

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

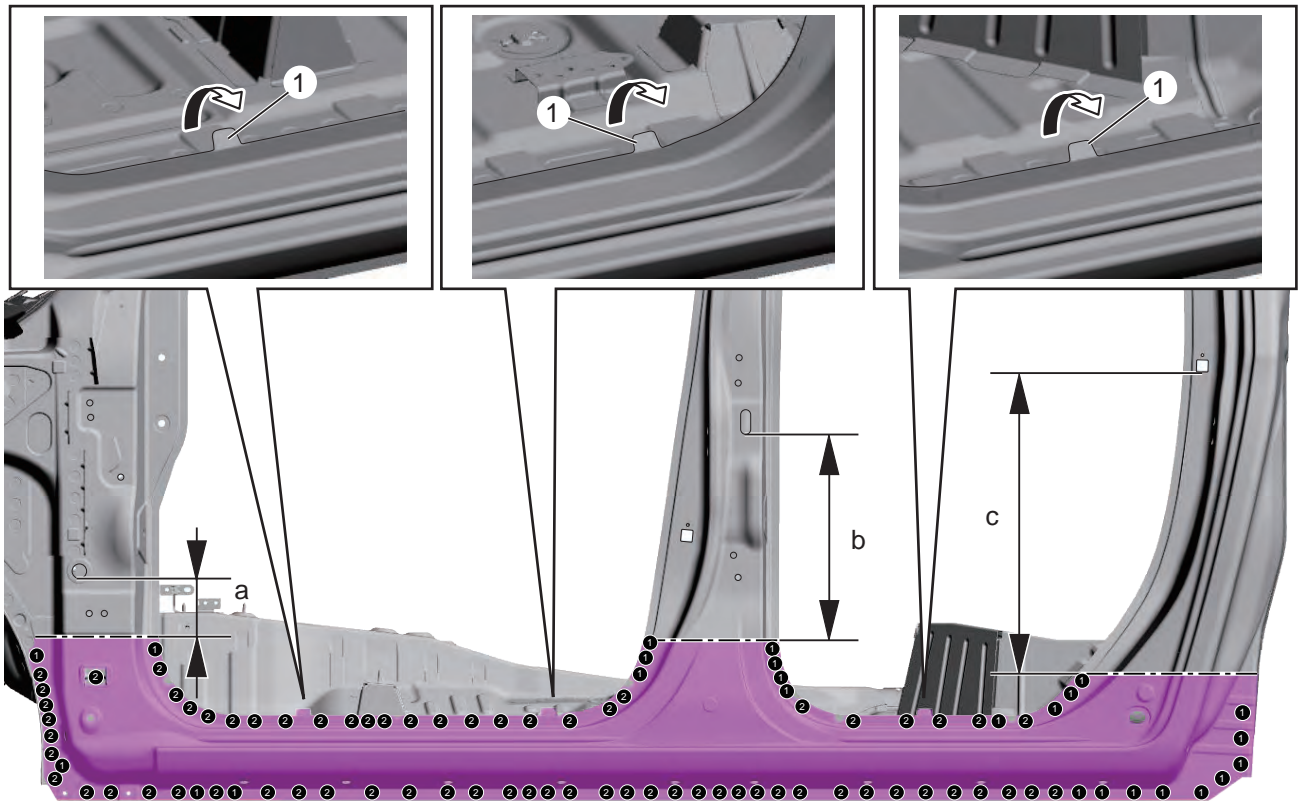


Note :

- 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.

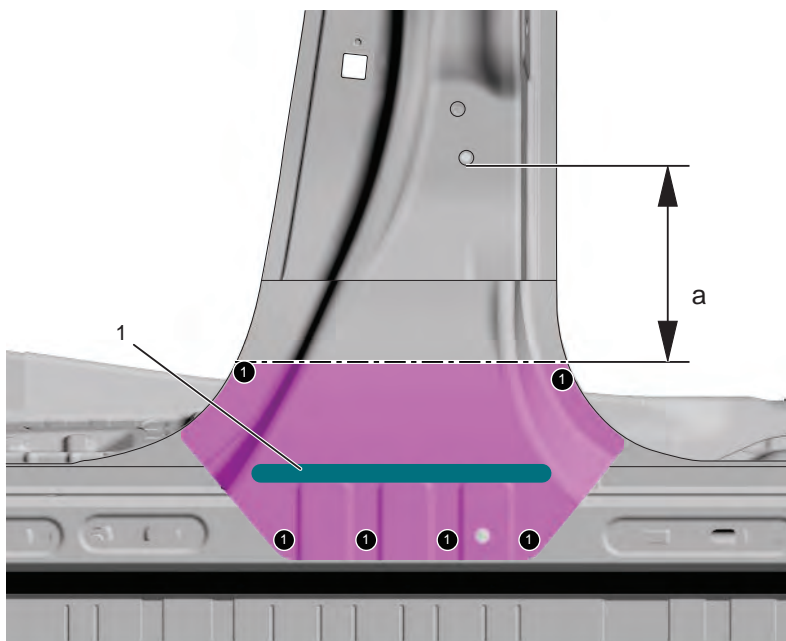
Removal :

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.



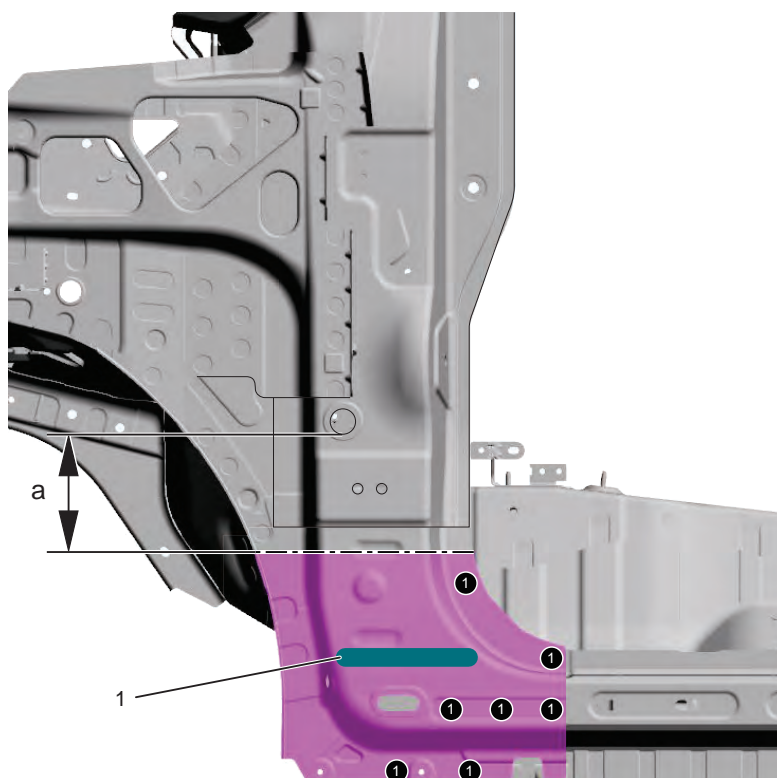
- 1. Tab
- a. 110 mm {4.33 in}
- b. 350 mm {13.78 in}
- c. 550 mm {21.65 in}

- 4. Mark at the shown position and cut the center pillar reinforcement.
- 5. Drill out welding spots and remove 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).
- a. 180 mm {7.09 in}

6. Mark at the shown position and cut the side inner lower reinforcement.
7. Remove the side inner lower reinforcement.



- a. 140 mm {5.51 in}

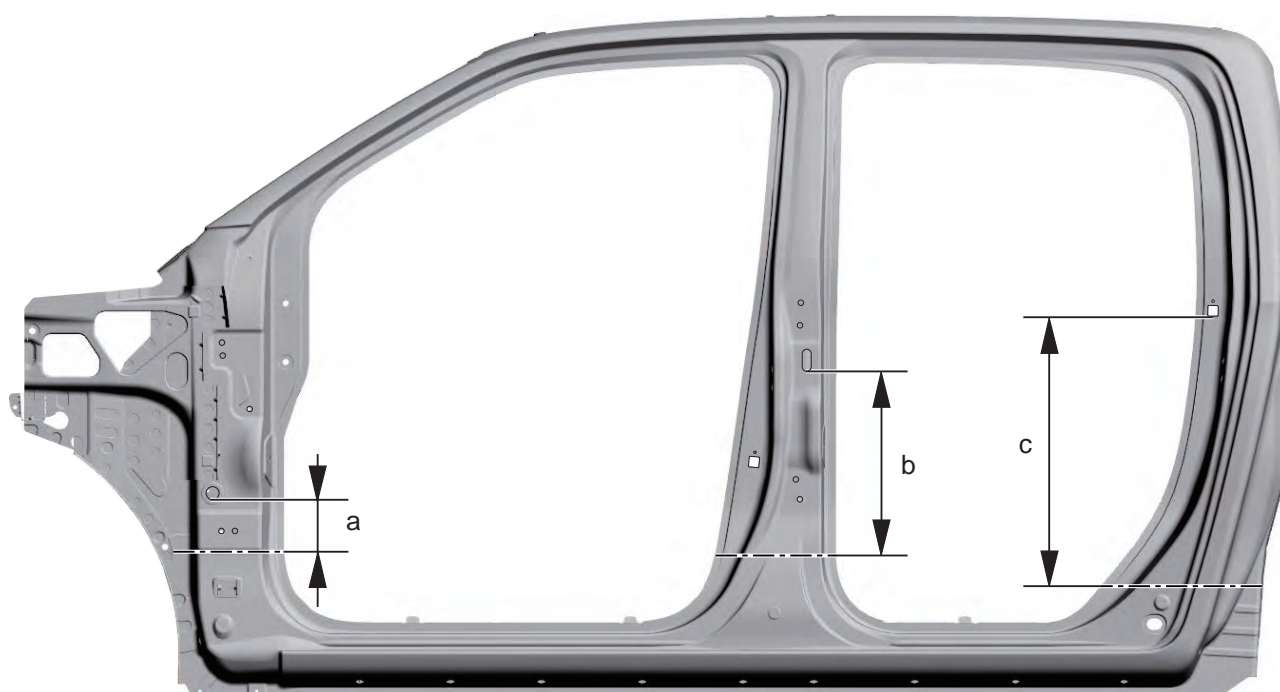
8. Drill out welding spots.
9. Remove the rocker reinforcement.



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. 330 mm {12.99 in}
- c. 530 mm {20.87 in}

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



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

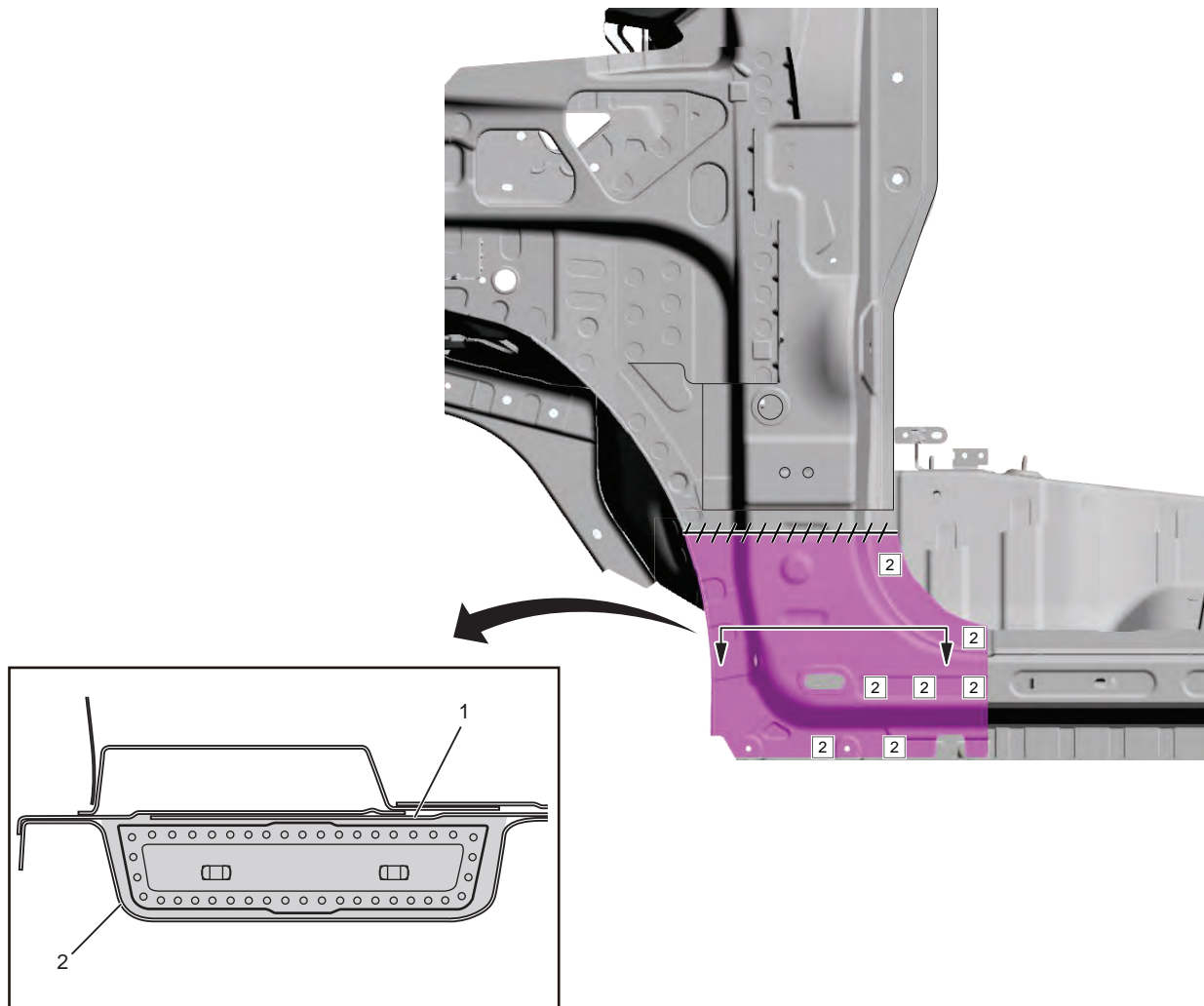


4. Install the rocker reinforcement.
5. Conduct resistance plug weld.



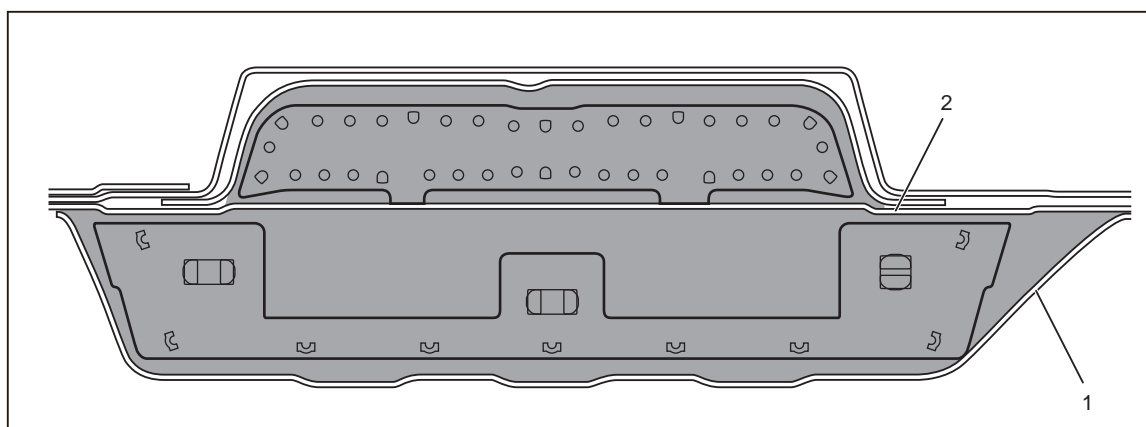
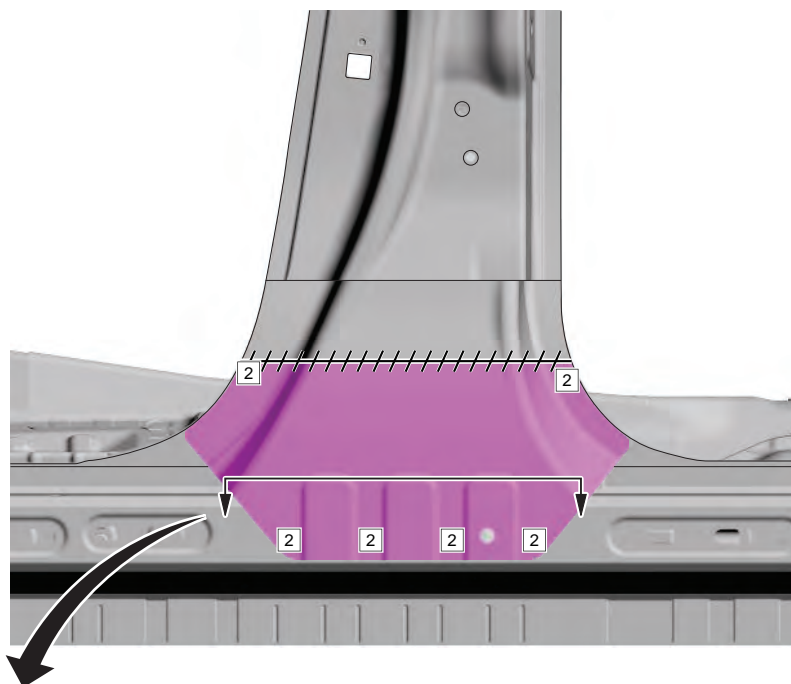
1. Apply adhesive
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6. Install the side inner lower reinforcement removed in step 7 of "Removal".
7. Conduct plug weld.
8. Conduct continuous weld.
9. Apply anti-corrosion wax to back side of continuous weld part.
10. Fill the openings between the side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



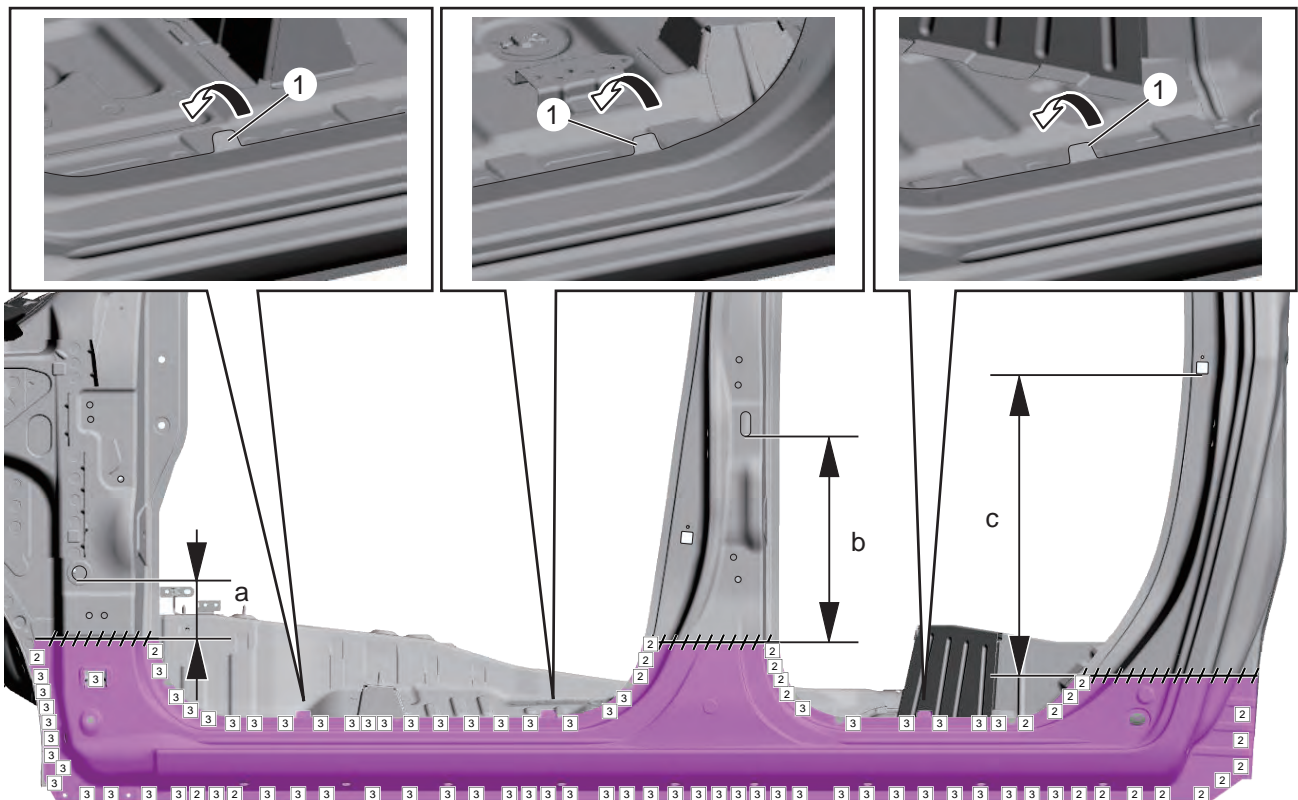
1. Rocker reinforcement
2. Side inner lower reinforcement

11. Install the center pillar reinforcement removed in step 5 of "Removal".
12. Conduct spot weld and plug weld.
13. Conduct continuous weld.
14. Apply anti-corrosion wax to back side of continuous weld part.
15. Fill the openings between the center pillar reinforcement and the rocker reinforcement with the sponge in the original baffle plate position.



1. Center pillar reinforcement
2. Rocker reinforcement

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16. Install the side sill outer panel to vehicle body and cut in stacked condition.
 17. Conduct resistance spot weld and plug weld.
 18. Conduct continuous weld.
 19. Apply anti-corrosion wax to back side of continuous weld part.
 20. 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}