

Rear body assembly Removal and Installation (for Crew Cab)

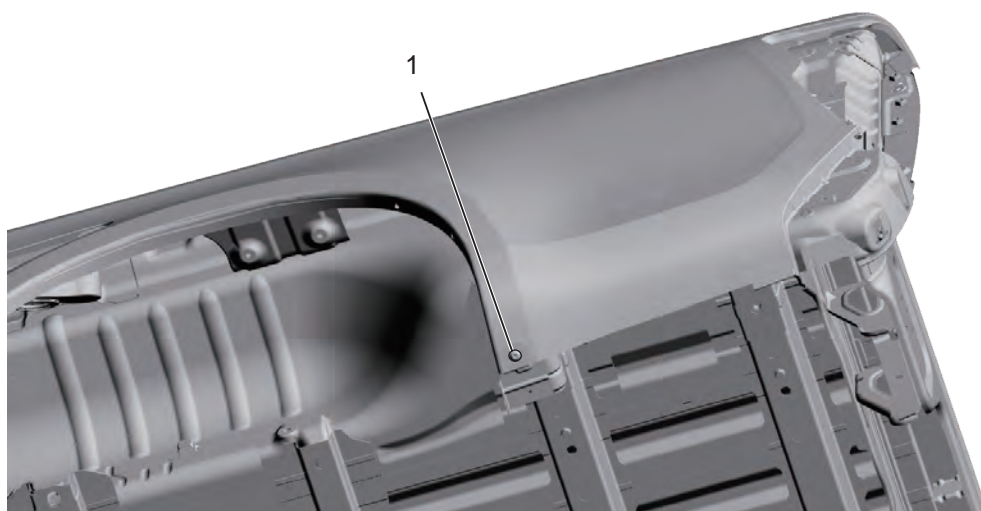
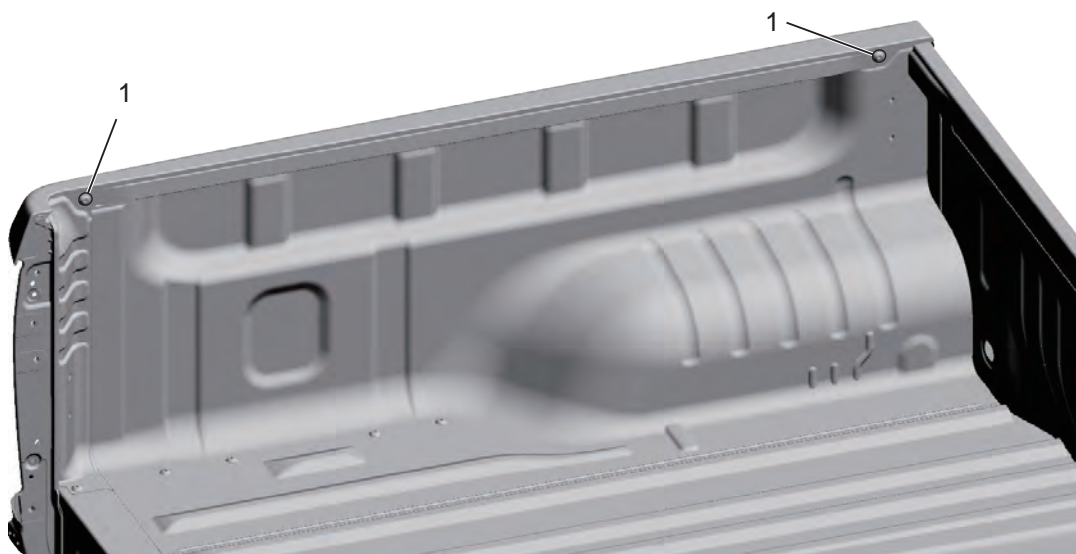


Note :

- Welding method and number of welding points are the same on both sides.

Side gate panel Removal :

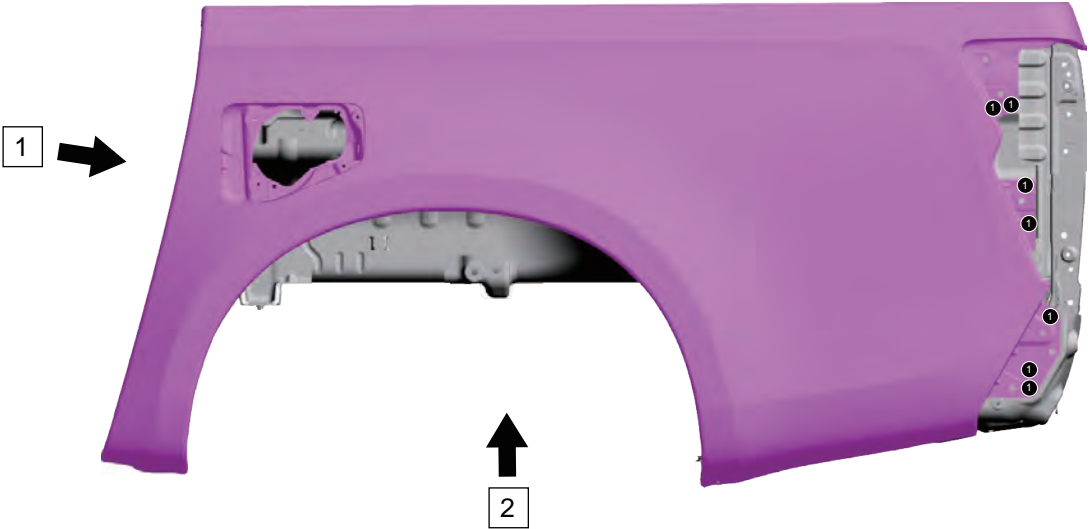
1. Unscrew the 3 bolts.



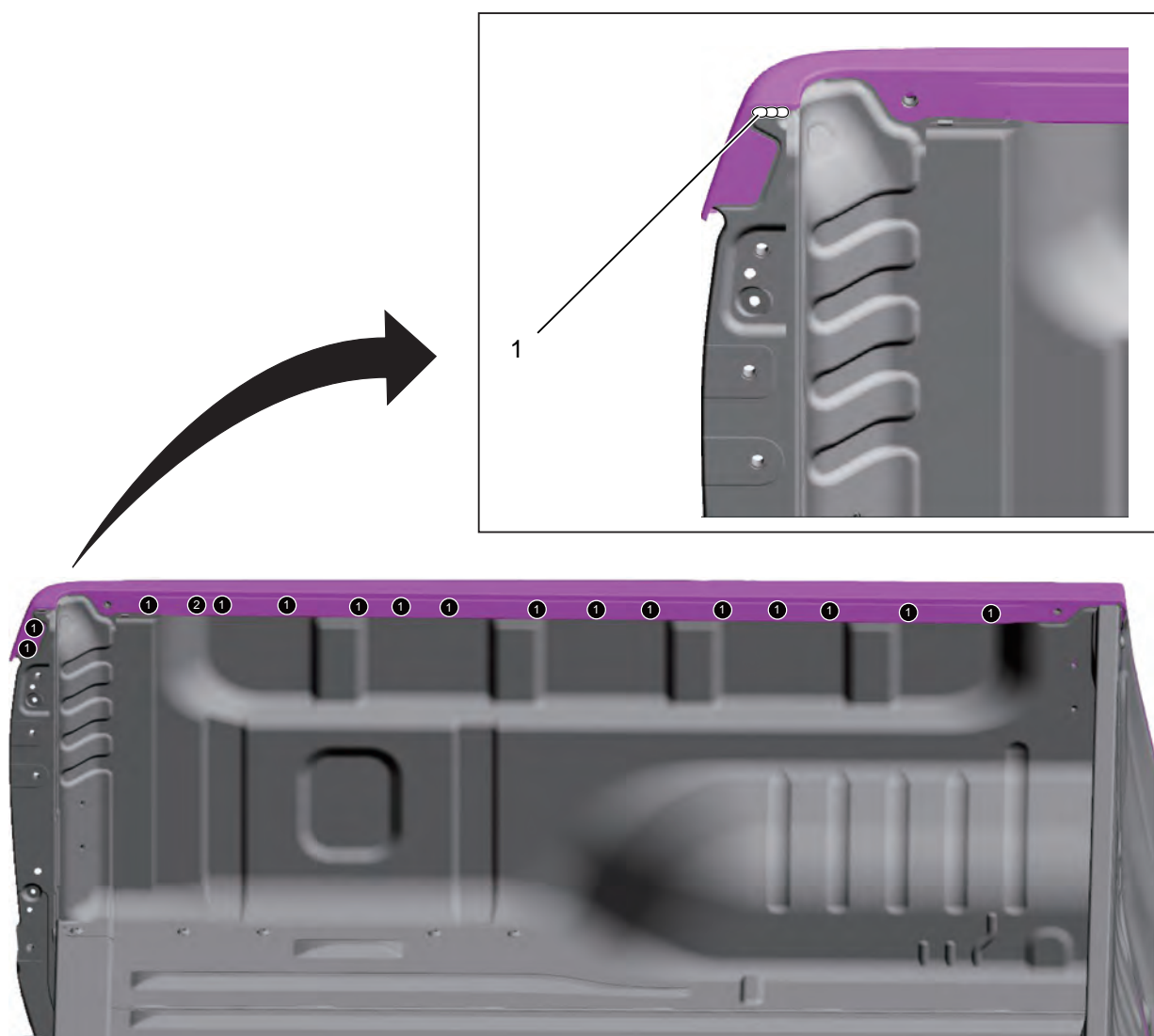
1. Bolt

2. Use a belt sander to scrape the fillet weld.
3. Drill out welding spots and remove the side gate panel.

Vehicle outside

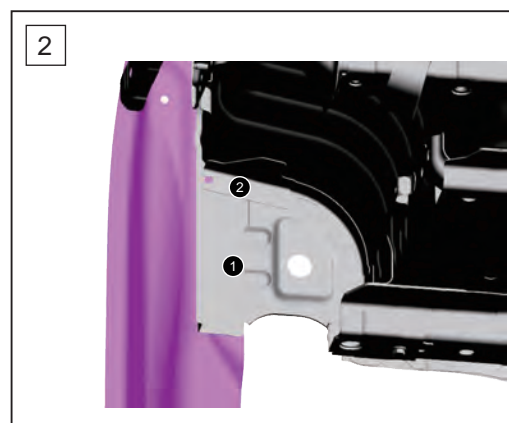
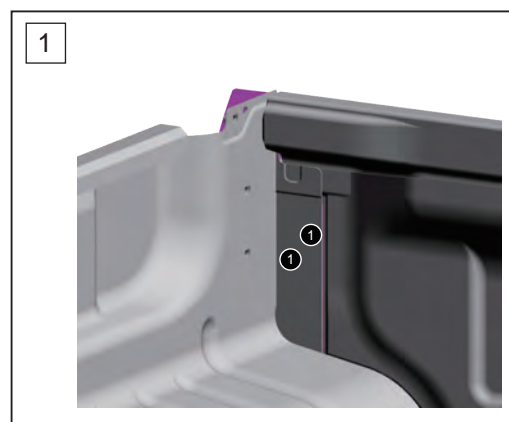
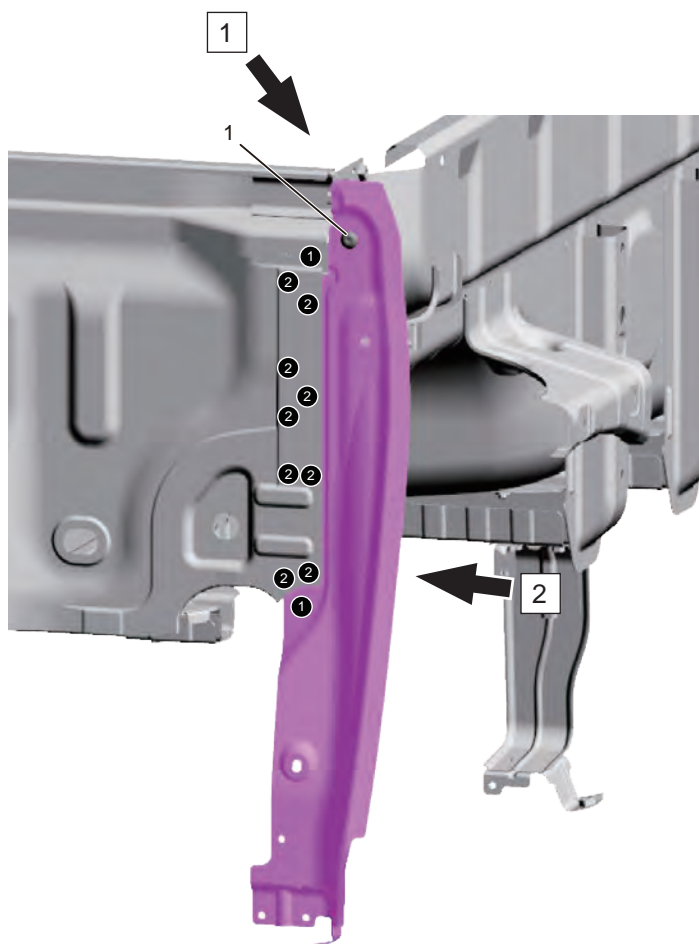


Vehicle inside



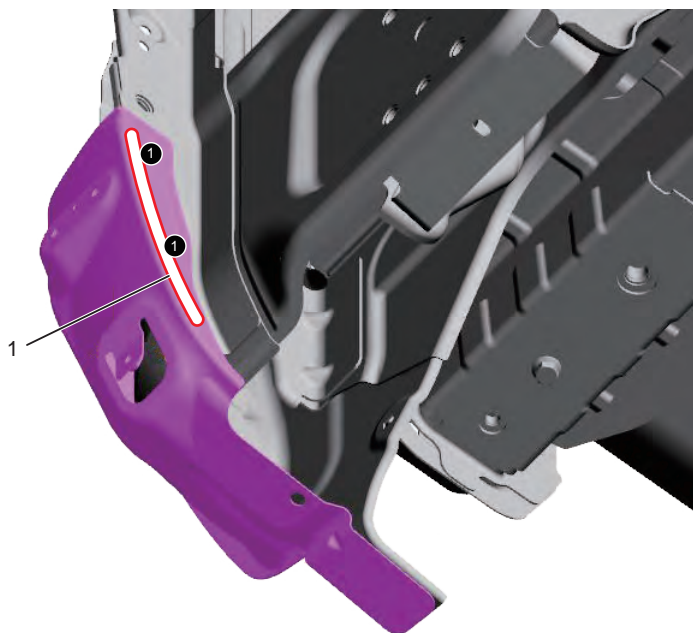
1. Fillet welding spot

4. Drill out welding spots and remove the rear body front filler.



1. Bolt

5. Drill out welding spots and remove the rear corner panel.



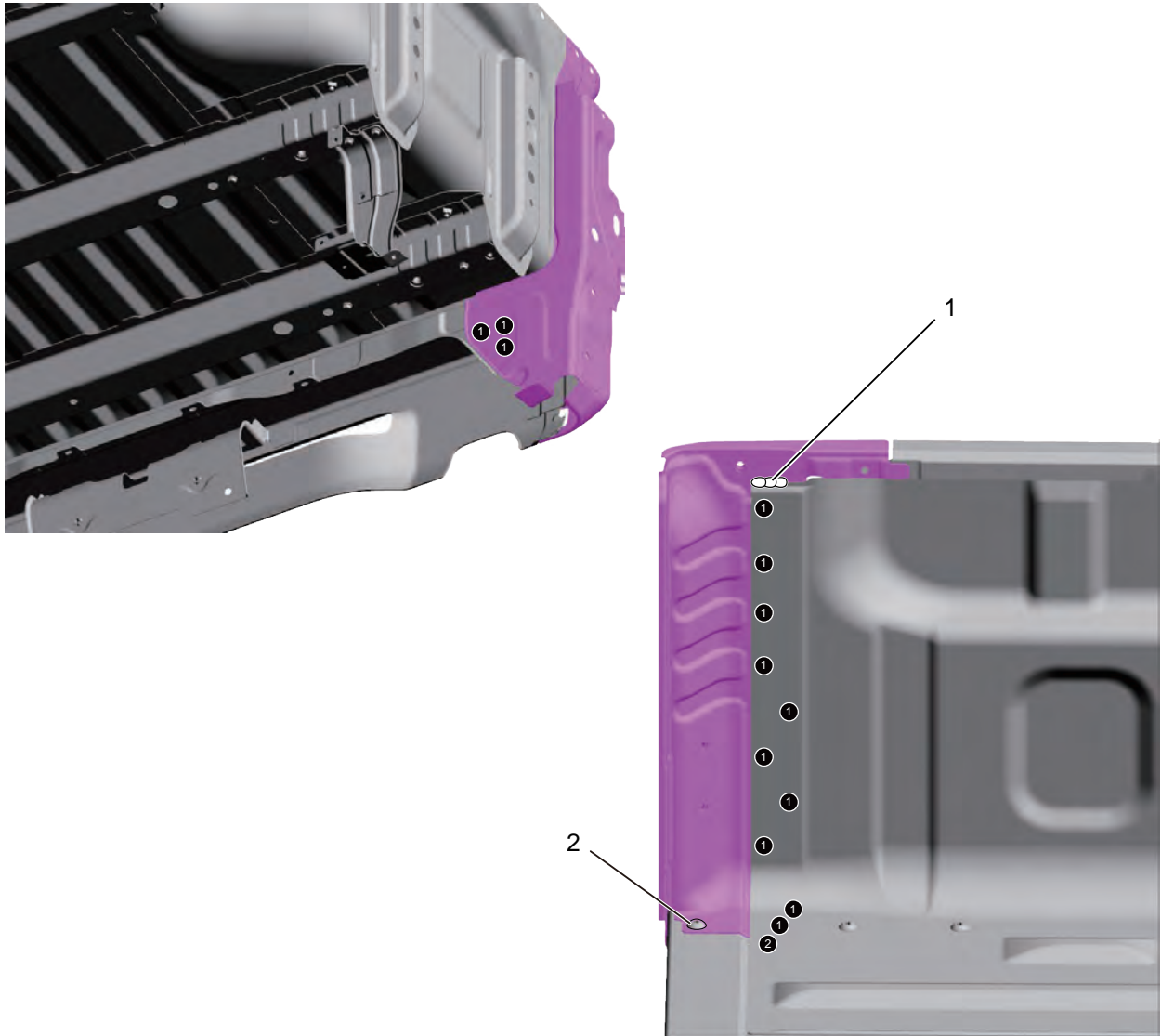
1. When heating around adhesive application portion to detach adhesive, be sure that temperature of said portion does not reach 170 °C (338 °F).
-

6. Drill out welding spots and remove the rear corner panel.



Rear corner panel Removal :

1. Unscrew the bolt.
2. Use a belt sander to scrape the fillet weld.
3. Drill out welding spots and remove the rear corner panel.



1. Fillet welding spot
2. Bolt

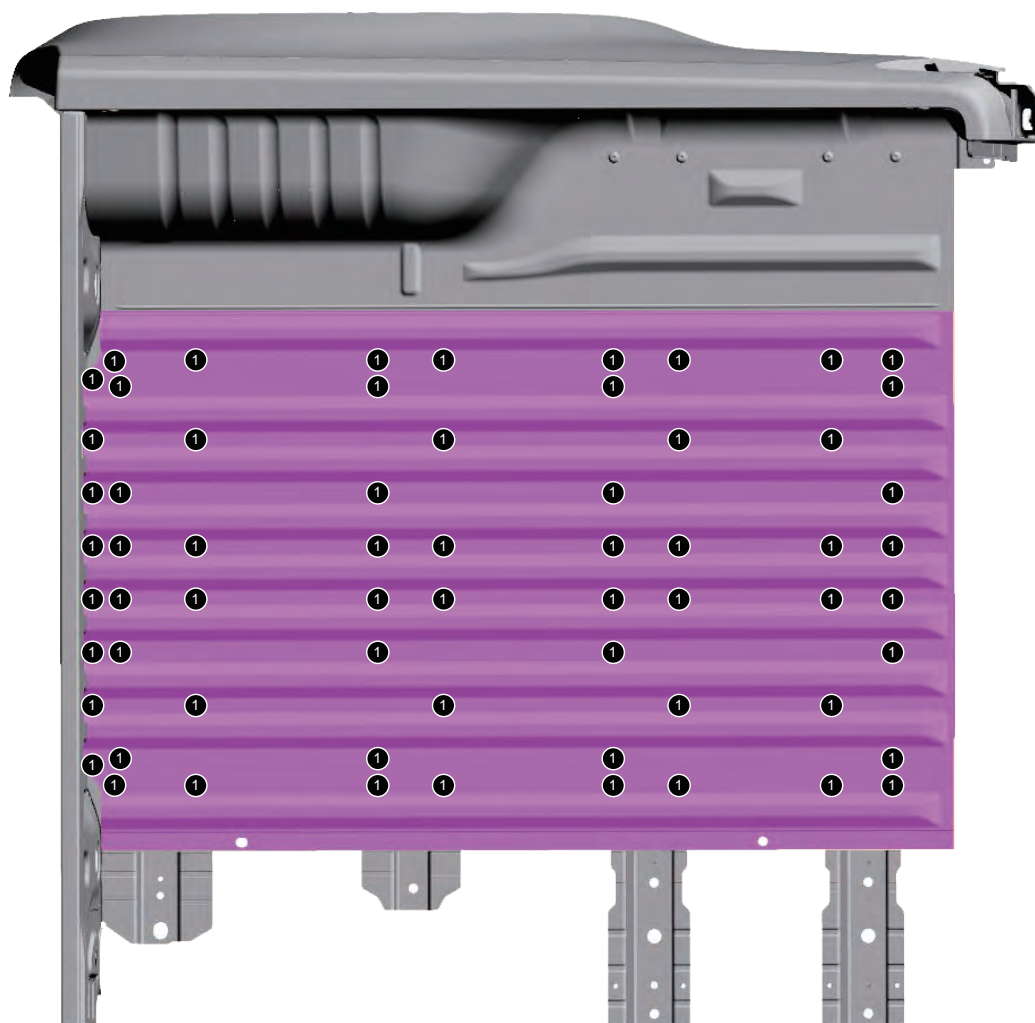
Rear body rear end bolster Removal :

1. Unscrew the bolt.
2. Drill out welding spots and remove the rear body rear end bolster.



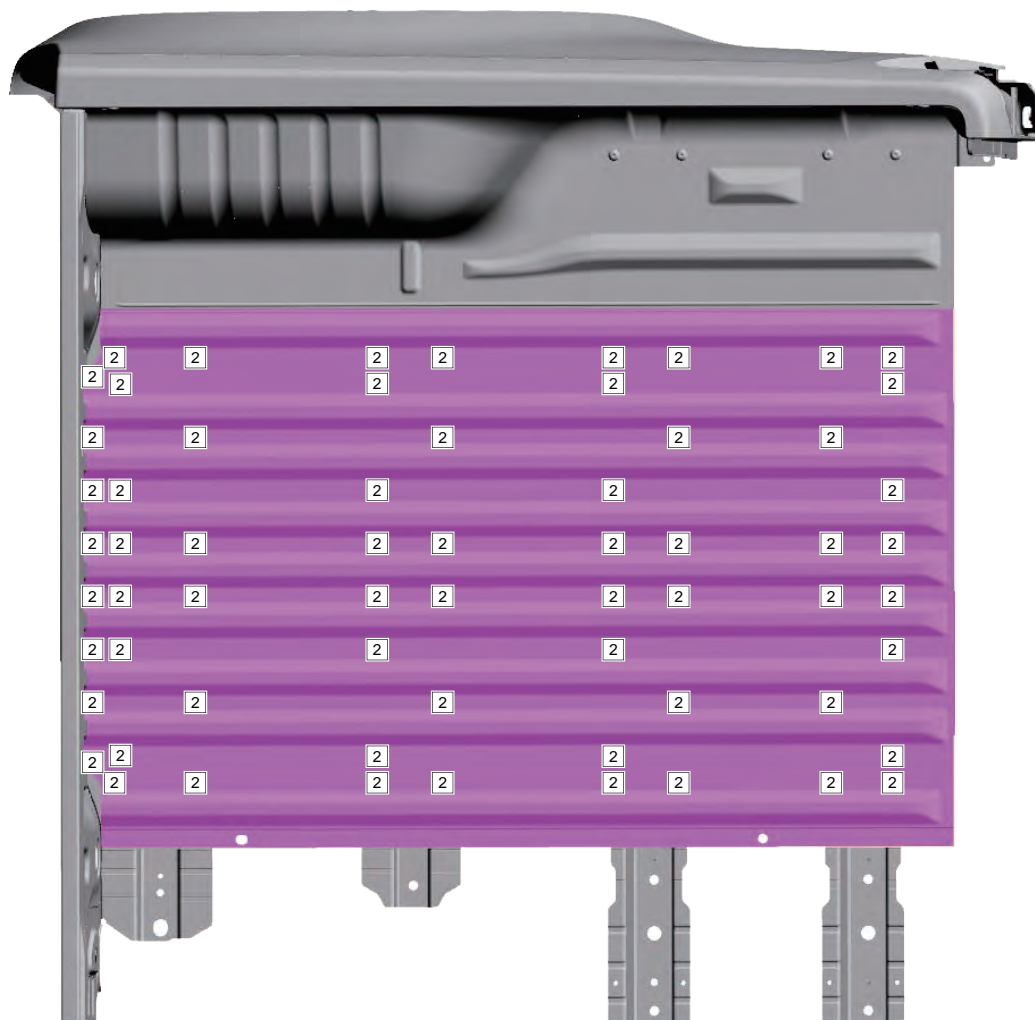
Rear body floor board panel Removal :

1. Drill out welding spots and remove the rear body floor board panel.



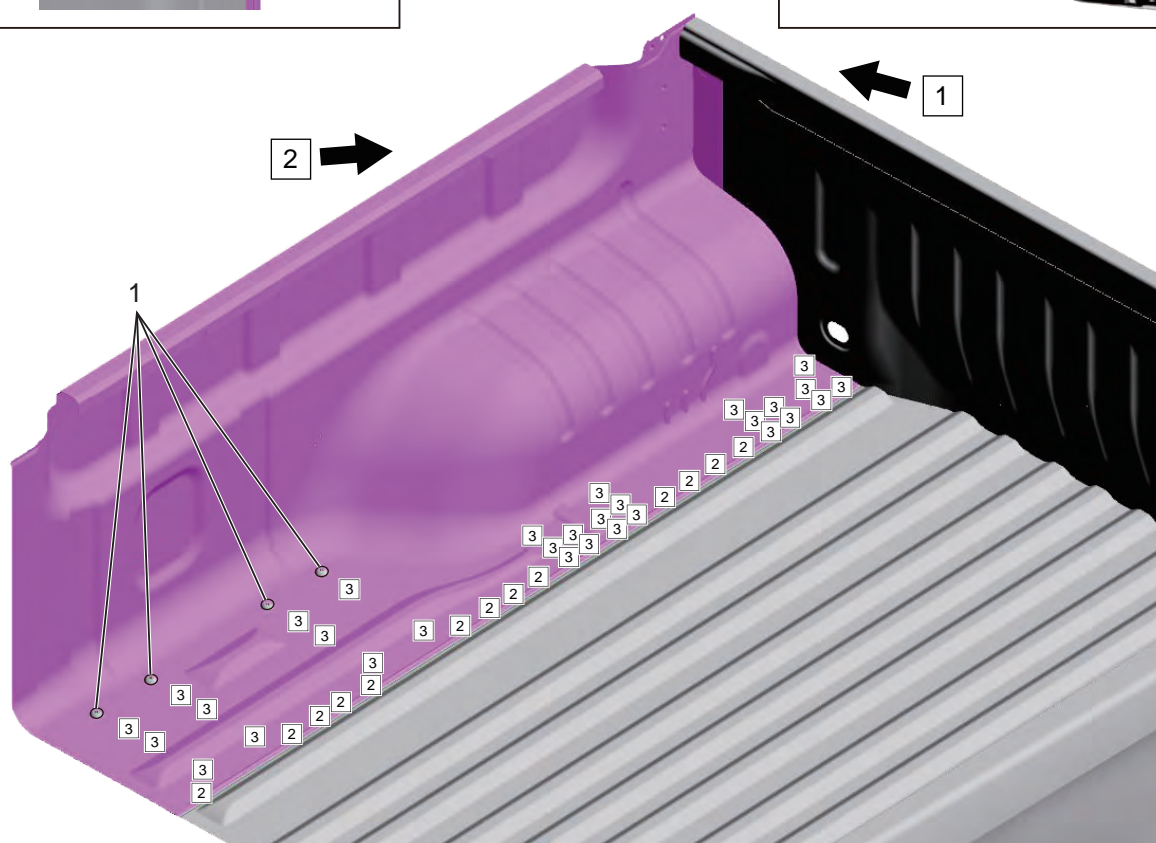
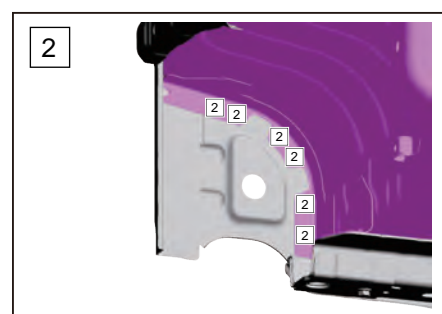
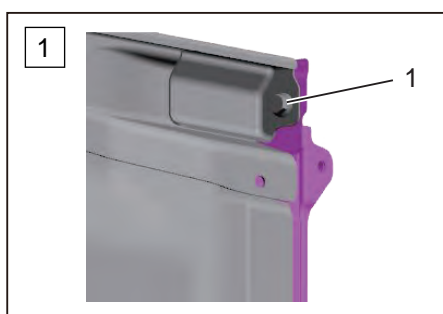
Rear body floor board panel Installation :

1. Install the rear body floor board panel.
2. Conduct resistance plug weld.



Rear body side inner panel Installation :

1. Install the rear body side inner panel.
2. Conduct resistance plug weld.
3. Tighten the 5 bolts to specified torque.
Tightening torque 13 N*m {1.3 kgf-m}



1. Bolt
-

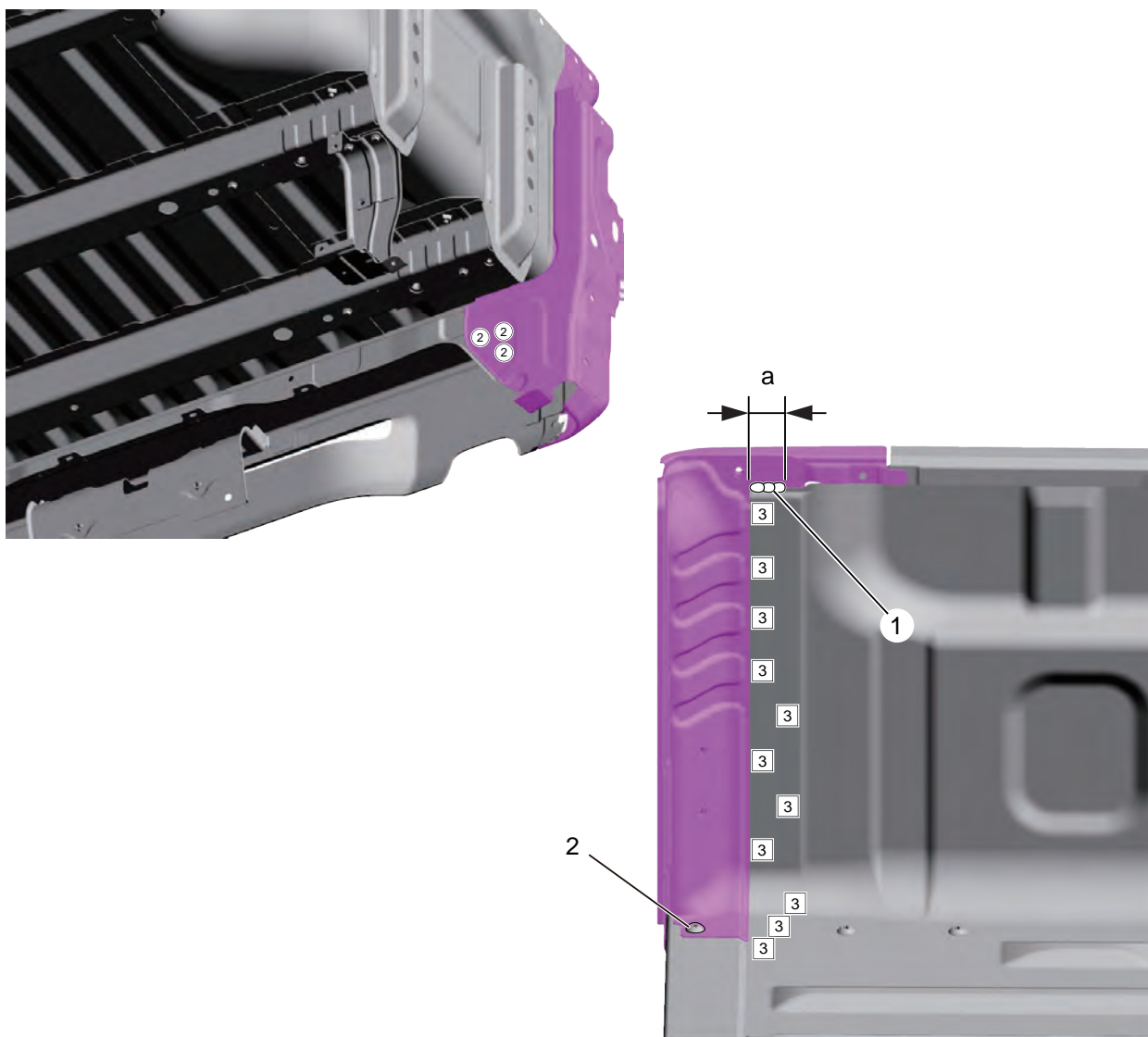
Rear body rear end bolster Installation :

1. Install the rear body rear end bolster.
2. Conduct resistance spot weld and plug weld.



Rear corner panel Installation :

1. Install the rear corner panel.
2. Conduct resistance spot weld and plug weld.
3. Conduct fillet weld.
4. Tighten the bolt to specified torque.
Tightening torque 13N*m {1.3 kgf-m}

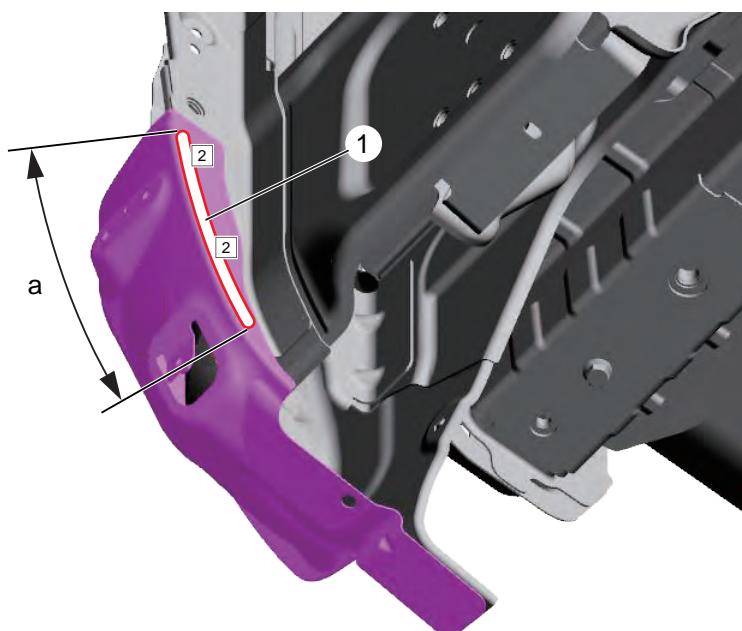


1. Fillet welding spot
2. Bolt
- a. 10 mm {0.39 in}

-
5. Install the rear corner panel.
 6. Conduct resistance spot weld.



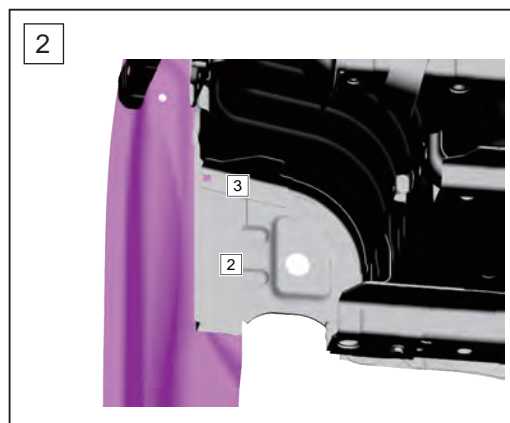
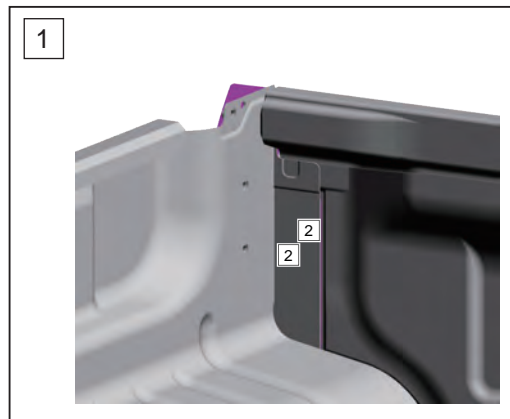
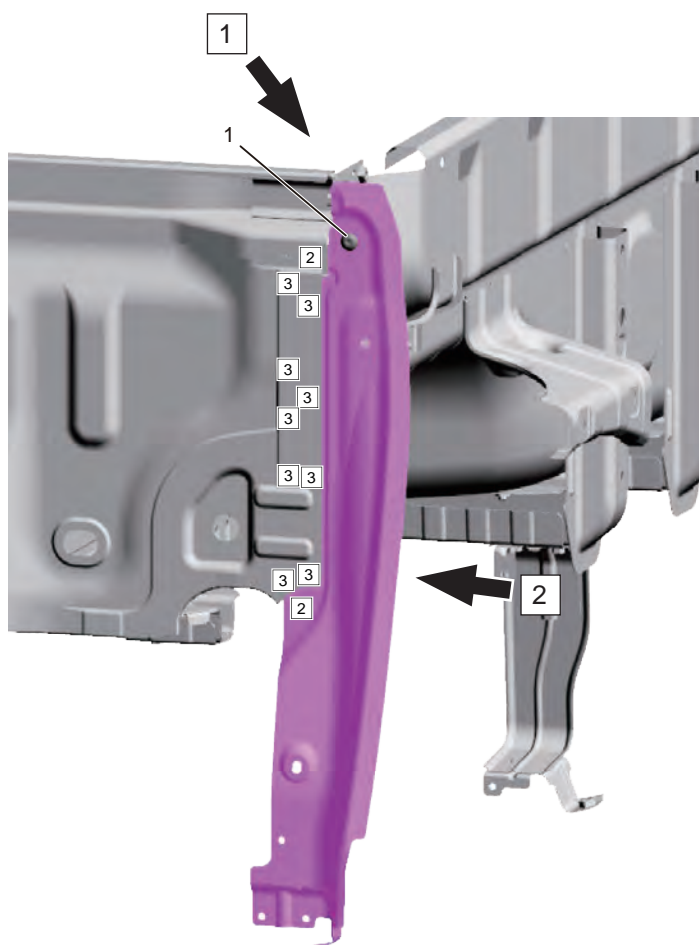
7. Install the side gate panel.
8. Conduct plug weld.



1. Apply adhesive
 - a. 160 mm {6.30 in}

310 Body Structure

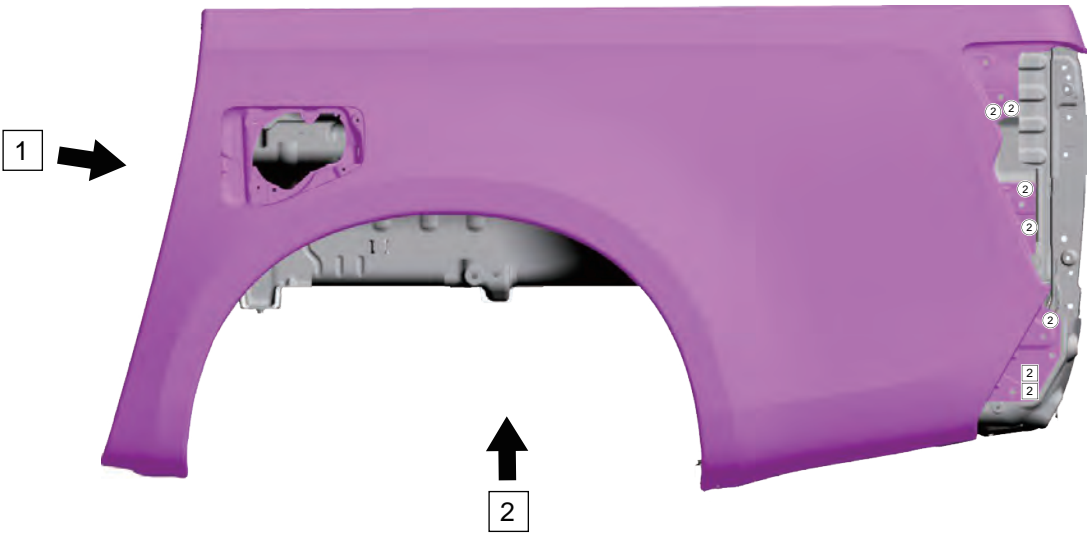
9. Install the rear body front filler.
10. Conduct resistance spot weld, plug weld and fillet weld.



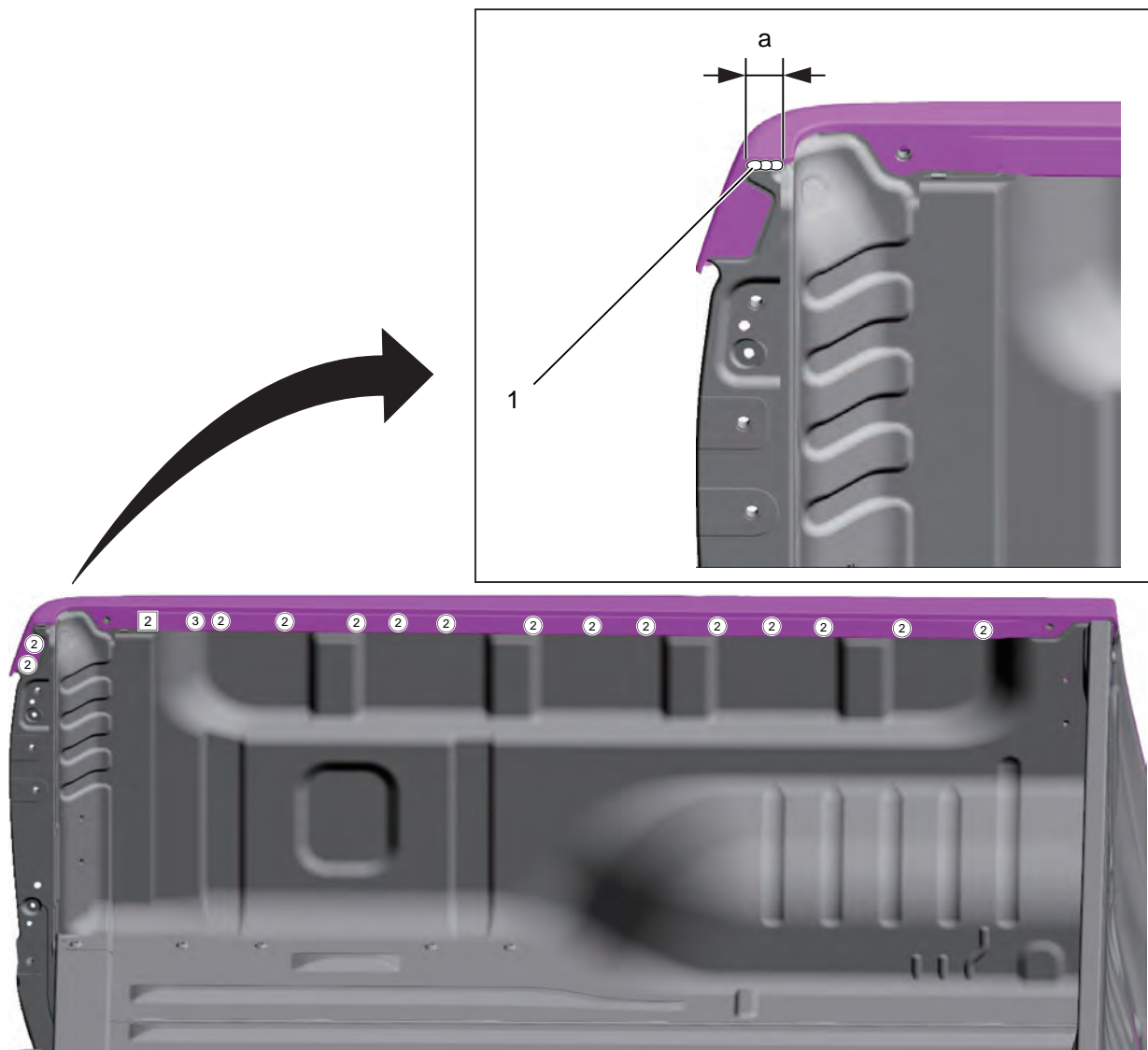
1. Bolt

11. Install the side gate panel.
12. Conduct resistance spot weld, plug weld and fillet weld.

Vehicle outside



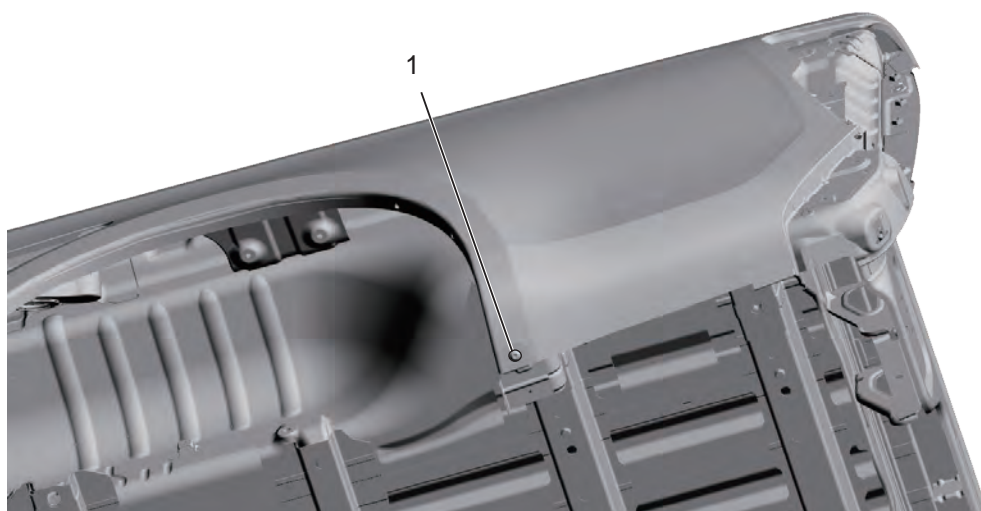
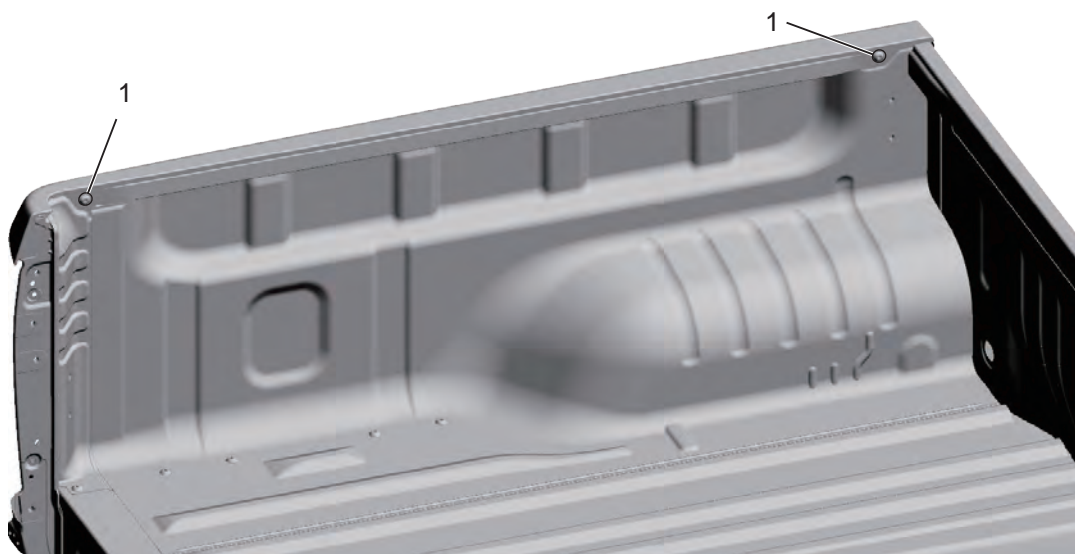
Vehicle inside



1. Fillet welding spot

a. 10 mm {0.39 in}

-
13. Tighten the 4 bolts to specified torque.
Tightening torque 13N*m {1.3 kgf-m}



1. Bolt
