOVAL

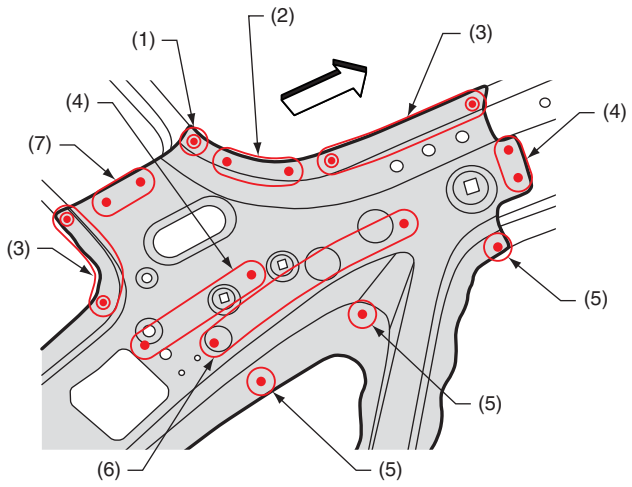
1) Rear quarter and reinforcement removed condition

- **Overall view**



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

- **Views**



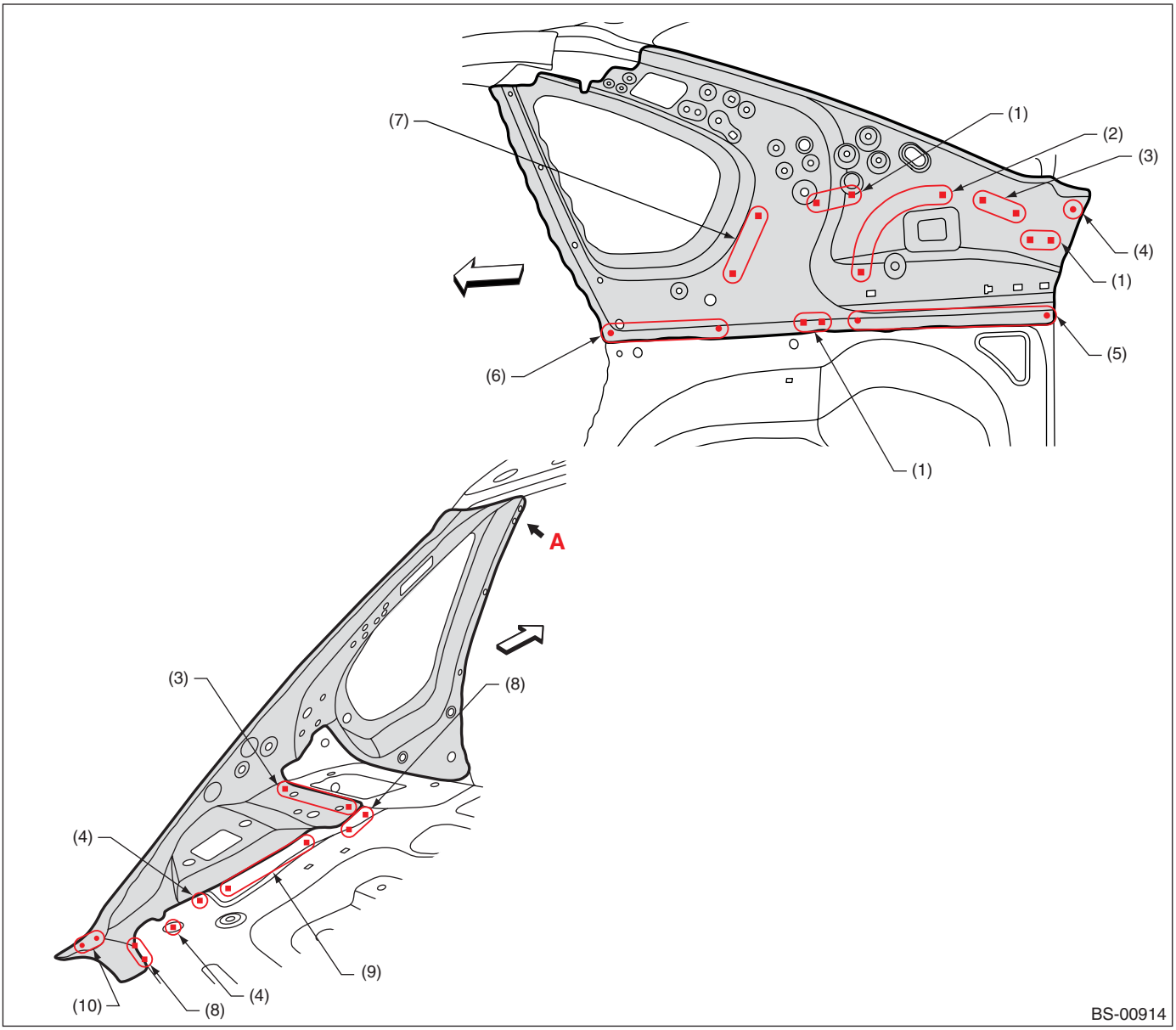
A

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)

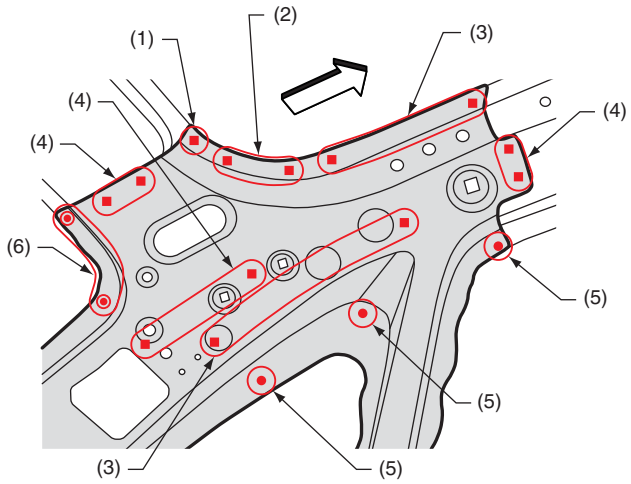
B: INSTALLATION

- **Overall view**



(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

- **Views**



A

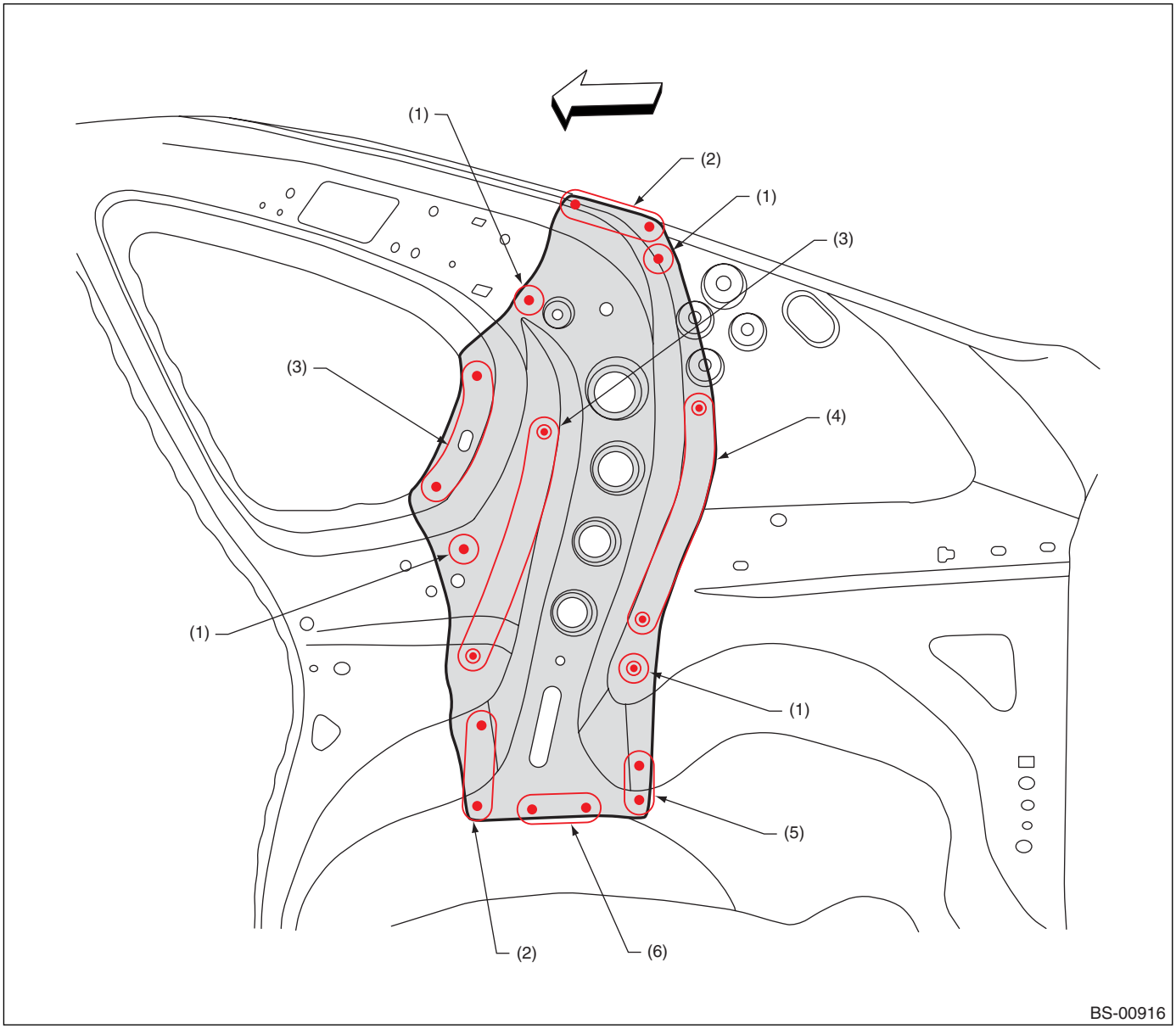
BS-00915

(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)

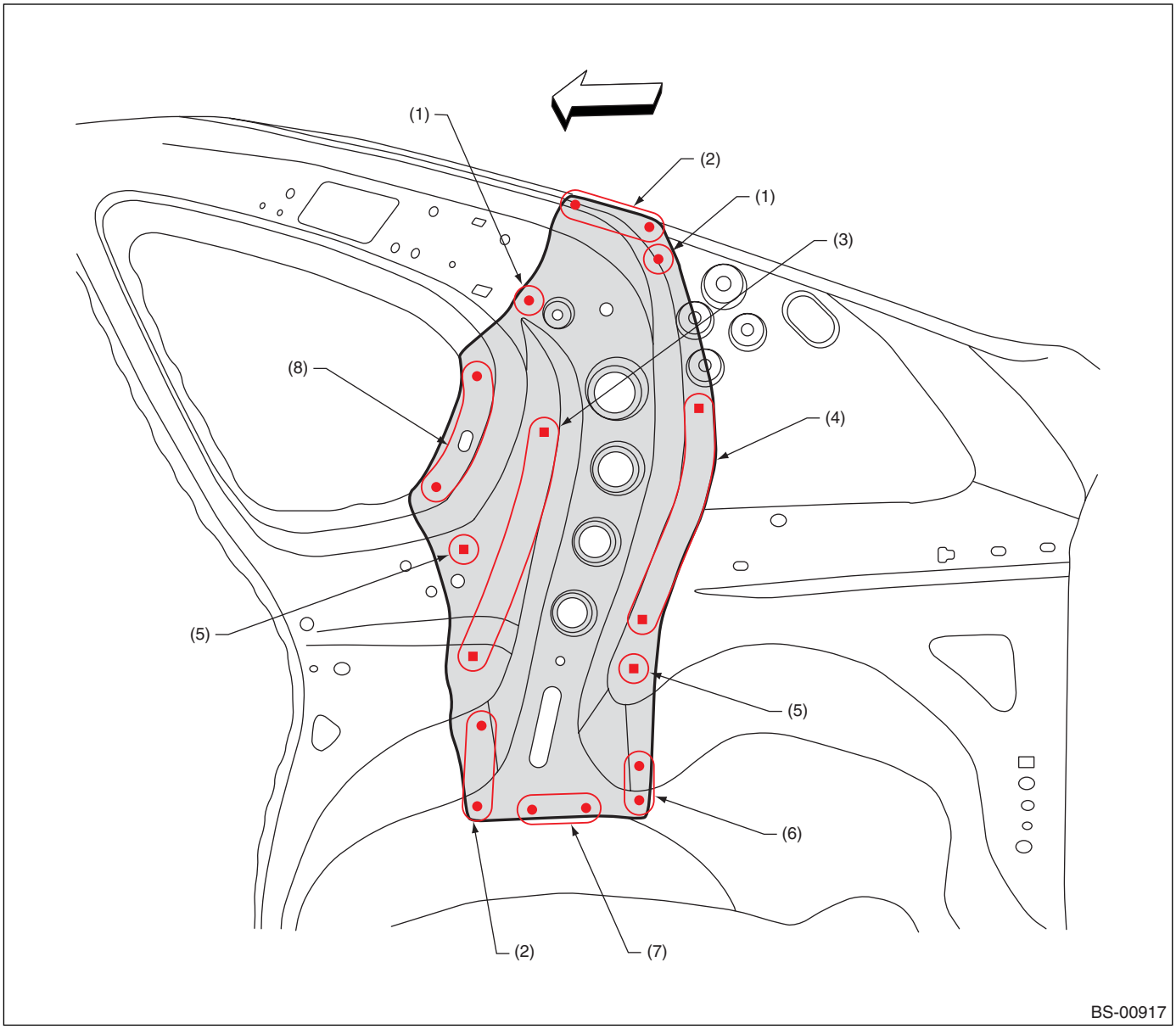
A: REMOVAL

1) Rear quarter removal condition



(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)

B: INSTALLATION



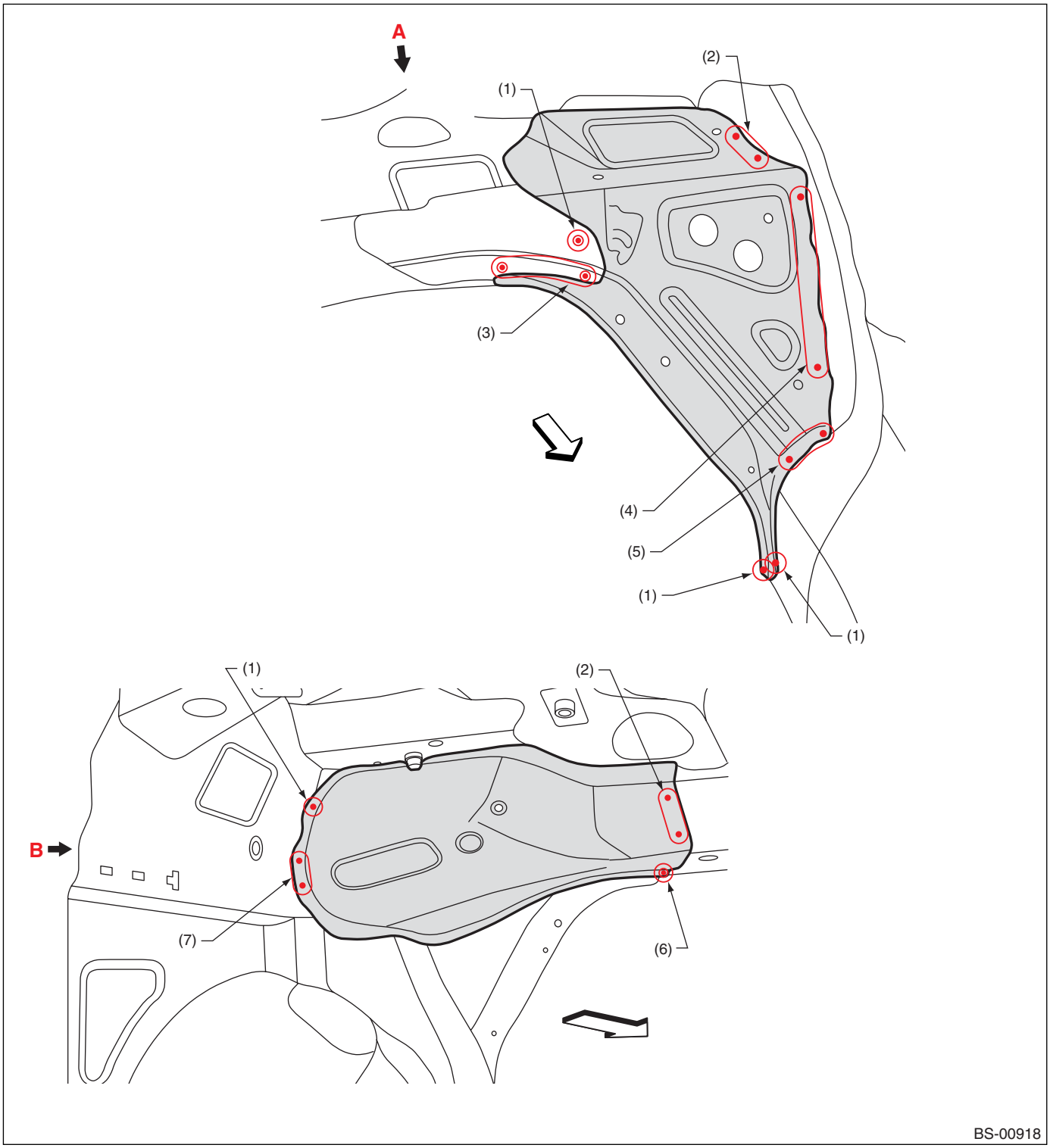
(1) 1 point
(2) 4 points
(3) 5 points (service)
(4) 3 points (service)
(5) 1 point (service)
(6) 3 points
(7) 2 points
(8) 6 points

29.Rear Bulkhead / Sedan (total replacement)

A: REMOVAL

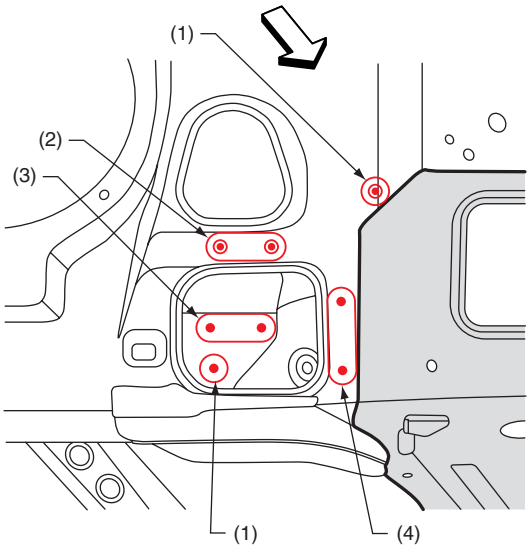
1) Rear quarter, rear quarter inner upper and reinforcement removed condition

- **Overall view**

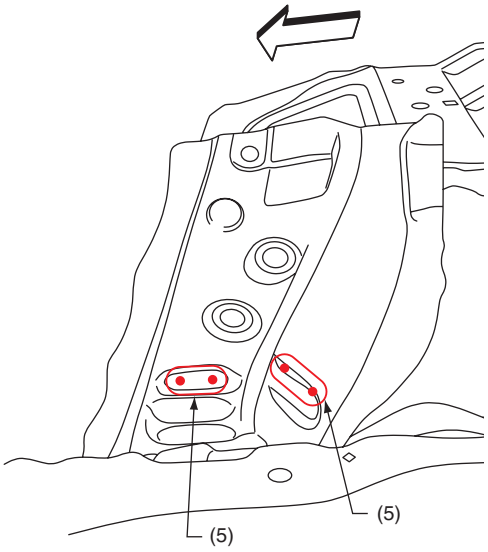


(1) 1 point (inside · 1)
(2) 2 points (outside · 1)
(3) 3 points (inside · 1)
(4) 5 points (inside · 1)
(5) 2 points (top · 1)
(6) 1 point (outside · 1)
(7) 2 points (inside · 1)

- **Views**



A



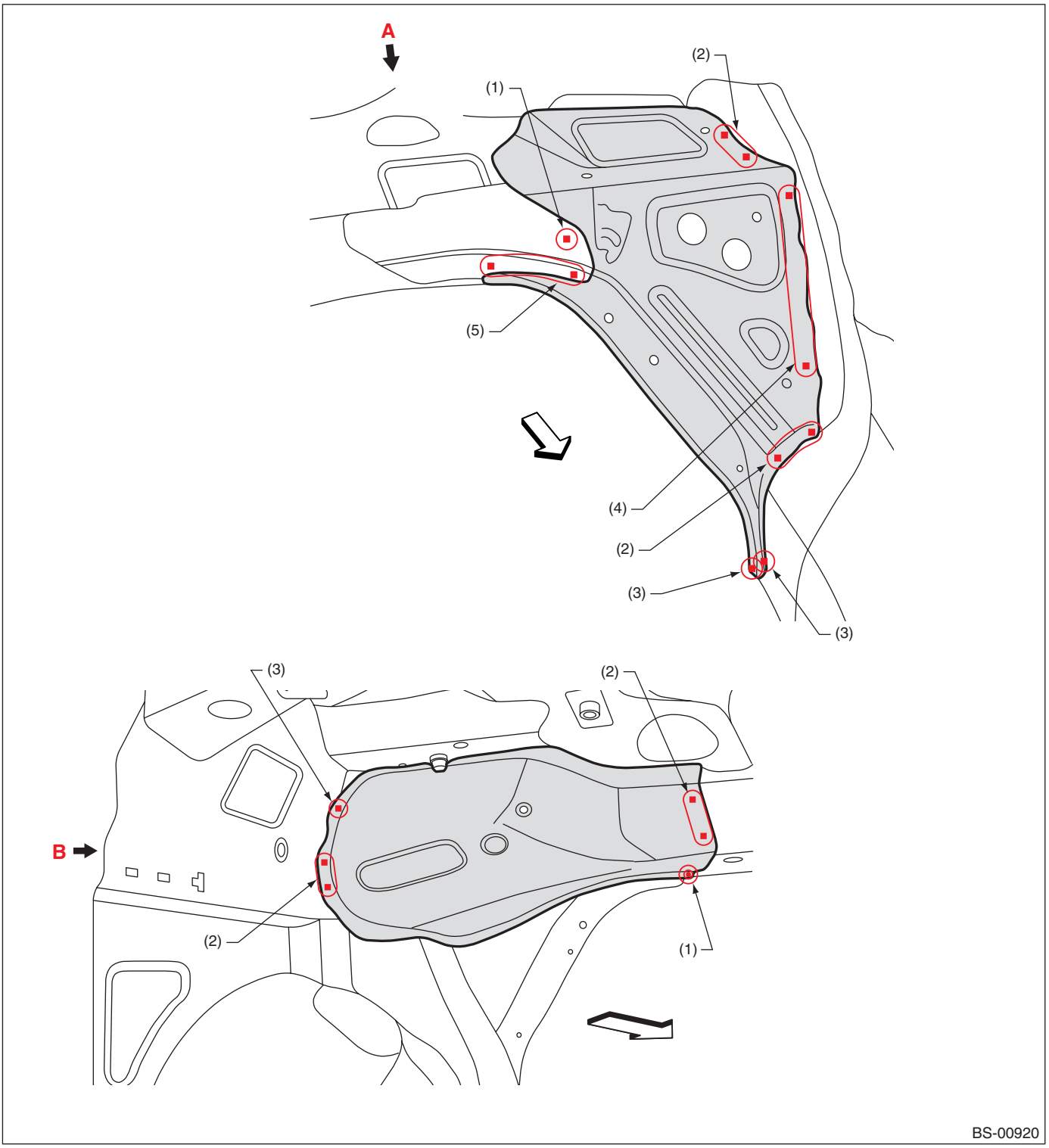
B

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)

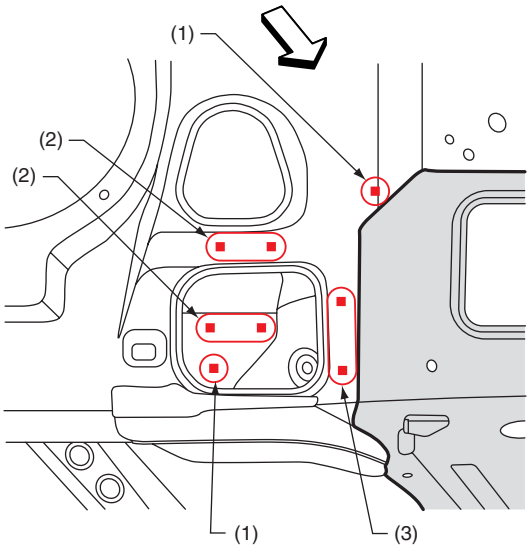
B: INSTALLATION

- **Overall view**

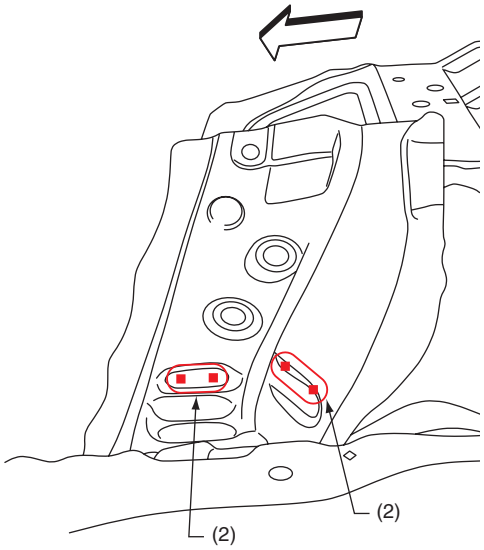


(1) 1 point
(2) 2 points (service)
(3) 1 point (service)
(4) 5 points (service)
(5) 3 points

- **Views**



A



B

BS-00921

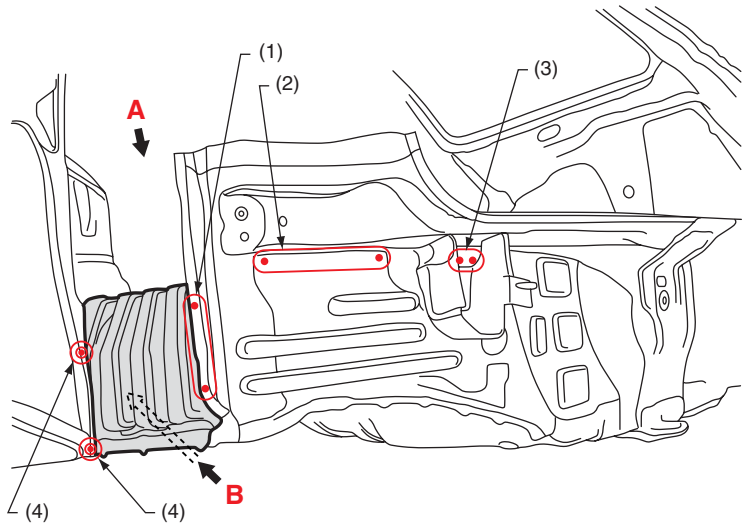
(1) 1 point (2) 2 points (3) 3 points

30.Rear Floor Side / Wagon (total replacement)

A: REMOVAL

1) Rear quarter and reinforcement D-pillar removed condition

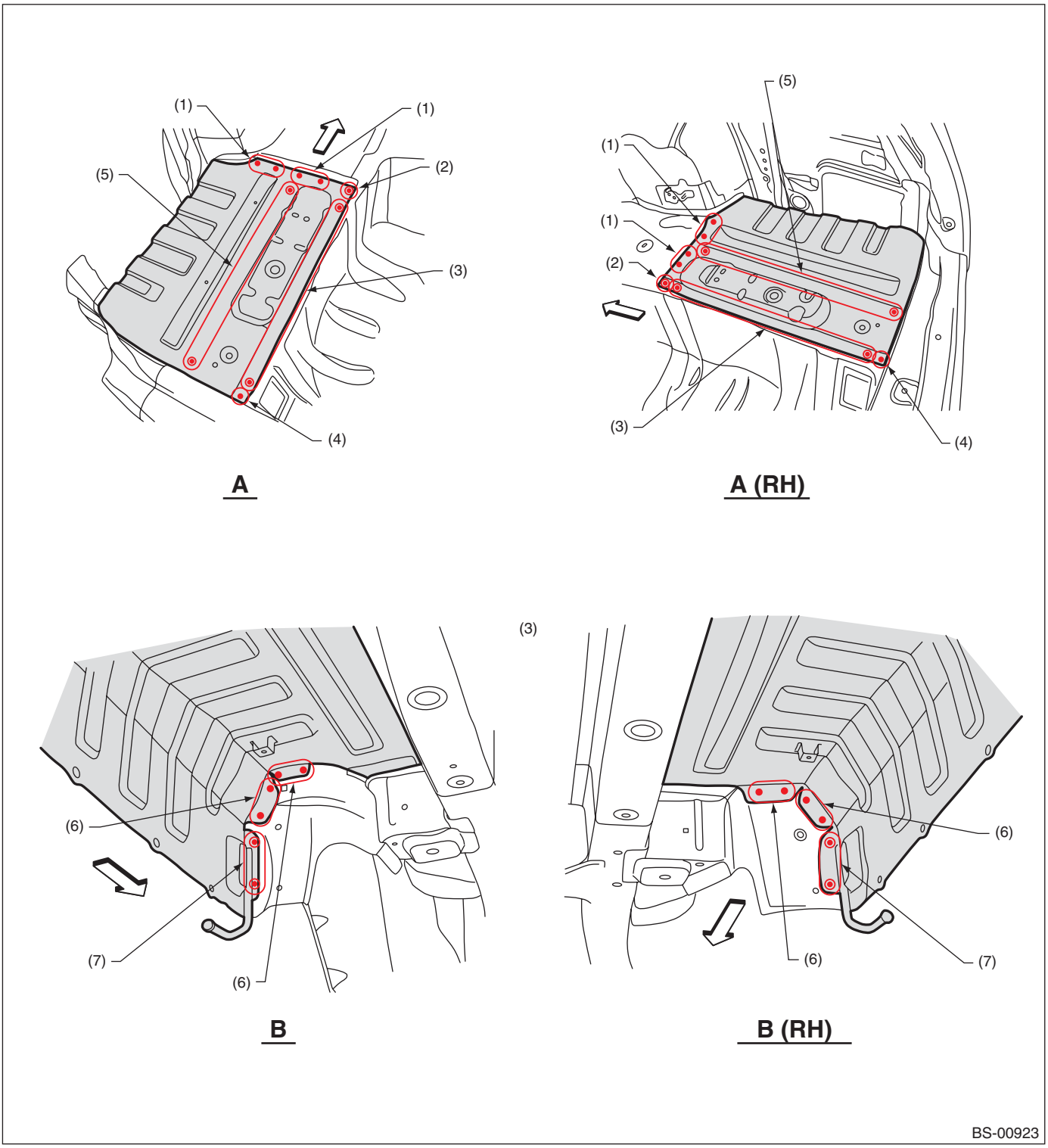
- **Overall view**



BS-00922

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

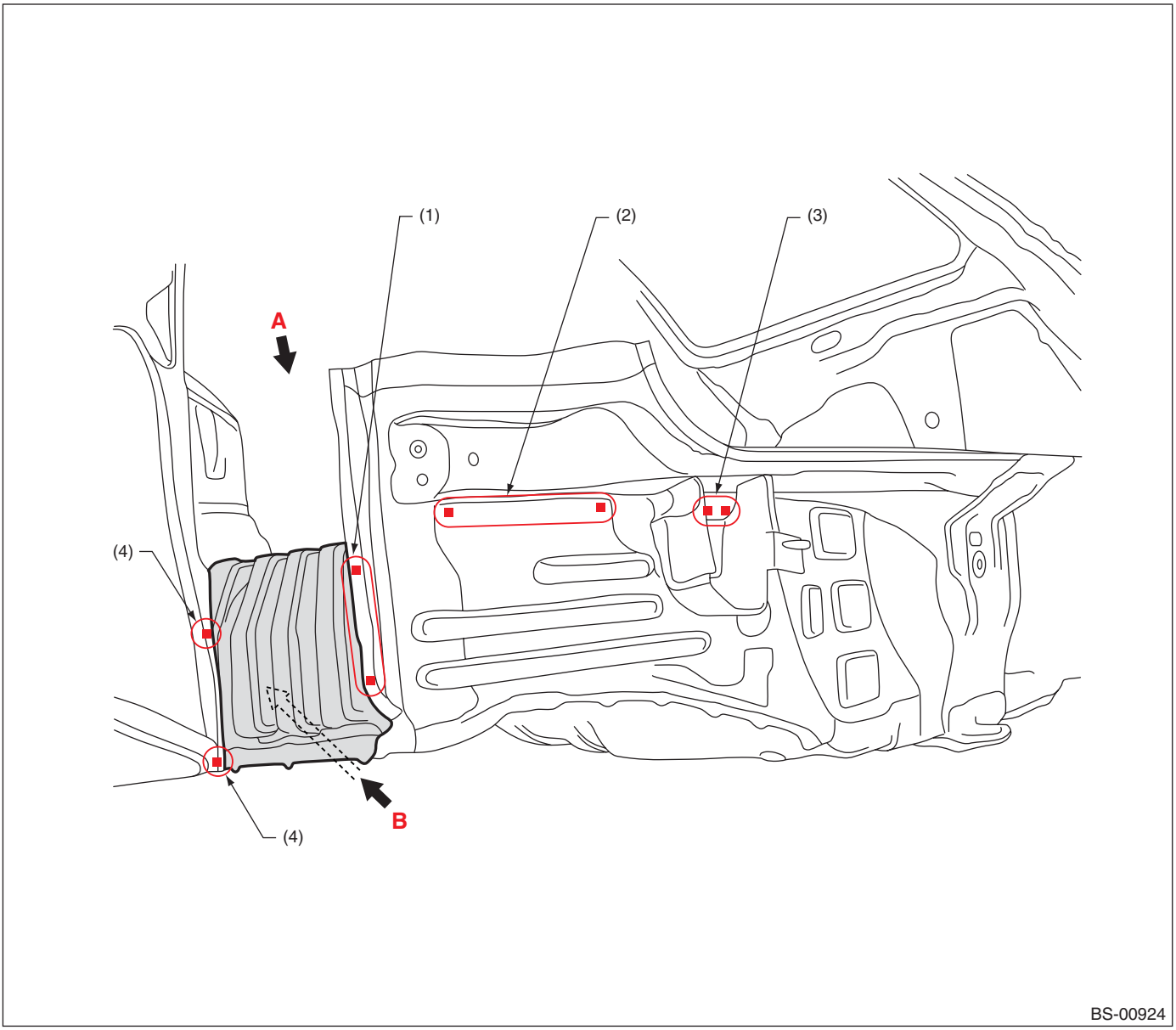
- **Views**



(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)

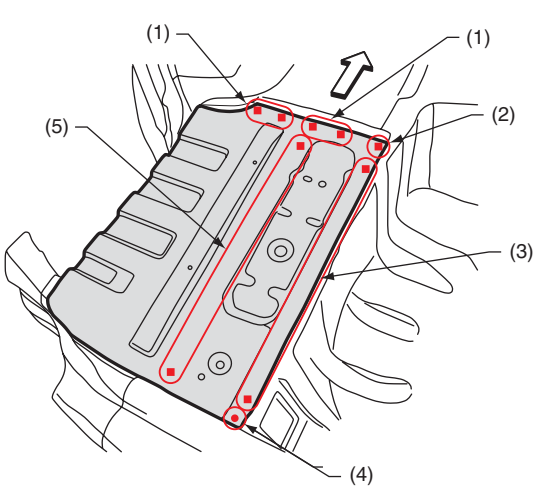
B: INSTALLATION

- **Overall view**

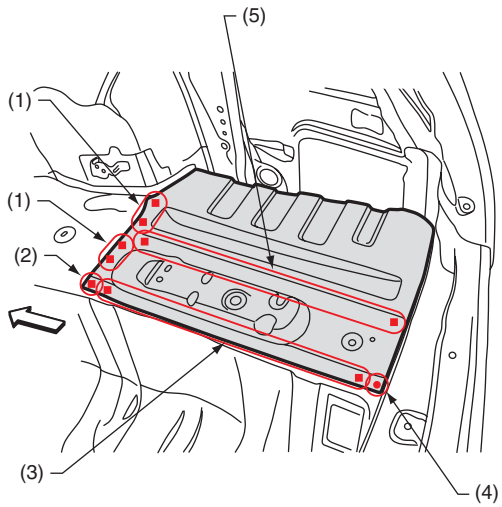


(1) 3 points
(2) 4 points
(3) 2 points
(4) 1 point

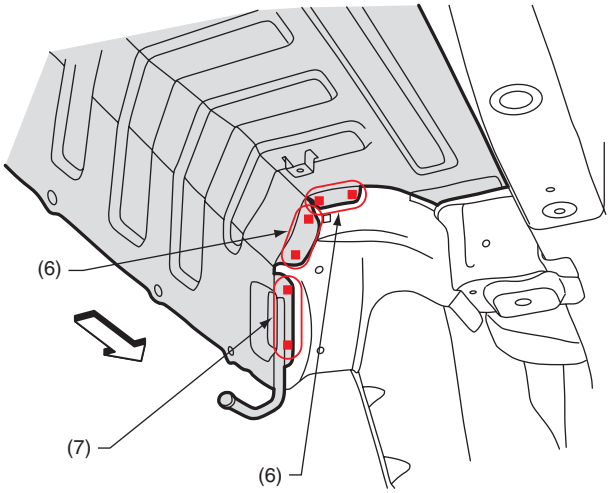
- **Views**



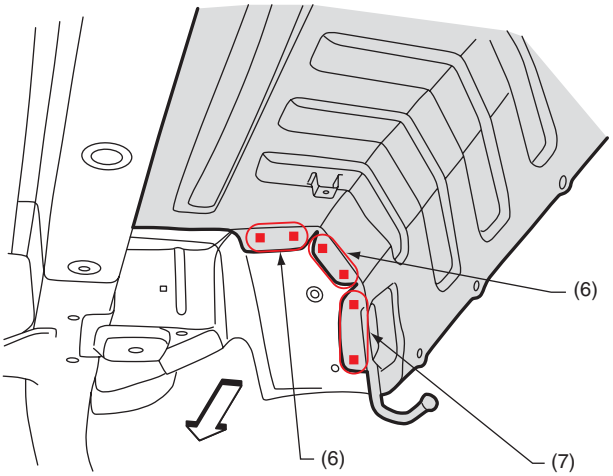
A



A (RH)



B



B (RH)

BS-00925

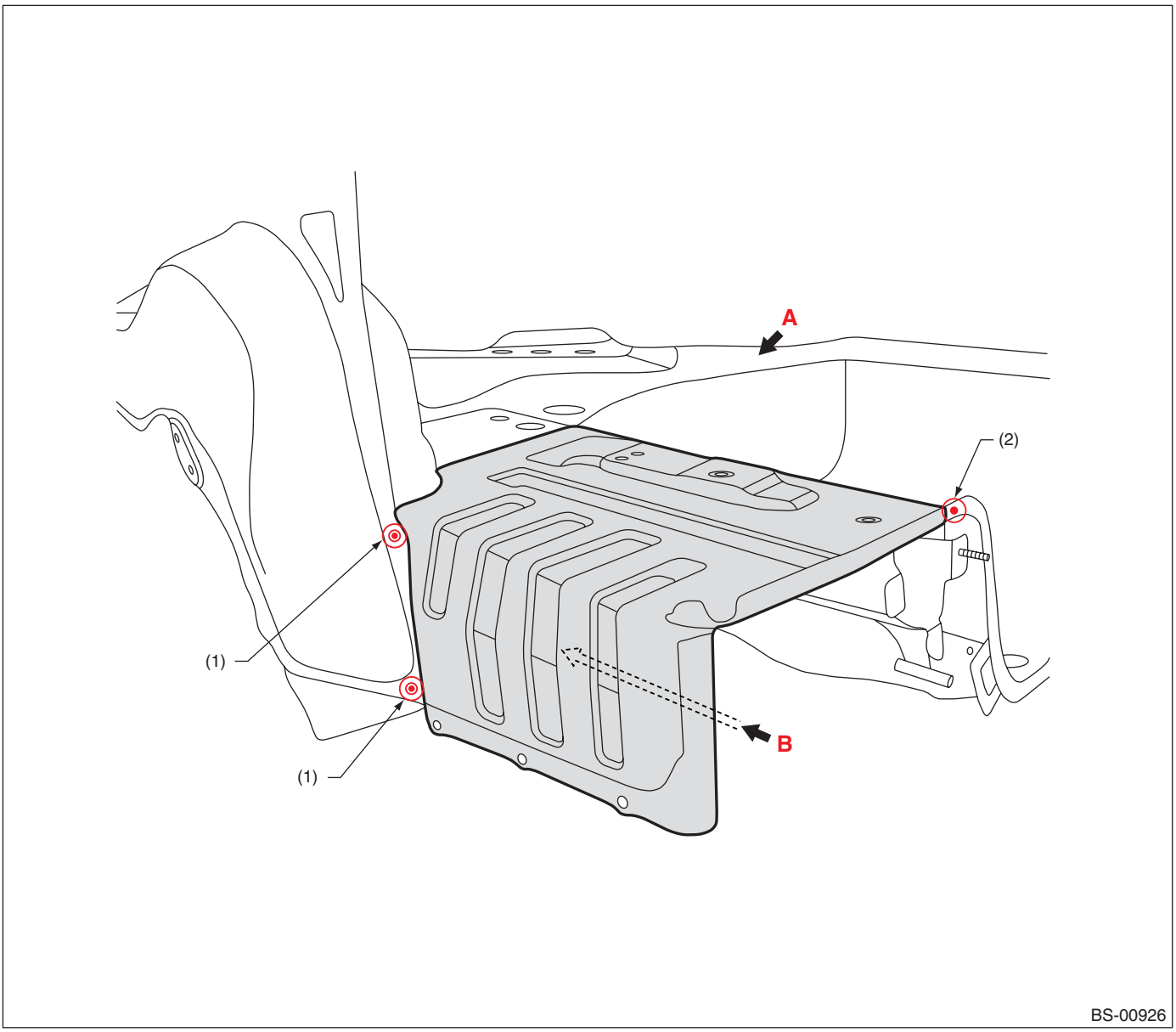
(1) 2 points (service)
(2) 1 point (service)
(3) 14 points (service)
(4) 1 point
(5) 13 points (service)
(6) 2 points
(7) 3 points

31.Rear Floor Side / Sedan (total replacement)

A: REMOVAL

1) Rear quarter and rear skirt removed condition

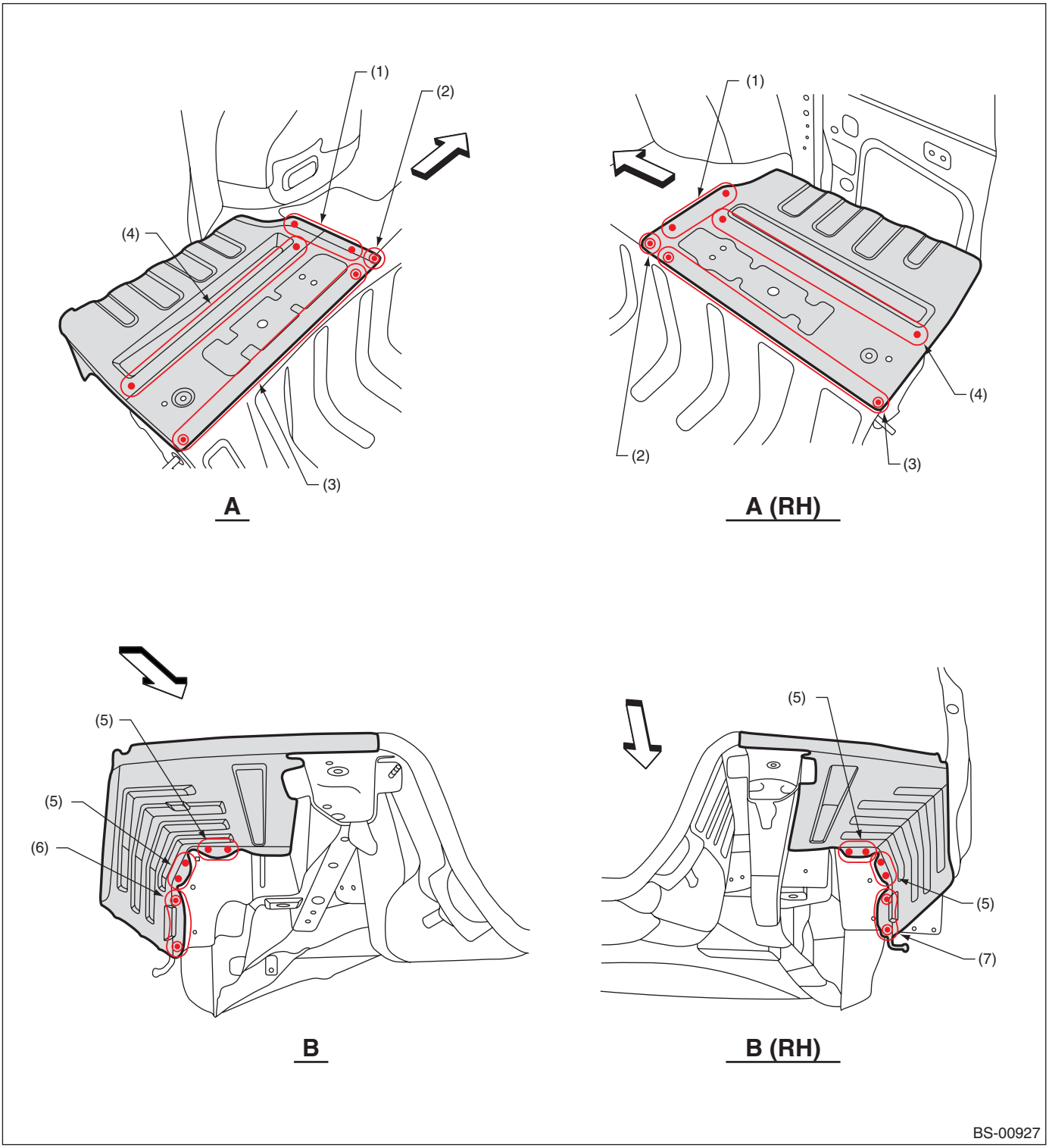
- **Overall view**



(1) 1 point (outside · 2)

(2) 1 point (outside · 1)

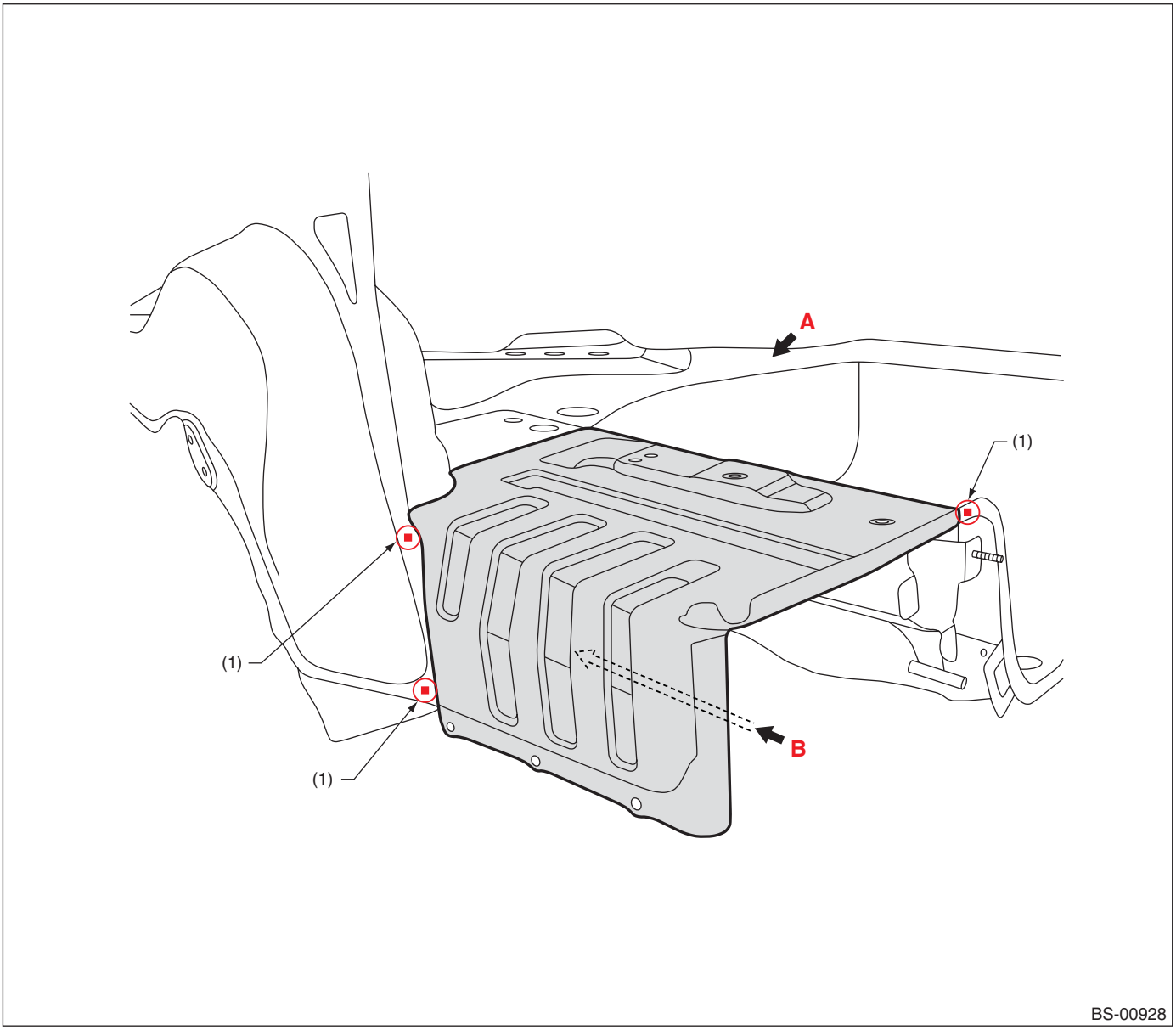
- **Views**



(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)

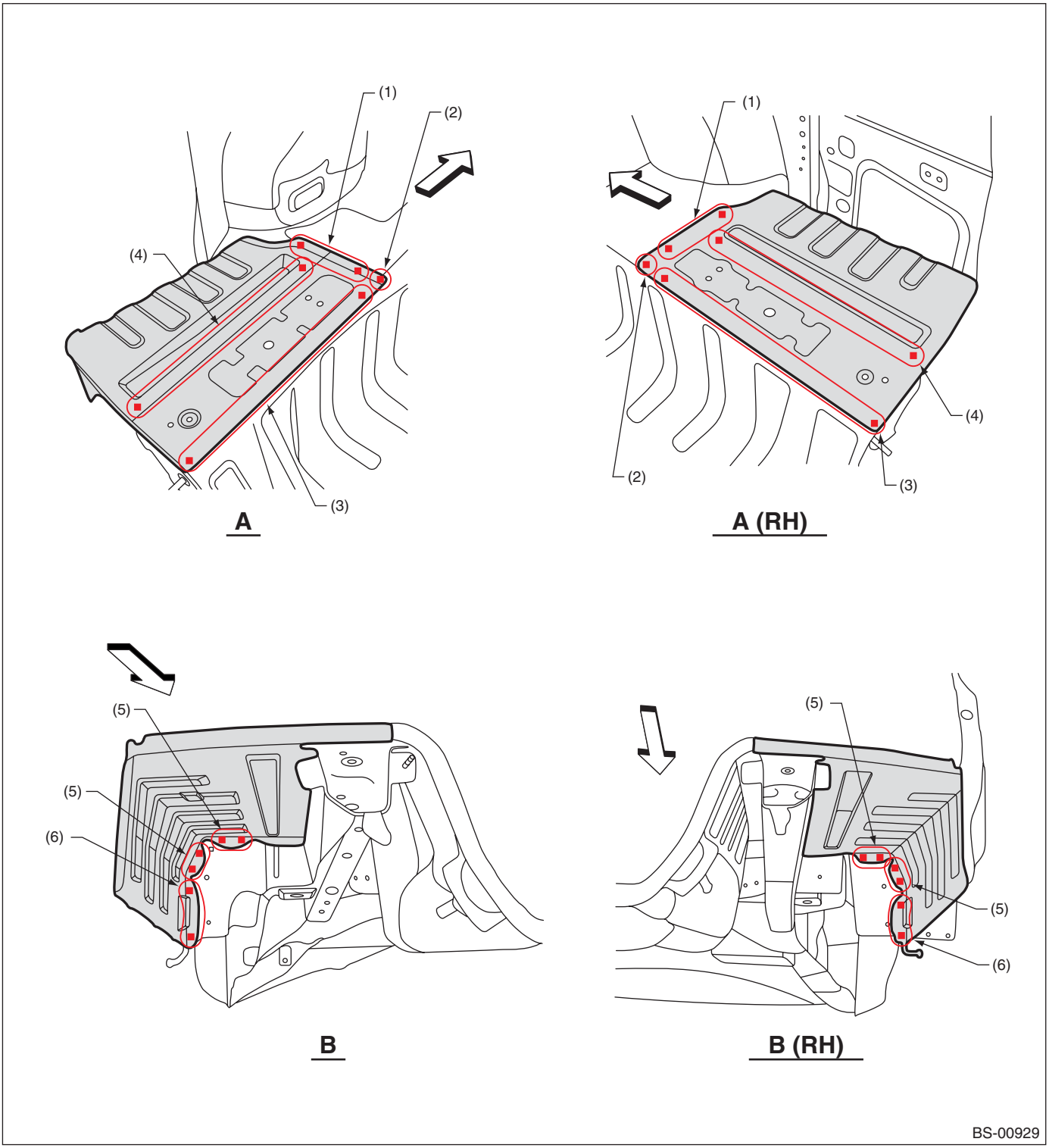
B: INSTALLATION

- **Overall view**



(1) 1 point

- **Views**

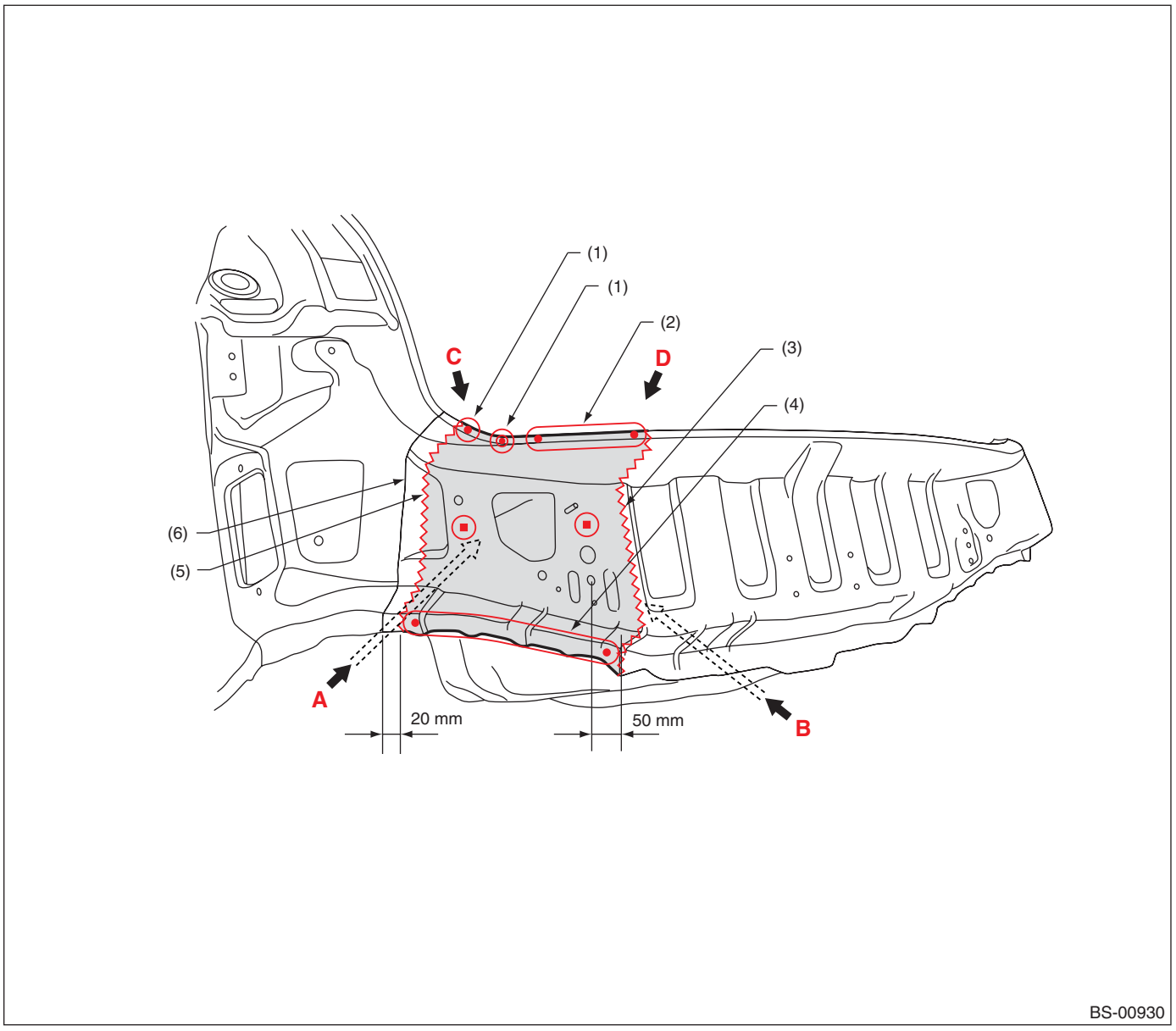


(1) 4 points (service)
(2) 1 point (service)
(3) 14 points (service)
(4) 13 points (service)
(5) 2 points
(6) 3 points

32.Rear Skirt / Wagon (partial replacement)

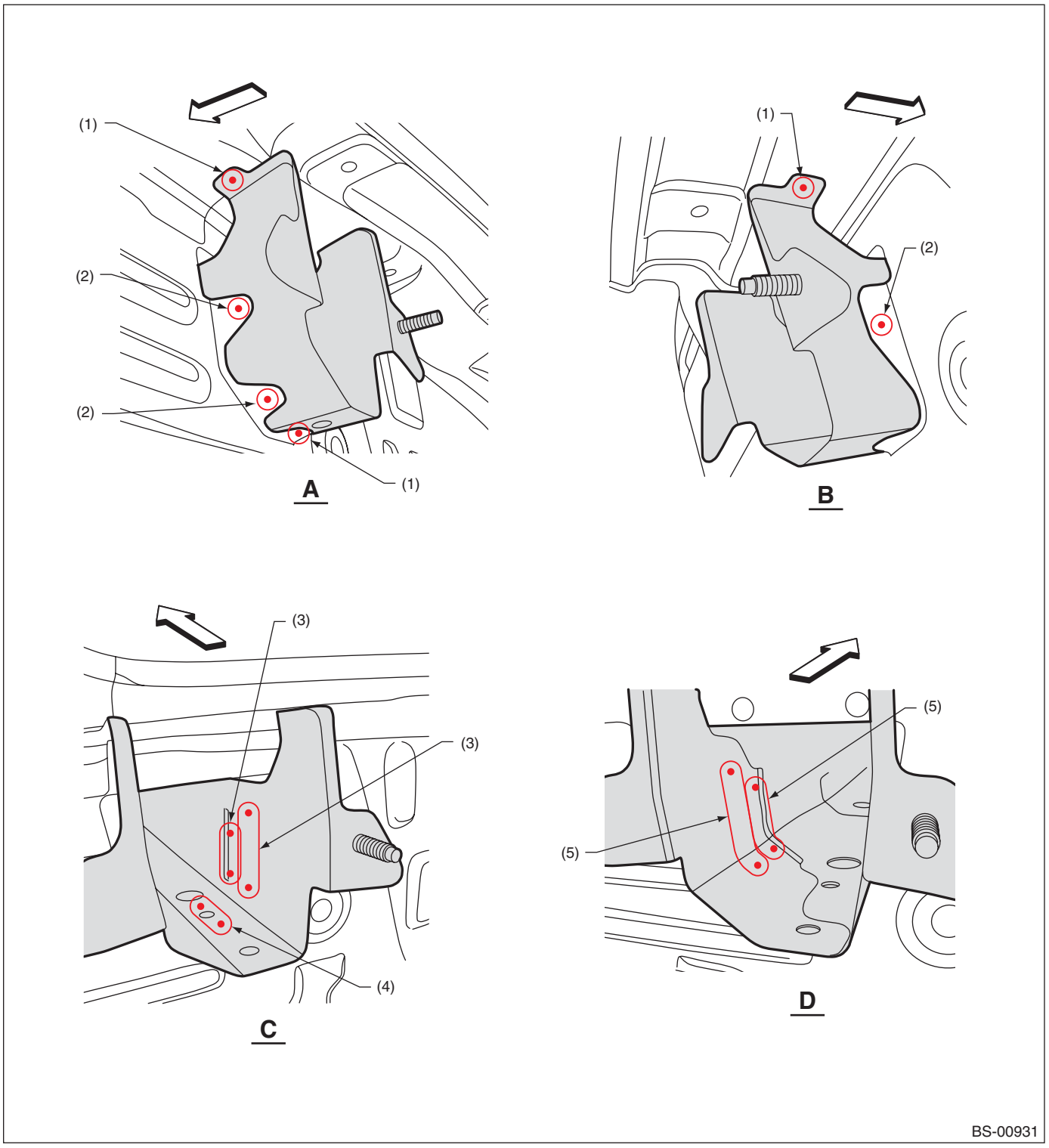
A: REMOVAL

- **Overall view**



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

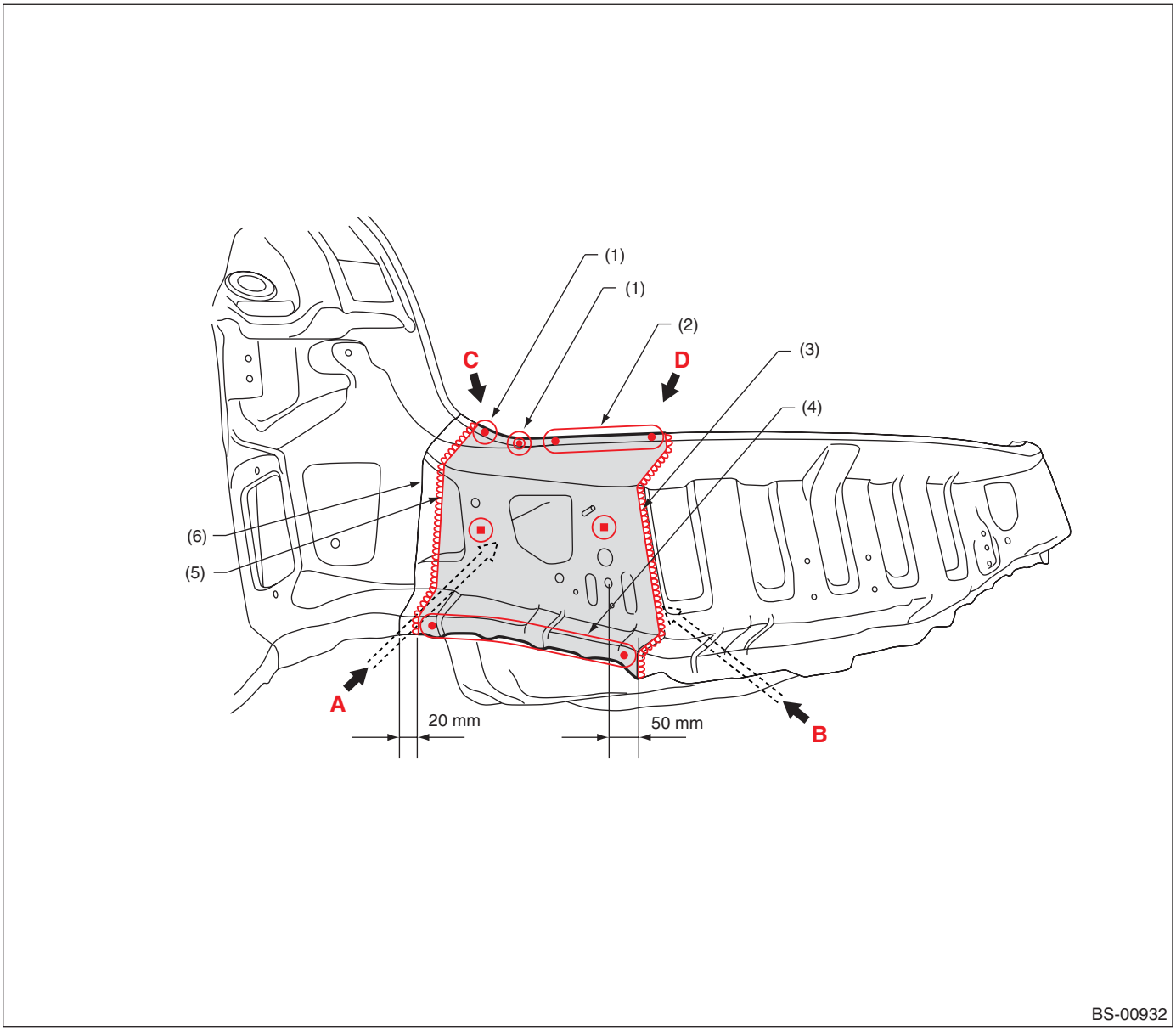
- **Views**



(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)

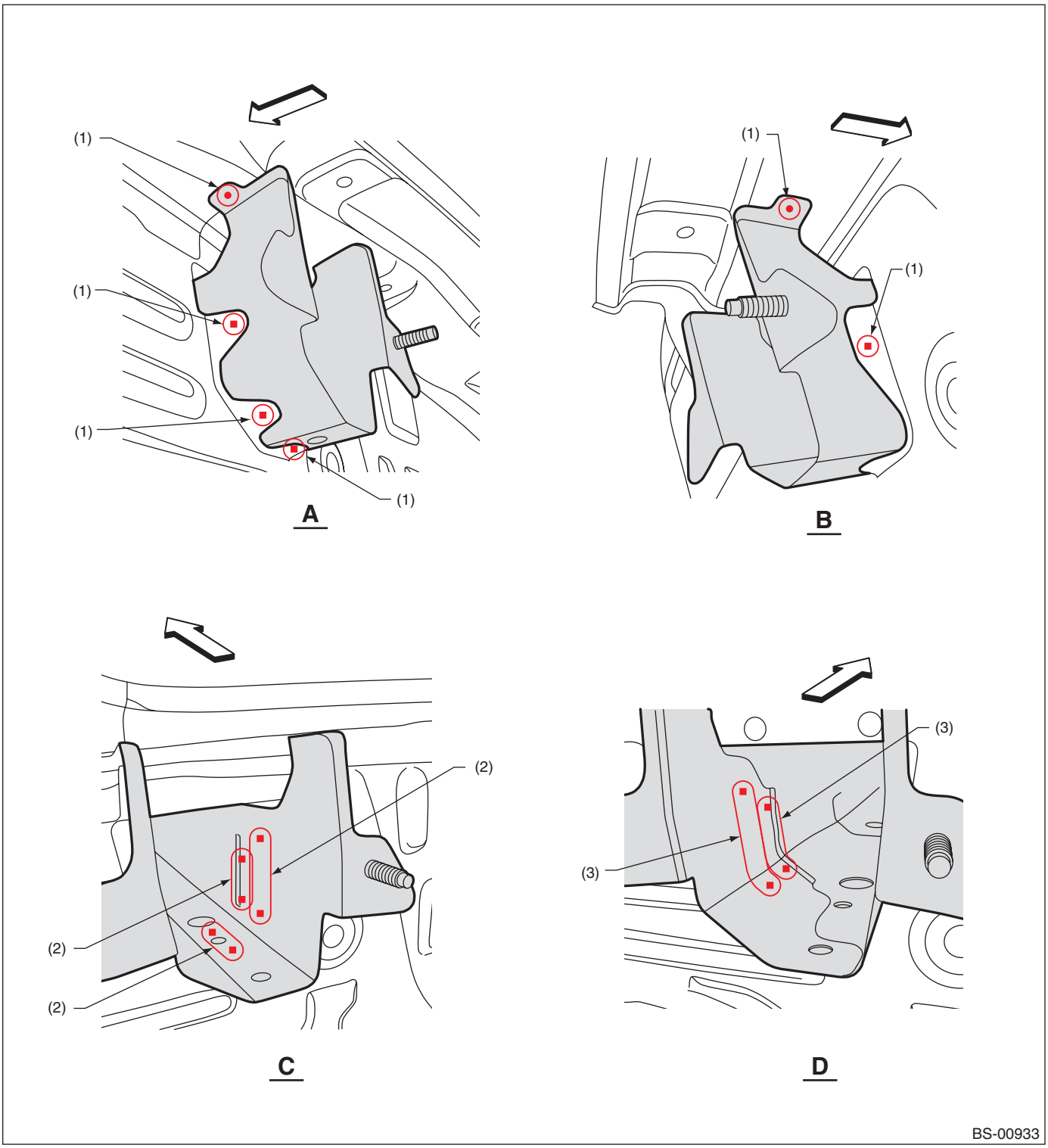
B: INSTALLATION

- **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

- **Views**

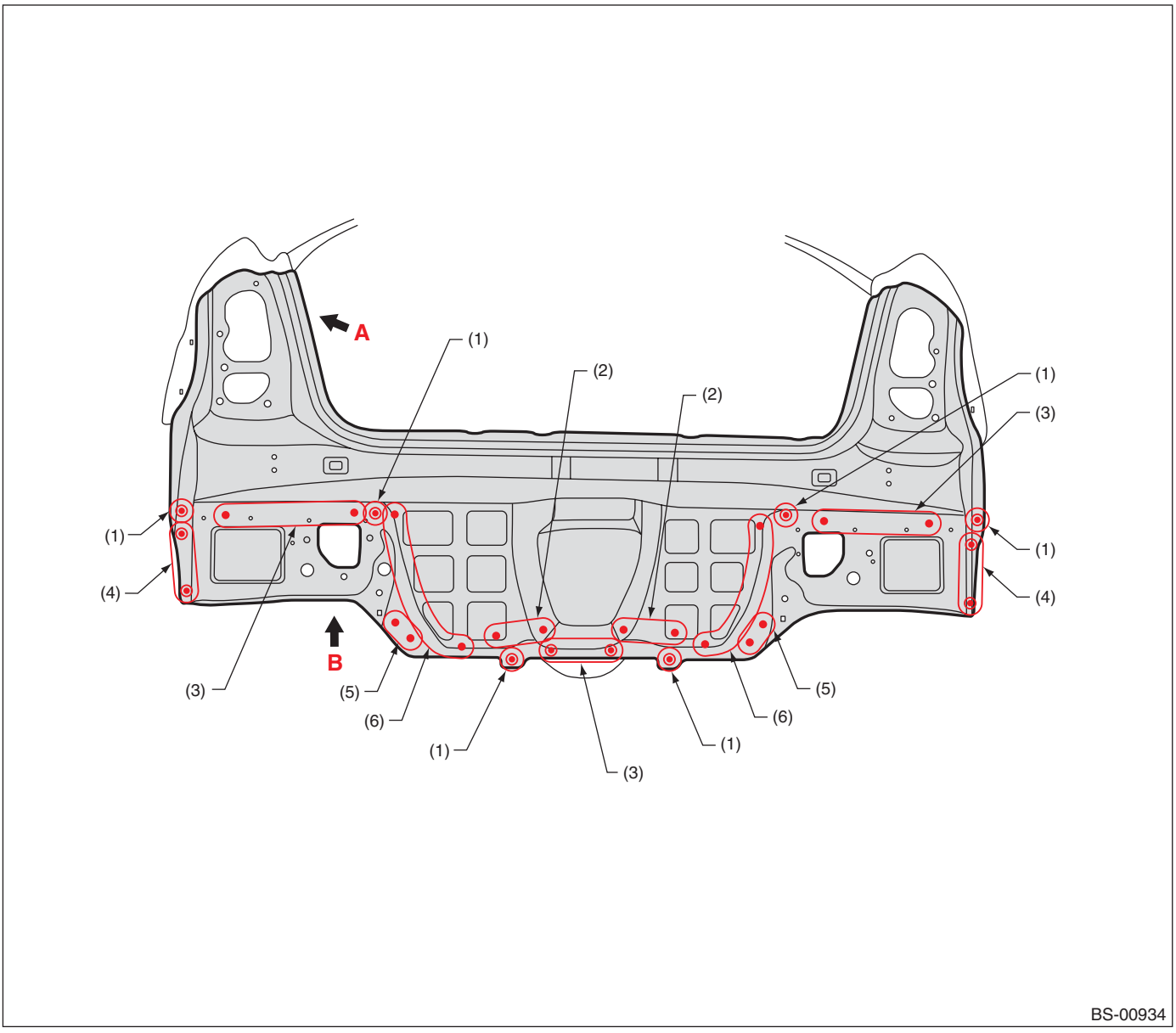


(1) 1 point (2) 2 points (3) 3 points

33.Rear Skirt / Sedan (total replacement)

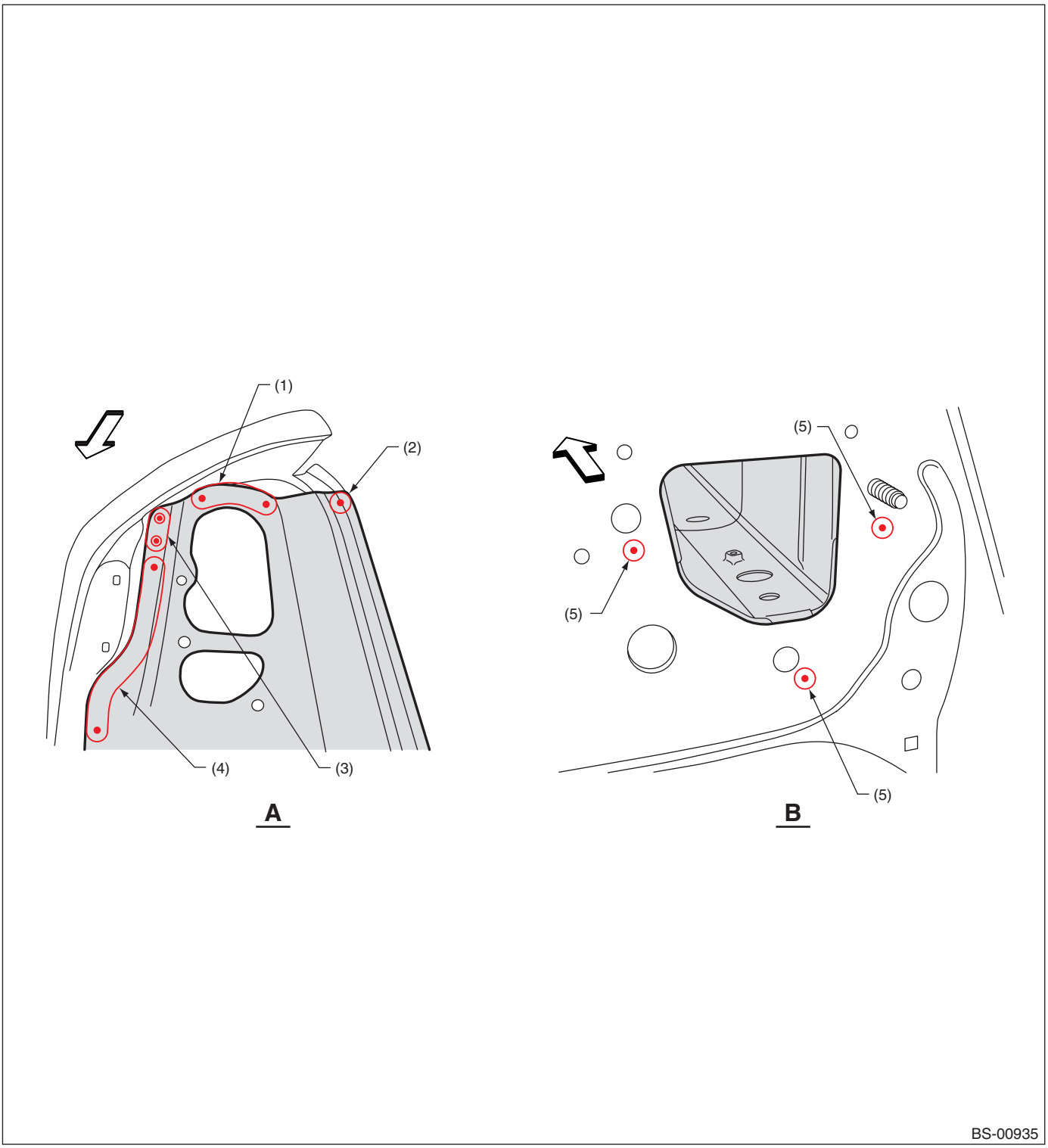
A: REMOVAL

- **Overall view**



(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)

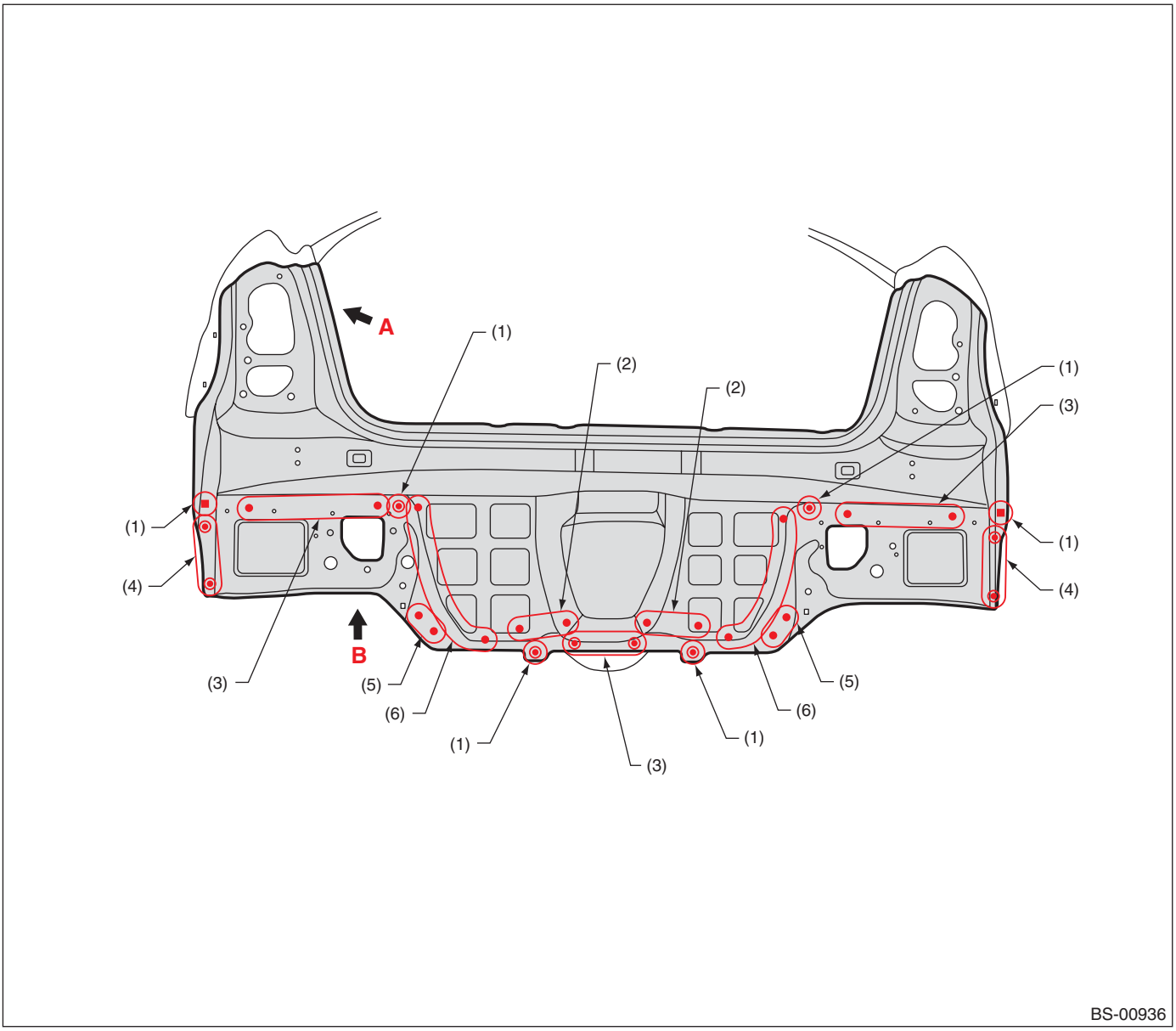
- **Views**



(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)

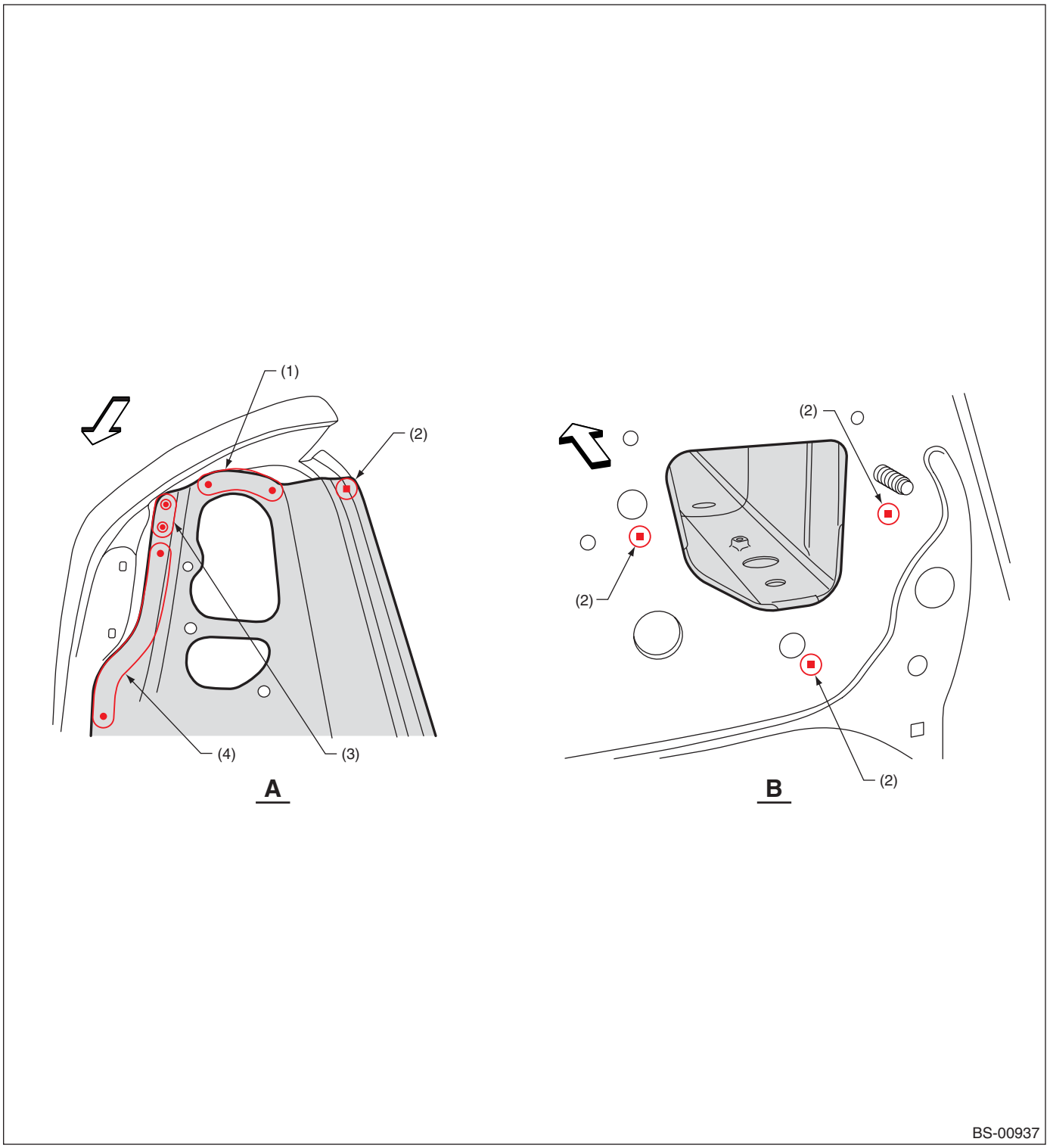
B: INSTALLATION

- **Overall view**



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

- **Views**

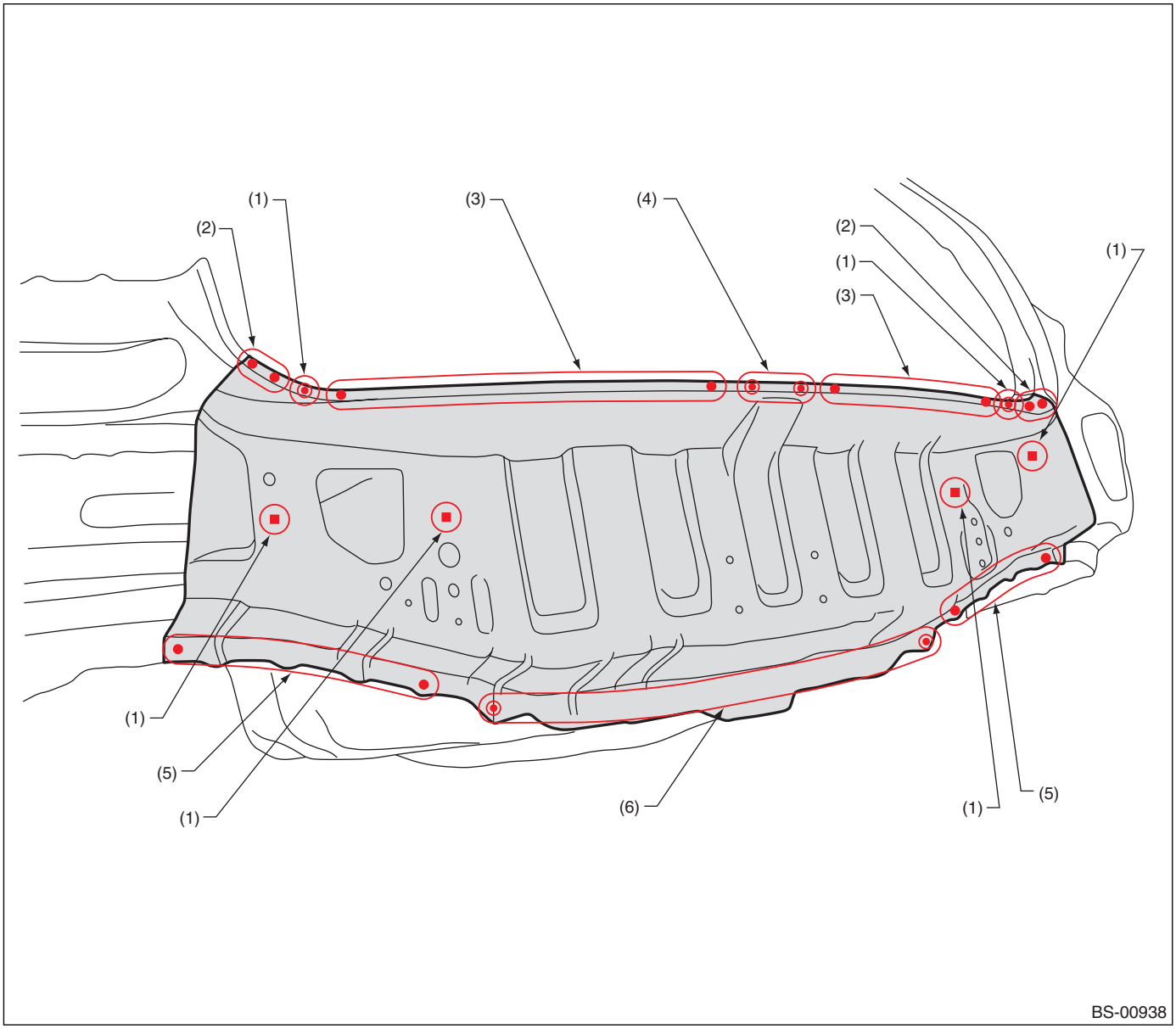


(1) 4 points
(2) 1 point
(3) 3 points
(4) 12 points

34.Rear Skirt Outer / Wagon (total replacement)

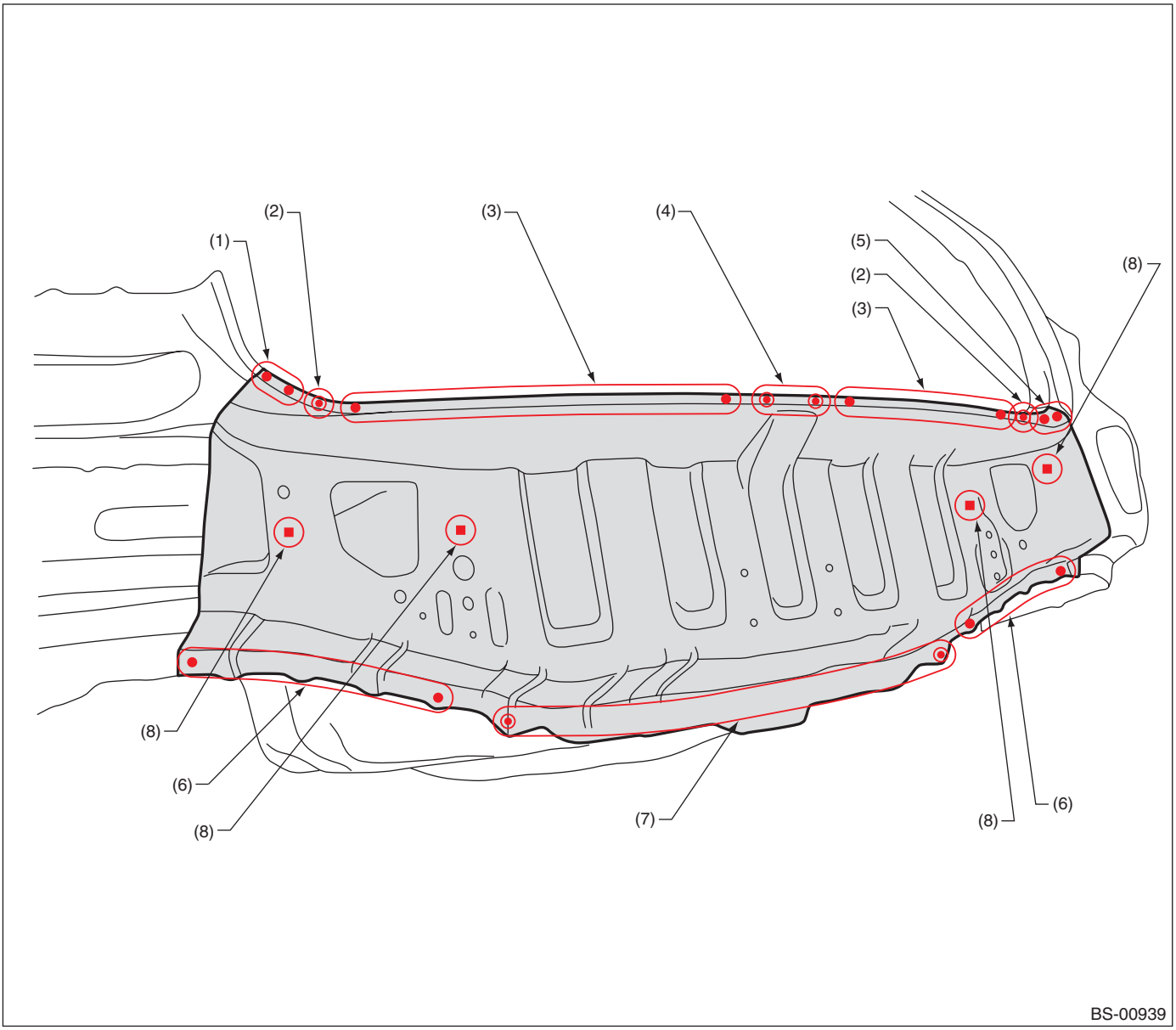
A: REMOVAL

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)

B: INSTALLATION



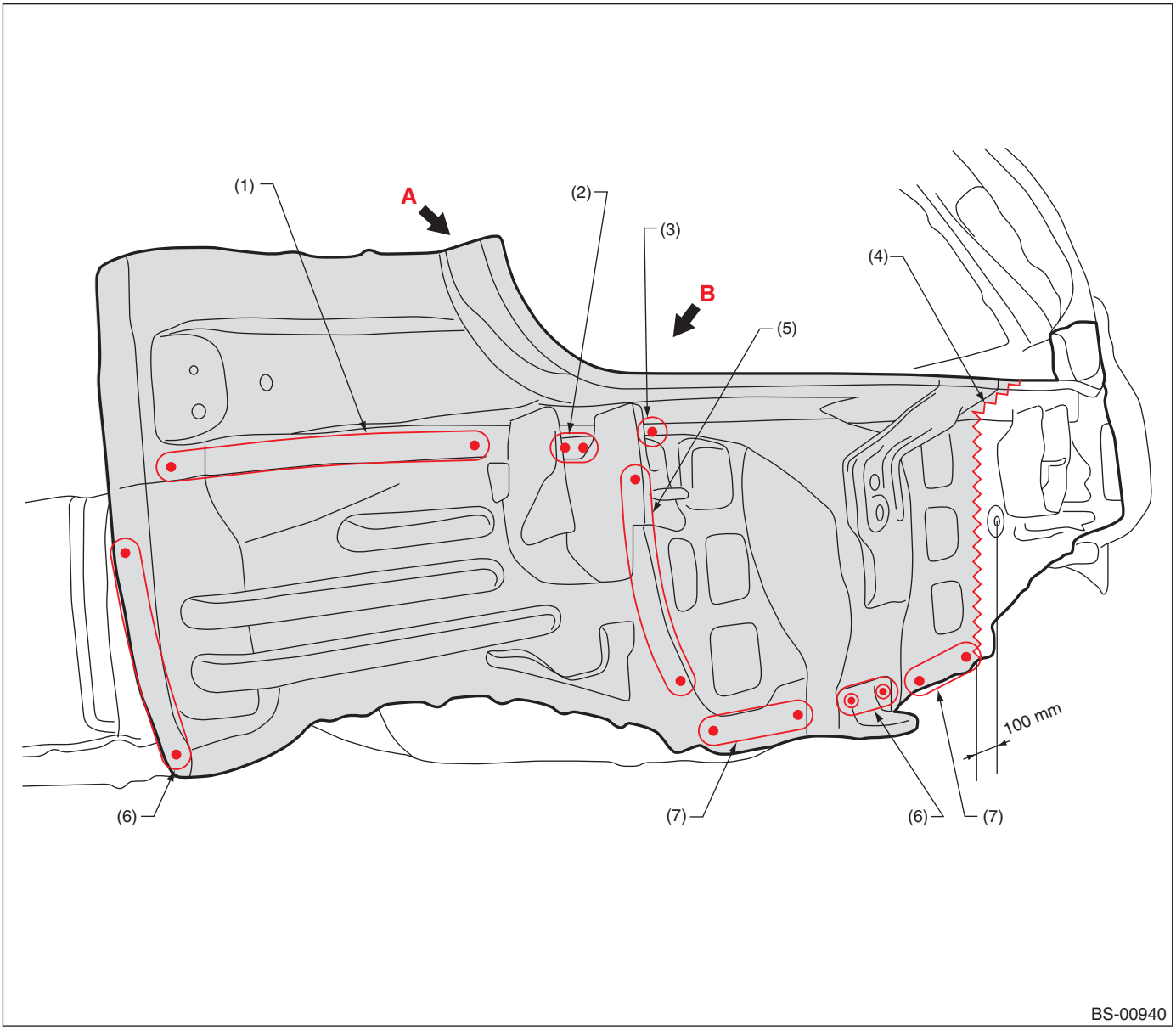
(1) 3 points
(2) 1 point
(3) 10 points
(4) 4 points
(5) 2 points
(6) 5 points
(7) 12 points
(8) 1 point (service)

35.Rear Skirt Inner / Wagon (partial replacement)

A: REMOVAL

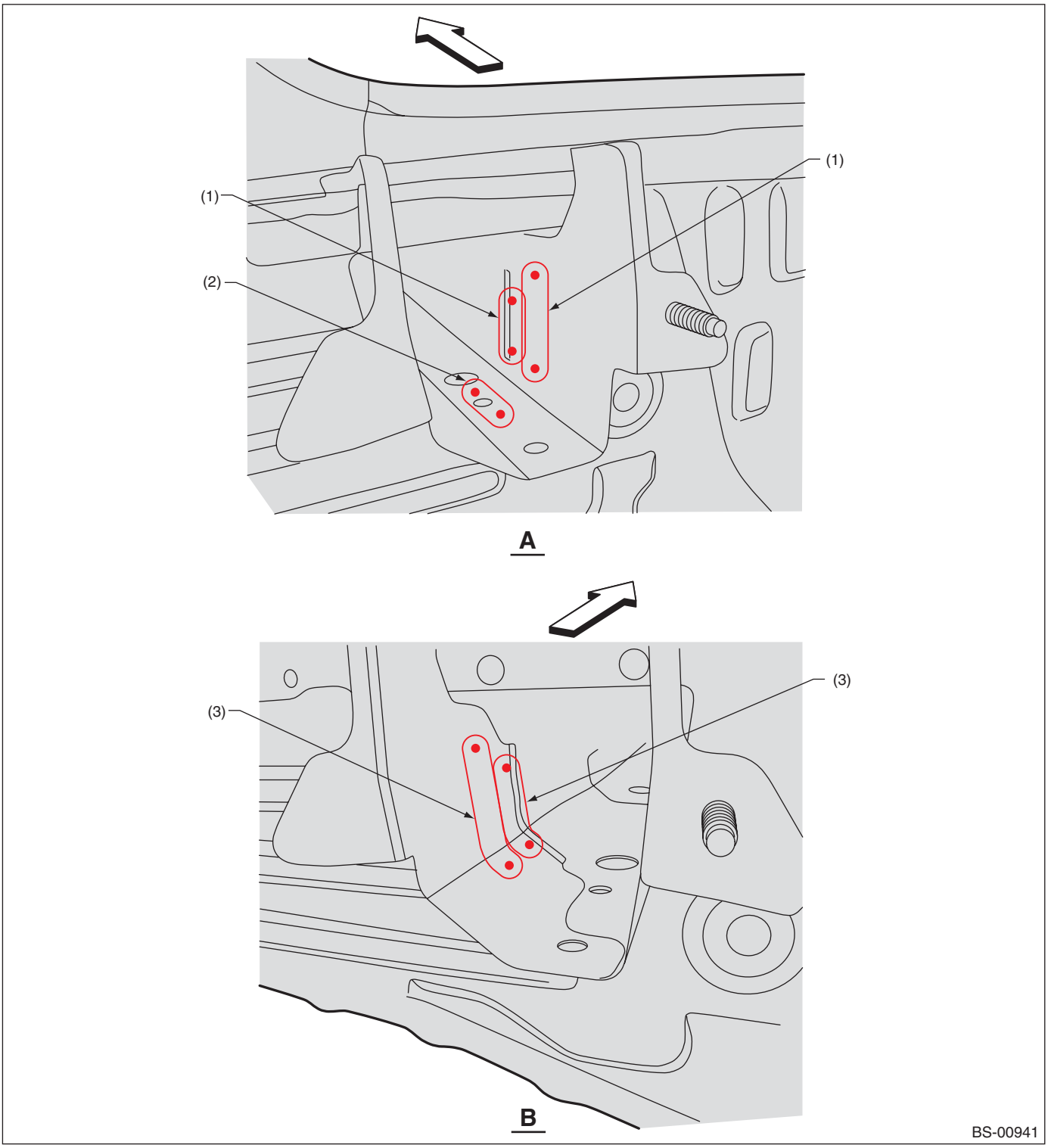
1) Rear quarter reinforcement D-pillar and rear skirt outer removed condition

- **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)

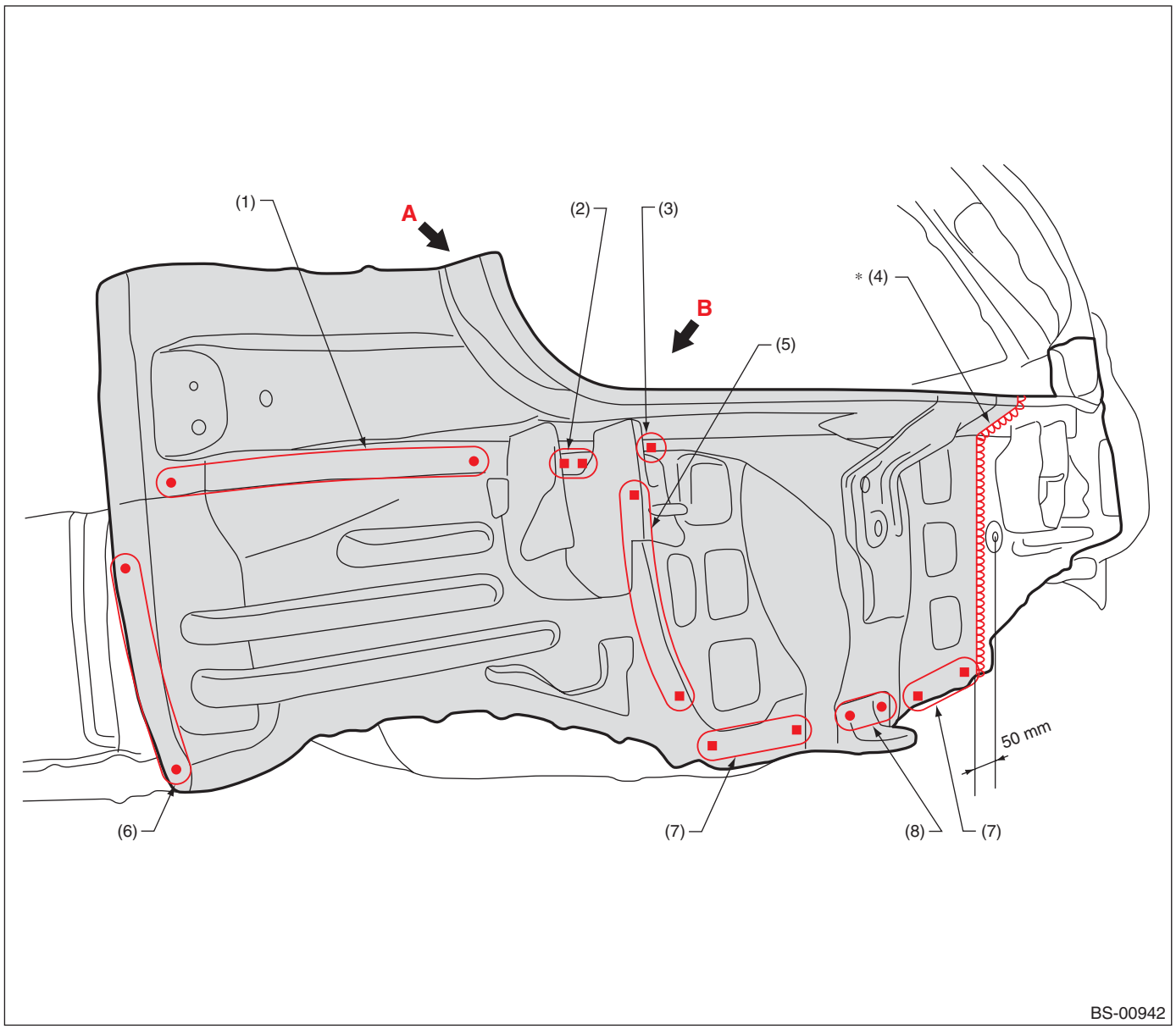
- **Views**



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

B: INSTALLATION

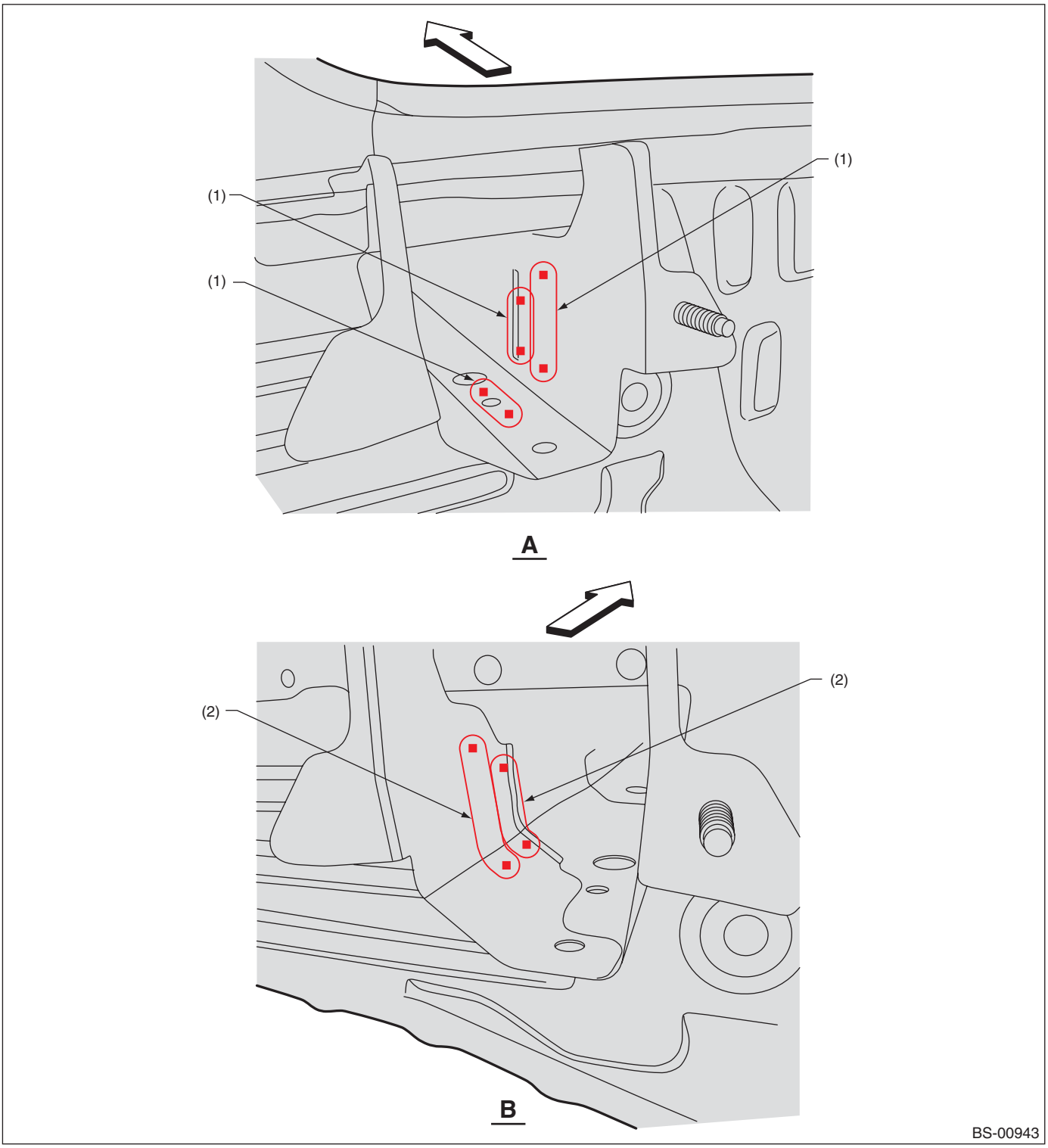
- **Overall view**



(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.

- **Views**



(1) 2 points (service)

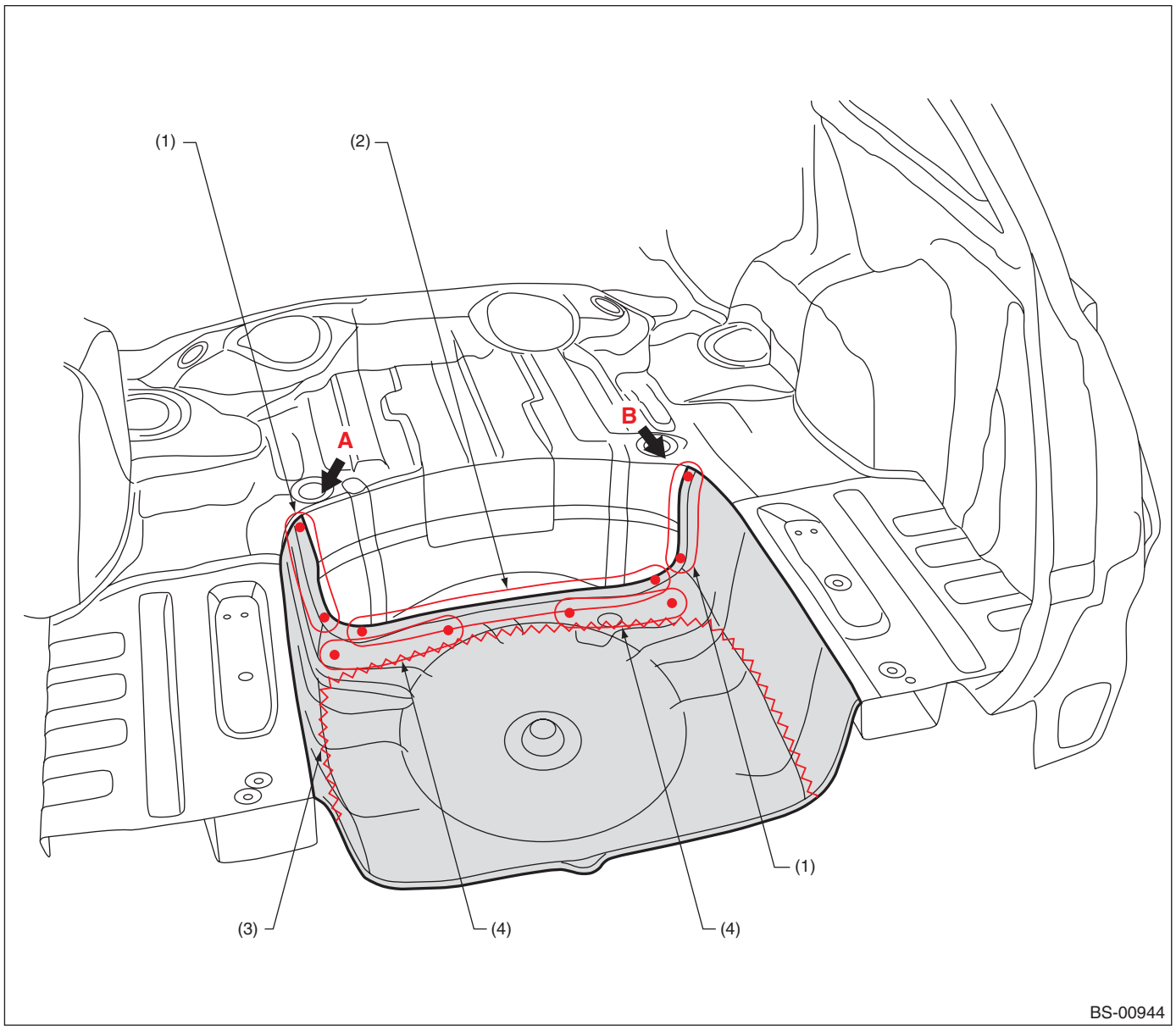
(2) 3 points (service)

36.Rear Floor Pan (total replacement)

A: REMOVAL

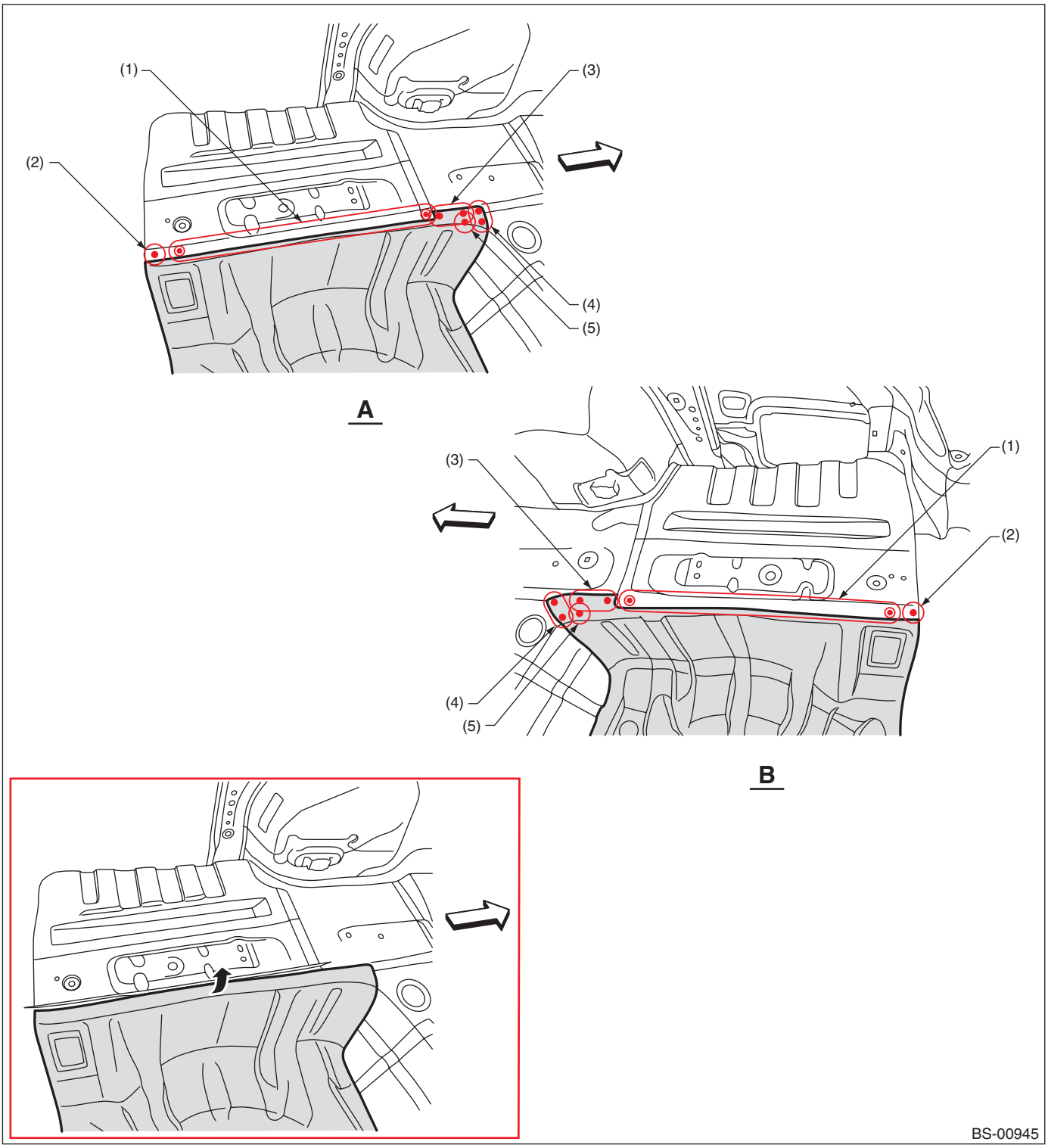
1) Rear skirt outer and rear skirt inner removed condition

- **Overall view**



(1) 5 points (inside · 1)
(2) 9 points (top · 1)
(3) Rough cutting (2300 mm)
(4) 4 points (top · 1)

- **Views**

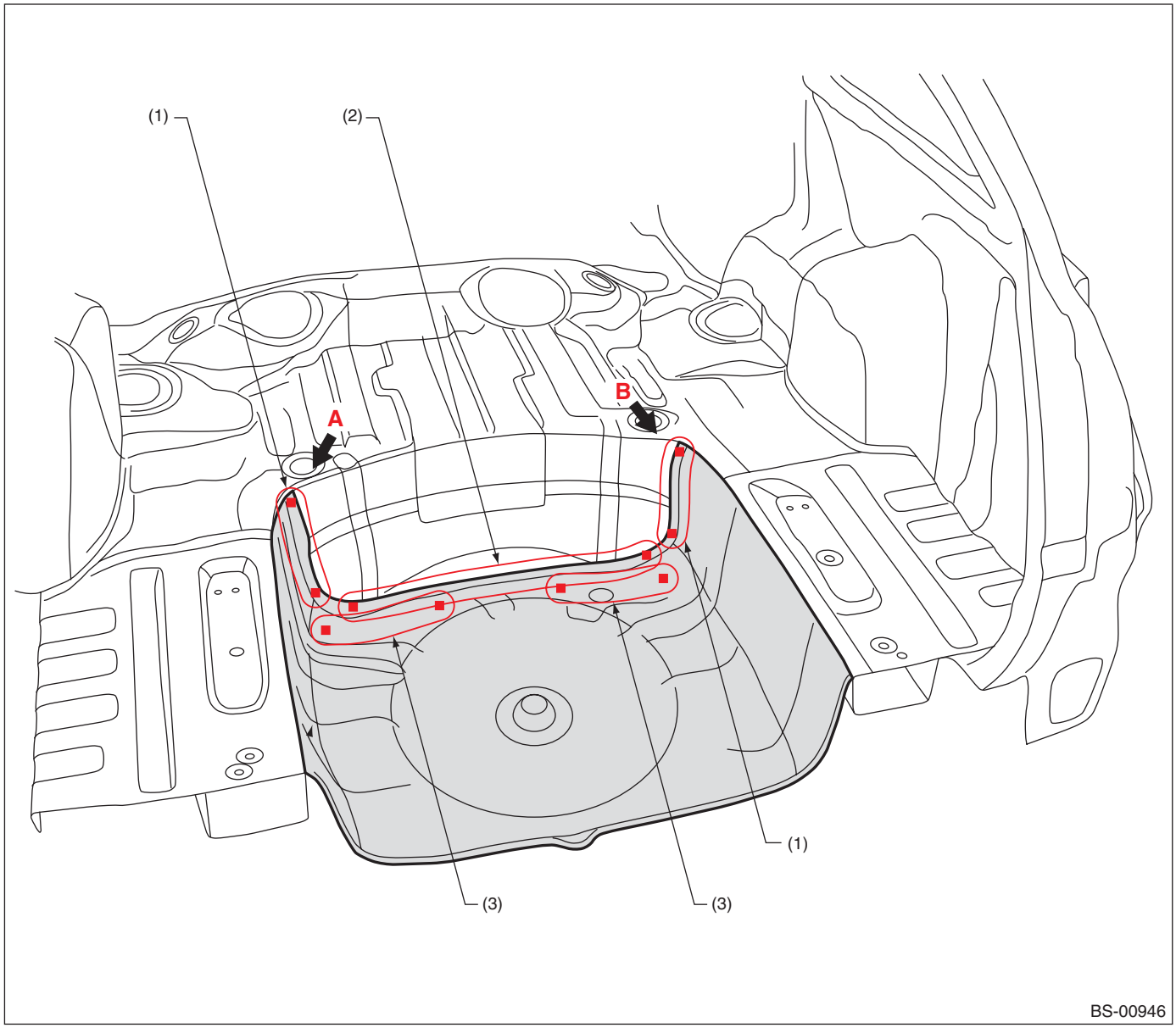


(1) 15 points (top · 2)
(2) 1 point (outside · 1)
(3) 3 points (top · 1)
(4) 2 points (top · 1)
(5) 1 point (top · 1)

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

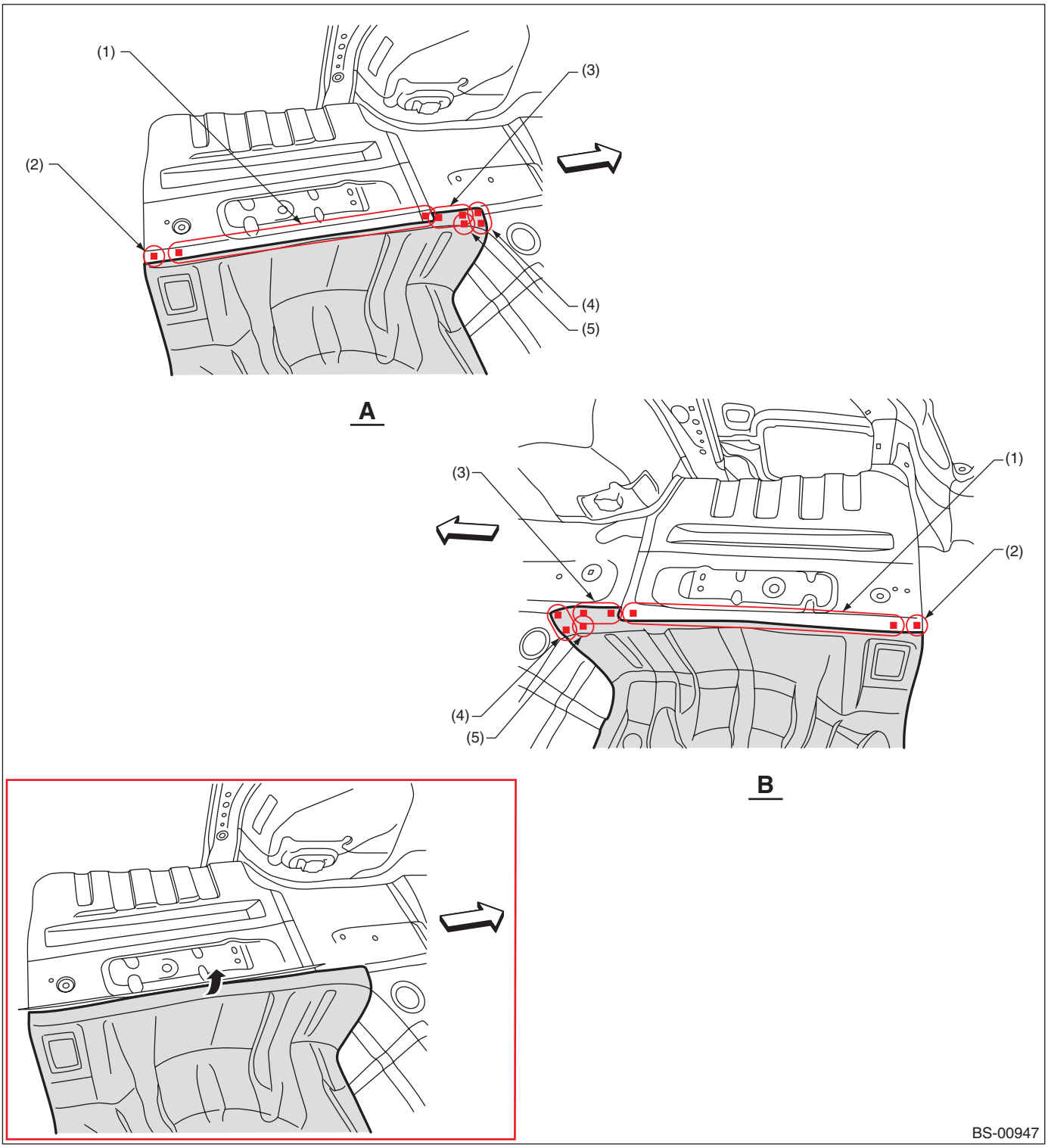
B: INSTALLATION

- **Overall view**



(1) 5 points (service)
(2) 9 points (service)
(3) 4 points (service)

- **Views**



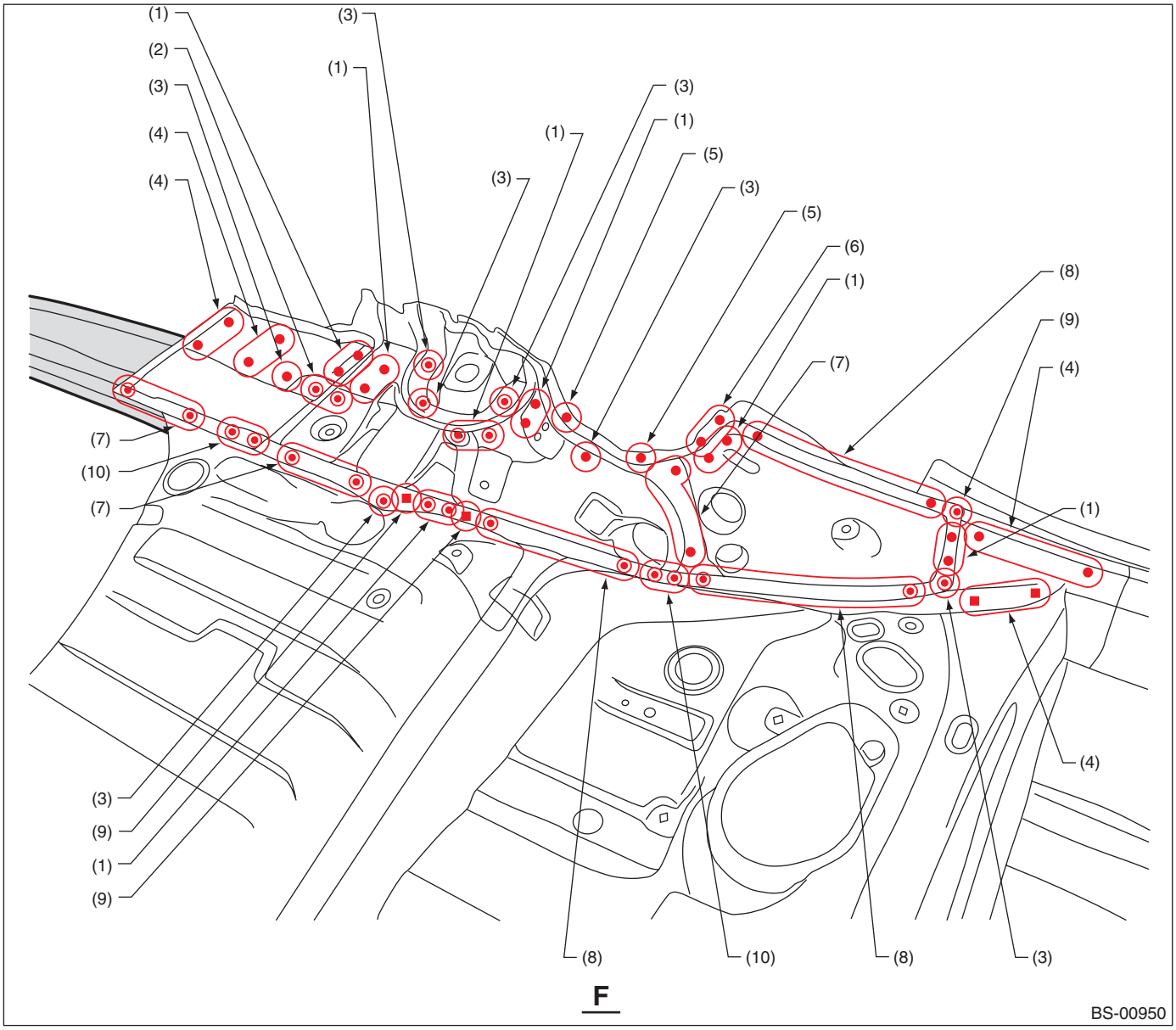
(1) 15 points
(2) 1 point
(3) 3 points (service)
(4) 2 points (service)
(5) 1 point (service)

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

37.Closing Plate (total replacement)

A: REMOVAL

- **Views**

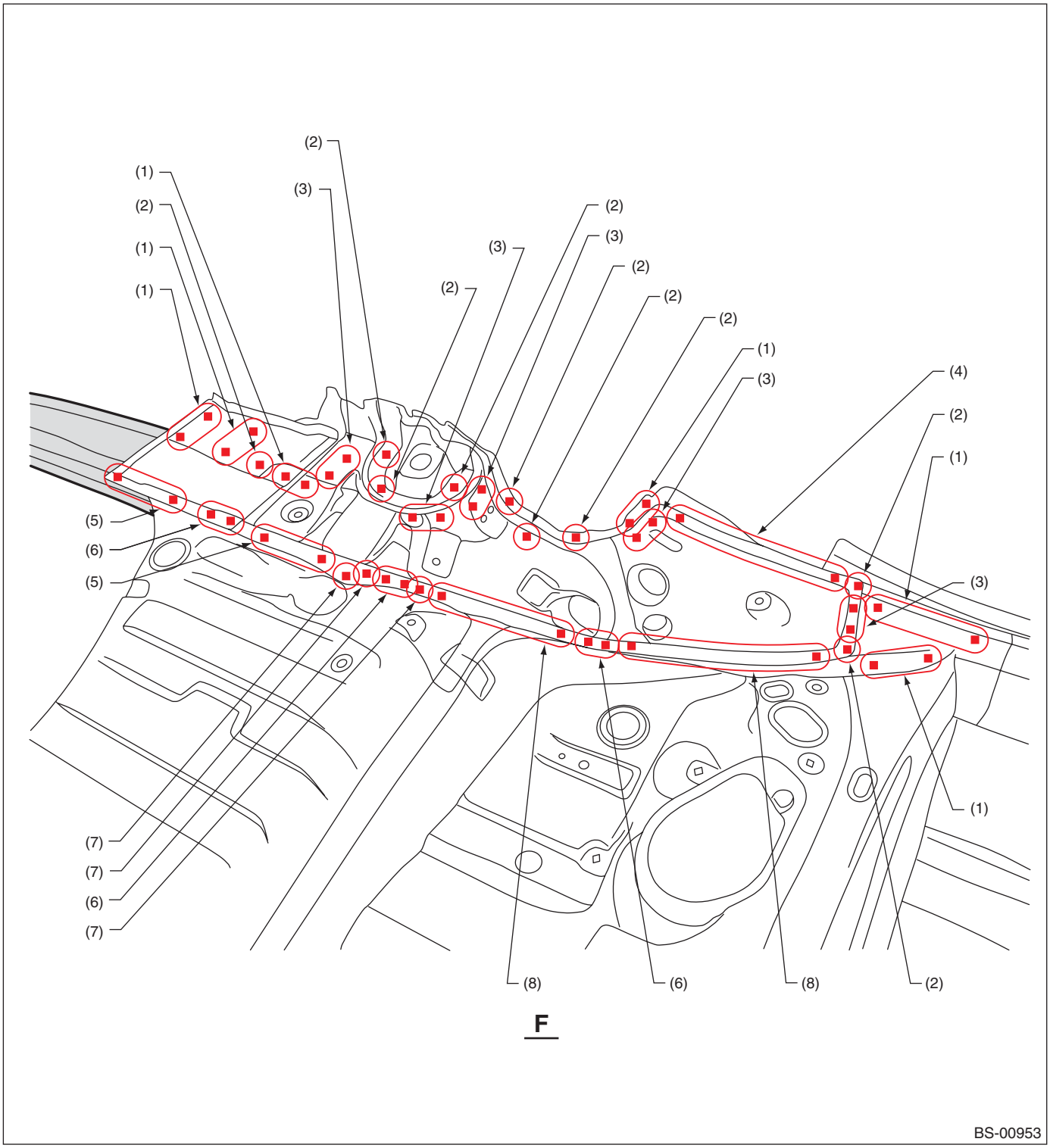


(1)	2 points (top · 1)	(5)	1 point (inside · 1)	(8)	5 points (top · 1)
(2)	3 points	(6)	3 points (inside · 1)	(9)	1 point (top · 2)
(3)	1 point (top · 1)	(7)	4 points (top · 1)	(10)	2 points (top · 2)
(4)	3 points (top · 1)				

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

B: INSTALLATION

- **Views**



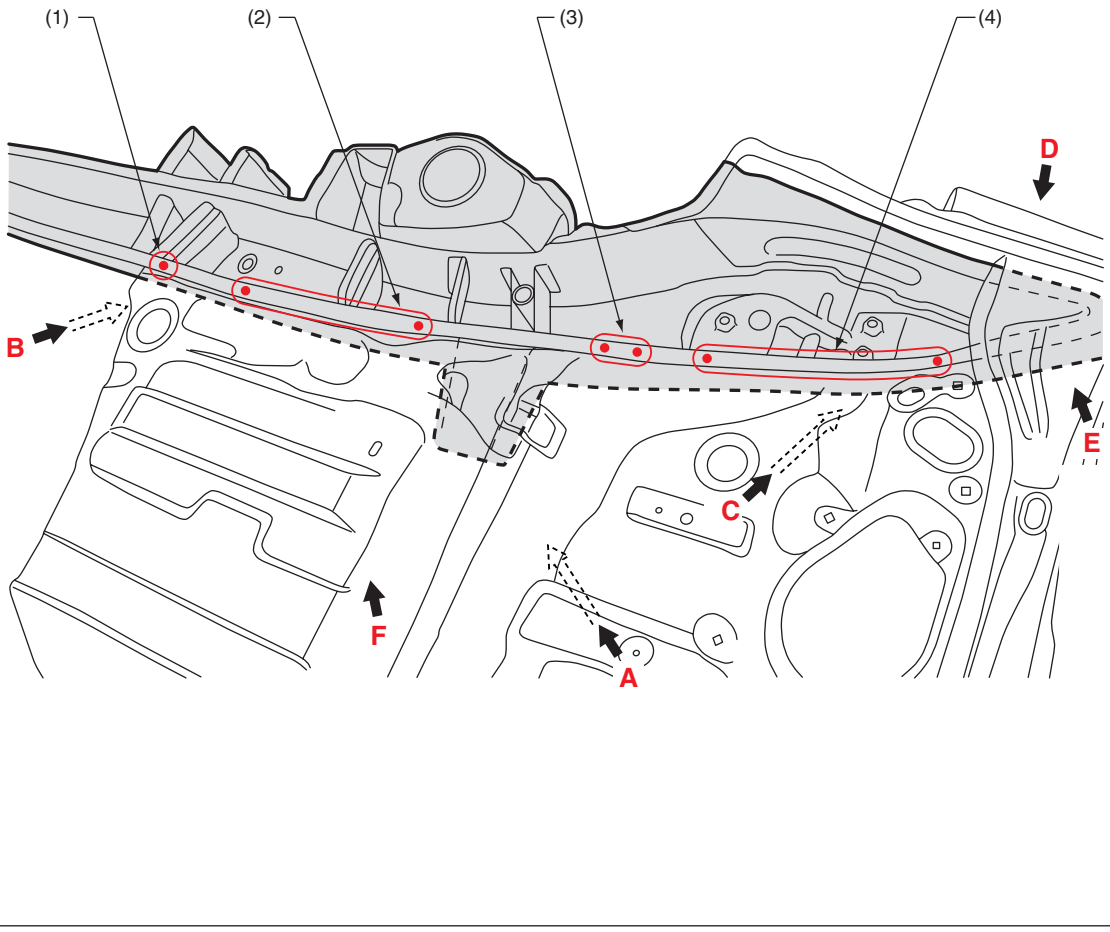
(1) 3 points
(2) 1 point
(3) 2 points
(4) 5 points
(5) 4 points (matching)
(6) 2 points (matching)
(7) 1 point (matching)
(8) 5 points (matching)

38.Rear Frame / Wagon (total replacement)

A: REMOVAL

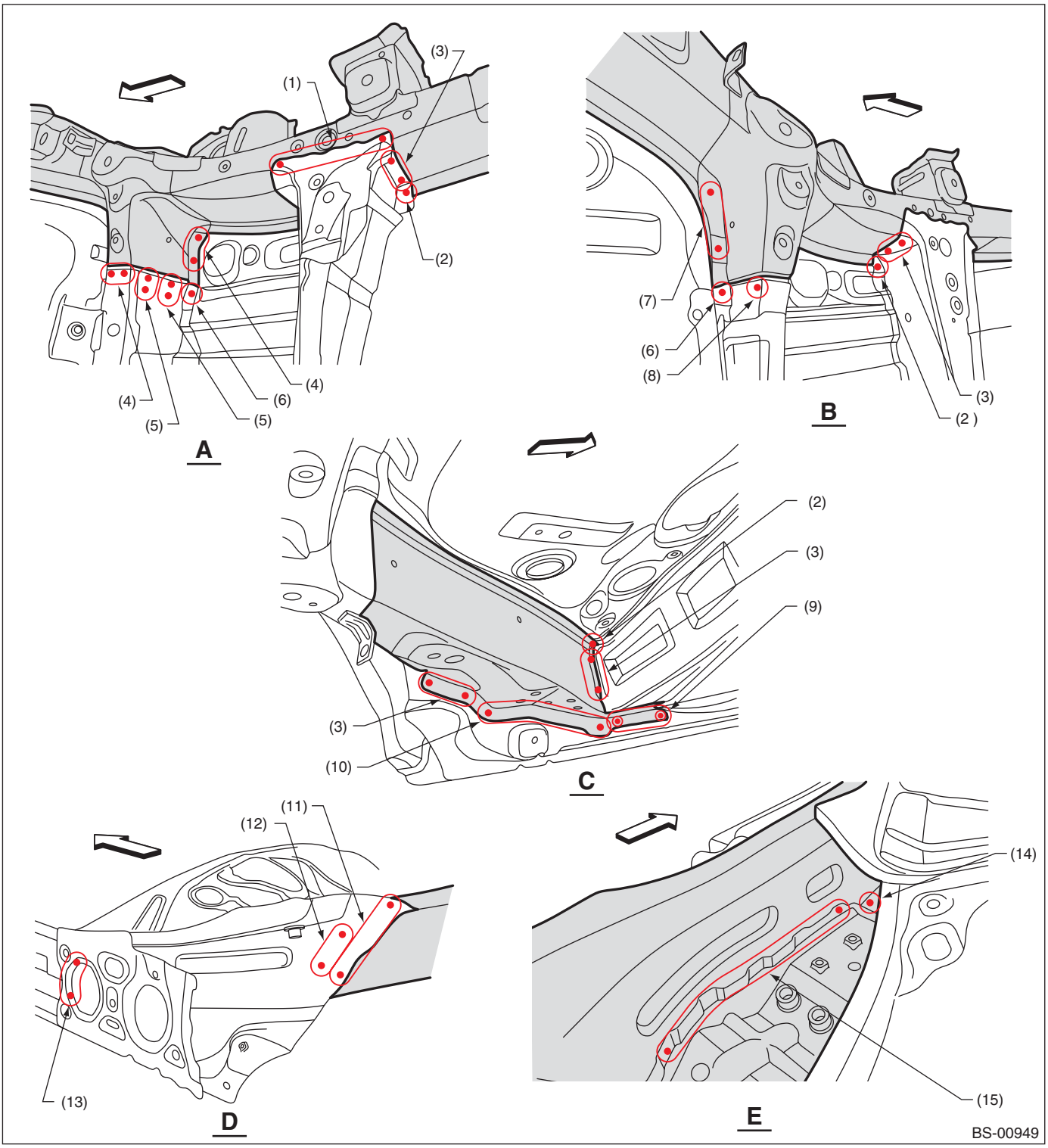
1) Rear quarter, reinforcement, D-pillar, closing plate front CP, rear wheel apron, rear floor pan, rear skirt outer and rear skirt inner removed condition

- **Overall view**



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

- **Views**

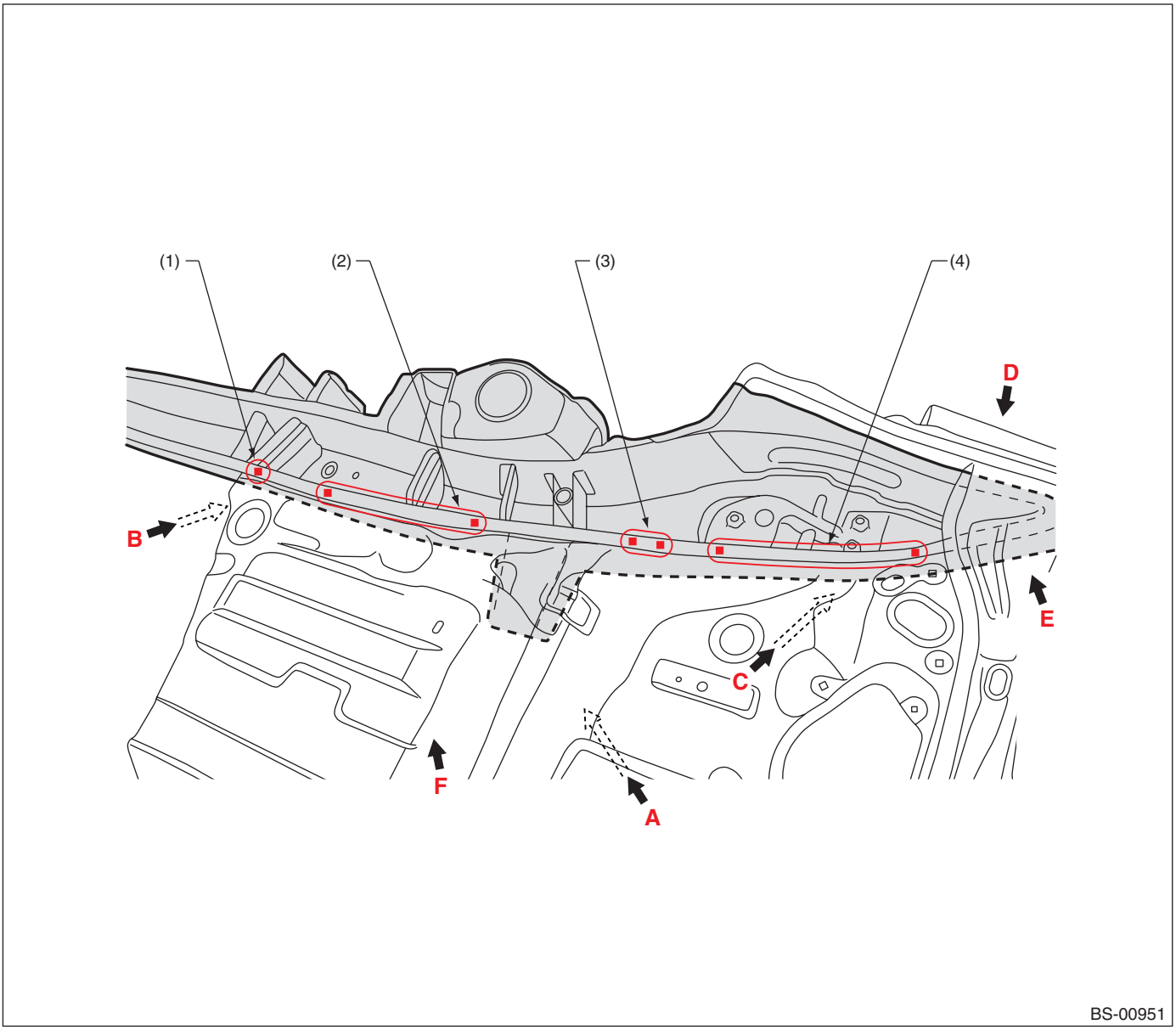


(1)	5 points (bottom · 1)	(6)	1 point (bottom · penetration)	(11)	4 points (outside · 1)
(2)	1 point (bottom · 1)	(7)	3 points (inside · penetration)	(12)	2 points (outside · 1)
(3)	3 points (inside · 1)	(8)	1 point (inside · penetration)	(13)	3 points (outside · 1)
(4)	2 points (bottom · penetration)	(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.

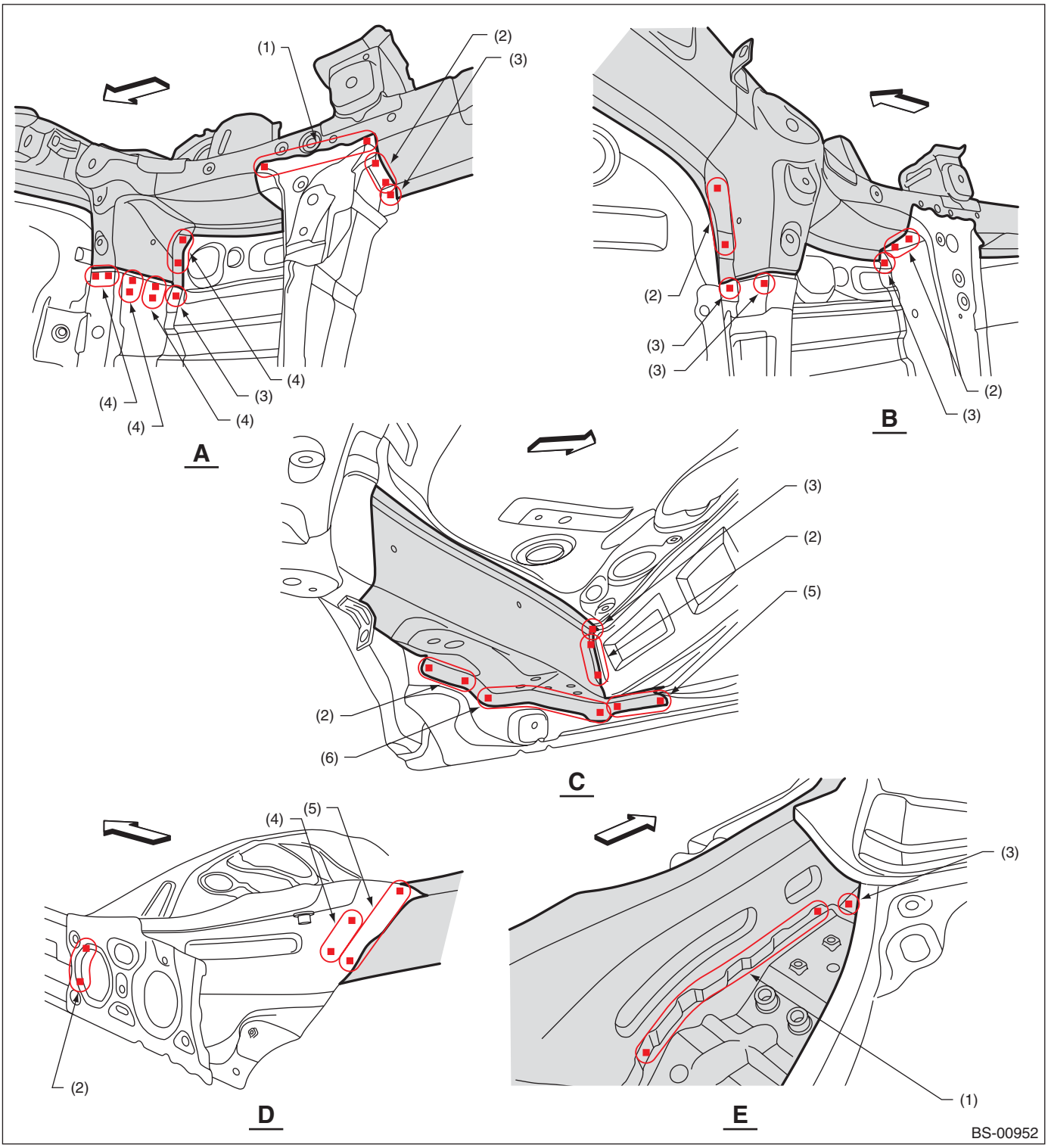
B: INSTALLATION

- **Overall view**



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

- **Views**



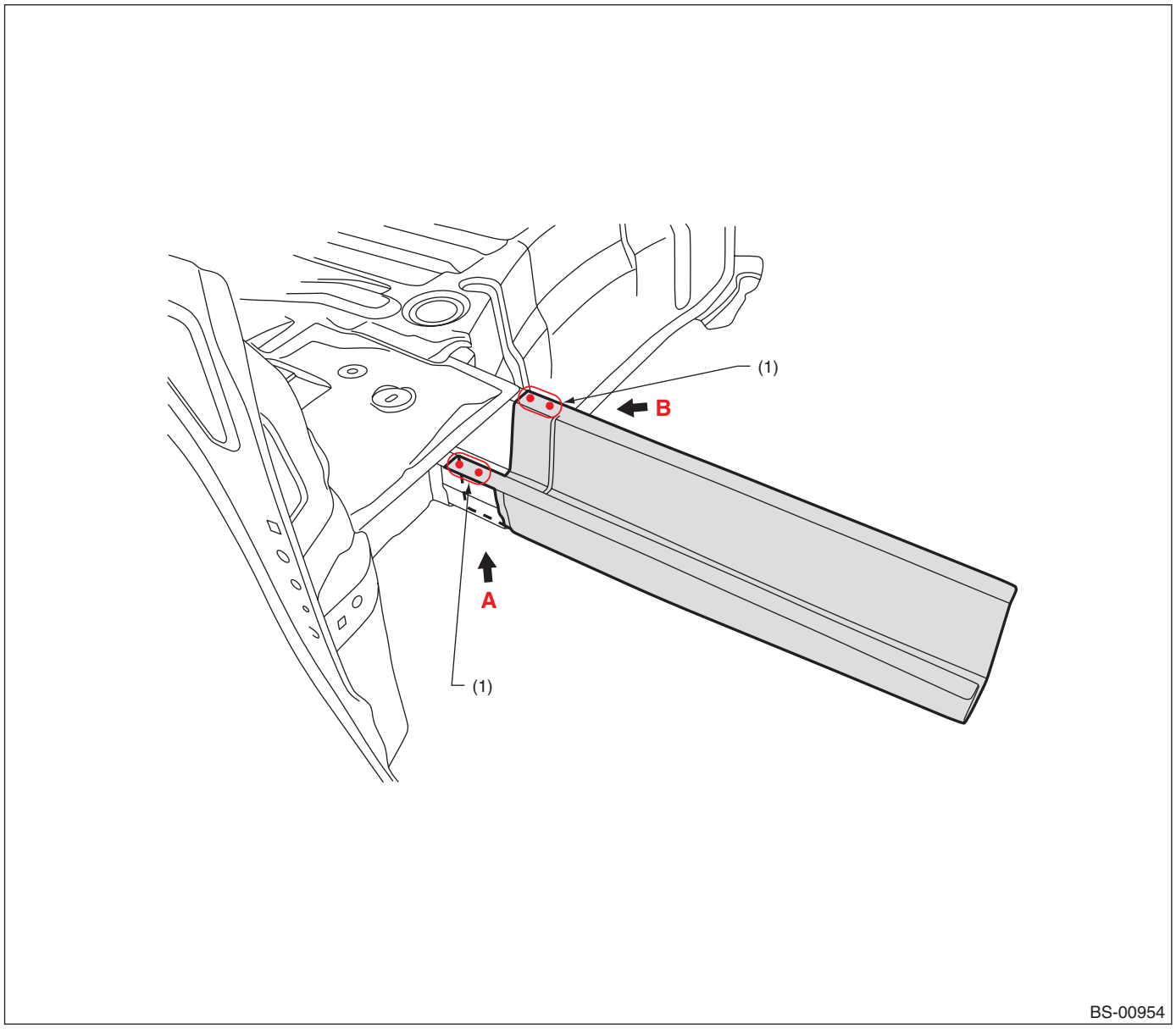
(1) 5 points
(2) 3 points
(3) 1 point
(4) 2 points
(5) 4 points
(6) 6 points

View E shows the closing plate front complete removed.

39.Rear Side Frame Rear (partial replacement)

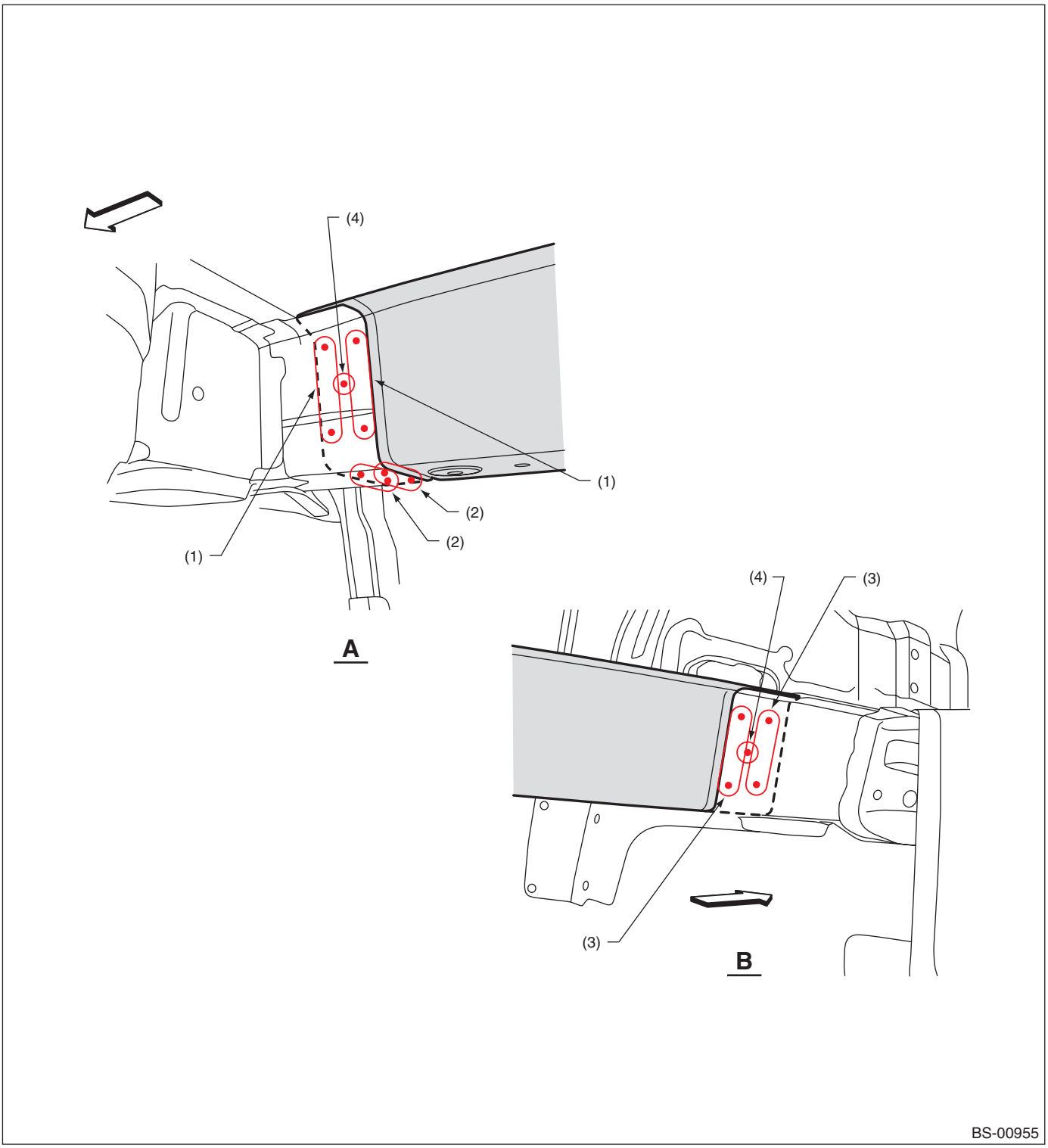
A: REMOVAL

- **Overall view**



(1) 2 points (top · 2)

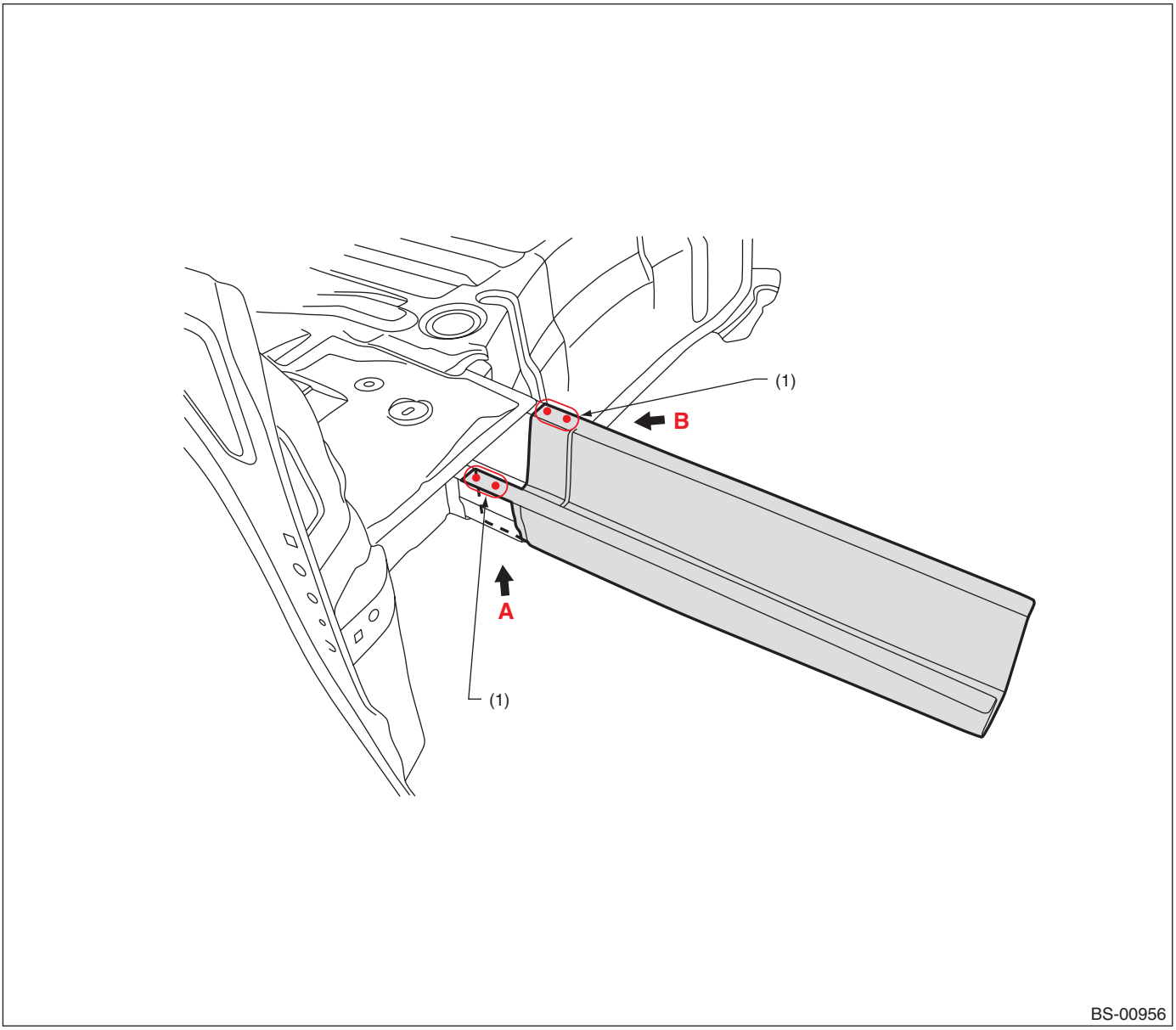
- **Views**



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

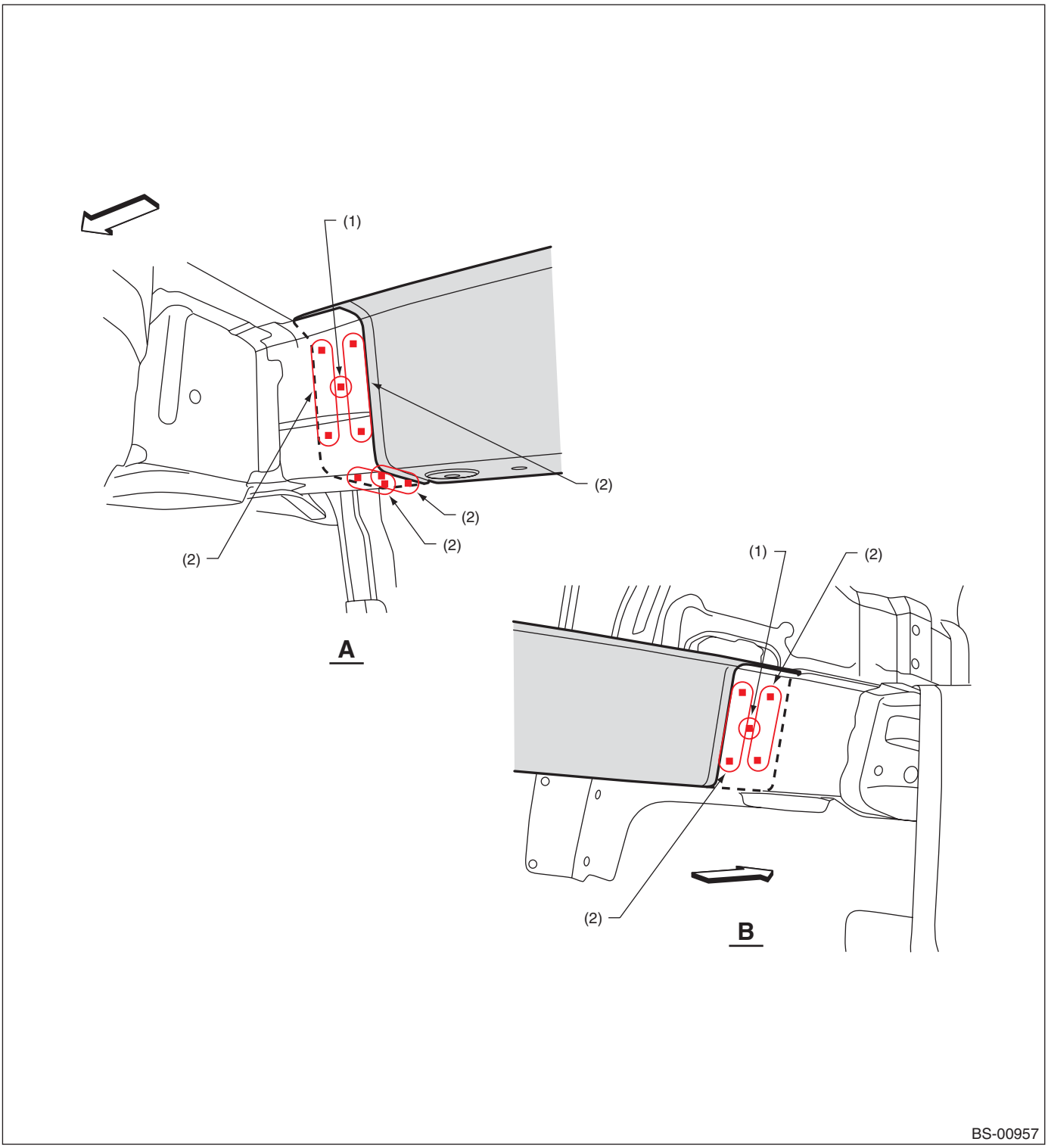
B: INSTALLATION

- **Overall view**



(1) 2 points

- **Views**



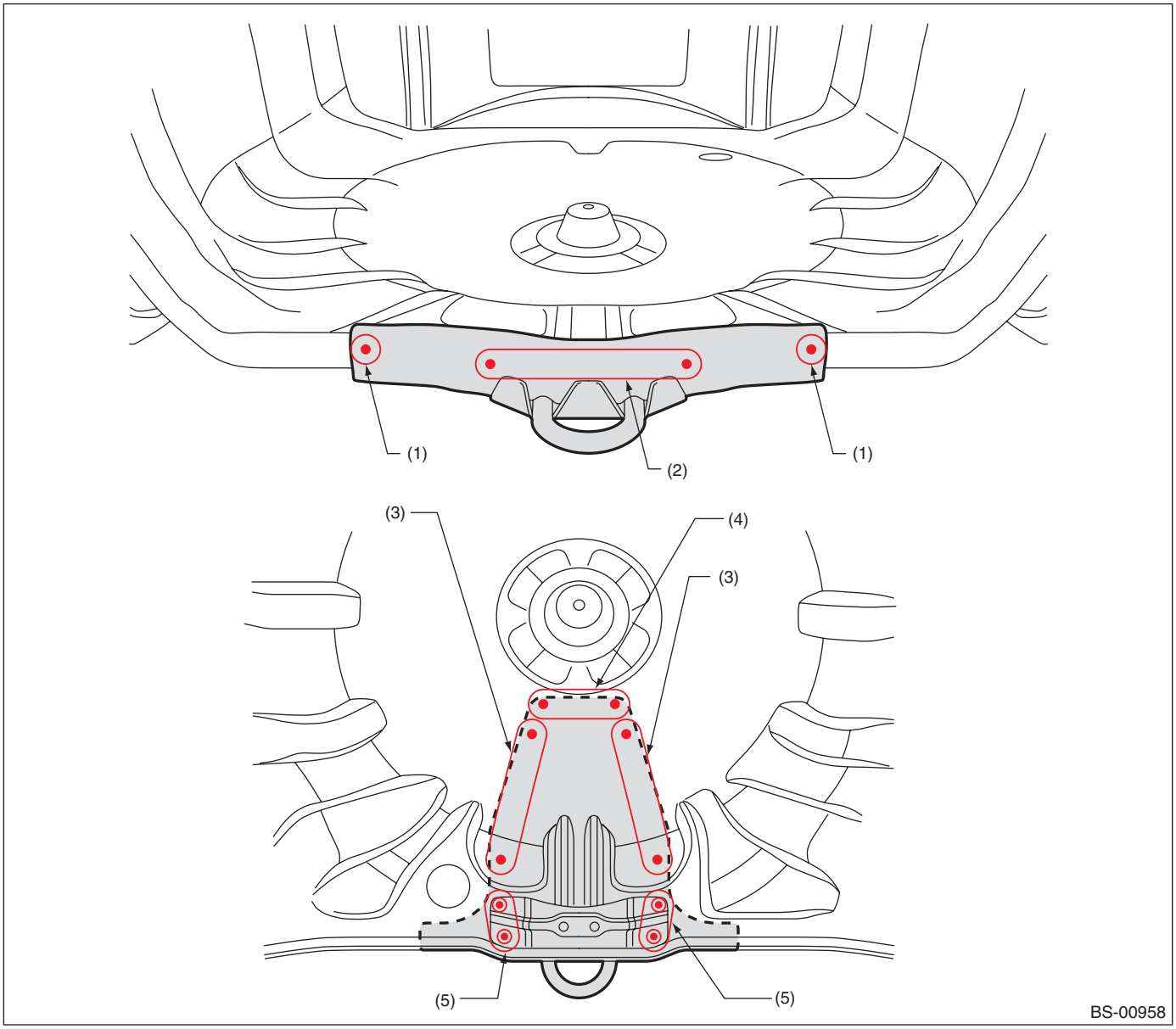
(1) 1 point

(2) 2 points

40.Plate Tractive (total replacement)

A: REMOVAL

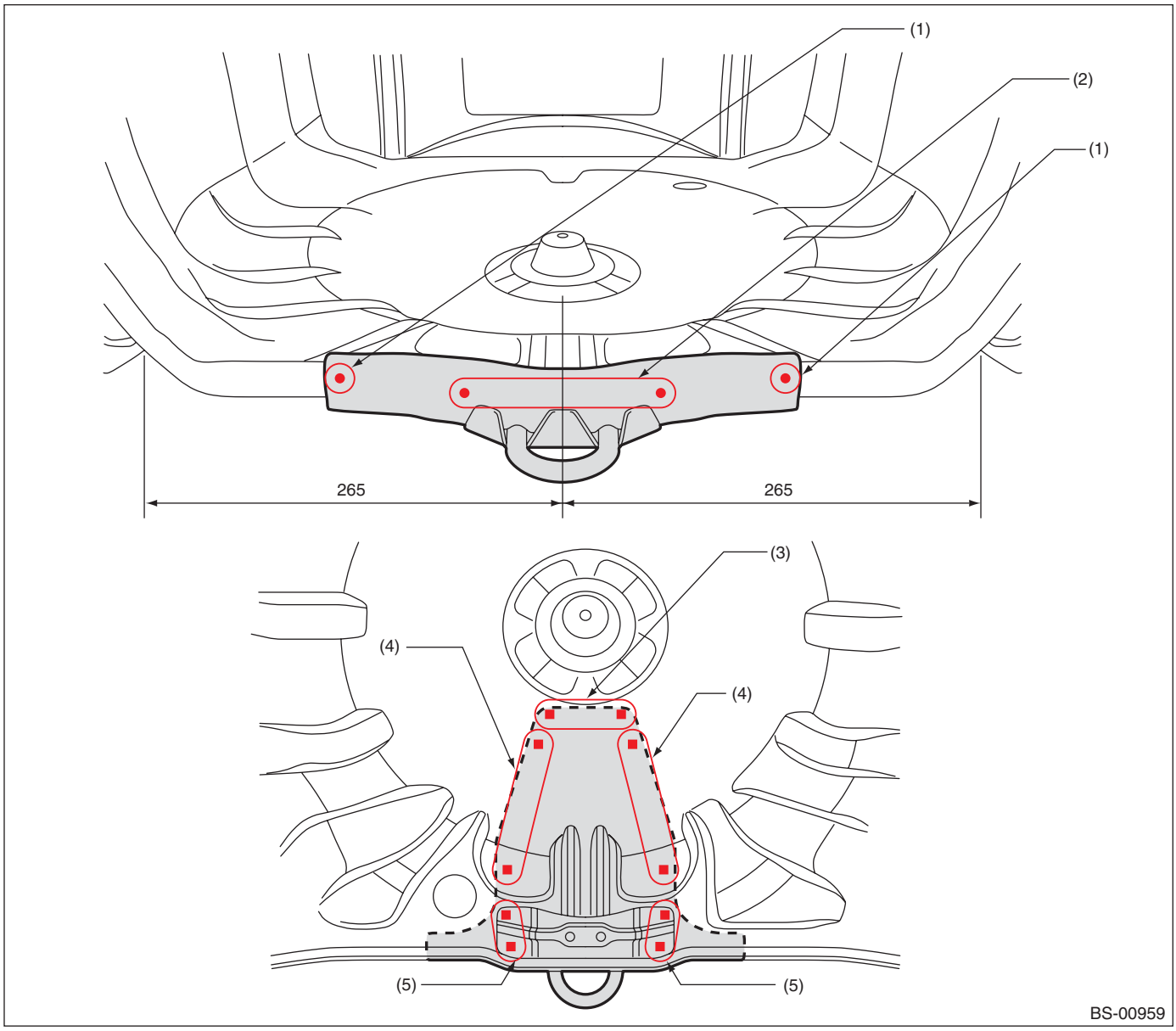
1) Rear skirt outer and rear skirt inner removed condition



(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

B: INSTALLATION



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

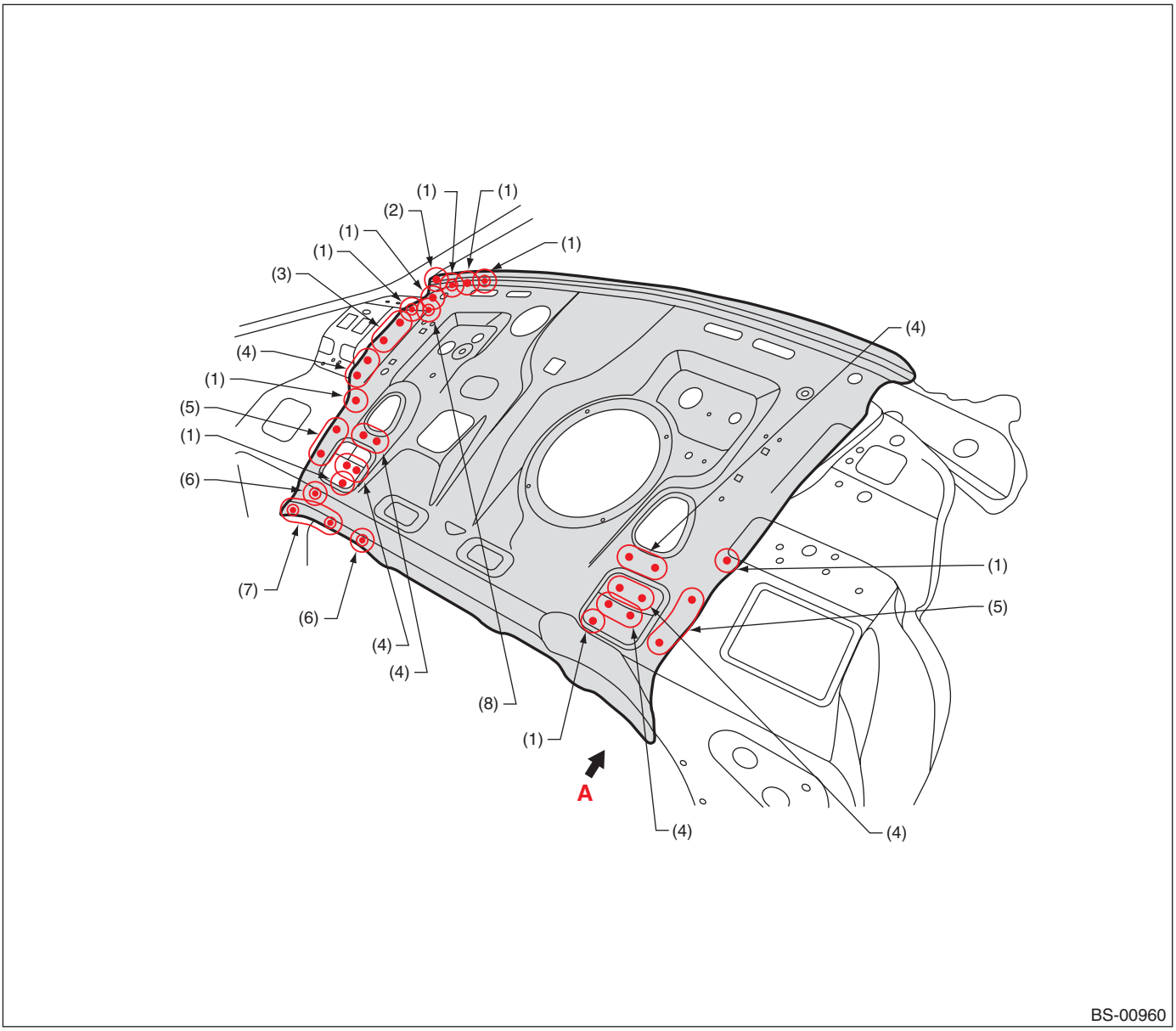
On sedans: rear skirt outer removed condition

41.Rear Panel / Sedan (total replacement)

A: REMOVAL

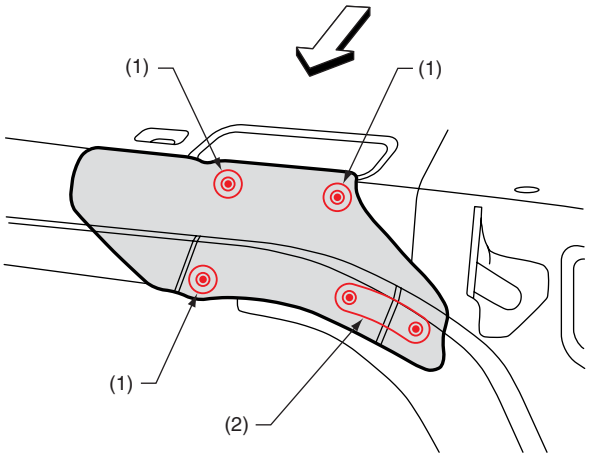
1) Rear quarter, rear quarter inner upper and reinforcement removed condition

- **Overall view**



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

- **Views**



A

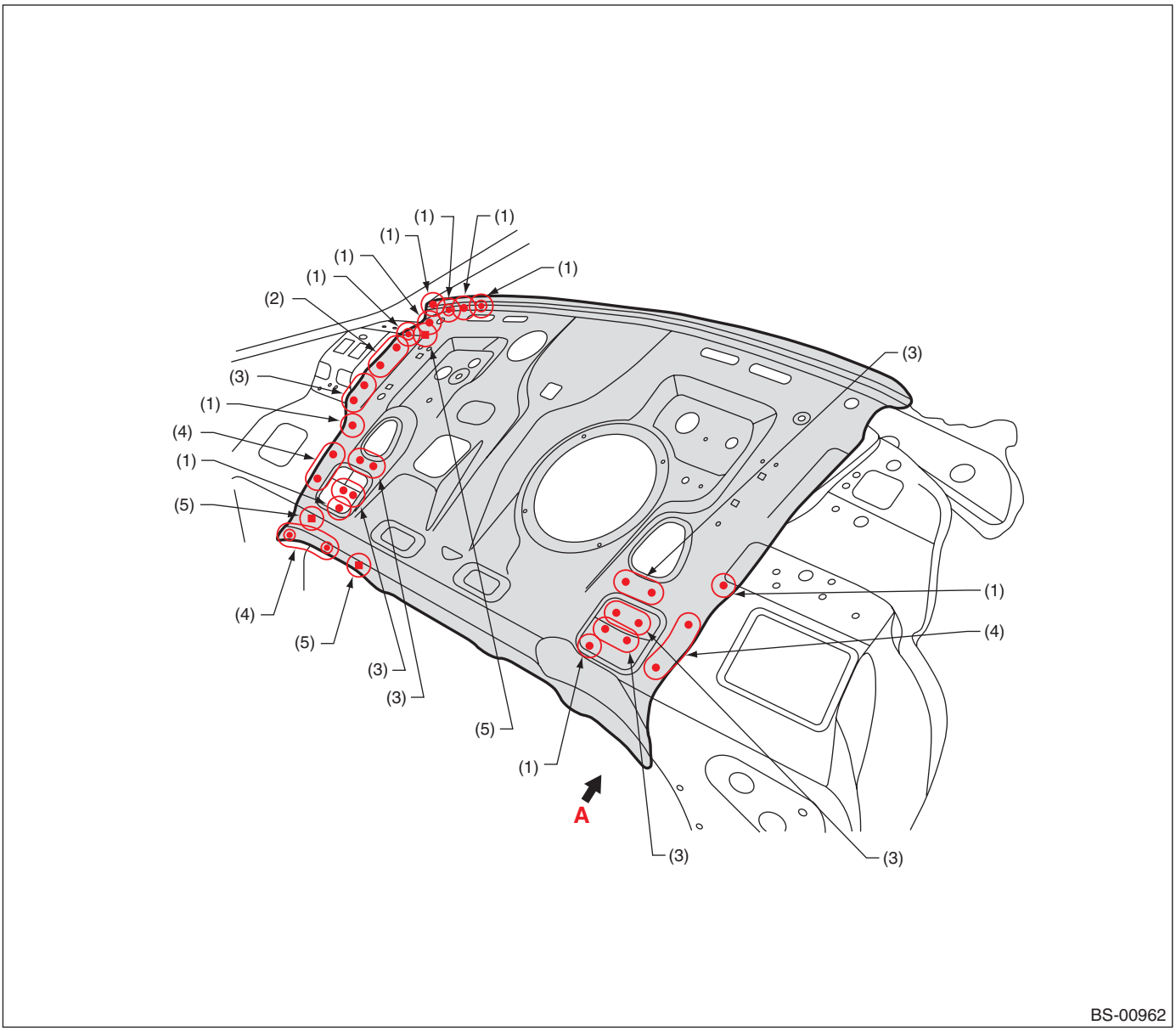
BS-00961

(1) 1 point (inside · 2)

(2) 3 points (inside · 1)

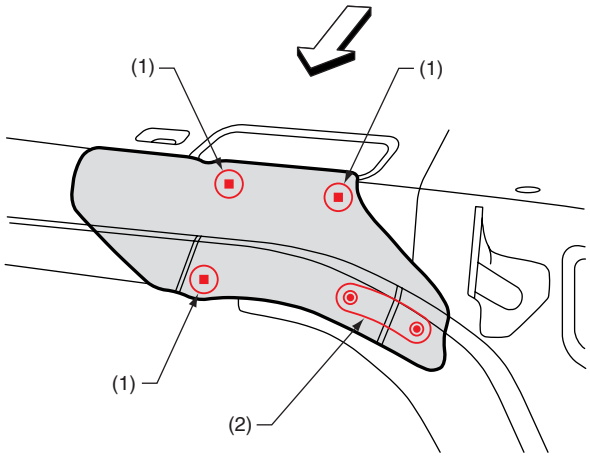
B: INSTALLATION

- **Overall view**



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

- **Views**



A

BS-00963

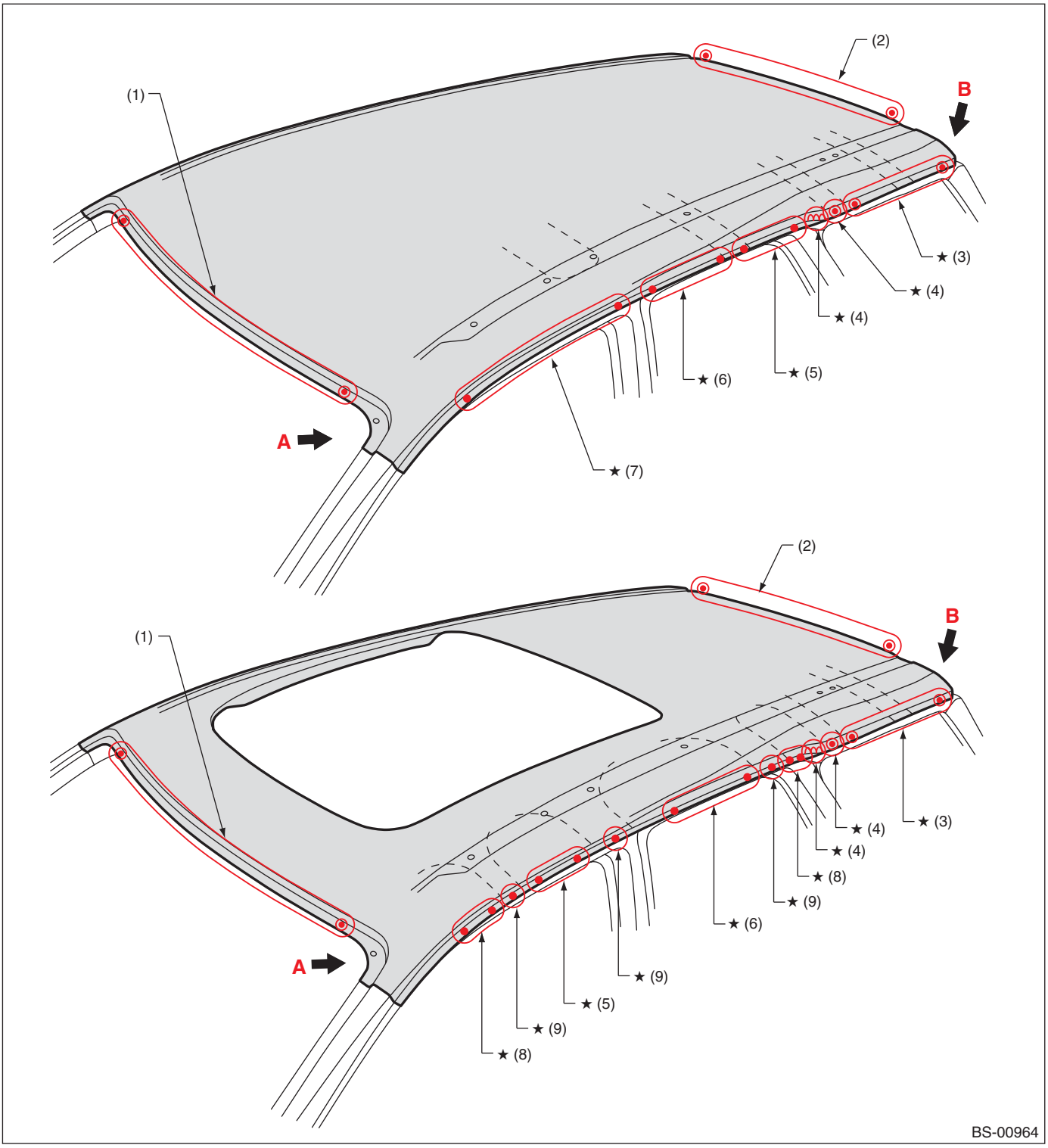
(1) 1 point (service · matching)

(2) 4 points

42.Roof Panel / Wagon (total replacement)

A: REMOVAL

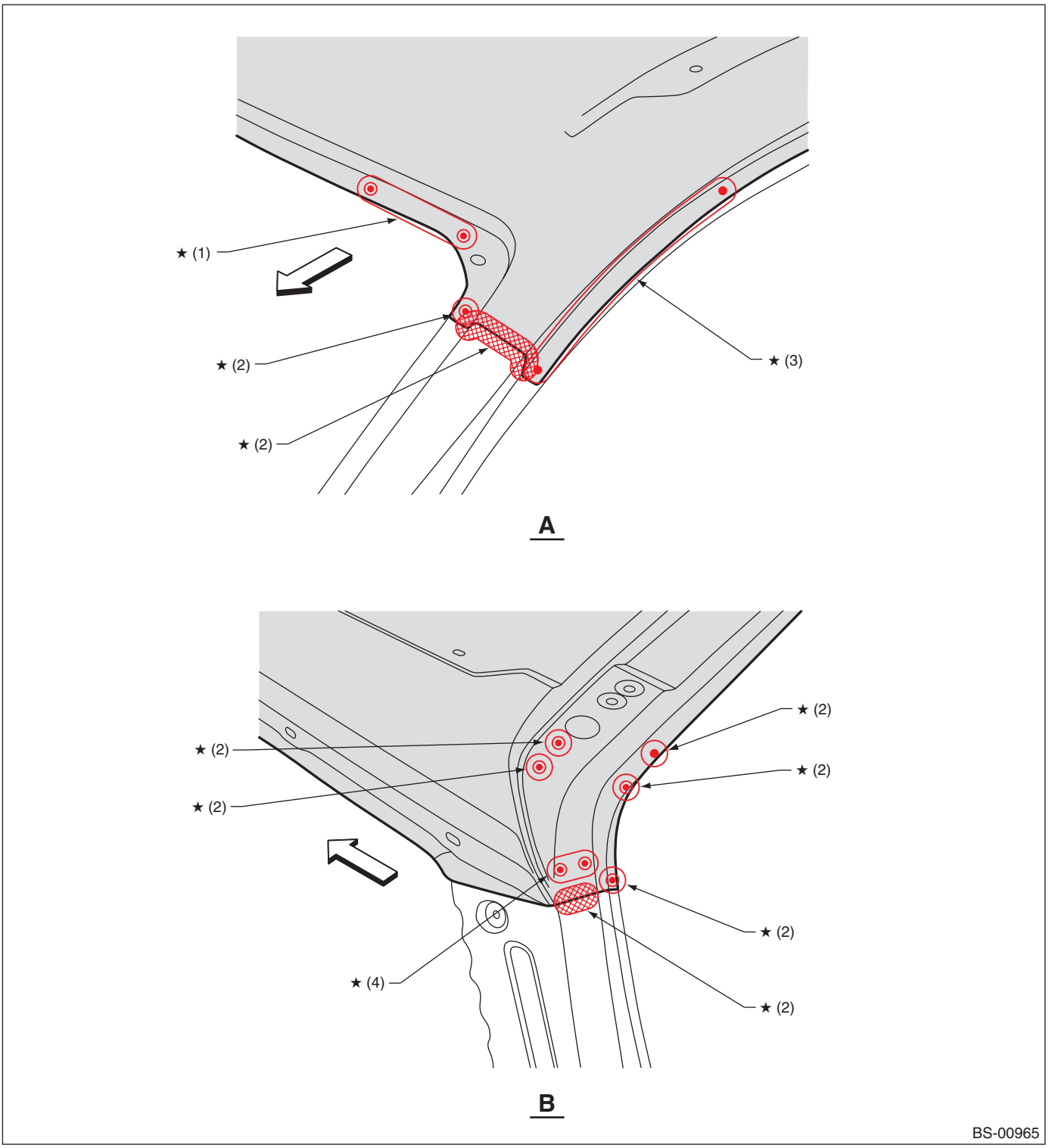
- **Overall view**



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

- **Views**



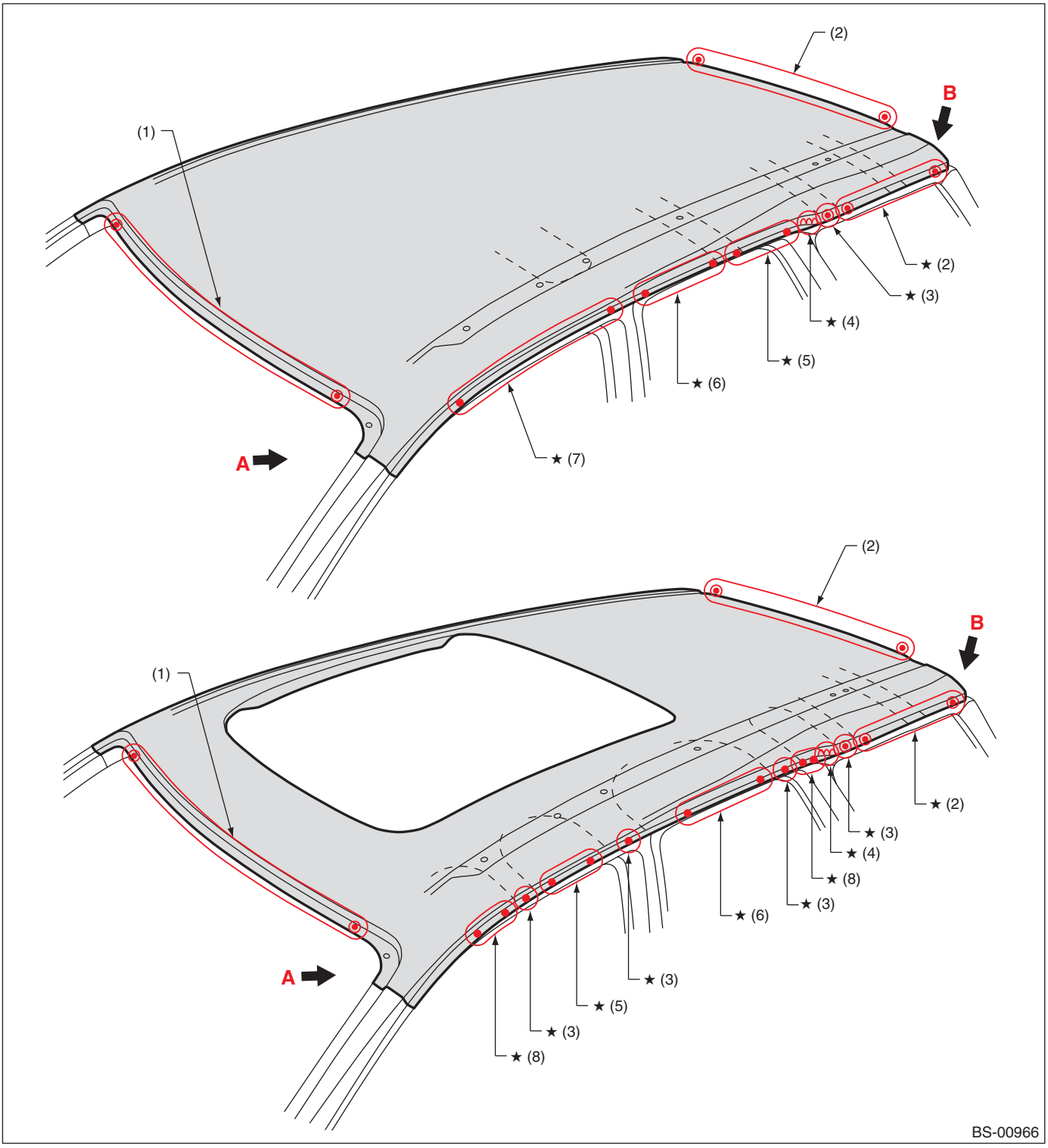
(1) 3 points (top · 1)
(2) 1 point (top · 1)
(3) 4 points (top · 1)
(4) 2 points (top · 1)

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.

B: INSTALLATION

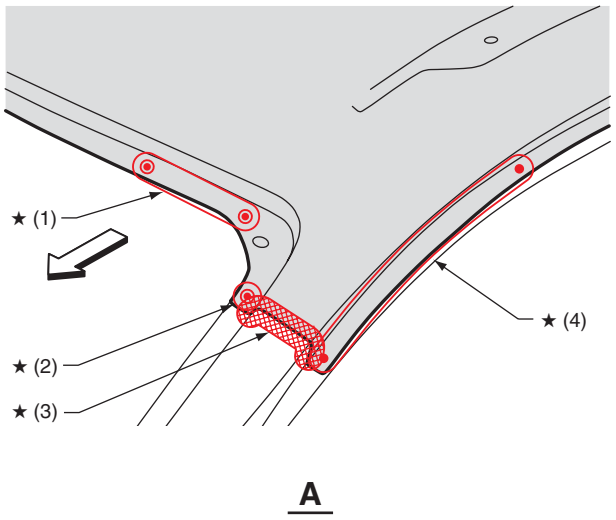
At the time of roof panel installation, apply adhesive at the locations shown in the following figure.

- **Overall view**

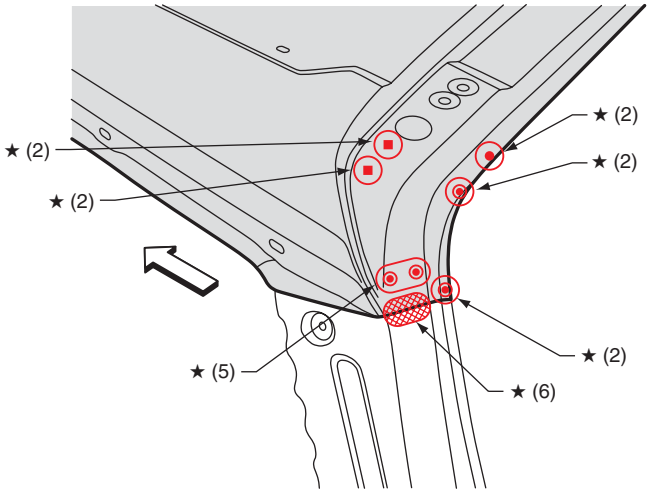


(1) 20 points
(2) 21 points
(3) 1 point
(4) 1 point (10 mm)
(5) 4 points
(6) 6 points
(7) 10 points
(8) 3 points

- **Views**



A

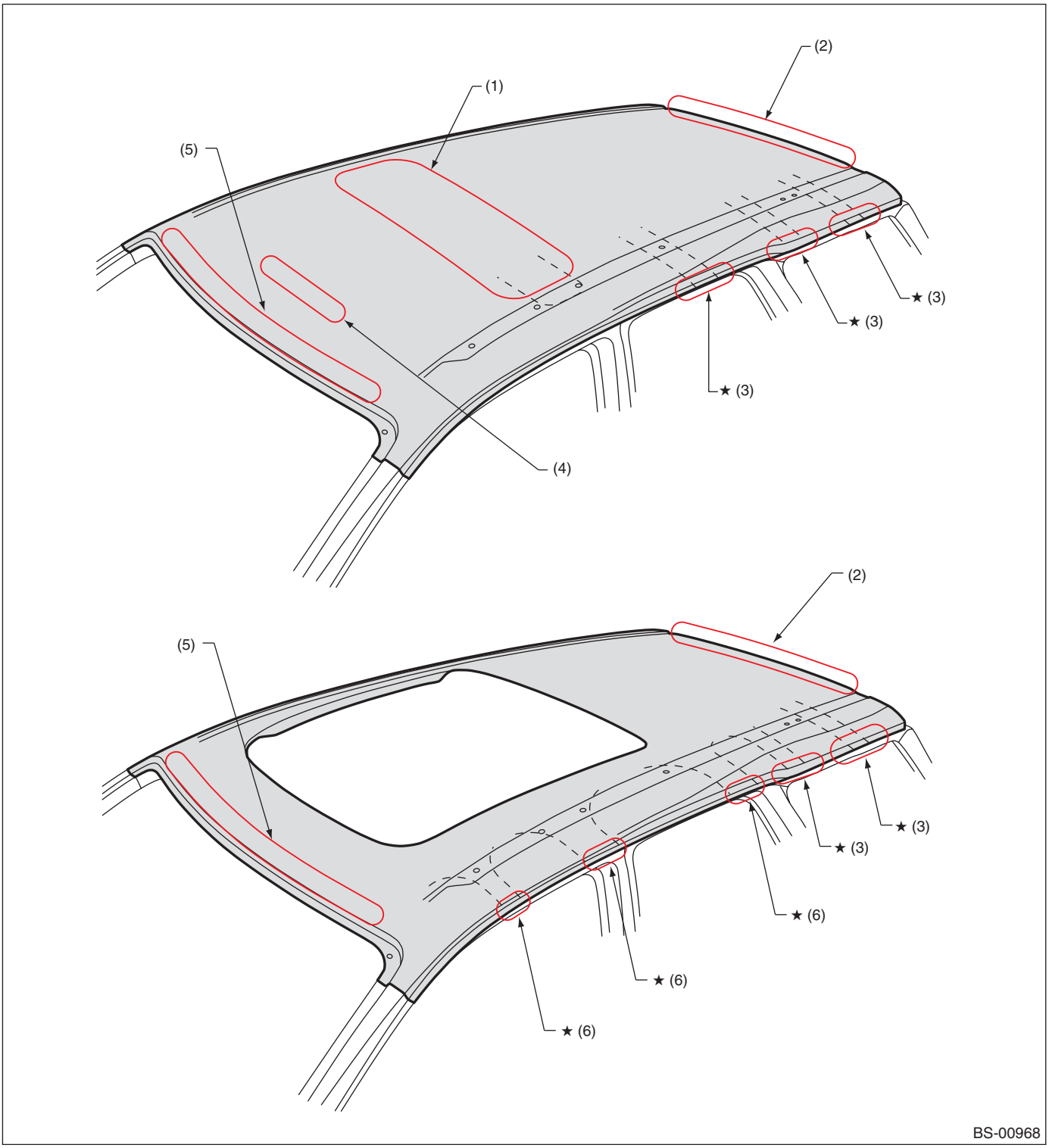


B

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)

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

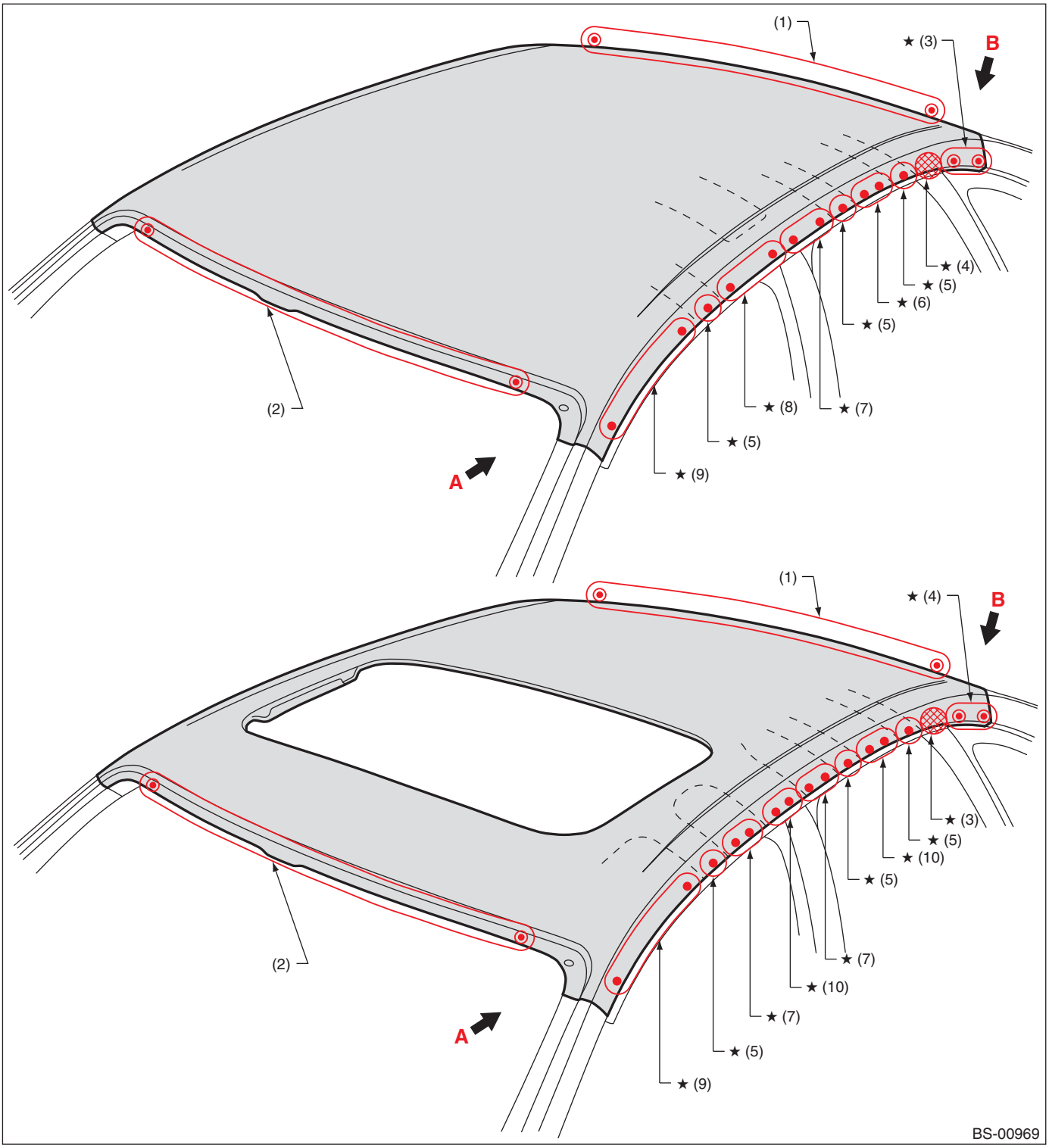


(1) 15 points
(2) 8 points
(3) 3 points
(4) 3 points (Only on overhead console equipped vehicles)
(5) 9 points
(6) 2 points

43.Roof Panel / Sedan (total replacement)

A: REMOVAL

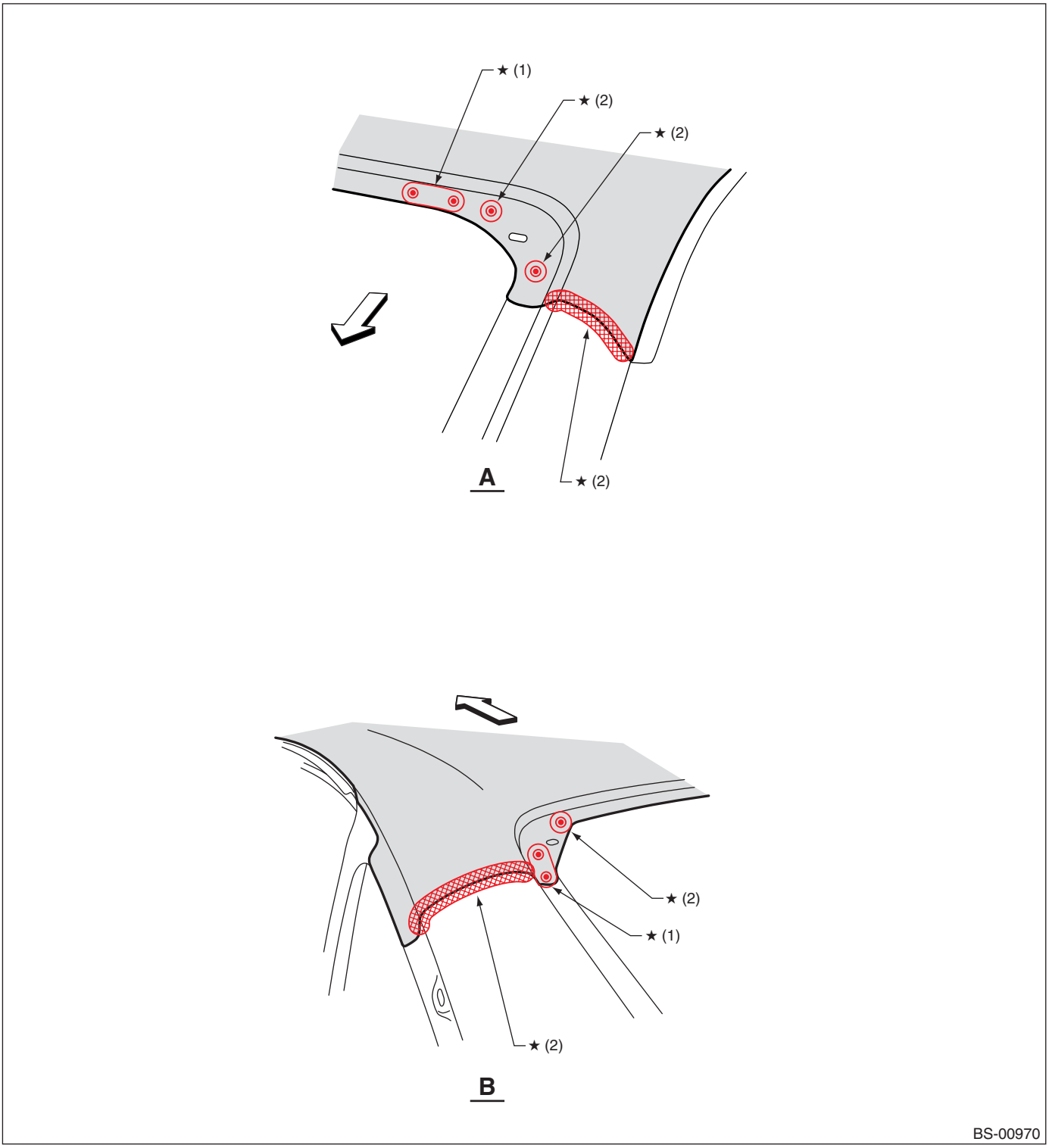
- **Overall view**



(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)

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**



(1) 2 points (top · 1)

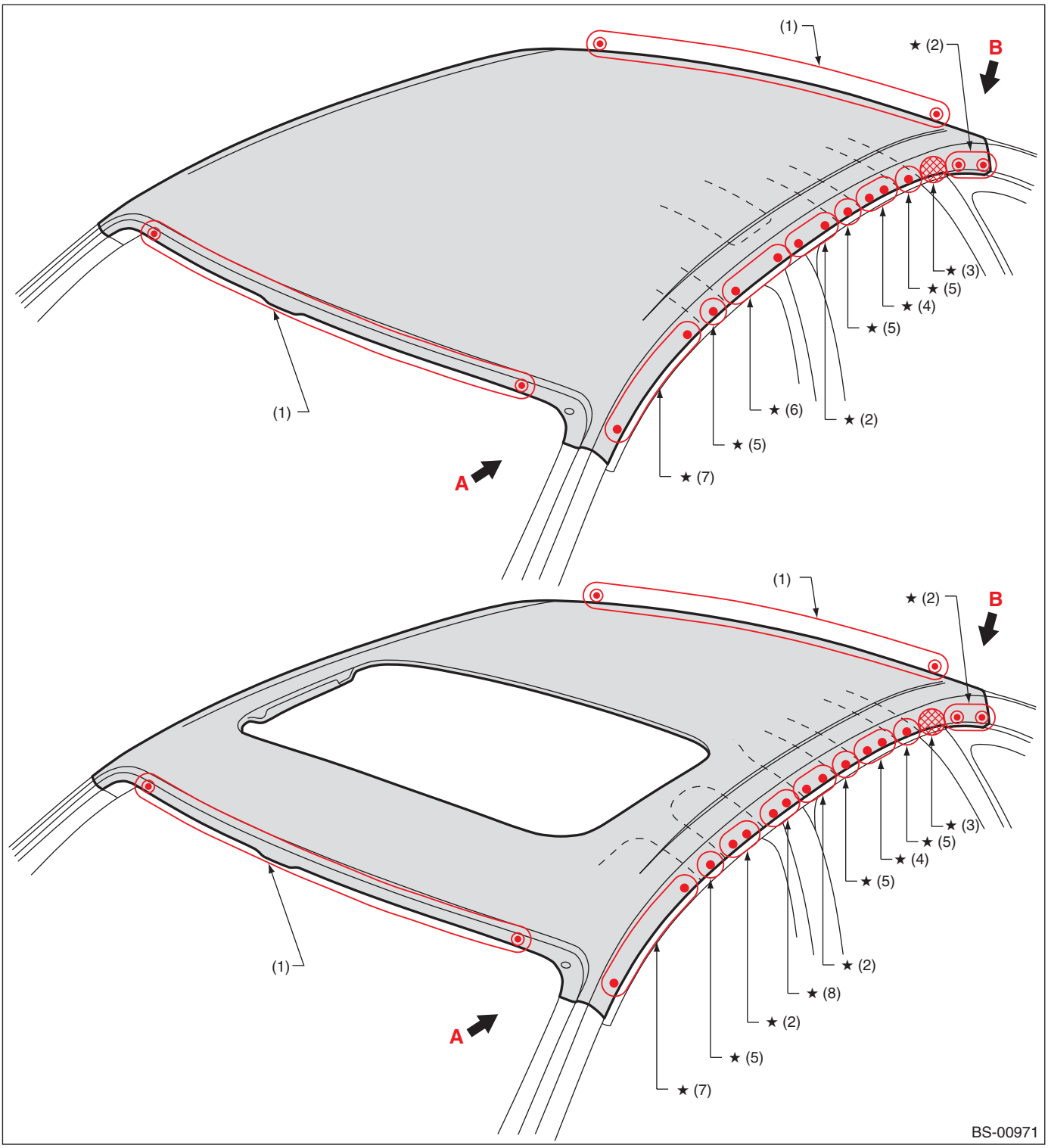
(2) 1 point (top · 1)

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.

B: INSTALLATION

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

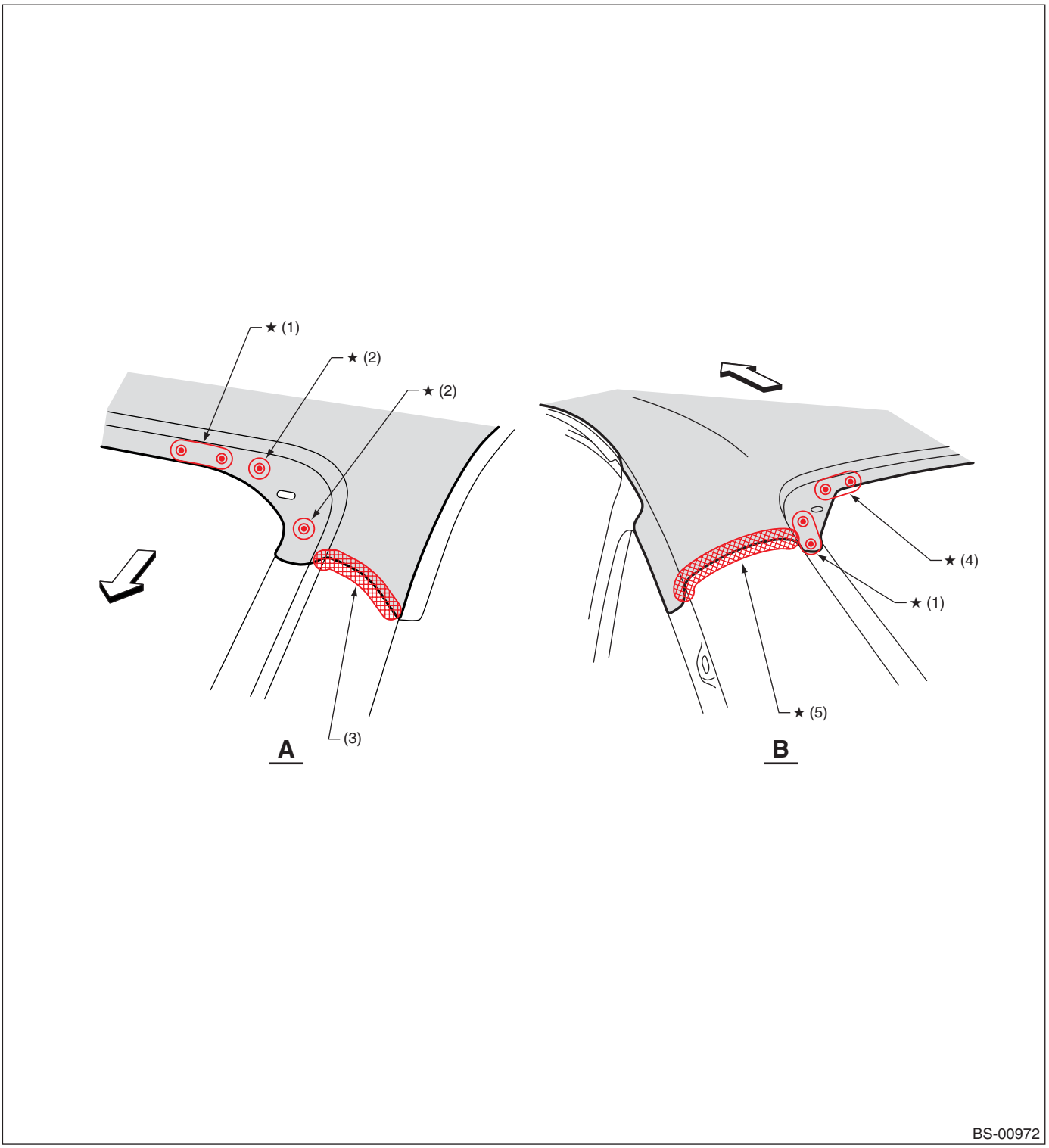
- **Overall view**



(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.

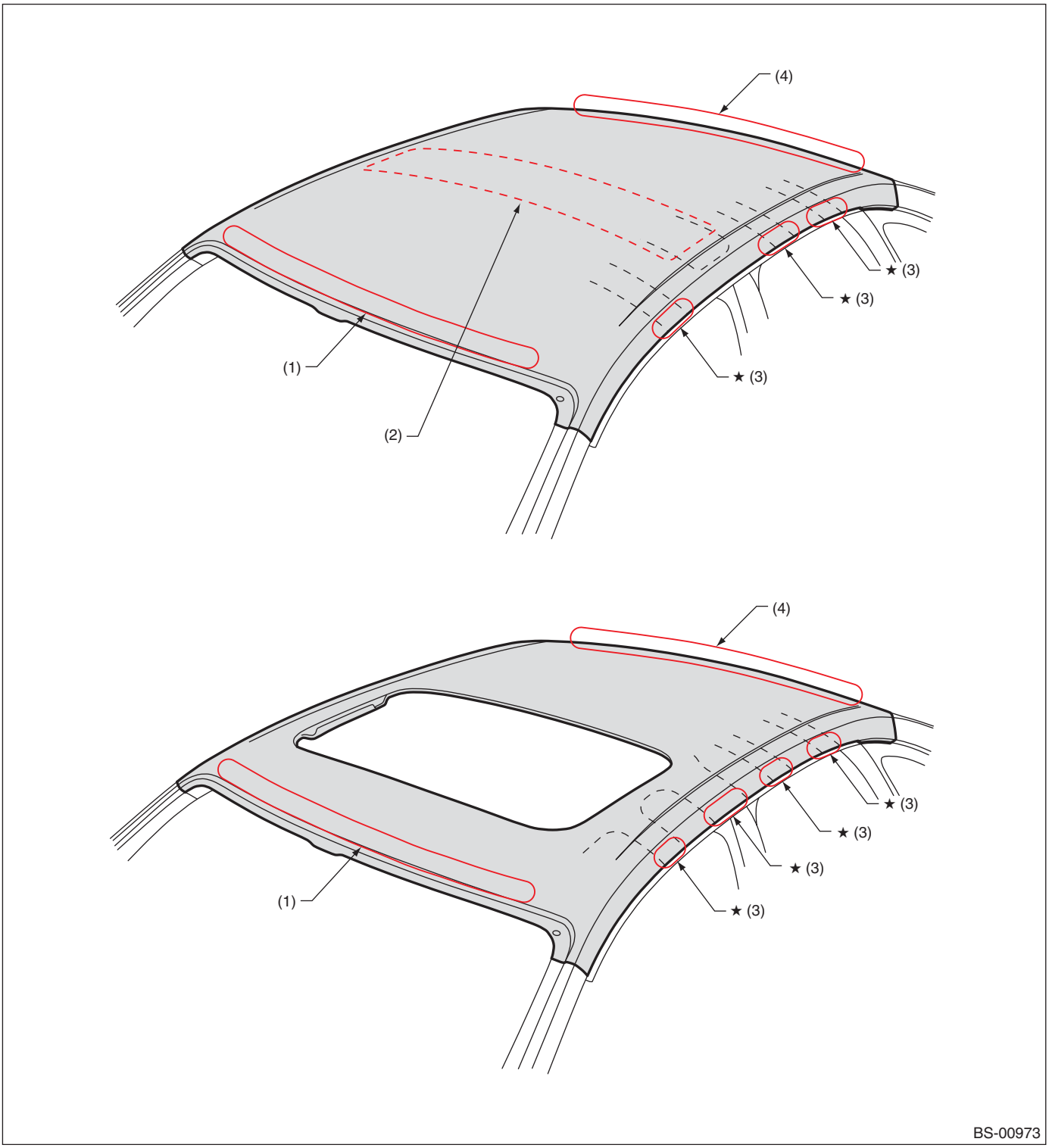
- **Views**



(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.

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



(1) 9 points
(2) 17 points
(3) 3 points
(4) 11 points