

Side sill outer panel Removal and Installation (for Crew Cab)

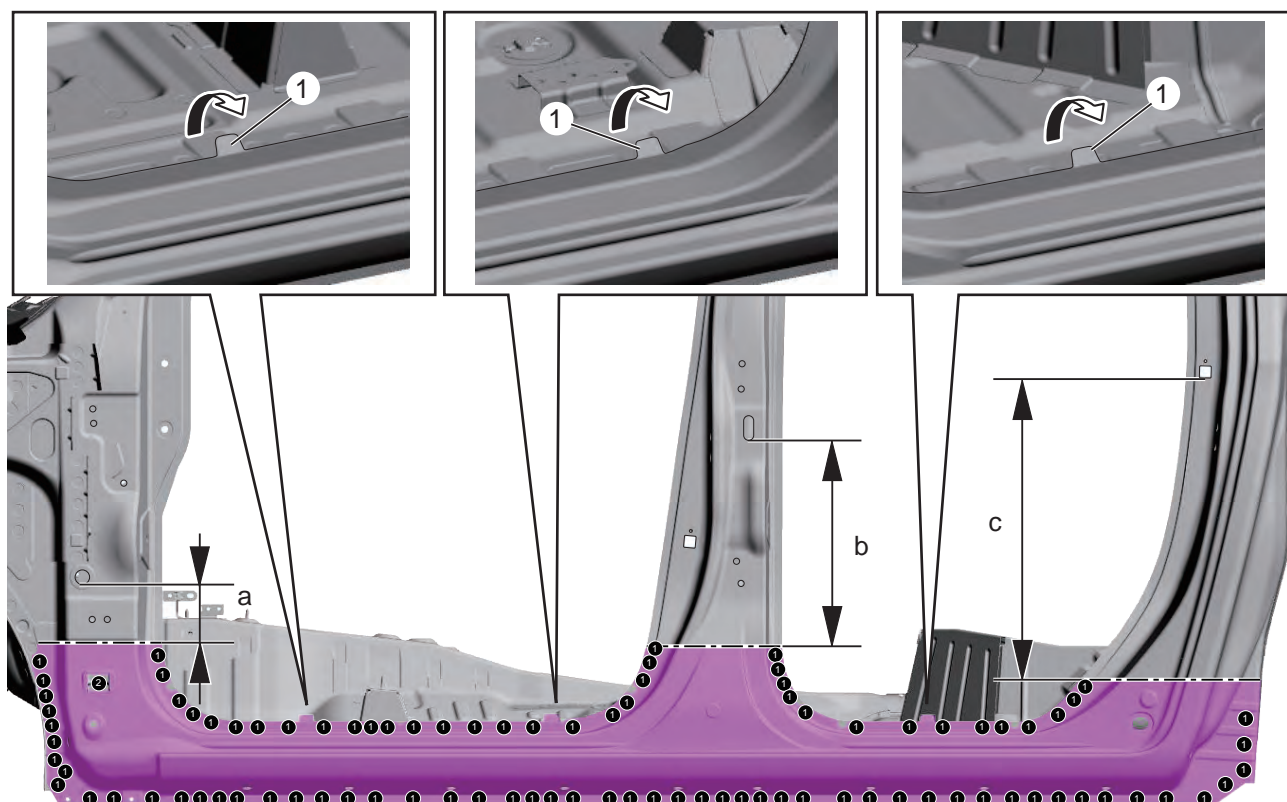


Note :

- 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.

Removal :

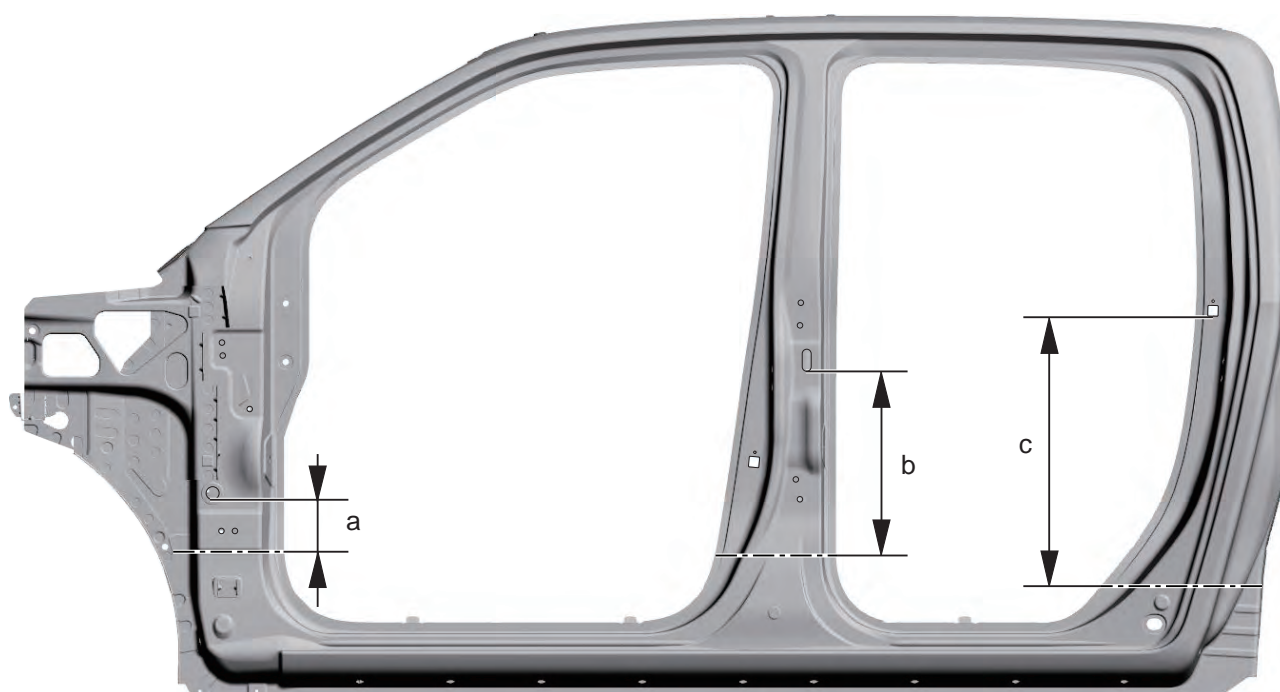
1. Mark at the shown position and cut the side sill outer panel.
2. Drill out welding spots.
3. Bend open the 3 metal tabs (arrow) and remove the side sill outer panel.



- 1. Tab
- a. 110 mm {4.33 in}
- b. 350 mm {13.78 in}
- c. 550 mm {21.65 in}

Installation :

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

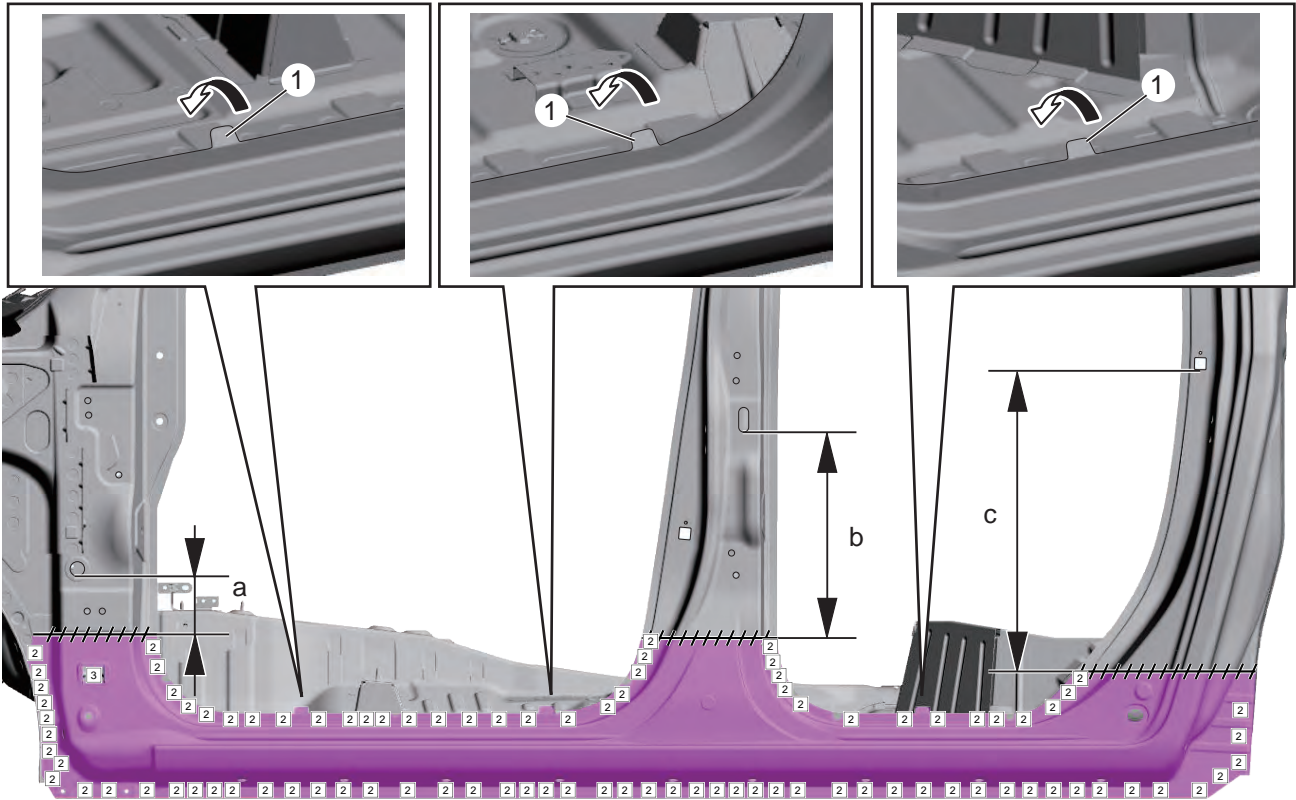


- a. 90 mm {3.54 in}
- b. 330 mm {12.99 in}
- c. 530 mm {20.87 in}

2. Drill out welding spots and remove the side sill outer panel.



3. Install the side sill outer panel to vehicle body and cut in stacked condition.
4. Conduct resistance spot weld and plug weld.
5. Conduct continuous weld.
6. Apply anti-corrosion wax to back side of continuous weld part.
7. Bend in the 3 metal tabs (arrow) of the side sill outer panel.



1. Tab
 - a. 100 mm {3.94 in}
 - b. 340 mm {13.39 in}
 - c. 540 mm {21.26 in}
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