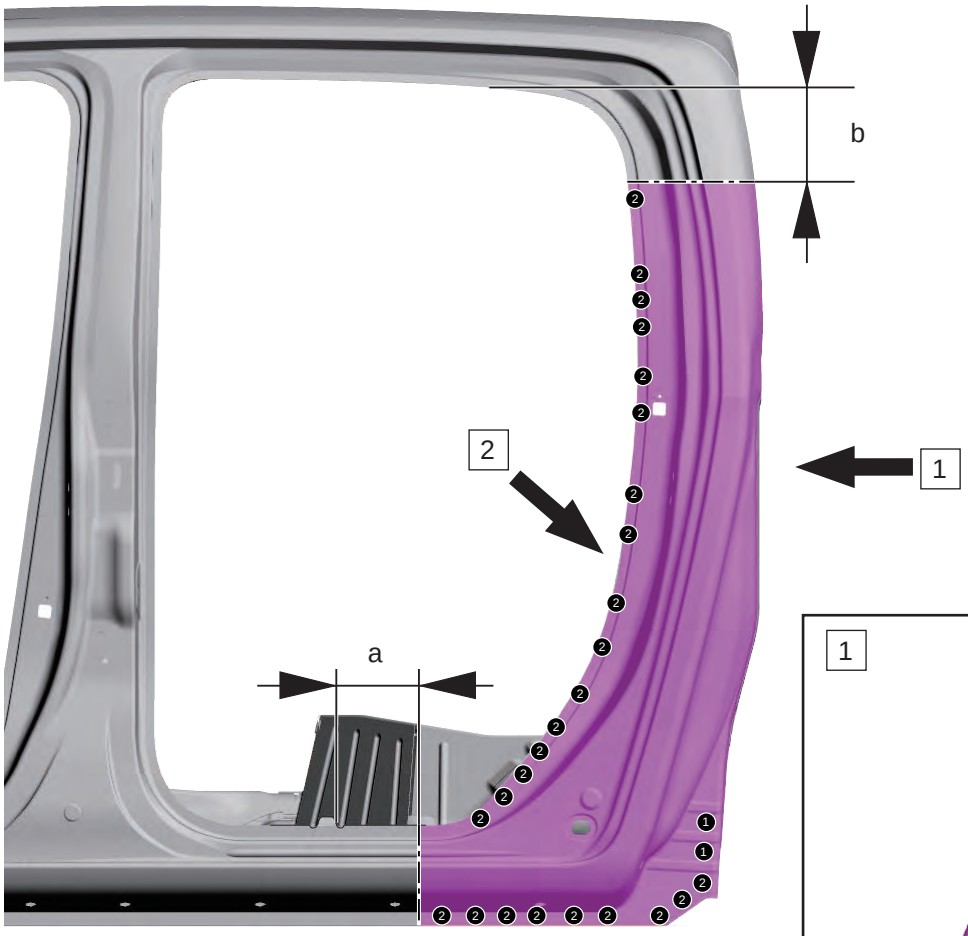
Rear pillar outer panel, Rear pillar inner lower panel Removal and Installation (for Crew Cab)

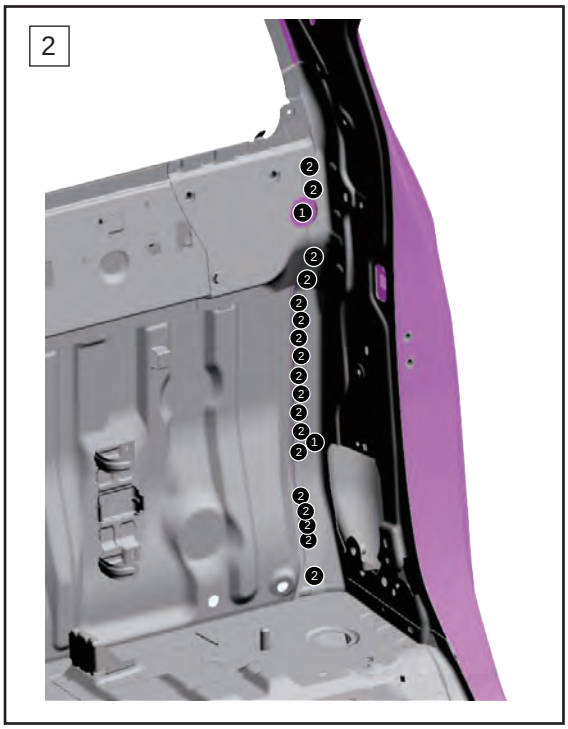
Note :

- 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 :

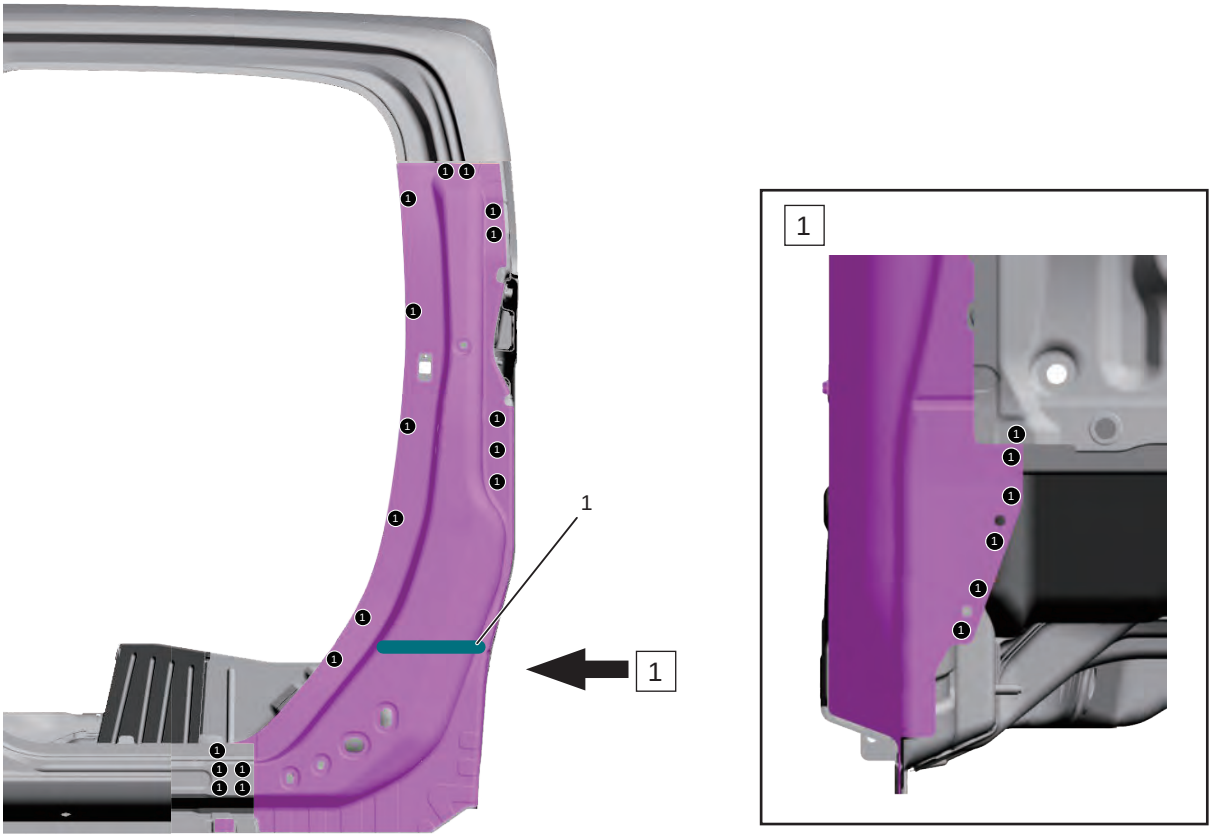
1. Mark at the shown position and cut the rear pillar outer panel.
2. Drill out welding spots and remove the rear pillar outer panel.





a. 100 mm {3.94 in}
b. 140 mm {5.51 in}

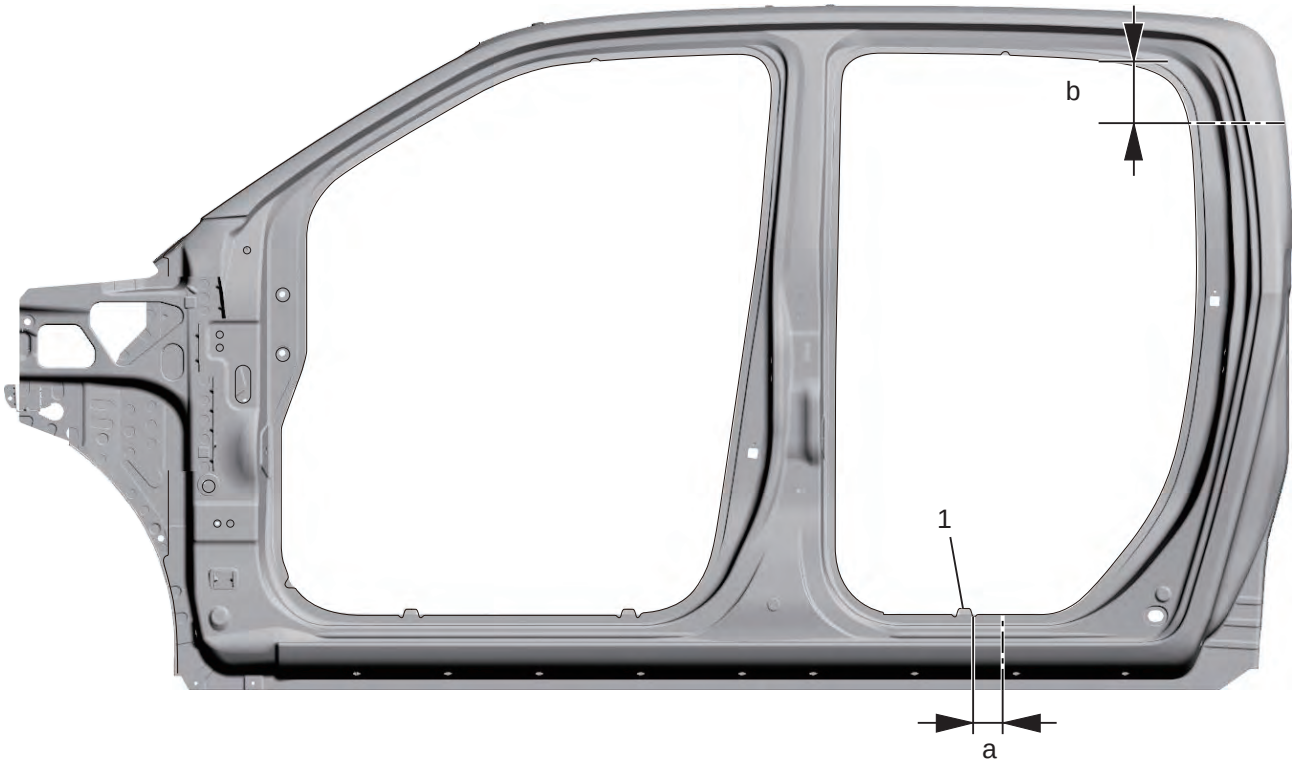
3. Drill out welding spots and remove the rear pillar inner lower panel.



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).

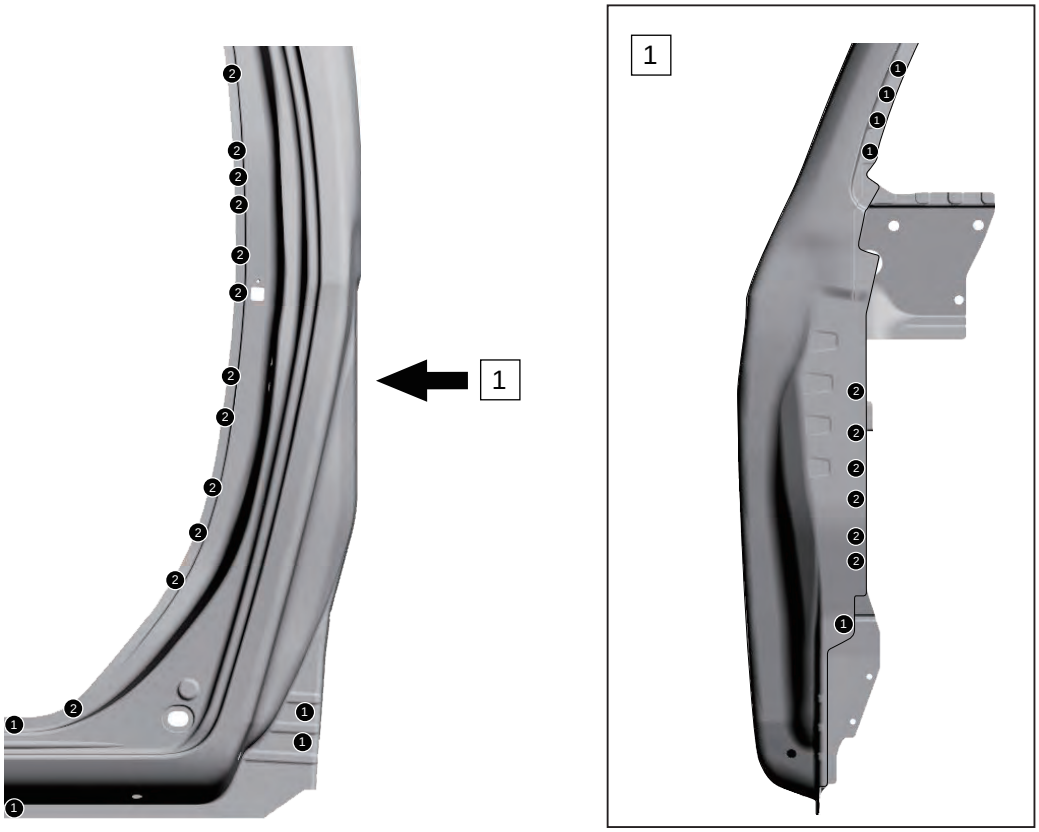
Installation :

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

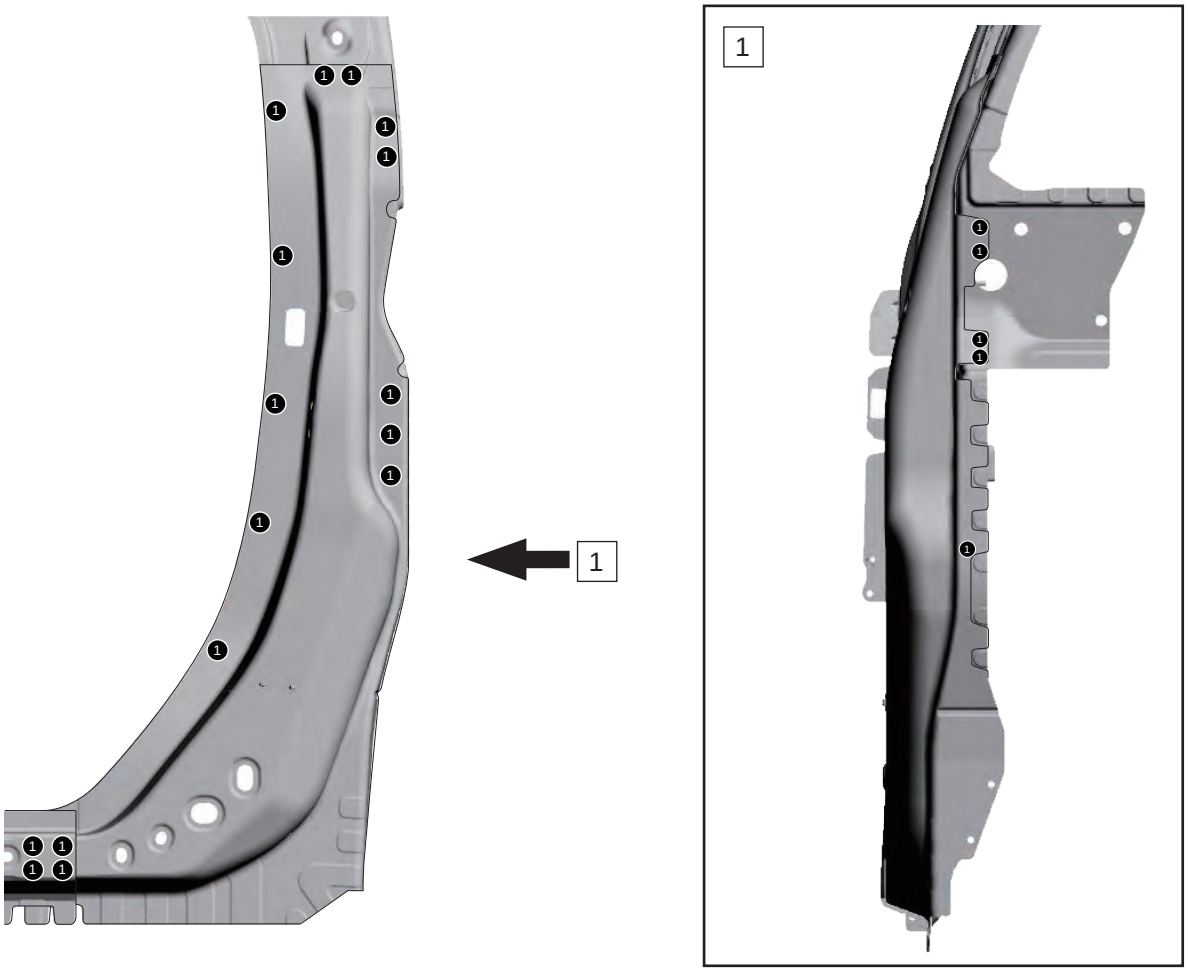


a. 80 mm {3.15 in}
b. 120 mm {4.72 in}

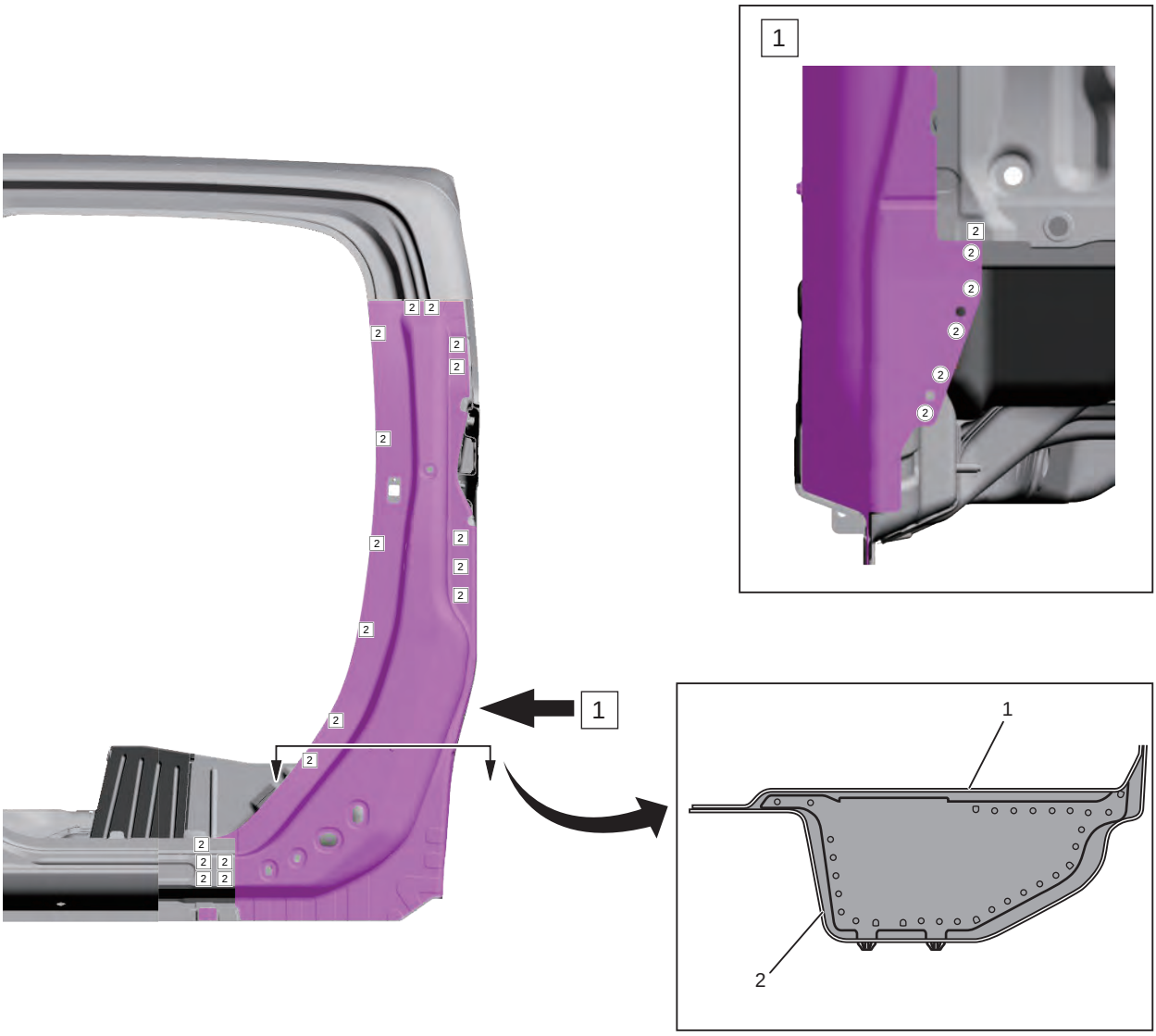
2. Drill out welding spots and remove the rear pillar outer panel.



3. Drill out welding spots and separate the rear pillar inner lower panel.

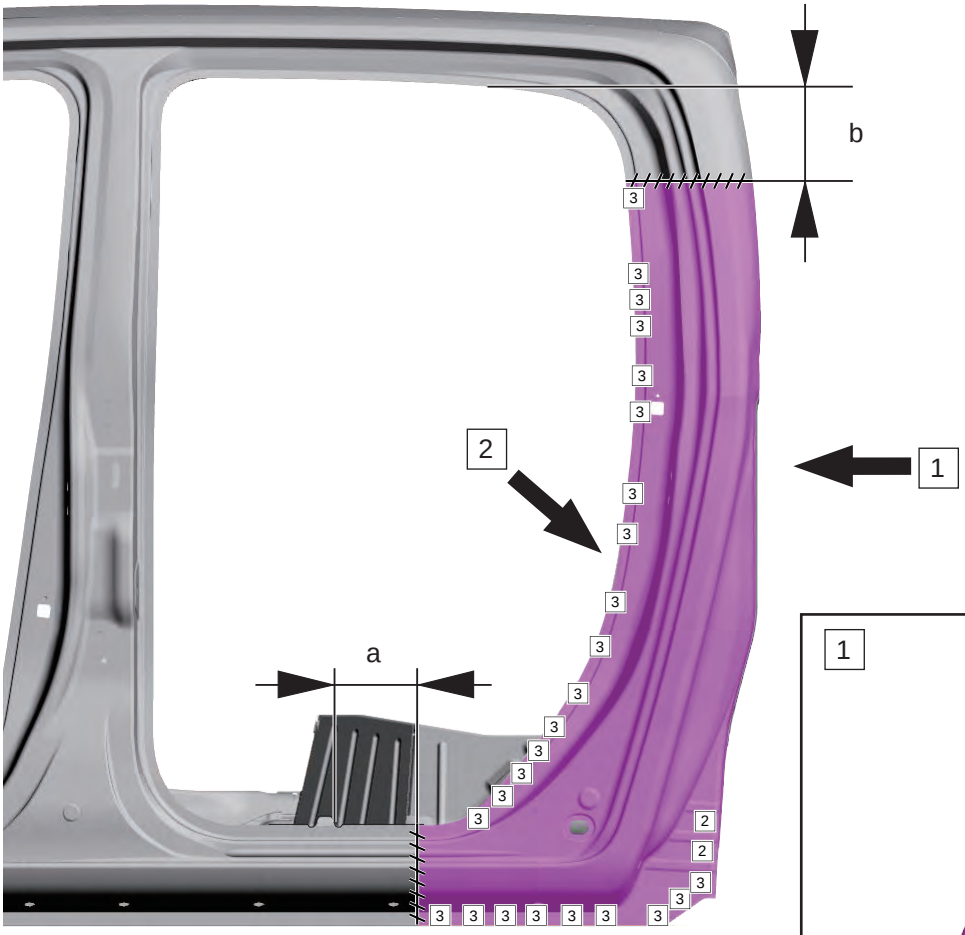


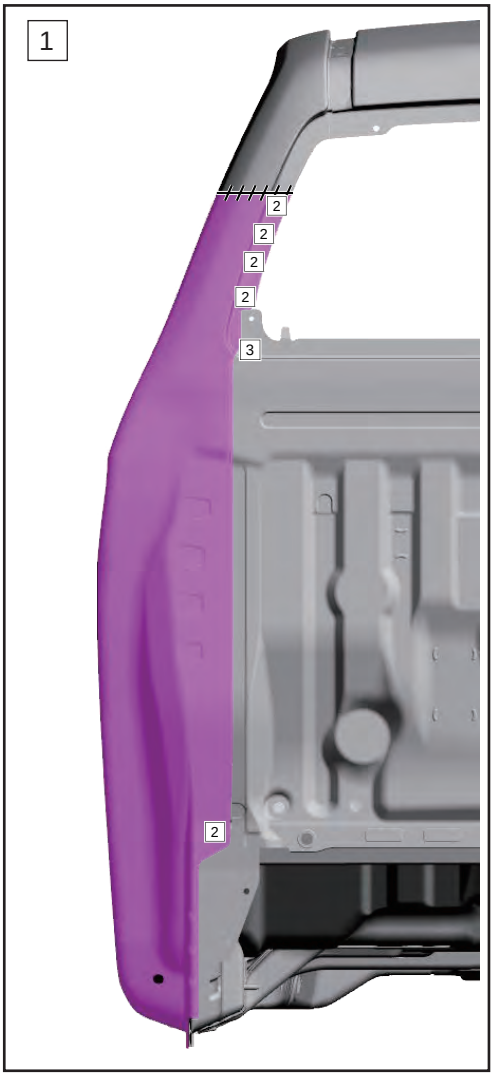
4. Install the rear pillar inner lower panel.
5. Conduct resistance spot weld and plug weld.
6. Fill the openings between the rear pillar inner panel and the rear pillar inner lower panel with the sponge in the original baffle plate position.

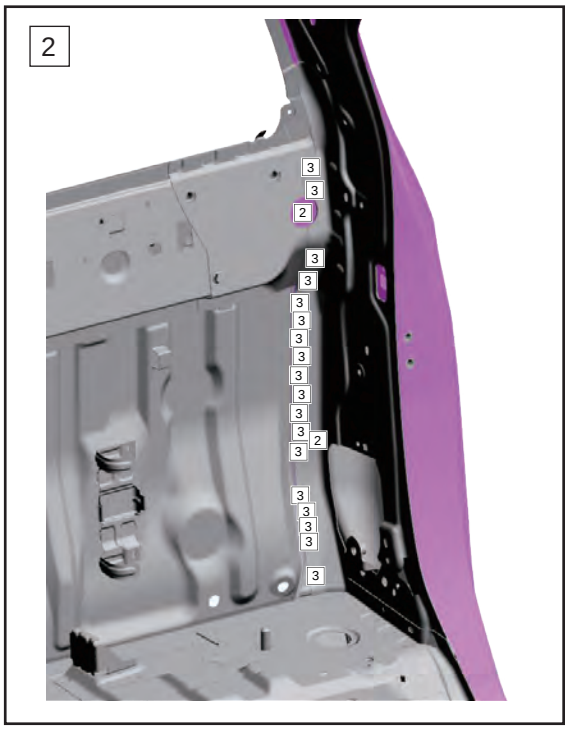


1. Rear pillar inner panel
2. Rear pillar inner lower panel

7. Install the rear pillar outer panel to vehicle body and cut in stacked condition.
8. Conduct resistance plug weld.
9. Conduct continuous weld.
10. Apply anti-corrosion wax to back side of continuous weld part.







a. 90 mm {3.54 in}
b. 130 mm {5.12 in}