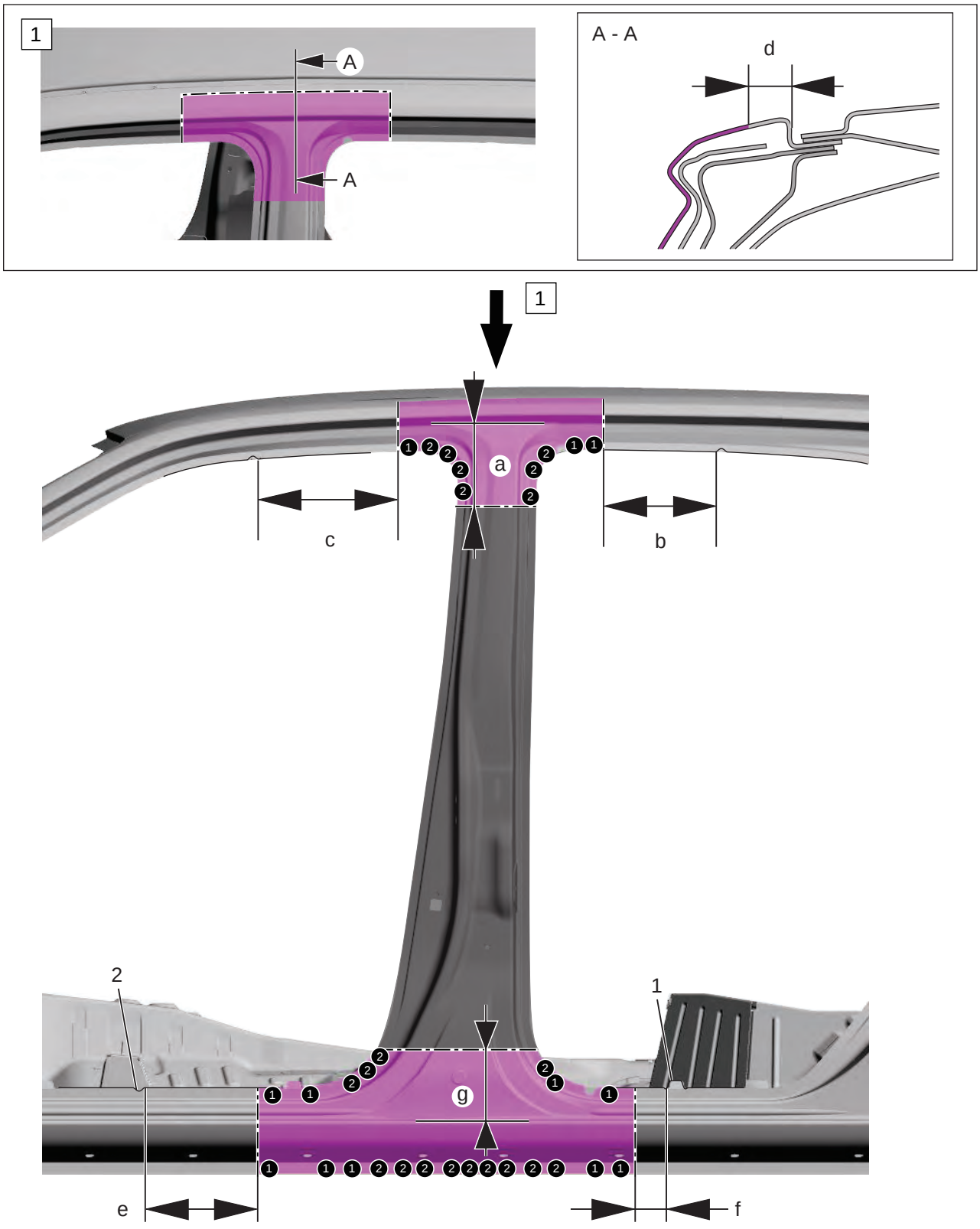
Center pillar outer panel, Center pillar inner panel Removal and Installation (for Crew Cab)

Note :

- Welding method and number of welding points are the same on both sides.
- The dimensions shown in the figure are reference values when cutting replacement part is placed on top of existing part. Determine the most appropriate cutting (or joint) line considering both size of replacement part and condition of existing part.
- The center pillar outer panel (upper part) and the header panel are to be reused.

Removal :

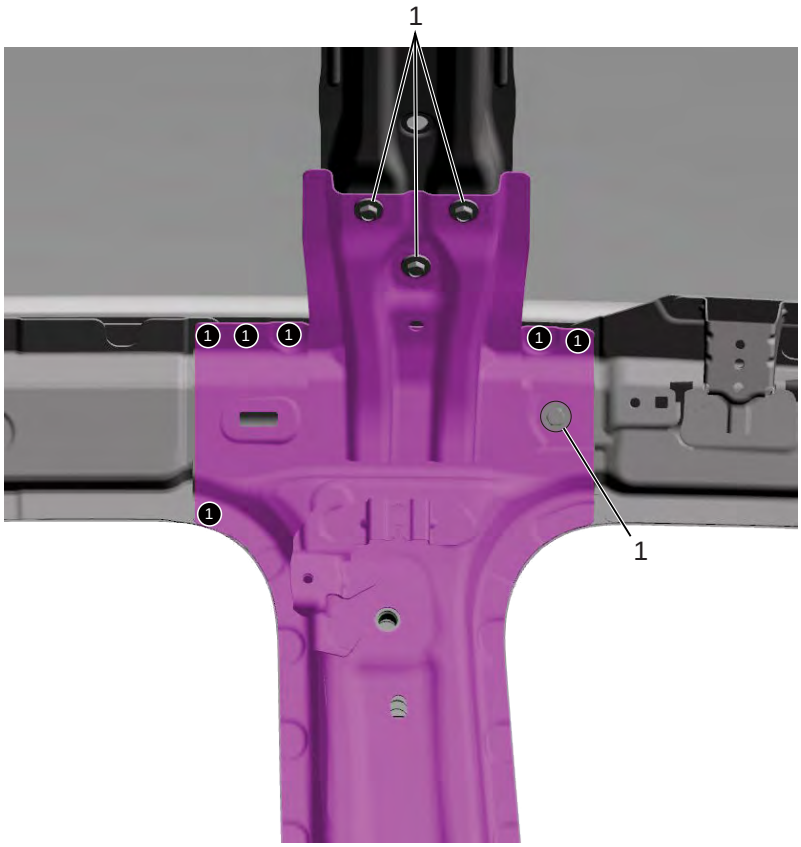
1. Mark at the shown position and cut the center pillar outer panel.
2. Cut the center pillar outer panel, the center pillar reinforcement and the center pillar inner panel at the same time at shown rough cutting position.
3. Drill out welding spots and remove the center pillar outer panel.


1
A
A
A - A
d
1
a
c
b
2
1
g
e
f

1. Tab
2. Cutout

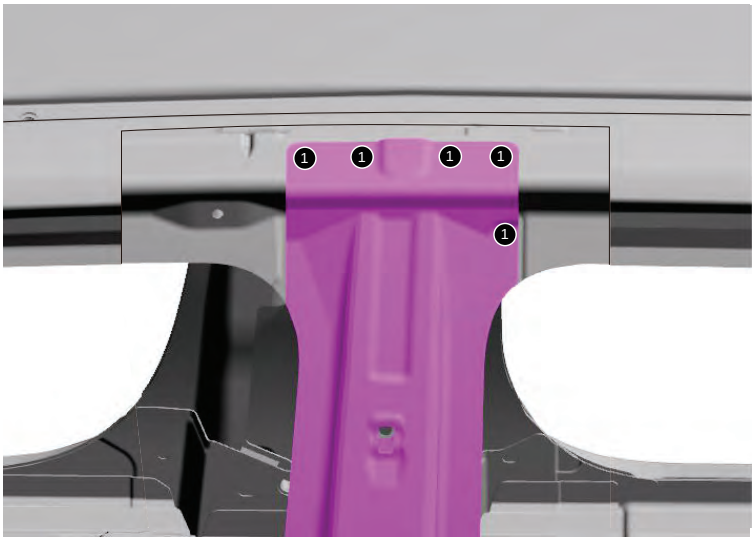
a. 160 mm {6.30 in}
b. 200 mm {7.87 in}
c. 240 mm {9.45 in}
d. 20 mm {0.79 in}
e. 220 mm {8.66 in}
f. 50 mm {1.97 in}
g. 130 mm {5.12 in}

4. Unscrew the 4 bolts.
5. Drill out welding spots and remove upper part of the center pillar inner panel.

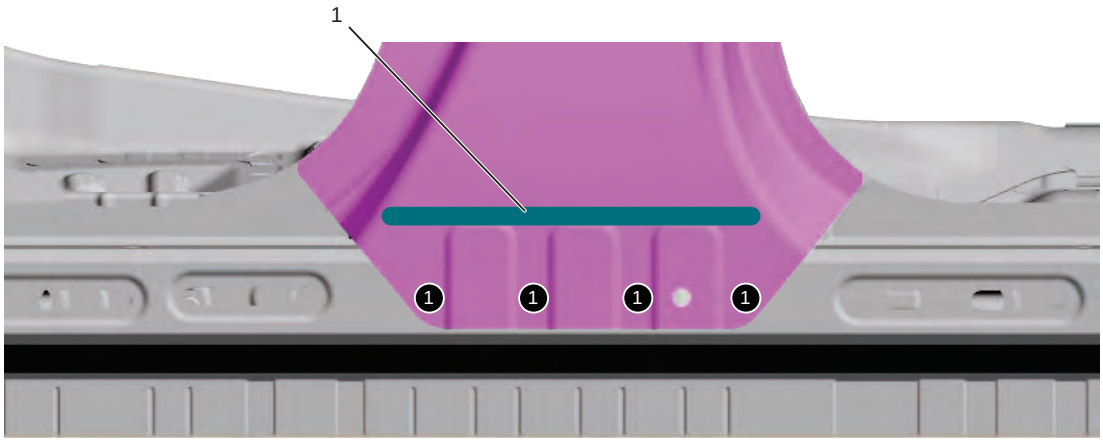


1. Bolt

6. Drill out welding spots and remove upper part of the center pillar reinforcement.

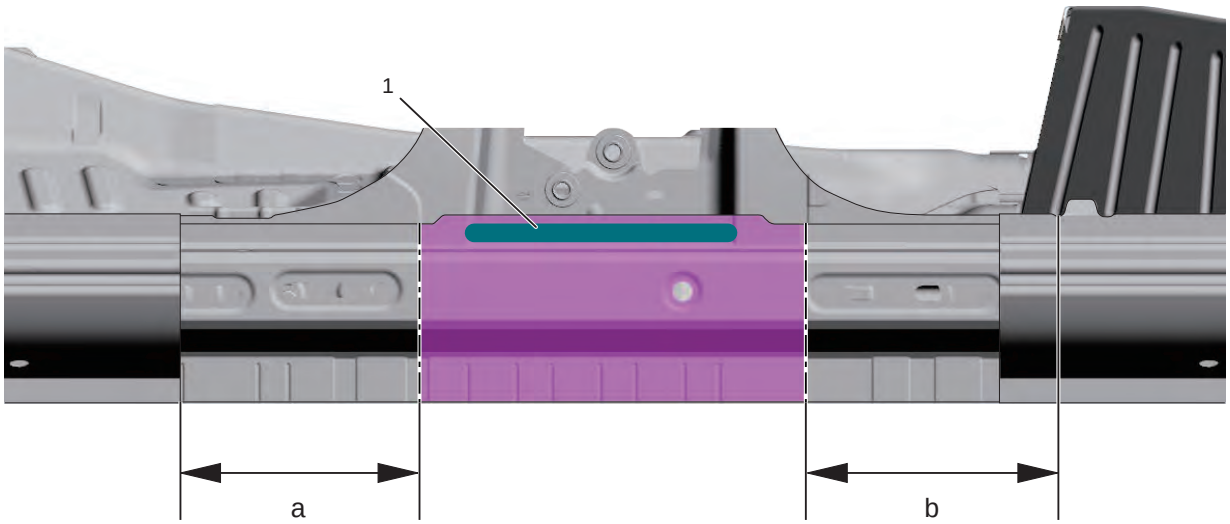


7. Drill out welding spots and remove lower part of the center pillar reinforcement.



1. When heating around formed material application portion to detach formed material, be sure that temperature of said portion does not reach 170 °C (338 °F).

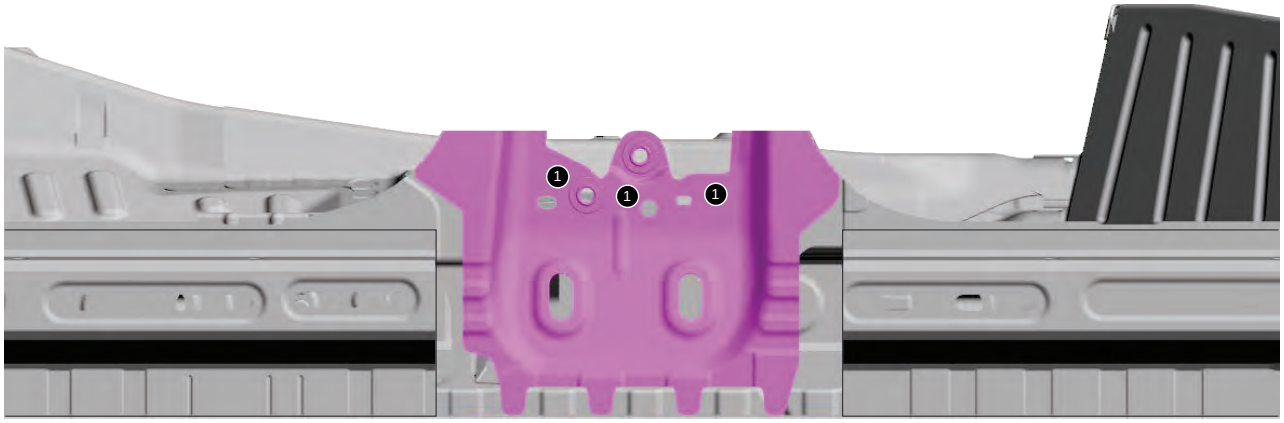
8. Mark at the shown position and cut the rocker reinforcement.
9. Remove the rocker reinforcement.



1. When heating around formed material application portion to detach formed material, be sure that temperature of said portion does not reach 170 °C (338 °F).

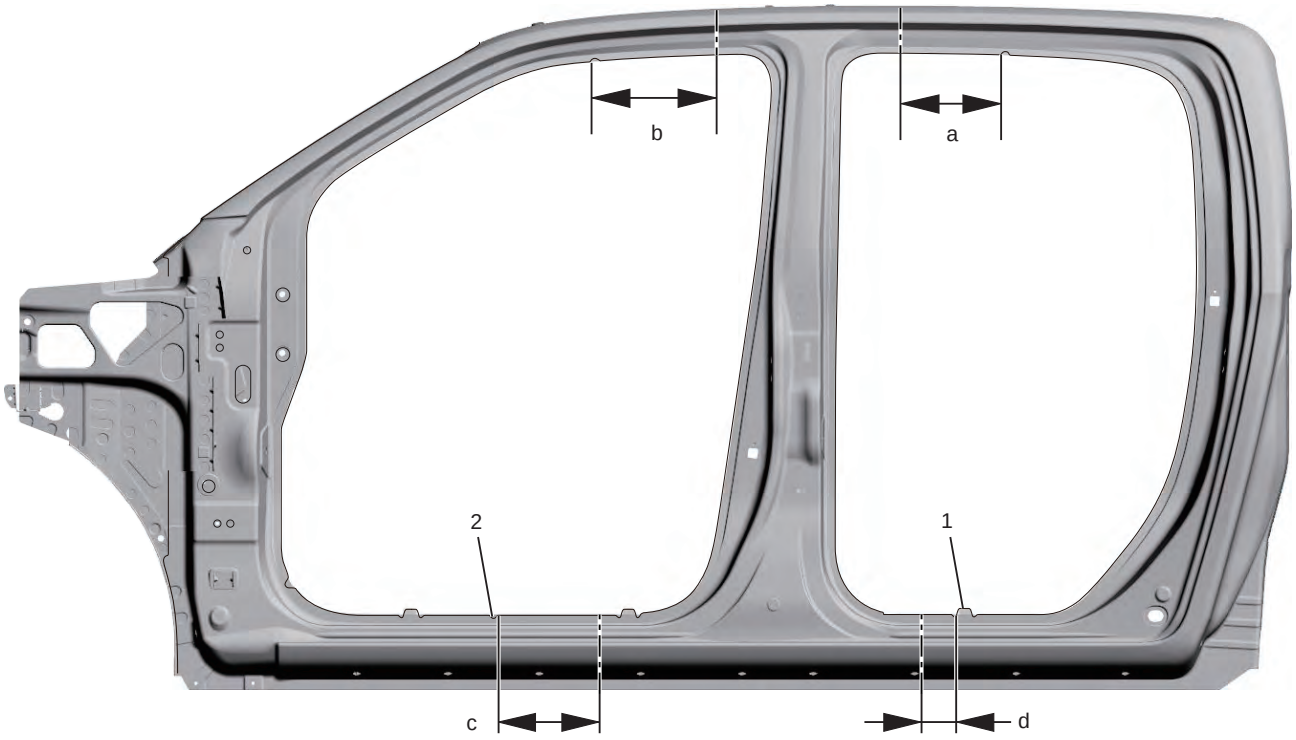
a. 180 mm {7.09 in}
b. 165 mm {6.50 in}

10. Drill out welding spots and remove lower part of the center pillar inner panel.



Installation :

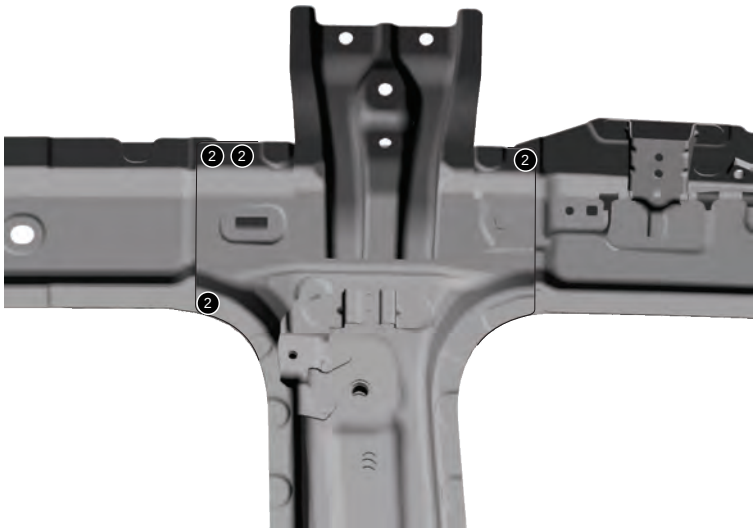
1. Cut off the spare parts as shown in figure.



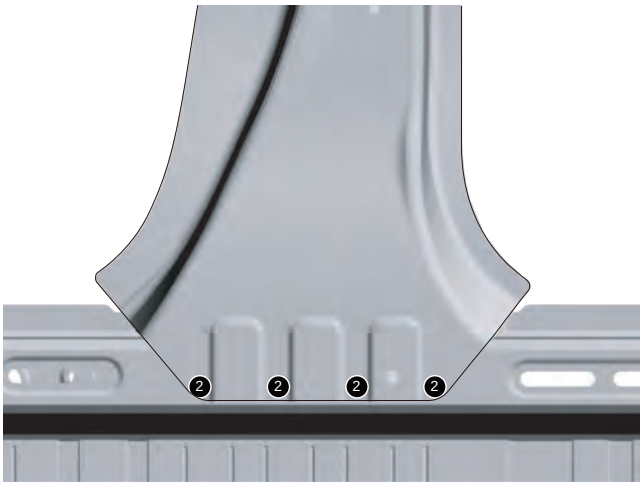
1. Tab
a. 180 mm {7.09 in}
b. 220 mm {8.66 in}
c. 200 mm {7.87 in}
d. 30 mm {1.18 in}

2. Drill out welding spots and remove the center pillar outer panel.

3. Drill out welding spots and remove the center pillar inner panel.



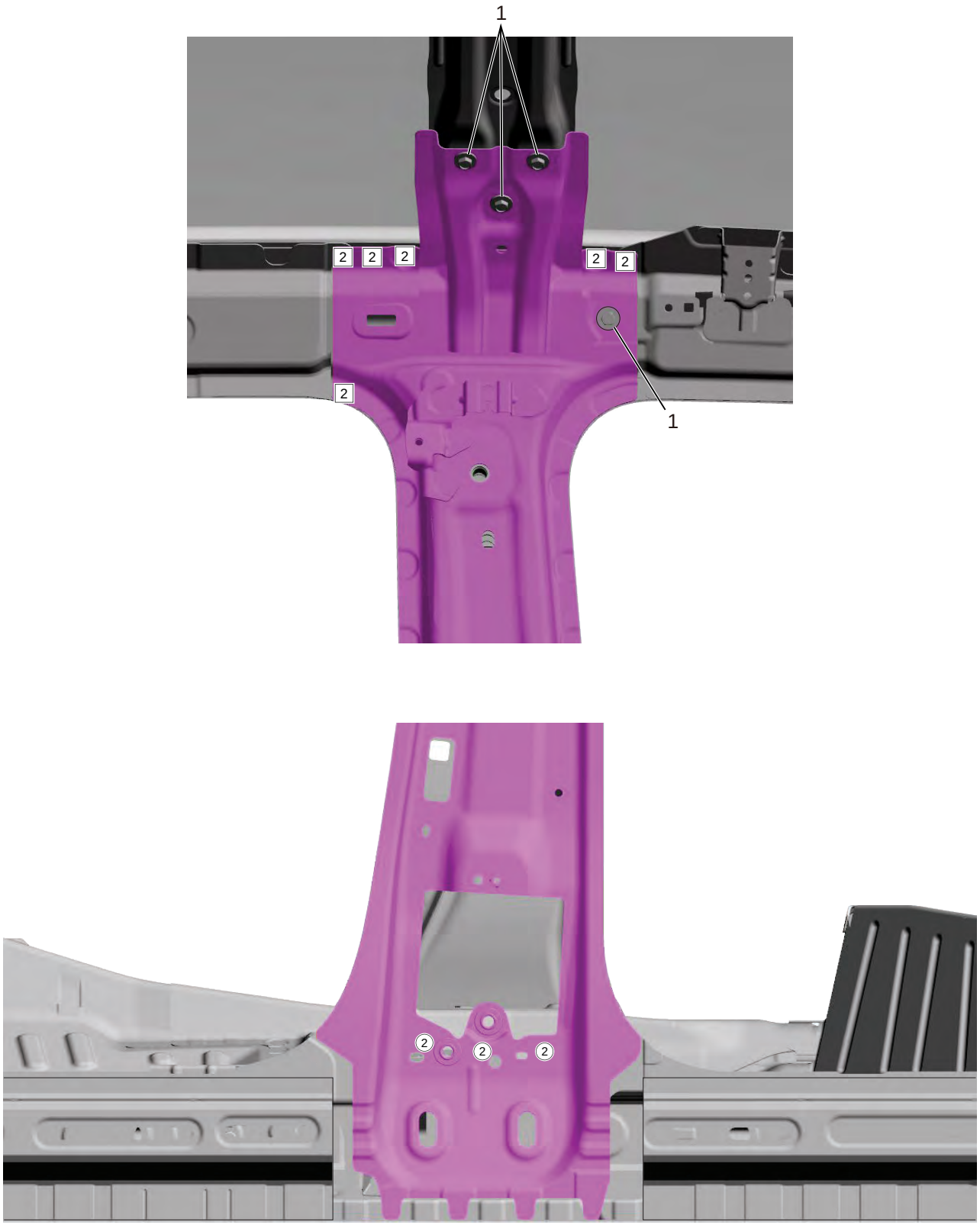
4. Drill out welding spots and remove the rocker reinforcement.



5. Install the center pillar inner panel.

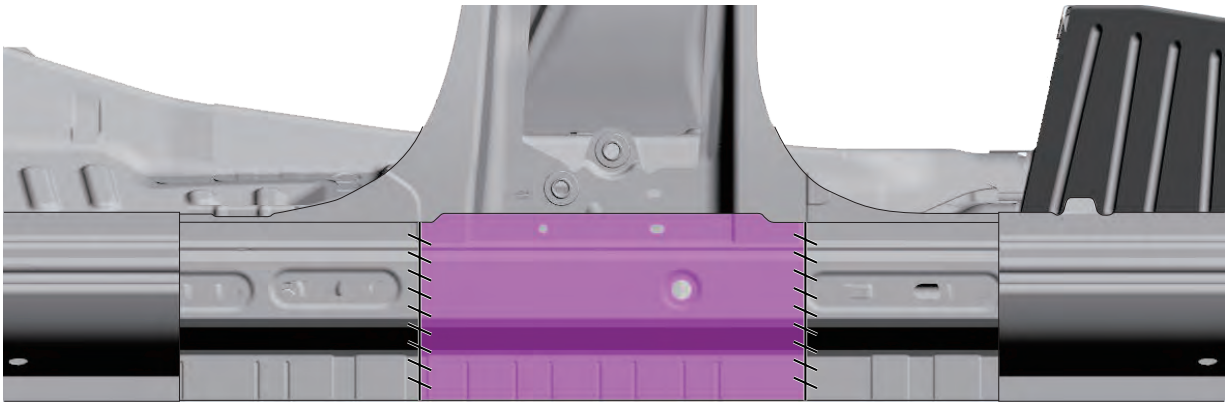
6. Tighten the bolt to specified torque.
Tightening torque: 8.4N·m {0.8 kgf-m}

7. Conduct spot weld and plug weld.

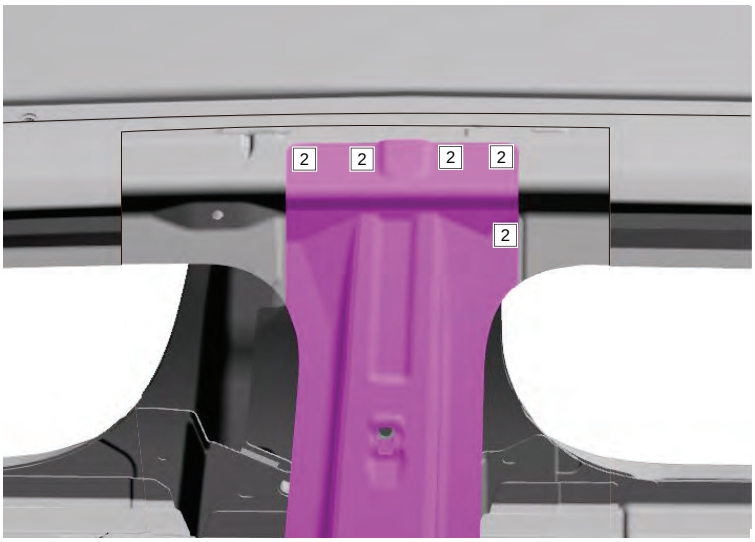


1. Bolt

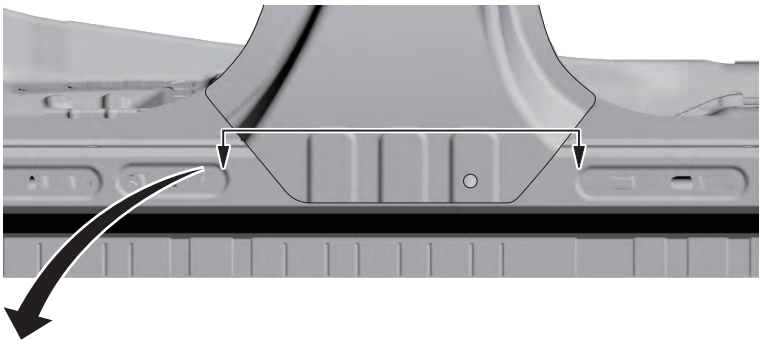
8. Install the rocker reinforcement removed in step 9 of “Removal”
9. Conduct continuous weld.

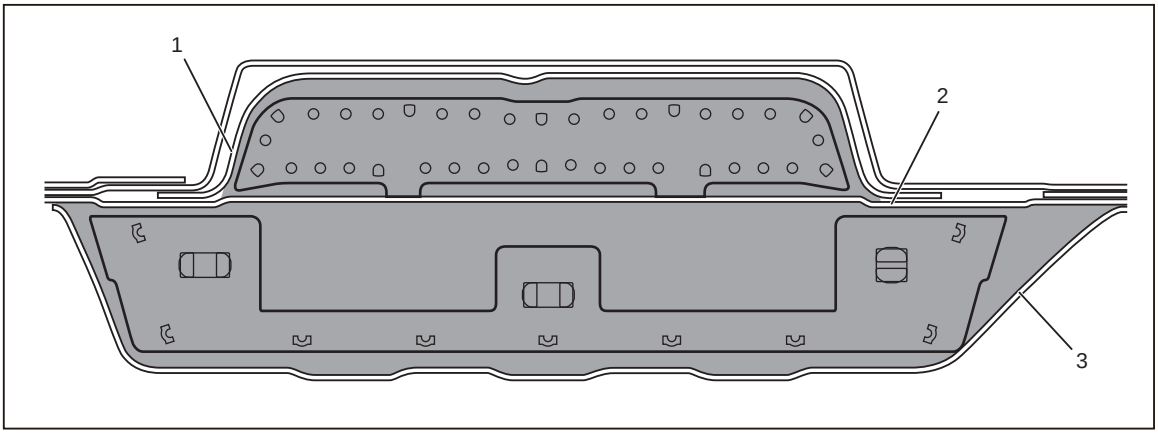


10. Install the center pillar reinforcement.
11. Conduct plug weld.



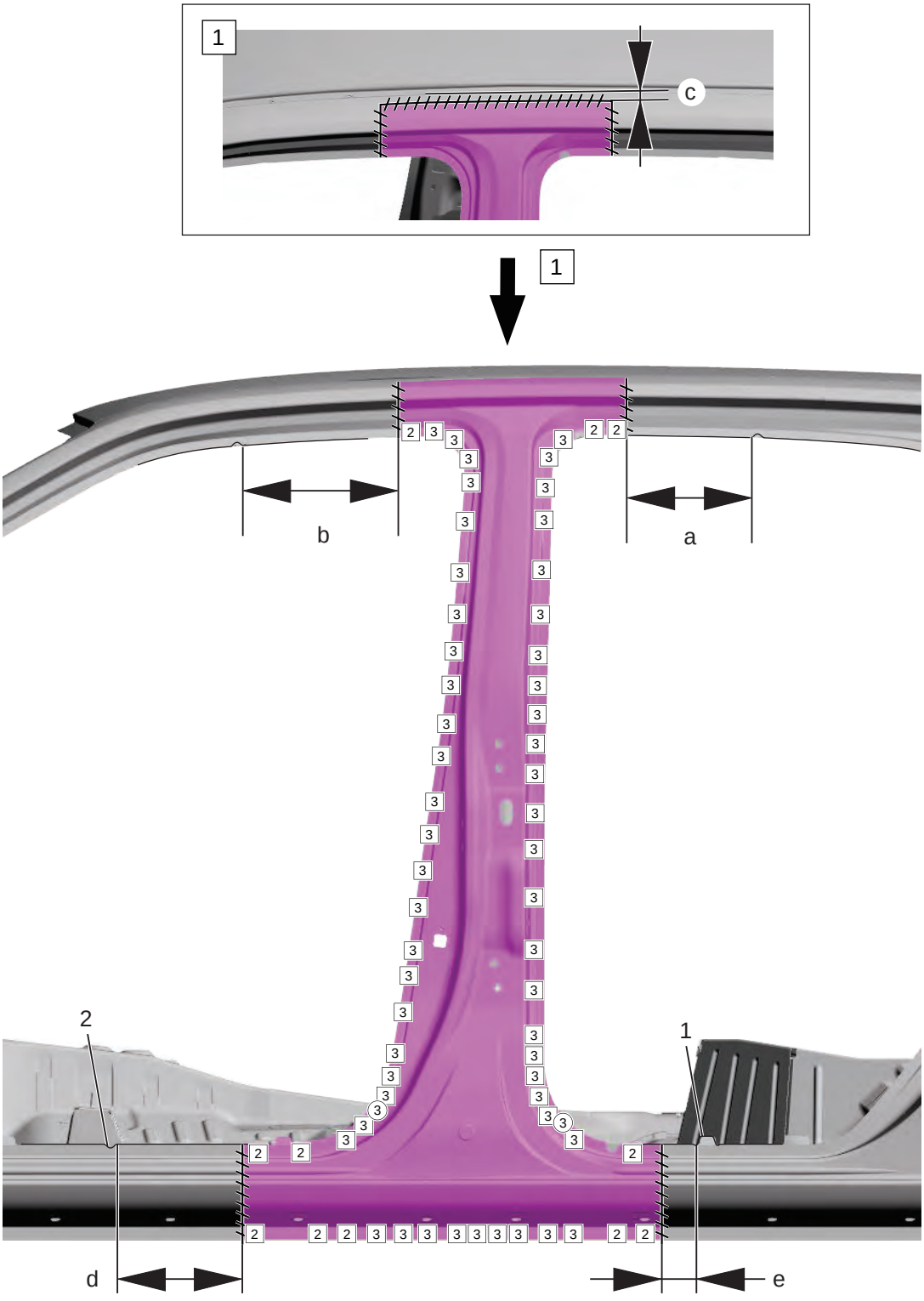
12. Fill the openings between the center pillar inner panel and the rocker reinforcement with the sponge in the original baffle plate position.





1. Center pillar inner panel
2. Rocker reinforcement
3. Center pillar reinforcement

13. Install the center pillar outer panel to vehicle body and cut in stacked condition.
14. Conduct plug weld and continuous weld.
15. Apply anti-corrosion wax to back side of continuous weld part.



1. Tab
2. Cutout

a. 190 mm {7.48 in}
b. 230 mm {9.06 in}
c. 10 mm {0.39 in}
d. 190 mm {7.48 in}
e. 40 mm {1.57 in}