
Side sill outer panel, Rocker reinforcement Removal and Installation (for Regular Cab)

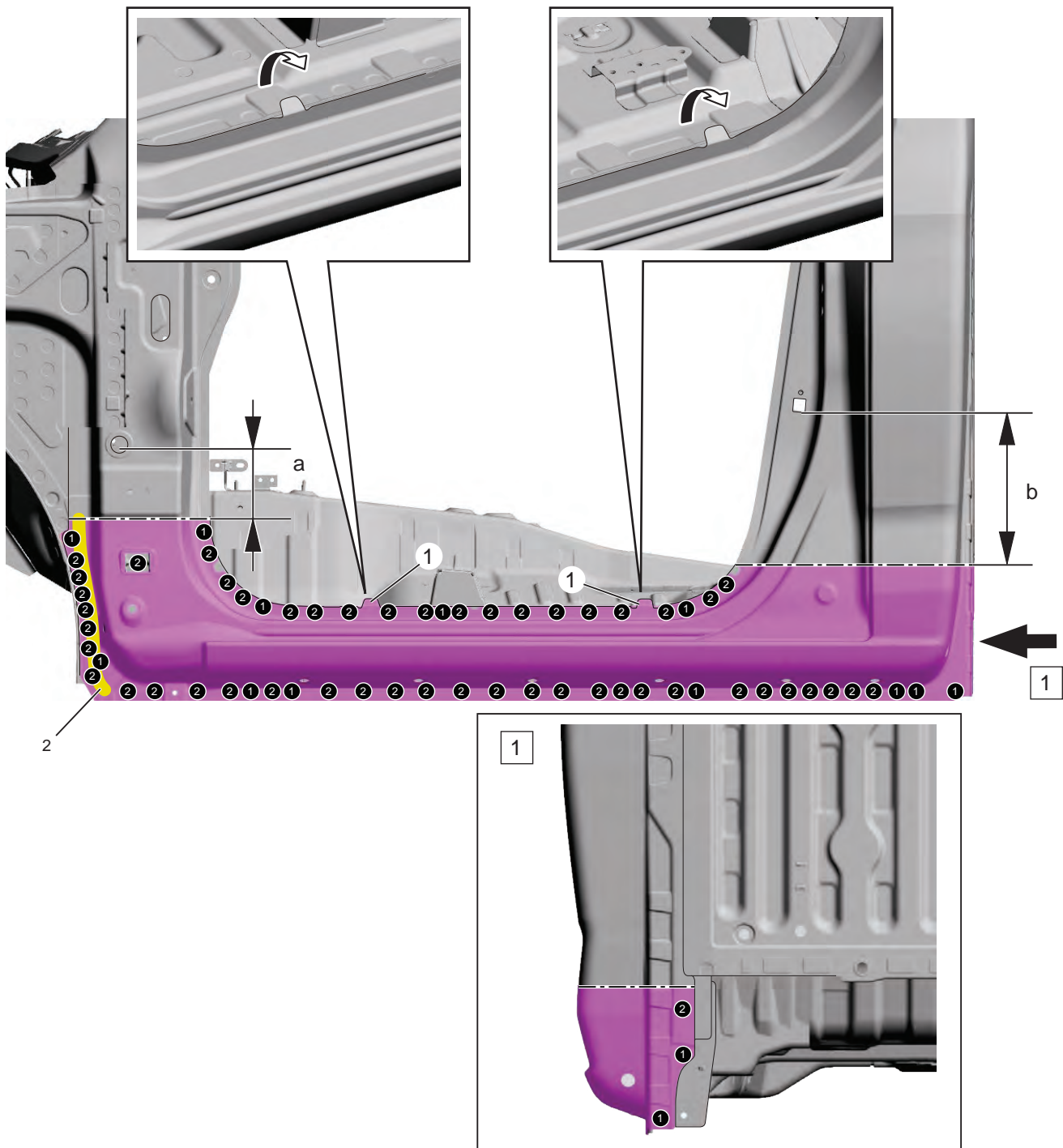


Note :

- 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.

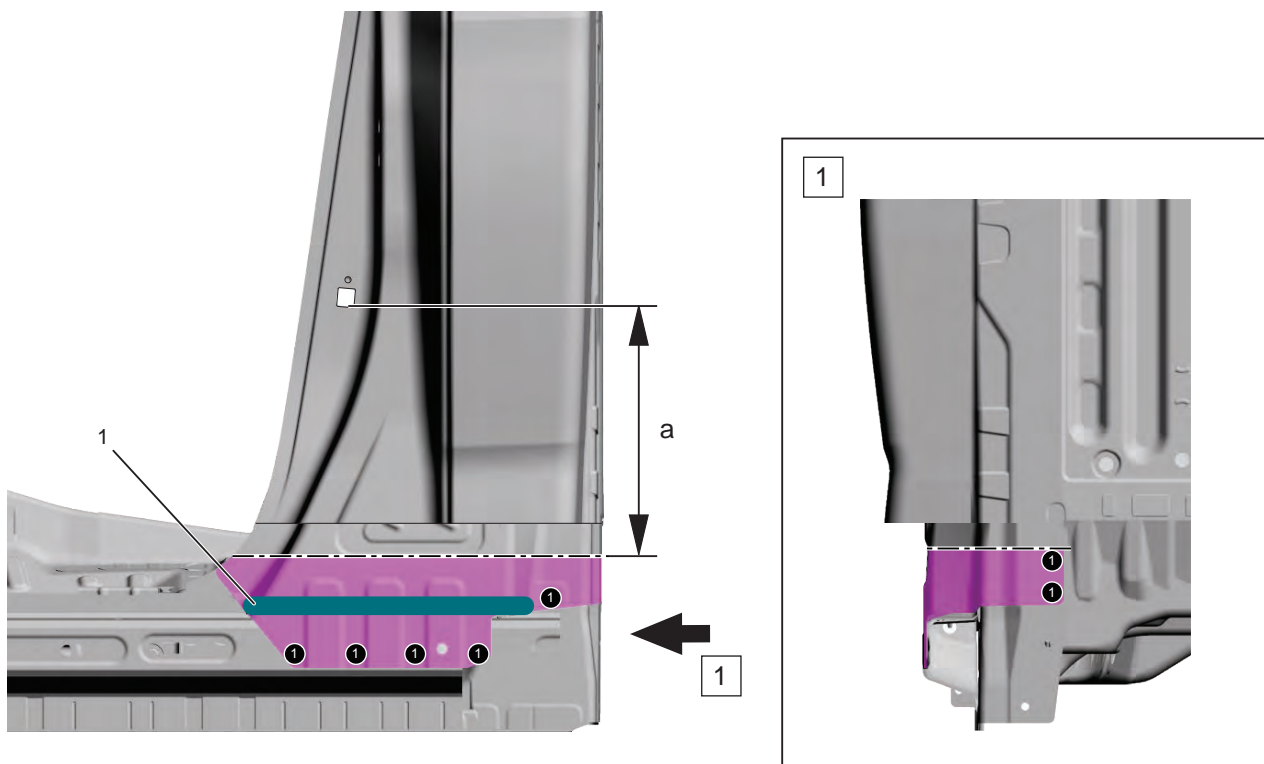
Removal :

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



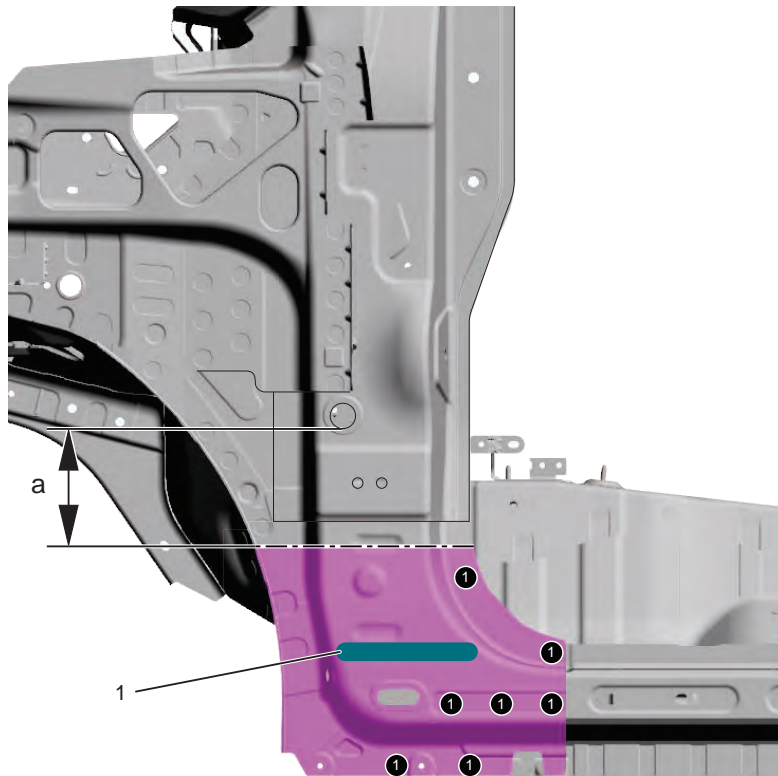
1. Tab
2. When heating around sealer application portion to detach body sealer, be sure that temperature of said portion does not reach 170 °C (338 °F).
 - a. 110 mm {4.33 in}
 - b. 245 mm {9.65 in}

4. Mark at the shown position and cut the rear pillar reinforcement.
5. Drill out welding spots.
6. Remove the rear 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).
- a. 275 mm {10.83 in}

7. Mark at the shown position and cut the side inner lower reinforcement.
8. Remove the side inner lower 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. 140 mm {5.51 in}

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9. Remove the rocker reinforcement.



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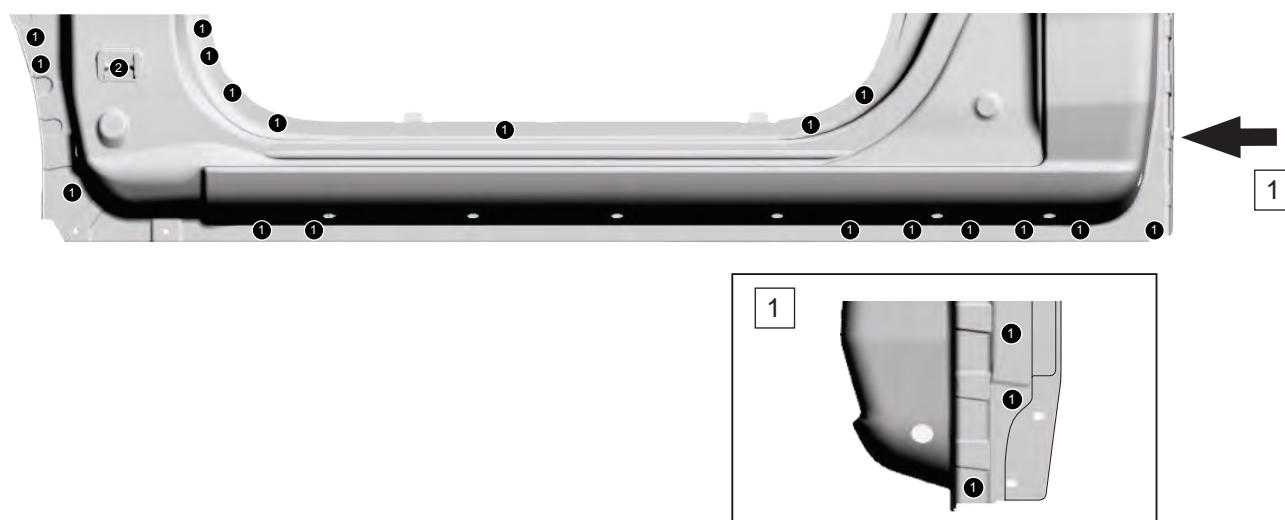
Installation :

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



- a. 90 mm {3.54 in}
- b. 225 mm {8.86 in}

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



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

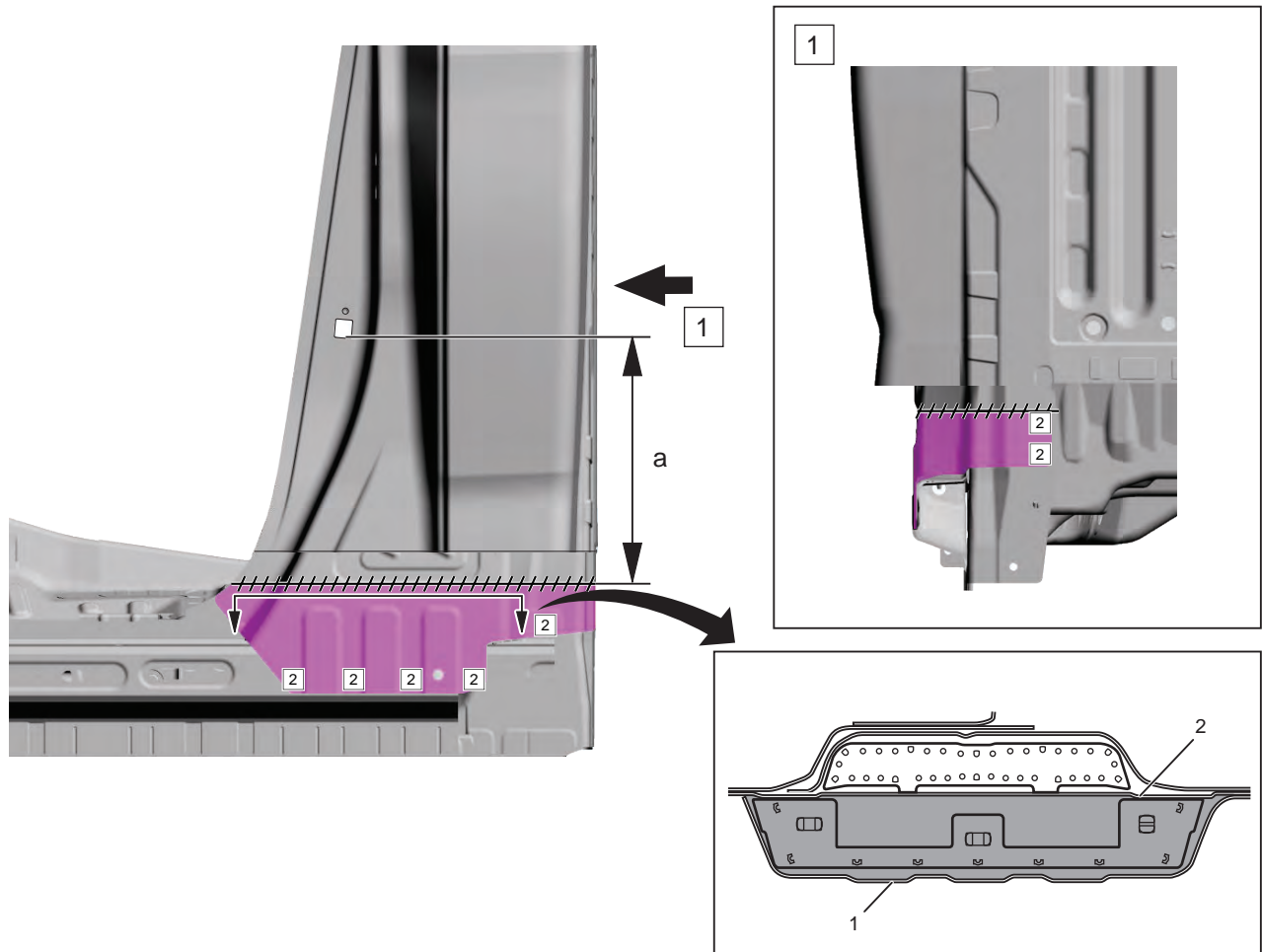


4. Install the rocker reinforcement.



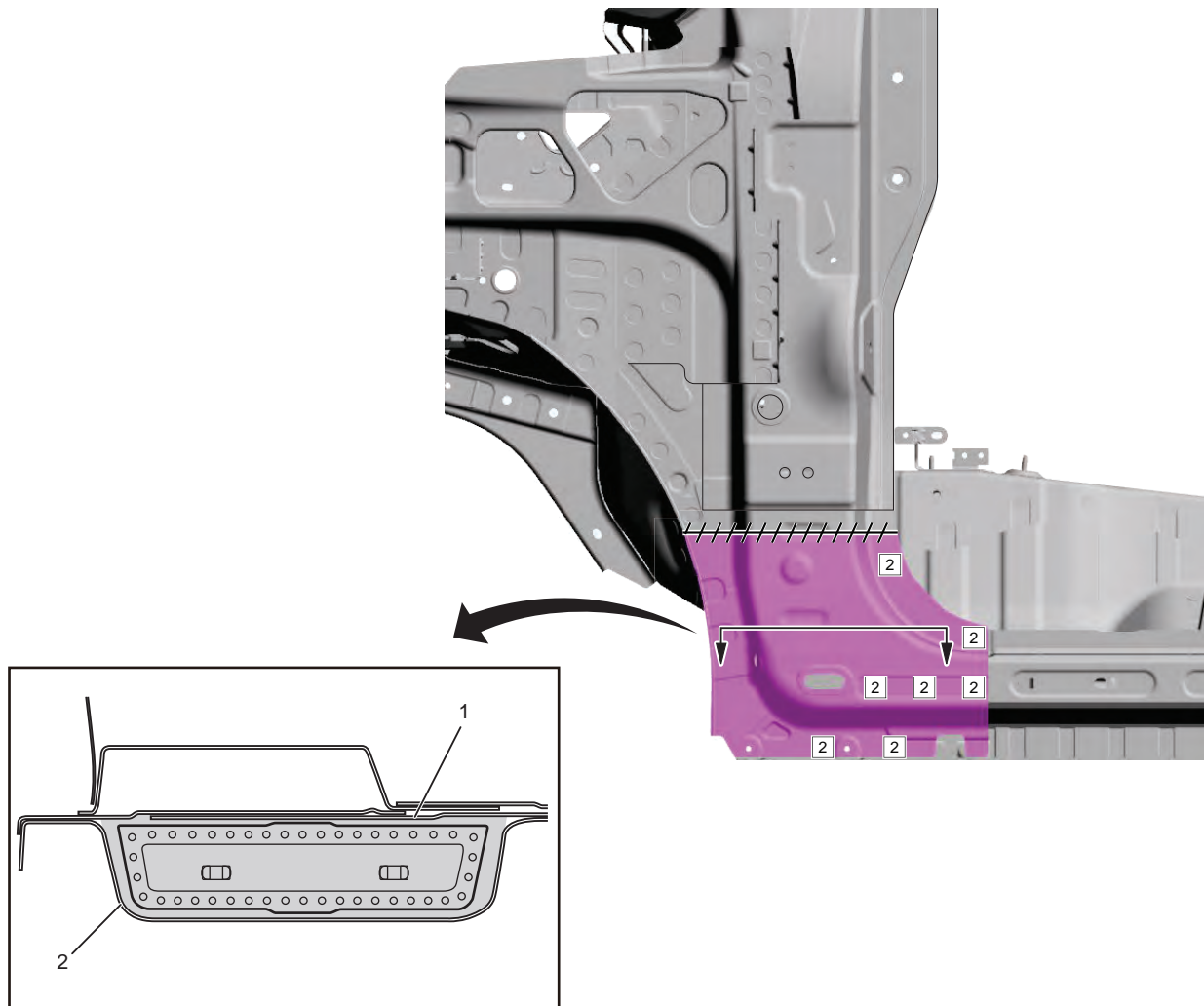
1. Apply adhesive
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5. Install the rear pillar reinforcement removed in step 6 of “Removal”.
6. Conduct plug weld.
7. Conduct continuous weld.
8. Apply anti-corrosion wax to back side of continuous weld part.
9. Fill the openings between the rear pillar reinforcement and the rocker reinforcement with the sponge in the original baffle plate position.



- 1. Rear pillar reinforcement
- 2. Rocker reinforcement

10. Install the side inner lower reinforcement removed in step 8 of "Removal".
11. Conduct plug weld.
12. Conduct continuous weld.
13. Apply anti-corrosion wax to back side of continuous weld part.
14. Fill the openings between the side inner lower reinforcement and the rocker reinforcement with the sponge in the original baffle plate position.



1. Rocker reinforcement
2. Side inner lower reinforcement

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15. Install the side sill outer panel to vehicle body and cut in stacked condition.
 16. Conduct resistance spot weld and plug weld.
 17. Conduct continuous weld.
 18. Apply anti-corrosion wax to back side of continuous weld part.
 19. Bend in the 2 metal tabs (arrow) of the side sill outer panel.

