



Technical Service Bulletin

SUBJECT:		No:	TSB-20-42B-002
2019 OUTLANDER PHEV BODY REPAIR MANUAL INFORMATION - SMR		DATE:	May 2020
		MODEL:	2019 Outlander PHEV
CIRCULATE TO:	<input type="checkbox"/> GENERAL MANAGER	<input type="checkbox"/> PARTS MANAGER	<input checked="" type="checkbox"/> TECHNICIAN
<input checked="" type="checkbox"/> SERVICE ADVISOR	<input checked="" type="checkbox"/> SERVICE MANAGER	<input checked="" type="checkbox"/> WARRANTY PROCESSOR	<input type="checkbox"/> SALES MANAGER

PURPOSE

A 2019 Outlander PHEV Body Repair Manual was not issued. Use the 2018 Body Repair Manual (MSSP-427B-2018) along with this TSB for complete body repair information on the 2019 Outlander PHEV.

AFFECTED VEHICLES

- 2019 Outlander PHEV

AFFECTED SERVICE MANUAL

2019 Outlander PHEV Service Manual:

- Group 1 - Body Construction
 - General Information
 - Body Construction Characteristics
- Group 3 - Welded Panel Replacements
 - General Information
 - Front Pillar
 - Front Pillar (Partial Replacement)
 - Center Pillar
 - Side Sill
 - Roof
 - Quarter Inner
 - Quarter Inner Lower
- Group 5 - Synthetic-Resin Parts
 - General Information
 - Location of Synthetic-Resin Parts
- Group 6 - Body Color
 - General Information
 - Body Coloring



GROUP 1

**BODY
CONSTRUCTION**

CONTENTS

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		REAR BODY	1-2

GENERAL INFORMATION

OUTLINE OF CHANGE

The section "REAR BODY" has been changed.

M4010000201054

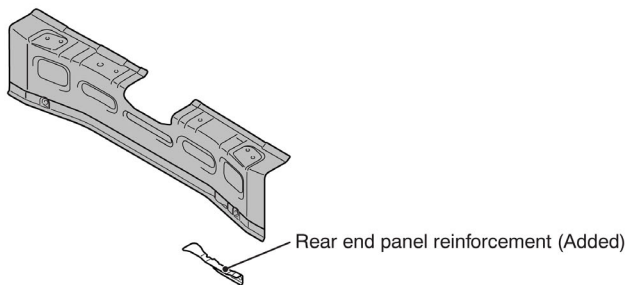
BODY CONSTRUCTION CHARACTERISTICS

REAR BODY

REAR END CROSSMEMBER

The following component has been added.

M4010012001143



NOTE :

 : Indicate the same parts as for previous models.

ABI00020AB

GROUP 3

**WELDED PANEL
REPLACEMENT**

CONTENTS

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GENERAL INFORMATION

M4030000900632

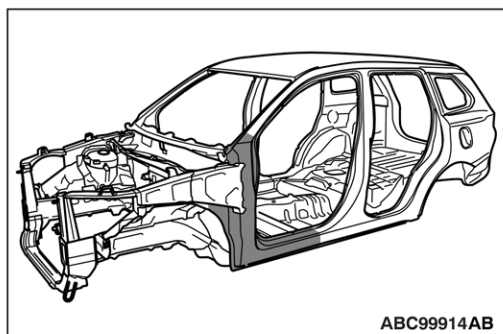
OUTLINE OF CHANGE


The sections "FRONT PILLAR", "FRONT PILLAR (PARTIAL REPLACEMENT)", "CENTER PILLAR", "SIDE SILL", "ROOF", "QUARTER INNER" and "QUARTER INNER LOWER" have been changed.

FRONT PILLAR

M4030005002362

Adhesive application points have been added. The other service procedures are the same as before.

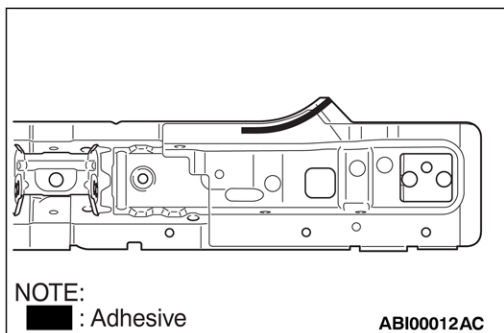
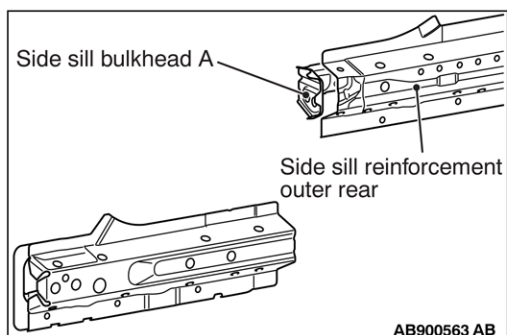


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
#####	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

NOTE ON REPAIR WORK

INSTALLATION

- When installing the new side sill reinforcement part, carry out the following procedure.
 - Remove the side sill reinforcement outer rear and the side sill bulkhead A from the side sill reinforcement.

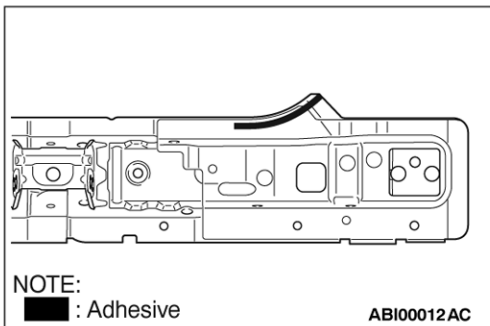
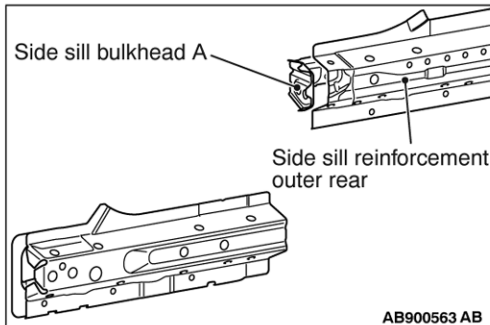


- <With spot welding>
Apply the adhesives to the areas shown in the figure.
<With MIG plug welding>
Increase the number of the specified welding spots by 40% without applying any adhesive.
Adhesive: Epoxyayresin adhesive
Brand: 3M™ AAD Part No.8115 or equivalent

NOTE ON REPAIR WORK**INSTALLATION**

1. When installing the new side sill reinforcement part, carry out the following procedure.

- (1) Remove the side sill reinforcement outer rear and the side sill bulkhead A from the side sill reinforcement.



- (2) <With spot welding>

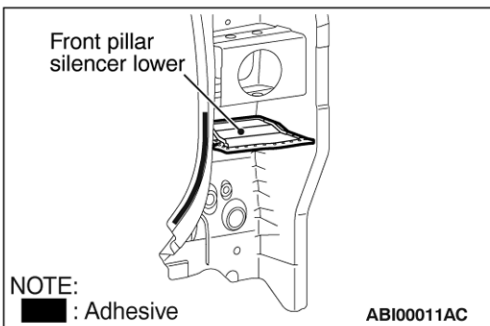
Apply the adhesives to the areas shown in the figure.

<With MIG plug welding>

Increase the number of the specified welding spots by 40% without applying any adhesive.

Adhesive: Epoxyayresin adhesive

Brand: 3M™ AAD Part No.8115 or equivalent



2. When installing the new front pillar reinforcement lower inner part, carry out the following procedure.

- (1) To prevent drooping of sound dampening foam material into the front pillar in the next process, install the front pillar silencer lower to the front pillar reinforcement lower inner. Then apply the butyl-tape to close the hole and gap of the front pillar silencer lower.

- (2) <With spot welding>

Apply the adhesives to the areas shown in the figure.

<With MIG plug welding>

Increase the number of the specified welding spots by 40% without applying any adhesive.

Adhesive: Epoxyayresin adhesive

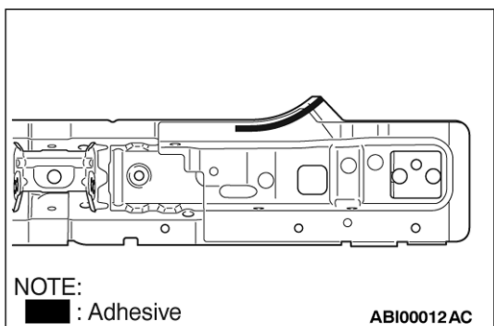
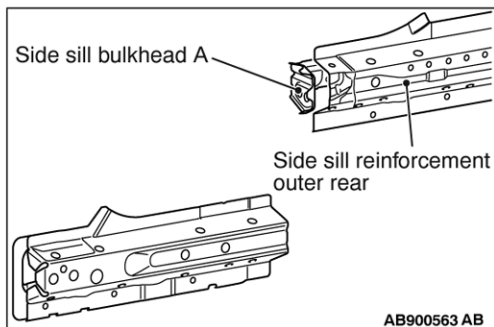
Brand: 3M™ AAD Part No.8115 or equivalent

NOTE ON REPAIR WORK

INSTALLATION

1. When installing the new side sill reinforcement part, carry out the following procedure.

(1) Remove the side sill reinforcement outer rear and the side sill bulkhead A from the side sill reinforcement.



(2) <With spot welding>

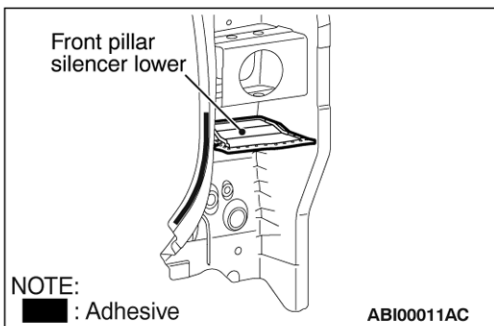
Apply the adhesives to the areas shown in the figure.

<With MIG plug welding>

Increase the number of the specified welding spots by 40% without applying any adhesive.

Adhesive: Epoxyayresin adhesive

Brand: 3M™ AAD Part No.8115 or equivalent



2. When installing the new front pillar reinforcement lower inner part, carry out the following procedure.

(1) To prevent drooping of sound dampening foam material into the front pillar in the next process, install the front pillar silencer lower to the front pillar reinforcement lower inner. Then apply the butyl-tape to close the hole and gap of the front pillar silencer lower.

(2) <With spot welding>

Apply the adhesives to the areas shown in the figure.

<With MIG plug welding>

Increase the number of the specified welding spots by 40% without applying any adhesive.

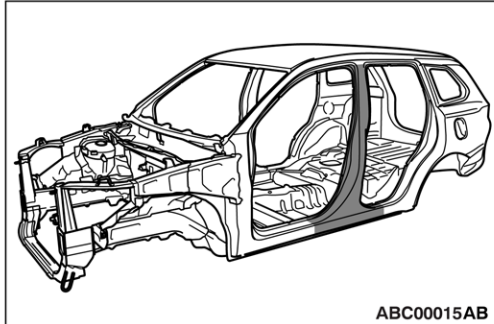
Adhesive: Epoxyayresin adhesive


Brand: 3M™ AAD Part No.8115 or equivalent

CENTER PILLAR

M4030006001588

Adhesive application points have been added. The other service procedures are the same as before.



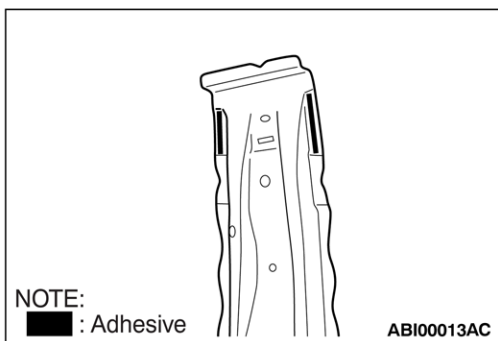
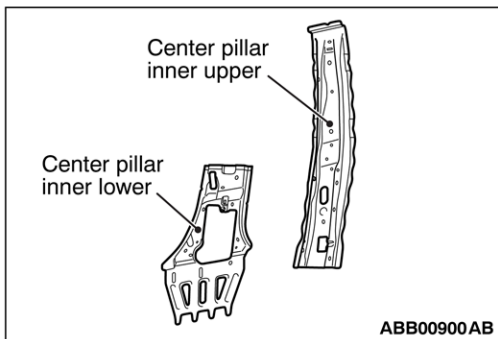
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

NOTE ON REPAIR WORK

INSTALLATION

1. When installing the new center inner pillar part, carry out the following procedure.

(1) Remove the center pillar inner lower from the center inner pillar.



(2) <With spot welding>

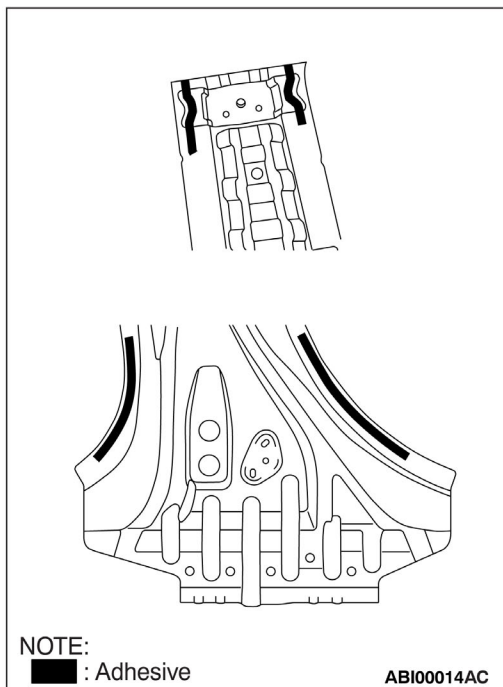
Apply the adhesives to the areas shown in the figure.

<With MIG plug welding>

Increase the number of the specified welding spots by 40% without applying any adhesive.

Adhesive: Epoxyayresin adhesive

Brand: 3M™ AAD Part No.8115 or equivalent



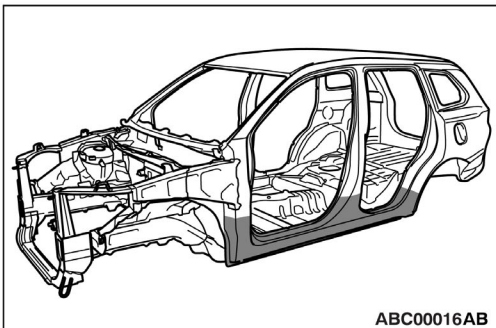
- When installing the new center pillar reinforcement part, carry out the following procedure.
 - <With spot welding>
 - Apply the adhesives to the areas shown in the figure.
 - <With MIG plug welding>
 - Increase the number of the specified welding spots by 40% without applying any adhesive.


Adhesive: Epoxyayresin adhesive
Brand: 3M™ AAD Part No.8115 or equivalent

SIDE SILL

M4030007001882

Adhesive application points have been added. The other service procedures are the same as before.



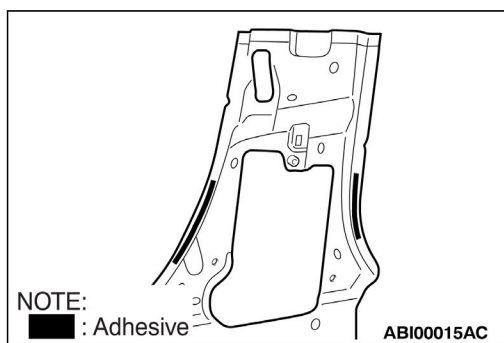
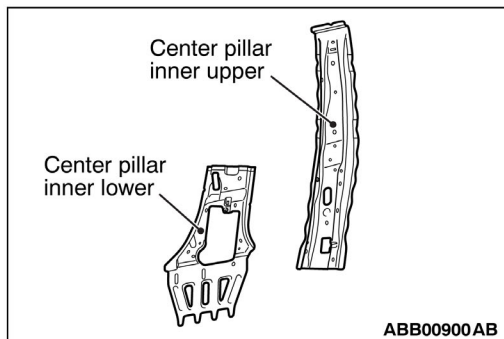
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■ : indicates two panels to be welded ▲ : indicates three panels to be welded)
++++	MIG spot welding
#####	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

NOTE ON REPAIR WORK

INSTALLATION

1. When installing the new center inner pillar part, carry out the following procedure.

(1) Remove the center pillar inner upper from the center inner pillar.



(2) <With spot welding>

Apply the adhesives to the areas shown in the figure.

<With MIG plug welding>

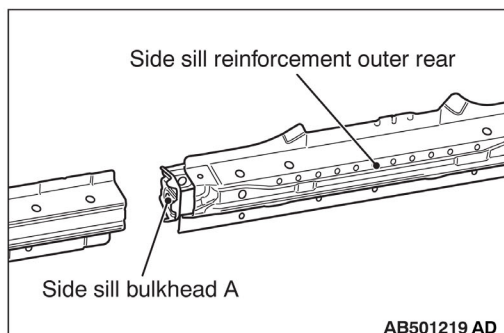
Increase the number of the specified welding spots by 40% without applying any adhesive.

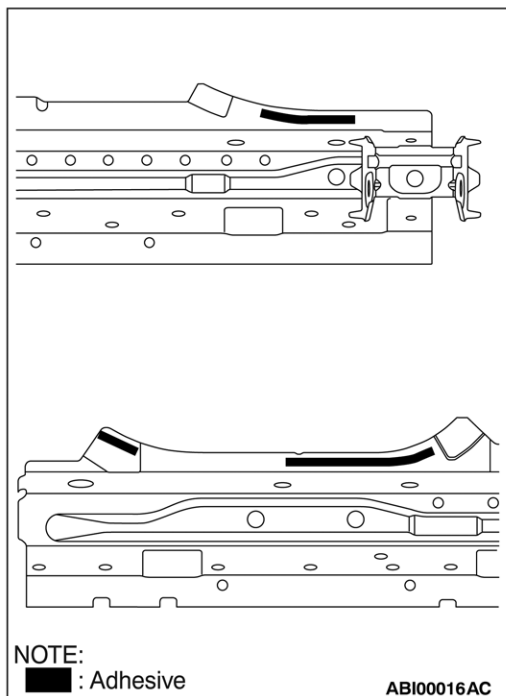
Adhesive: Epoxyayresin adhesive

Brand: 3M™ AAD Part No.8115 or equivalent

2. When installing the new side sill reinforcement, carry out the following procedure.

(1) Use only the side sill reinforcement outer rear and the side sill bulkhead A.





(2) <With spot welding>

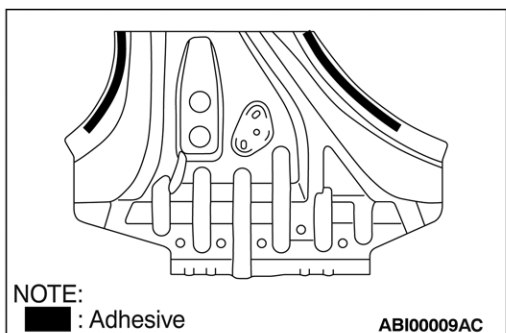
Apply the adhesives to the areas shown in the figure.

<With MIG plug welding>

Increase the number of the specified welding spots by 40% without applying any adhesive.

Adhesive: Epoxyayresin adhesive

Brand: 3M™ AAD Part No.8115 or equivalent



3. When installing the new center pillar reinforcement part, carry out the following procedure.

<With spot welding>

Apply the adhesives to the areas shown in the figure.

<With MIG plug welding>

Increase the number of the specified welding spots by 40% without applying any adhesive.

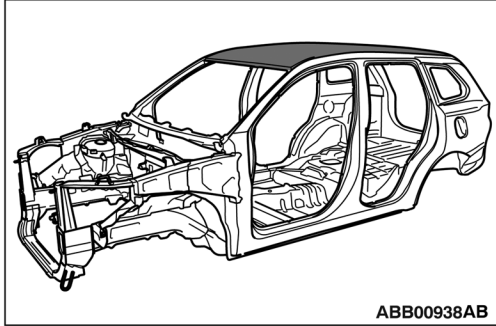
Adhesive: Epoxyayresin adhesive


Brand: 3M™ AAD Part No.8115 or equivalent

ROOF

M4030011001982

Adhesive application points have been added. The other service procedures are the same as before.



Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
#####	MIG arc welding (continuous)
○○○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

NOTE ON REPAIR WORK

INSTALLATION

When installing the new roof panel part, carry out the following procedure.

<With spot welding>

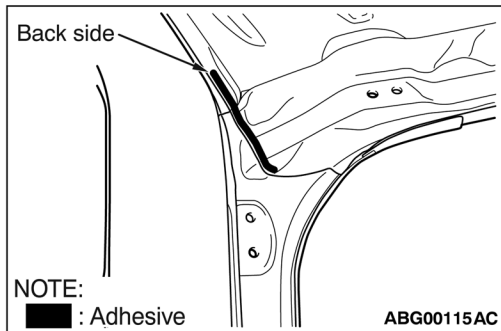
Apply the adhesives to the areas shown in the figure.

<With MIG plug welding>

Increase the number of the specified welding spots by 40% without applying any adhesive.

Adhesive: Epoxyayresin adhesive

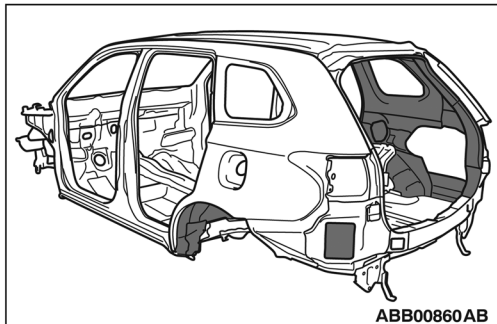
Brand: 3M™ AAD Part No.8115 or equivalent




QUARTER INNER

M4030012001695

Adhesive application points have been added. The other service procedures are the same as before.



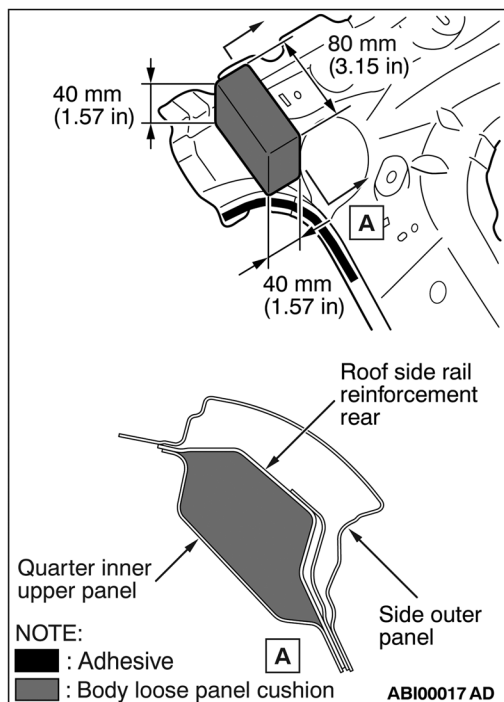
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
#####	MIG arc welding (continuous)
○○○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

NOTE ON REPAIR WORK

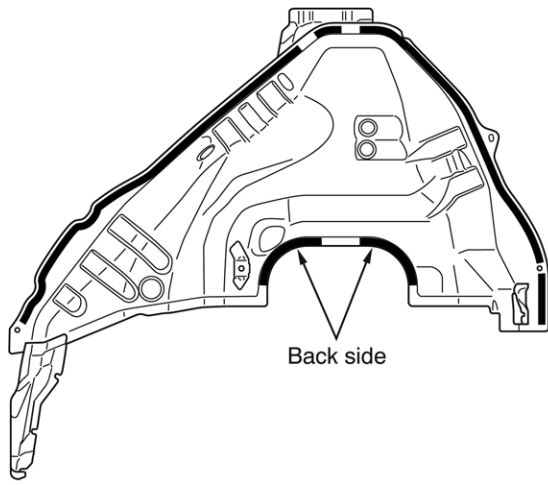
INSTALLATION

- When installing the new quarter panel upper inner parts, carry out the following procedure.
 - Machine the body loose panel cushion (MR565301 or MR435765) for replacement as shown and apply it to the quarter panel upper inner parts because the sound dampening foam material cannot be filled into the quarter panel upper inner.
 - <With spot welding>
Apply the adhesives to the areas shown in the figure.
<With MIG plug welding>
Increase the number of the specified welding spots by 40% without applying any adhesive.

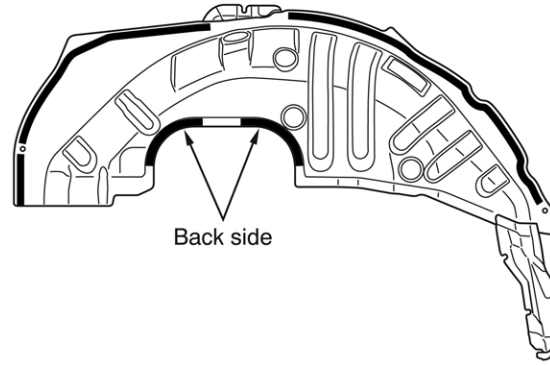
Adhesive: Epoxyayresin adhesive
Brand: 3M™ AAD Part No.8115 or equivalent



(Left side)



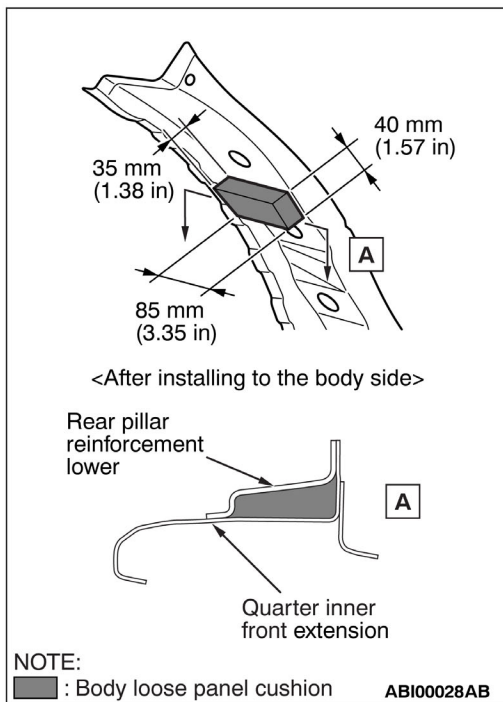
(Right side)



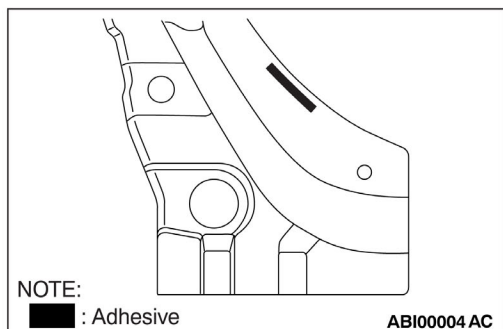
NOTE:  : Adhesive

ABG00113AD

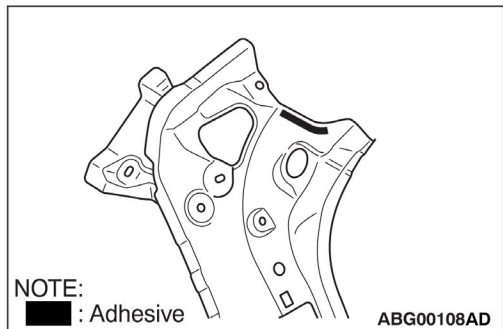
2. When installing the new rear wheel house panel inner part, carry out the following procedure.
<With spot welding>
Apply the adhesives in advance to the areas shown in the figure.
<With MIG plug welding>
Increase the number of the specified welding spots by 40% without applying any adhesive.
Adhesive: Epoxyayresin adhesive
Brand: 3M™ AAD Part No.8115 or equivalent
3. When installing the new rear pillar reinforcement lower part, carry out the following procedure.



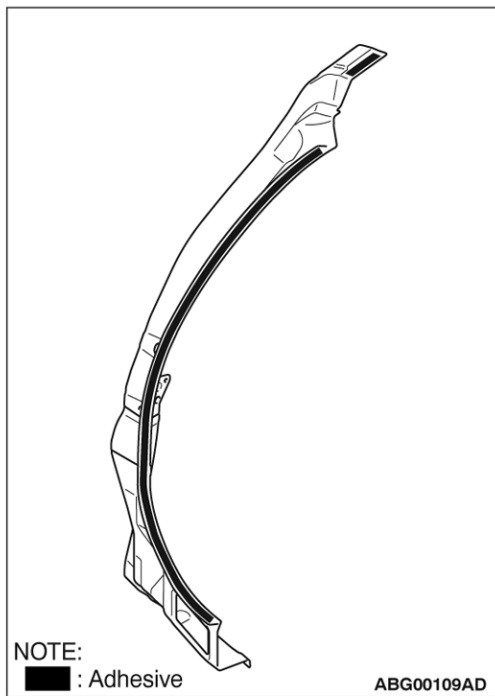
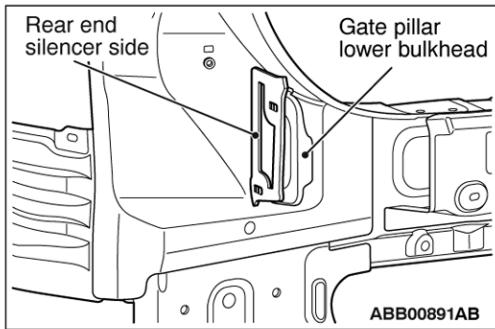
- (1) Machine the body loose panel cushion (MR565301 or MR435765) for replacement as shown and apply it to the rear pillar reinforcement lower part because the sound dampening foam material cannot be filled into the rear pillar reinforcement lower.



- (2) <With spot welding>
Apply the adhesives in advance to the areas shown in the figure.
<With MIG plug welding>
Increase the number of the specified welding spots by 40% without applying any adhesive.
Adhesive: Epoxyayresin adhesive
Brand: 3M™ AAD Part No.8115 or equivalent



4. When installing the new rear inner pillar part, carry out the following procedure.
<With spot welding>
Apply the adhesives in advance to the areas shown in the figure.
<With MIG plug welding>
Increase the number of the specified welding spots by 40% without applying any adhesive.
Adhesive: Epoxyayresin adhesive
Brand: 3M™ AAD Part No.8115 or equivalent



5. When installing the new gate pillar reinforcement parts, carry out the following procedure.

(1) To prevent drooping of sound dampening foam material into the gate pillar in the next process, install the rear end silencer side to the gate pillar lower bulkhead. Then apply the butyl-tape to close the gap of the rear end silencer side.

(2) <With spot welding>

Apply the adhesives in advance to the areas shown in the figure.

<With MIG plug welding>

Increase the number of the specified welding spots by 40% without applying any adhesive.

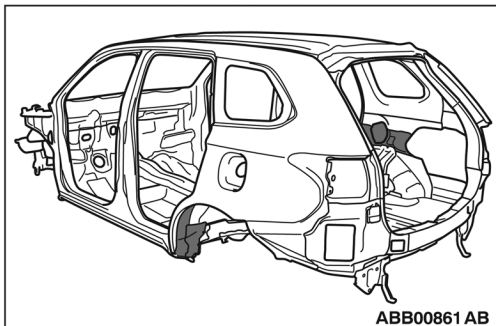
Adhesive: Epoxyayresin adhesive


Brand: 3M™ AAD Part No.8115 or equivalent

QUARTER INNER LOWER

M4030001100543

Adhesive application points have been added. The other service procedures are the same as before.



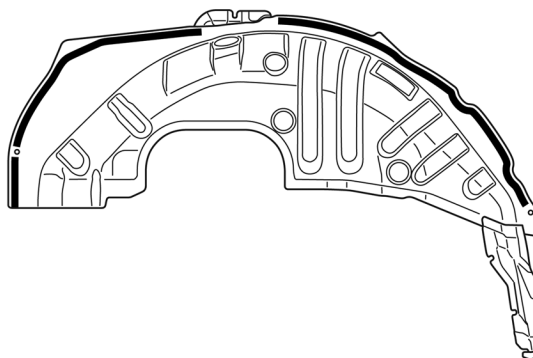
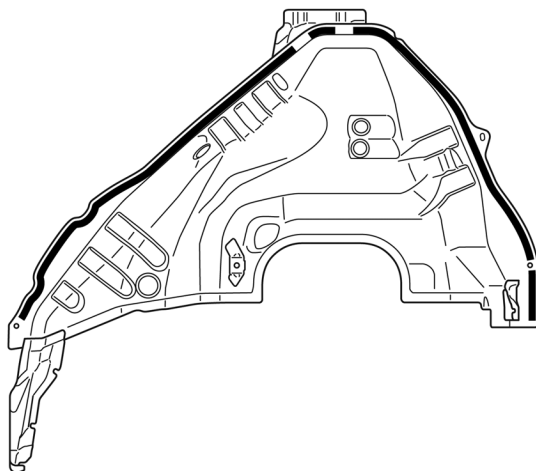
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

NOTE ON REPAIR WORK

INSTALLATION

(Left side)

(Right side)



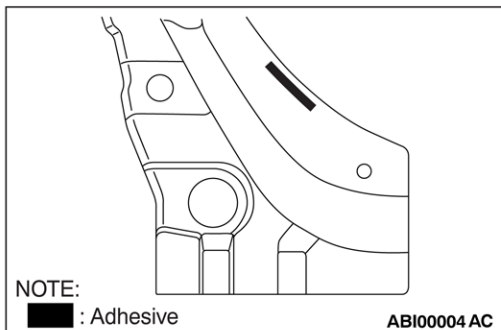
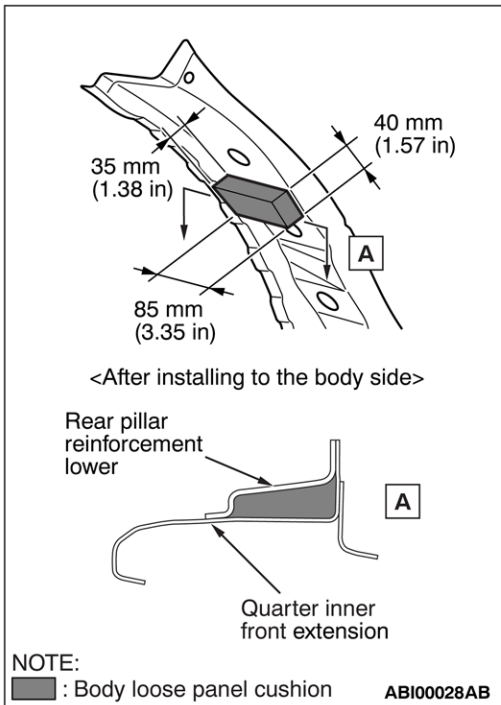
NOTE:  : Adhesive

ABG00114AC

- When installing the new quarter panel lower inner part and the new quarter panel extension inner part, carry out the following procedure.
 - <With spot welding>
Apply the adhesive to the rear wheel house panel inner as shown.
 - <With MIG plug welding>
Increase the number of the specified welding spots by 40% without applying any adhesive.

Adhesive: Epoxyayresin adhesive

Brand: 3M™ AAD Part No.8115 or equivalent



2. When installing the new rear pillar reinforcement lower part, carry out the following procedure.

(1) Machine the body loose panel cushion (MR565301 or MR435765) for replacement as shown and apply it to the rear pillar reinforcement lower part because the sound dampening foam material cannot be filled into the rear pillar reinforcement lower.

(2) <With spot welding>

Apply the adhesives in advance to the areas shown in the figure.

<With MIG plug welding>

Increase the number of the specified welding spots by 40% without applying any adhesive.

Adhesive: Epoxyayresin adhesive

Brand: 3M™ AAD Part No.8115 or equivalent

GROUP 5

**SYNTHETIC-RESIN
PARTS**

CONTENTS

GENERAL INFORMATION	5-2	LOCATION OF SYNTHETIC-RESIN PARTS	5-2
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GENERAL INFORMATION

M4050000100188

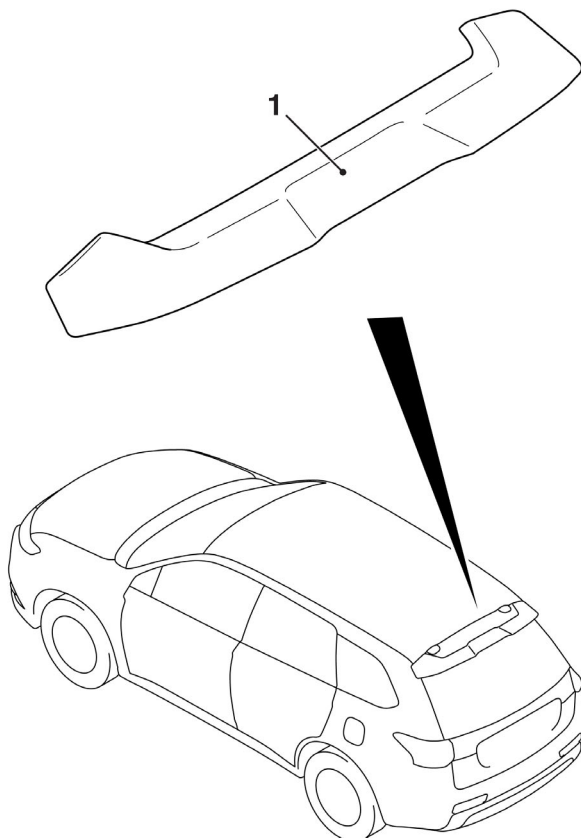
OUTLINE OF CHANGE

The section "LOCATION OF SYNTHETIC-RESIN PARTS" below has been changed.

LOCATION OF SYNTHETIC-RESIN PARTS

M4050001002469

Indicates the main usage location that has been added. Since resin parts get deformed by heat, remove the parts before work if necessary by referring to the temperature shown below.



ABI00010AC

No.	Part Name	Name of Resin	Abbreviation	Heat-resistant Temp [°C (°F)]
1	Roof air spoiler	Acrylonitrile butadiene styrene	ABS	80 (176)

NOTE:

- The material symbols for synthetic-resin parts are embossed on the parts in hidden places.
- Heat resistant temperature means a temperature at which parts may be deformed by heat during work.
- When drying parts with an infrared light, protect them with a heat resistant cover.

GROUP 6

BODY COLOR

CONTENTS

GENERAL INFORMATION	6-2	BODY COLORING	6-2
		FRONT BUMPER EXTENSION	6-2

GENERAL INFORMATION

M4060000201554

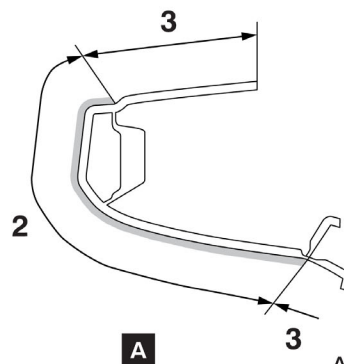
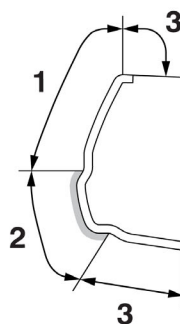
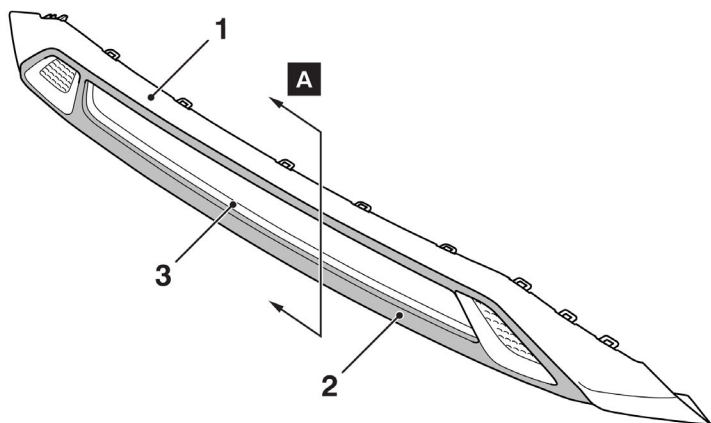
OUTLINE OF CHANGE

The section body coloring of "FRONT BUMPER EXTENSION" has been added.

BODY COLORING

FRONT BUMPER EXTENSION

M4060001700043



1	Body color
2	Silver (AC11169)
3	Material color

ABI00007AD