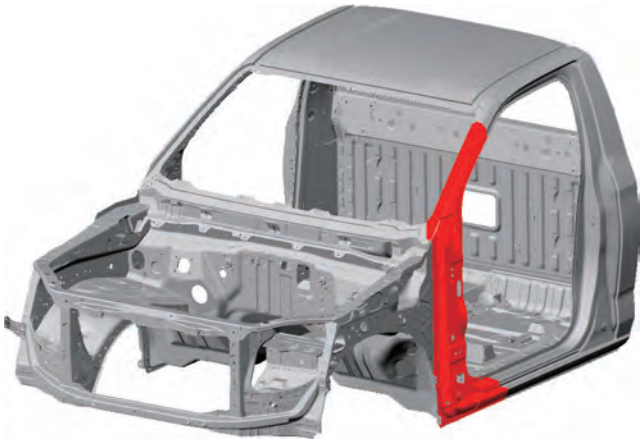
Front pillar outer panel, Front pillar inner panel, Body side inner reinforcement, Side inner lower reinforcement Removal and Installation (for Regular Cab)

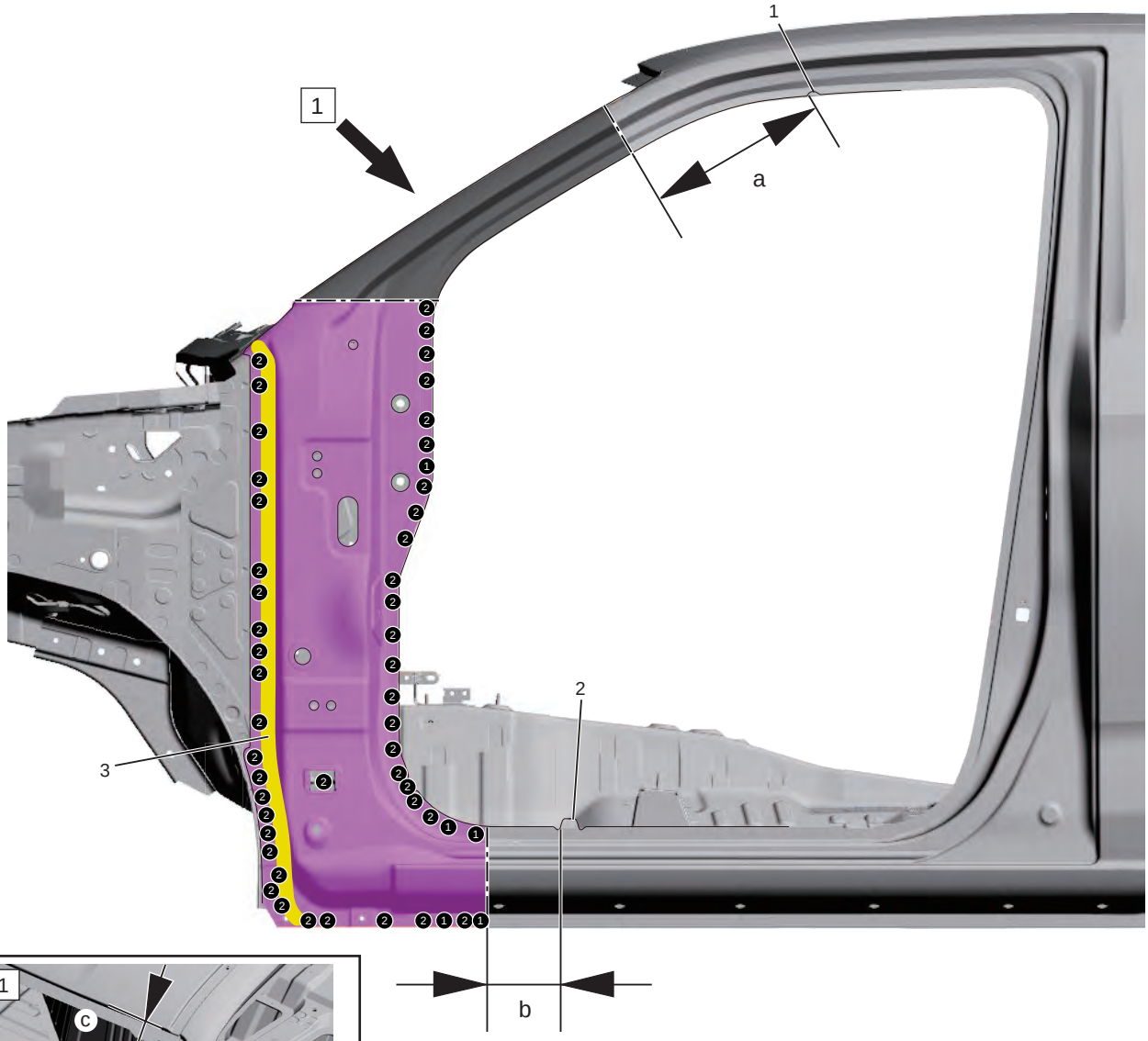


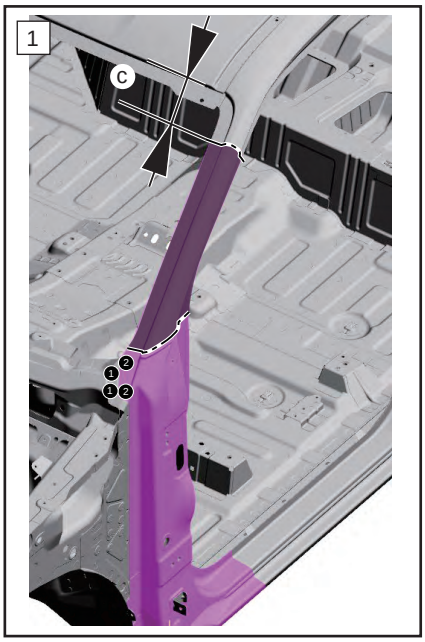
Note :

- The figure shows condition where the front fender and the cowl side reinforcement are removed.
- 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 front pillar outer panel, the front pillar inner panel and the side inner reinforcement at the same time at shown rough cutting position.
2. Drill out welding spots and remove the front pillar outer panel.

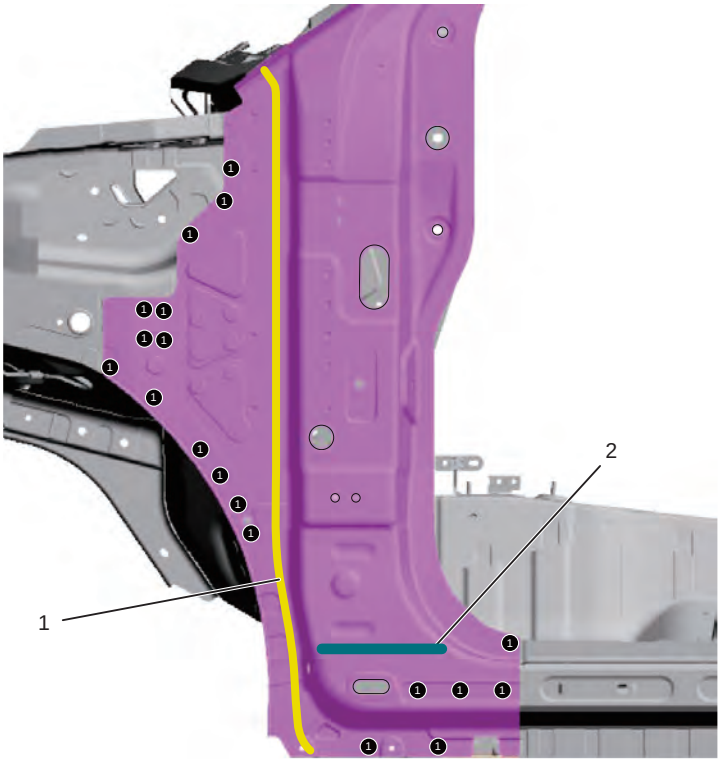

1
1
a
2
3
b


1
c

1. Cutout
2. Tab
3. When heating around sealer application portion to detach body sealer, be sure that temperature of said portion does not reach 170 °C (338 °F).

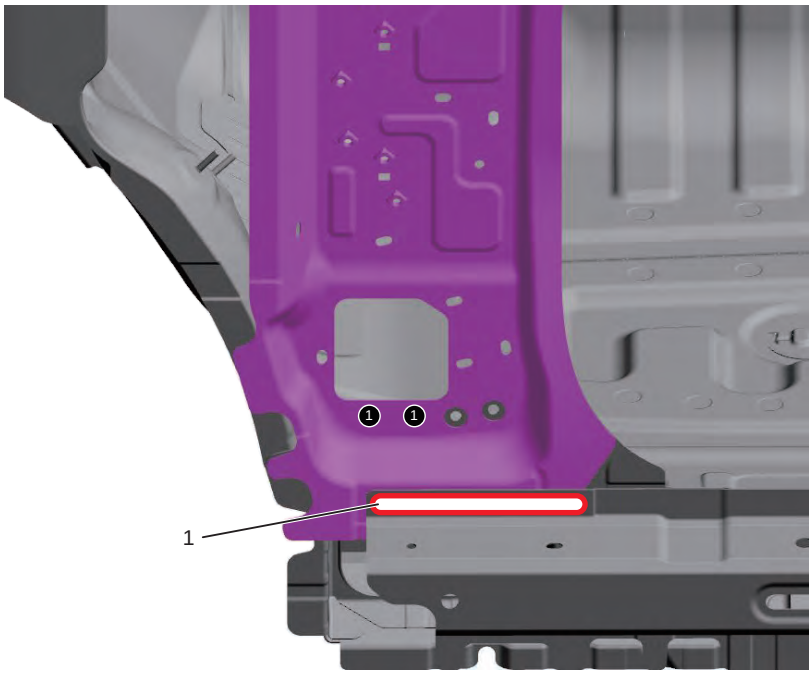
a. 300 mm {11.81 in}
b. 100 mm {3.94 in}
c. 130 mm {5.12 in}

3. Drill out welding spots and remove the side inner lower reinforcement.



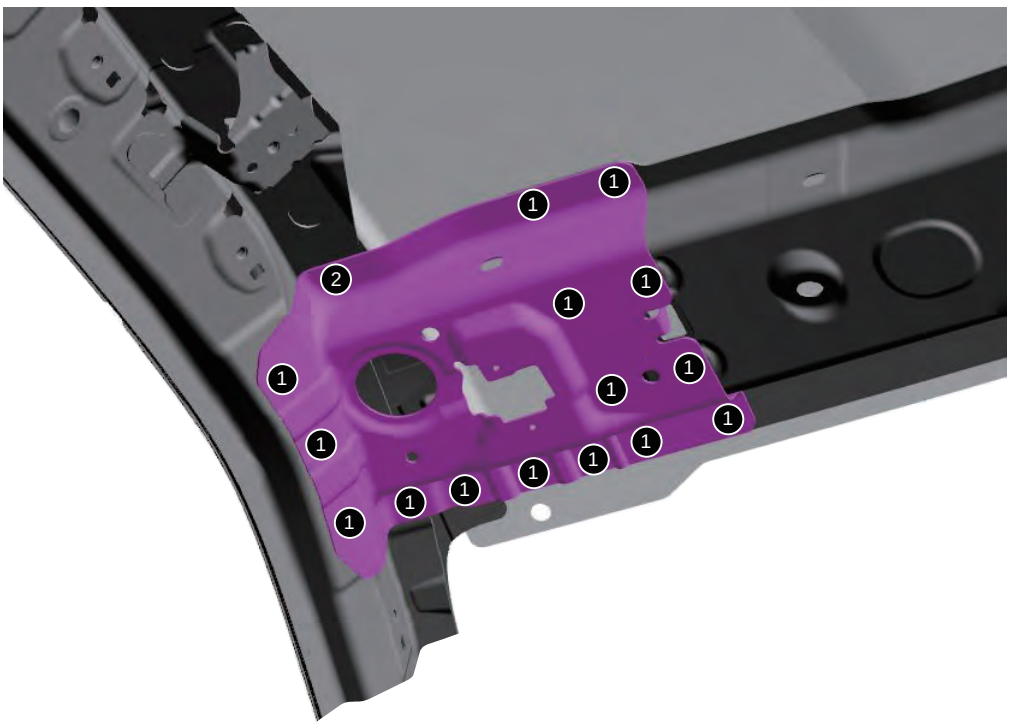
1. When heating around sealer application portion to detach body sealer, be sure that temperature of said portion does not reach 170 °C (338 °F).
2. When heating around formed material application portion to detach formed material, be sure that temperature of said portion does not reach 170 °C (338 °F).

4. Drill out welding spots and remove the dash side inner panel and the front pillar inner panel.

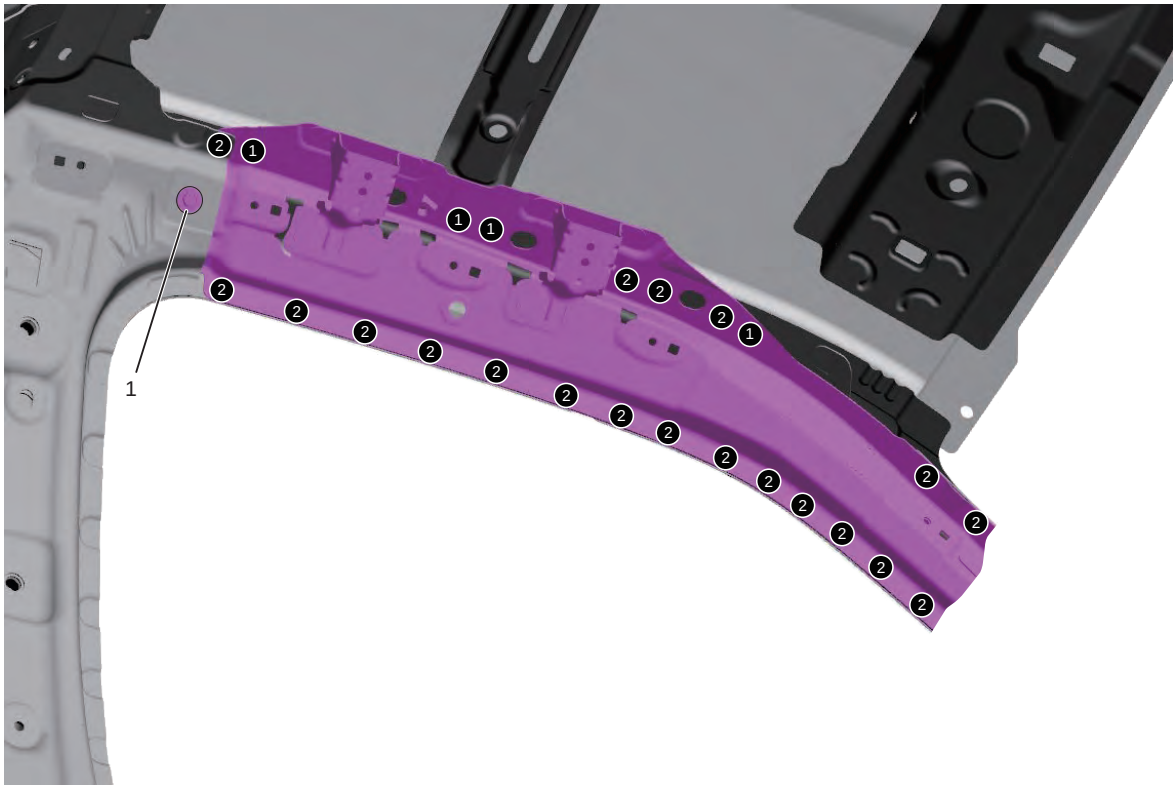


1. When heating around adhesive application portion to detach adhesive, be sure that temperature of said portion does not reach 170 °C (338 °F).

5. Drill out welding spots and remove a part of the front pillar inner panel.

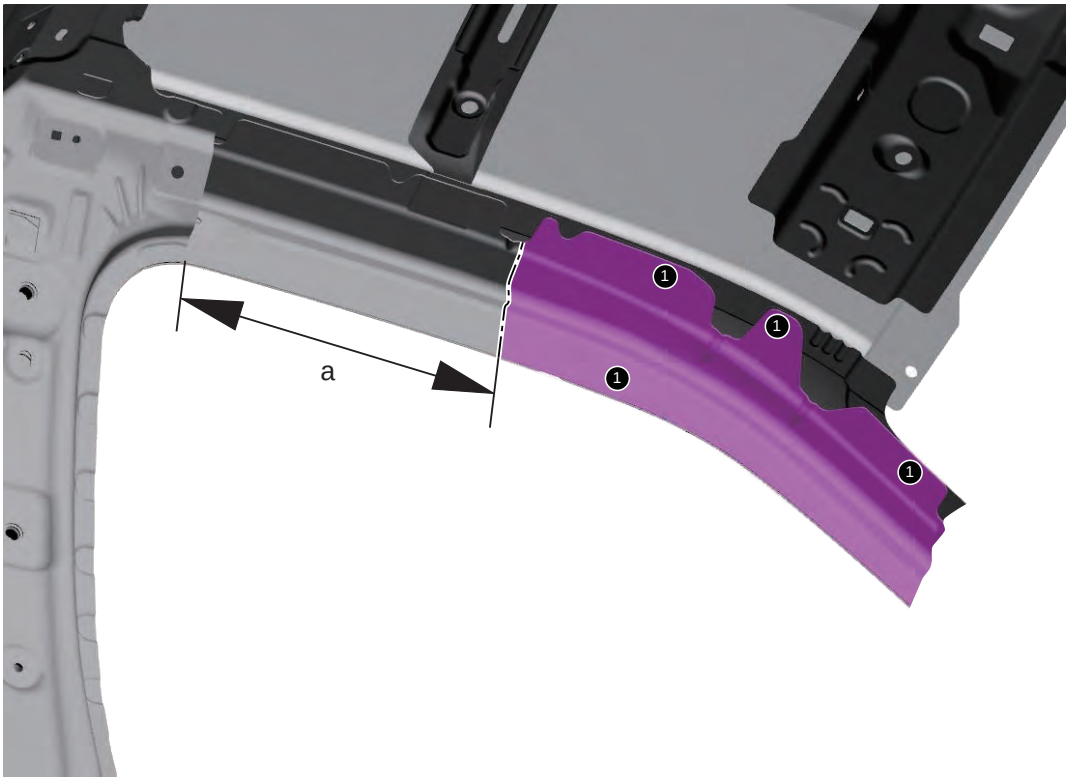


6. Unscrew the bolt.
7. Drill out welding spots and remove the front pillar inner panel.



1. Bolt

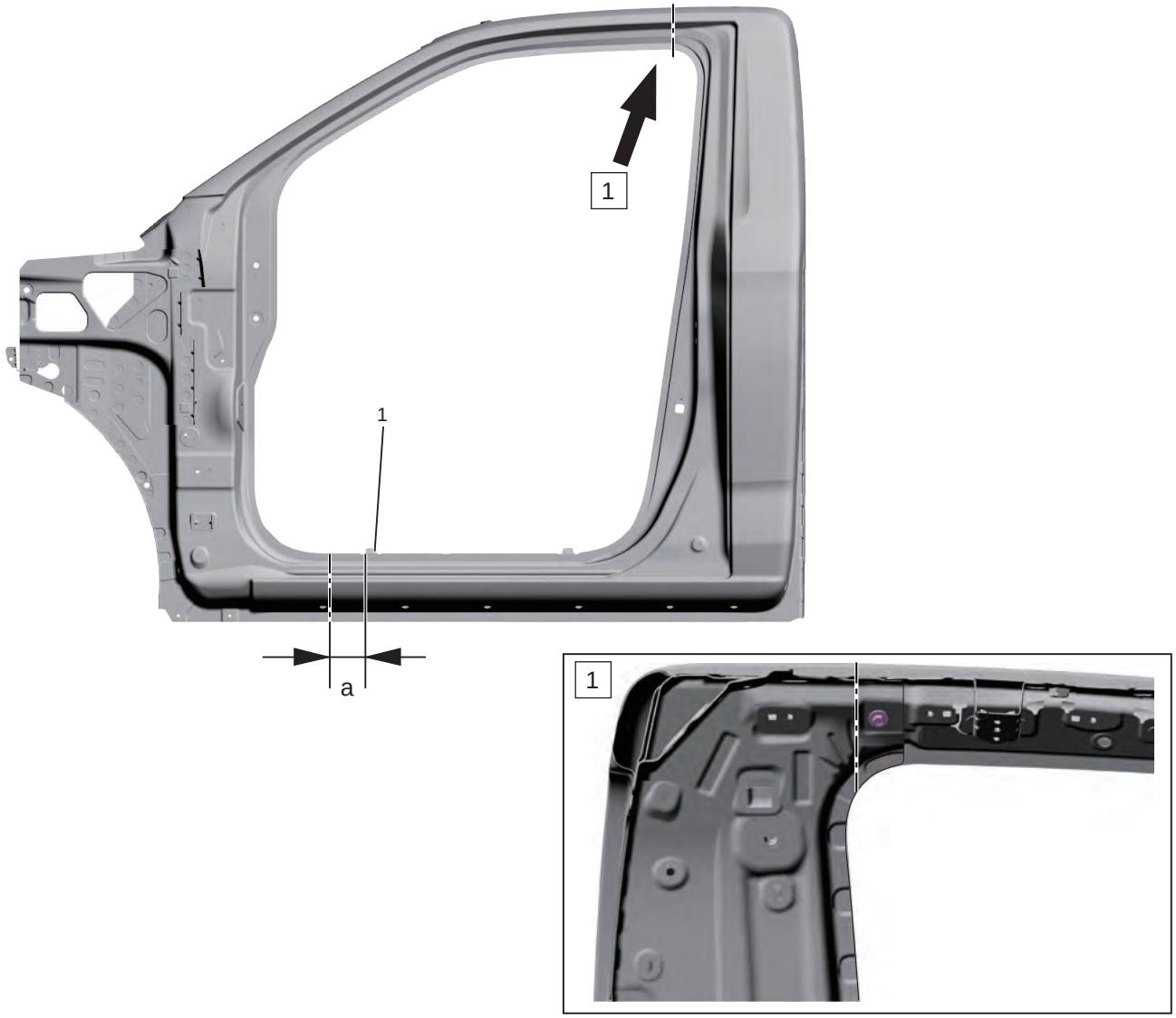
8. Drill out welding spots and remove the body side inner reinforcement.
9. Mark at the shown position and cut the side inner reinforcement.



a. 240 mm {9.45 in}

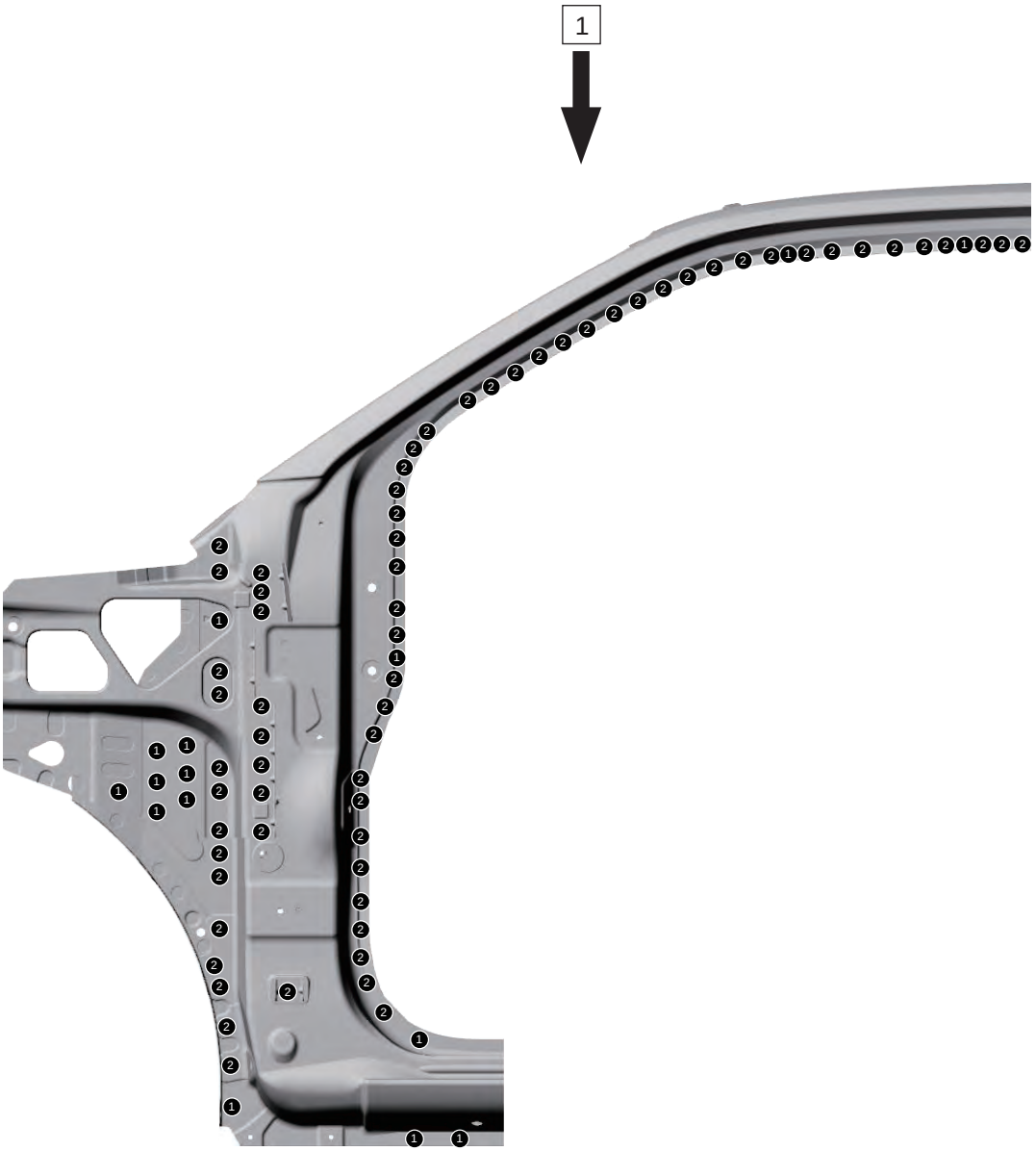
Installation :

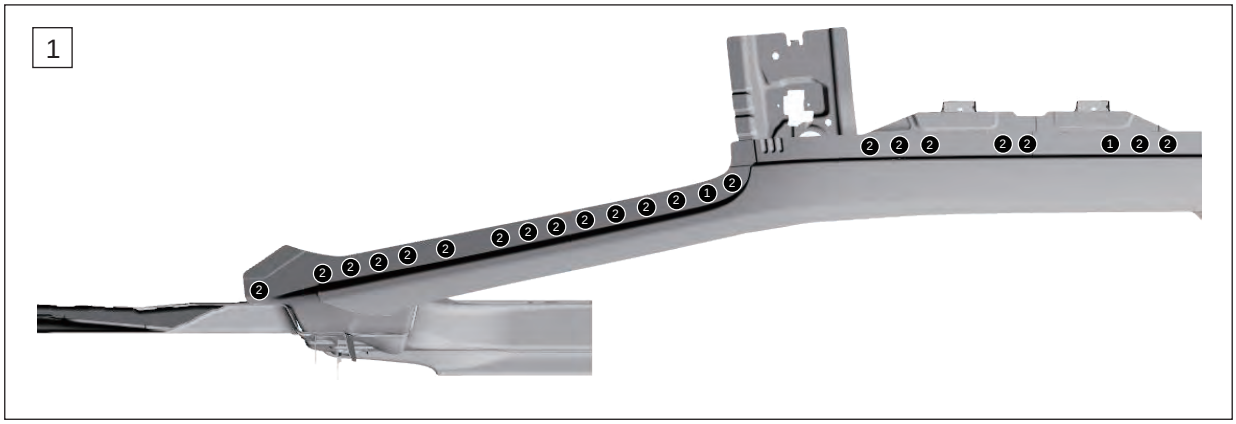
1. Cut off the spare parts as shown in figure.



1. Tab
a. 80 mm {3.15 in}

2. Drill out welding spots and separate the front pillar outer panel from the front pillar inner panel, the body side inner reinforcement and the inner lower reinforcement.

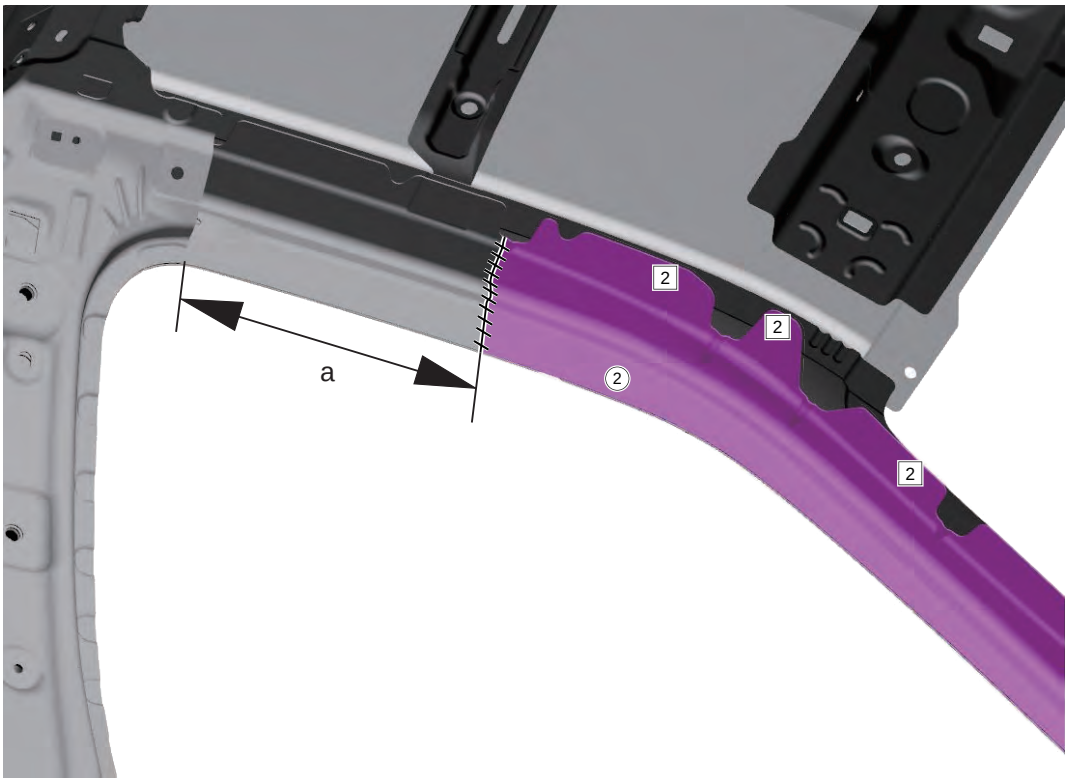




3. Drill out welding spots and separate the front pillar inner panel from dash side inner panel.
4. Drill out welding spots and separate a part of the front pillar inner panel.

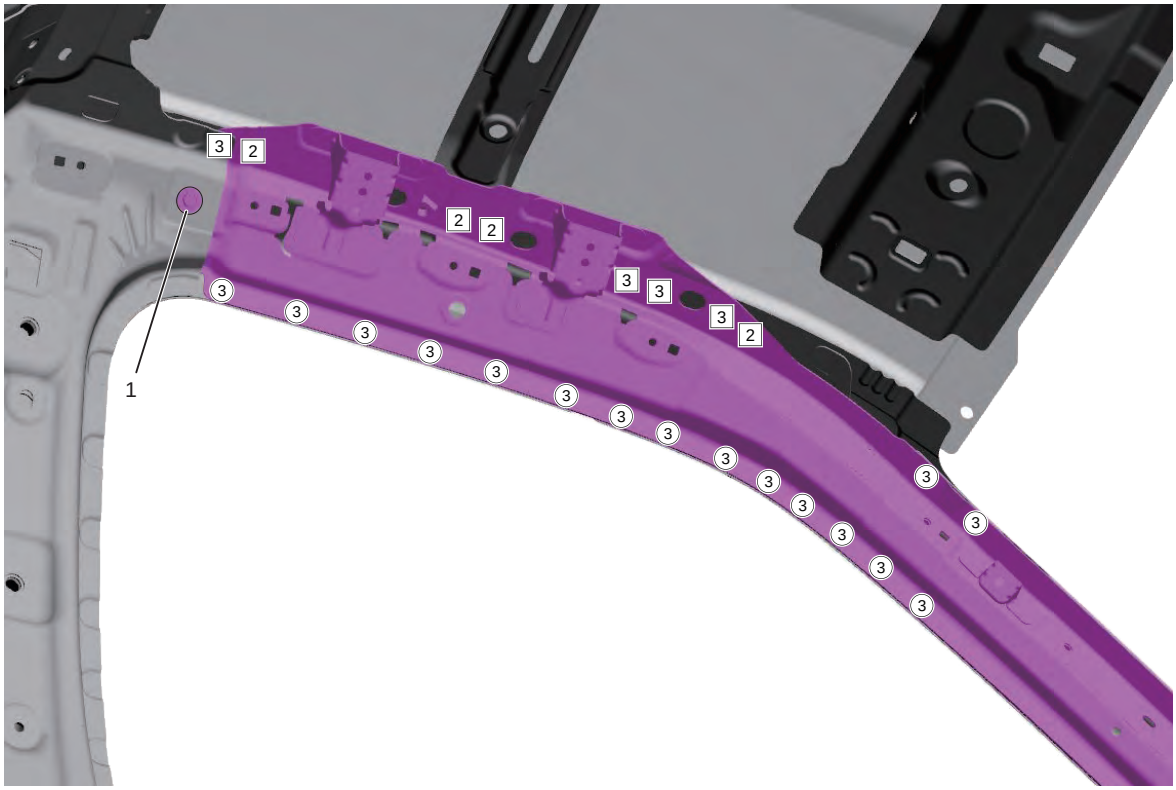
5. Drill out welding spots and separate the side inner lower reinforcement and body side reinforcement.
6. Drill out welding spots and remove the rocker reinforcement.

7. Install the body side inner reinforcement to vehicle body and cut in stacked condition.
8. Conduct resistance spot weld and plug weld.
9. Conduct continuous weld.



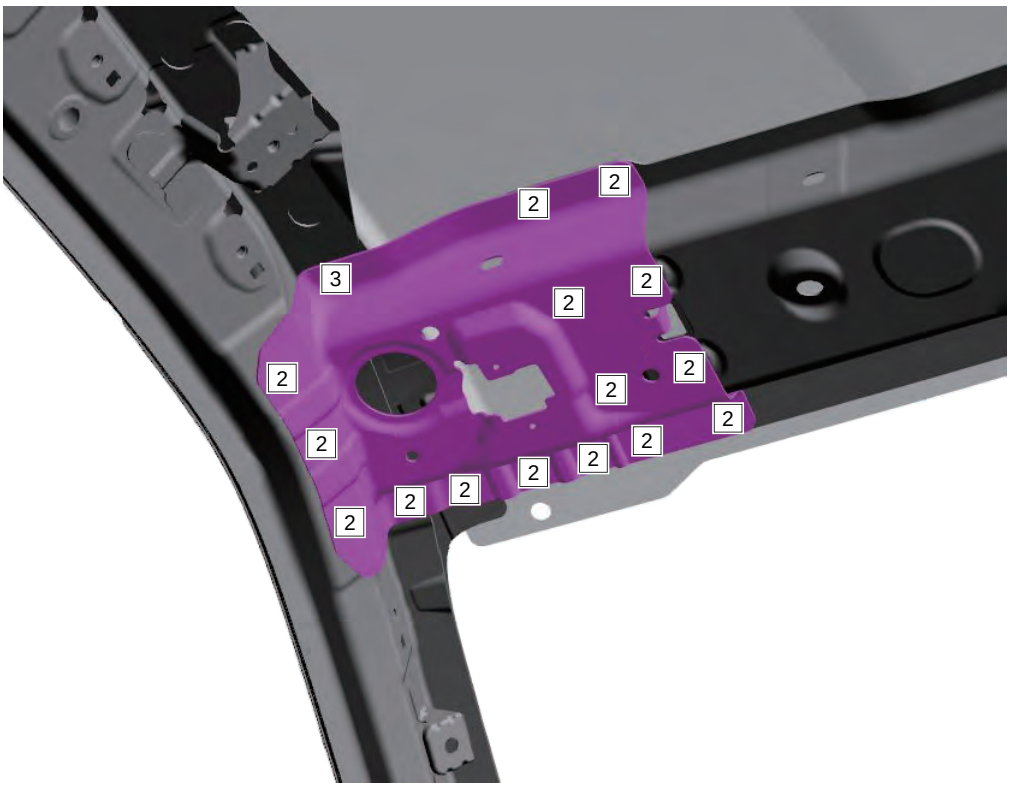
a. 230 mm {9.06 in}

10. Install the front pillar inner panel.
11. Tighten the bolt to specified torque.
    Tightening torque: 8.4 N·m {0.8 kgf-m}
12. Conduct resistance spot weld and plug weld.

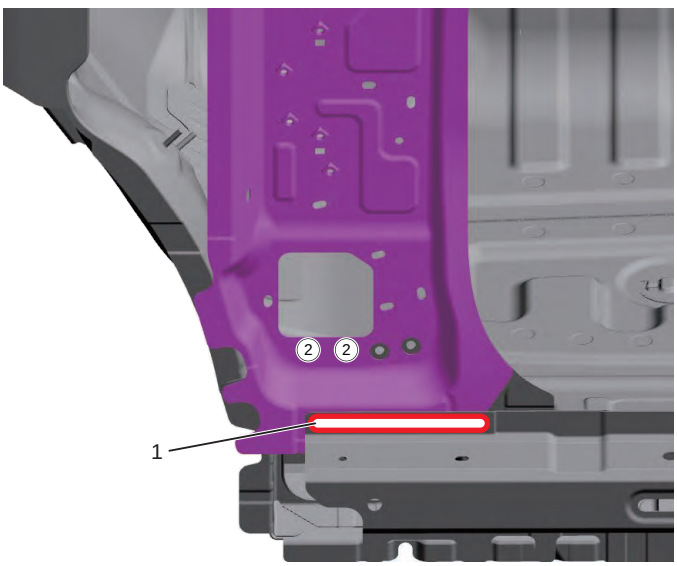


1. Bolt

13. Install a part of the front pillar inner panel.
14. Conduct plug weld.

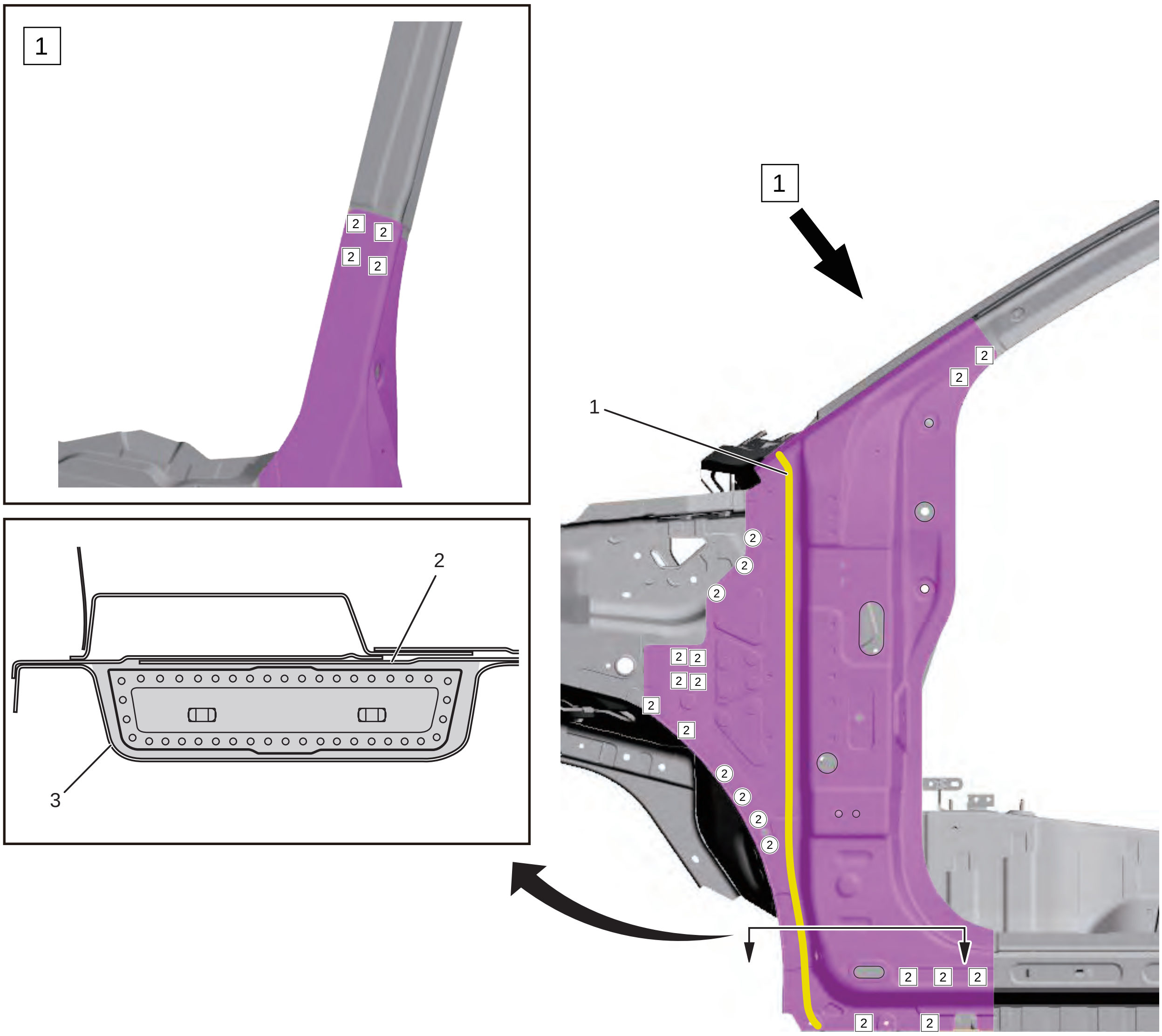


15. Install the dash side inner panel and the front pillar inner panel.
16. Conduct resistance spot weld and plug weld.



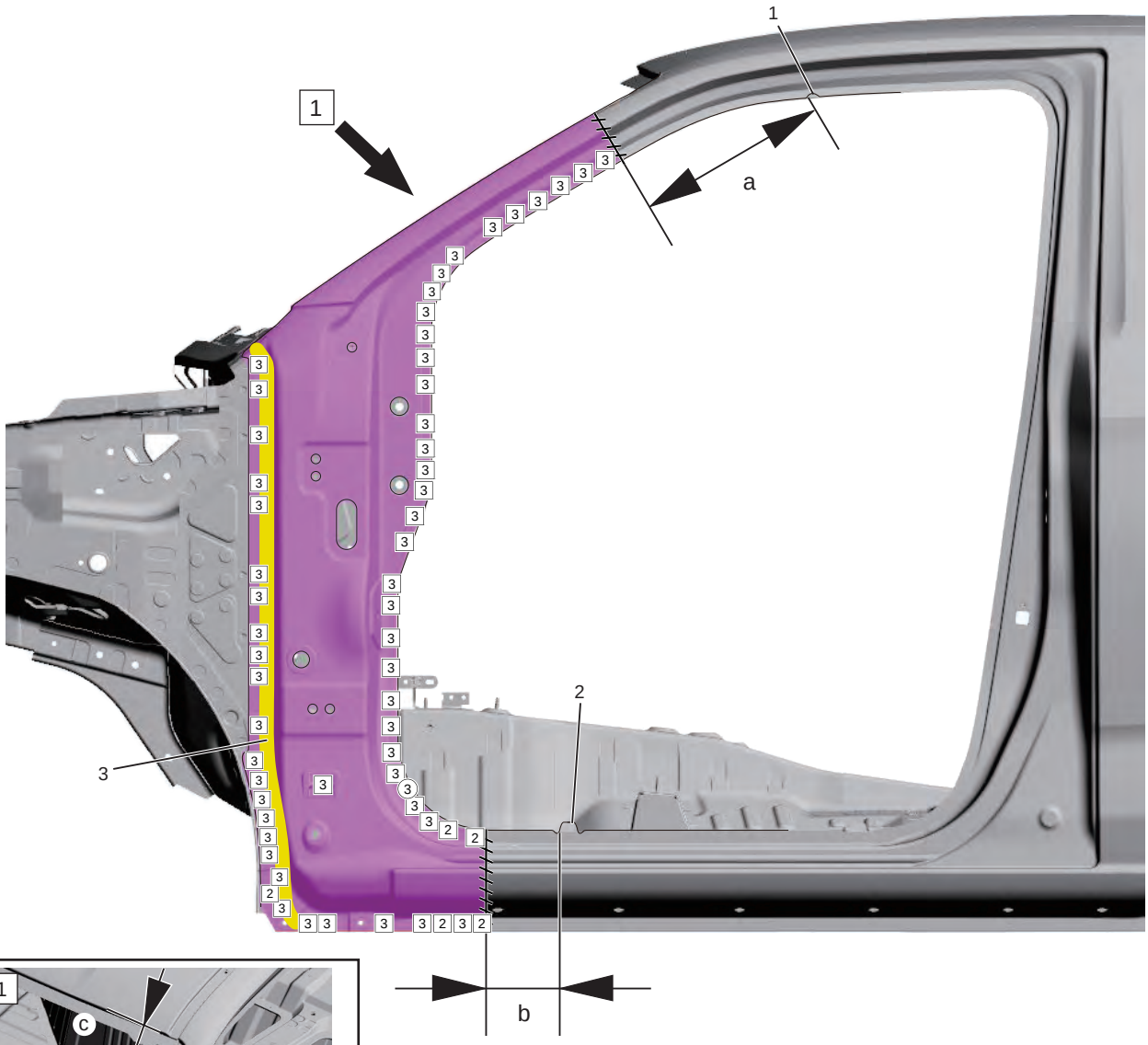
1. Apply adhesive

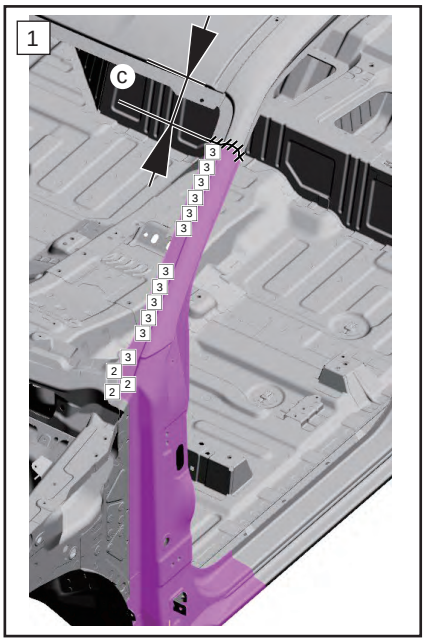
17. Install the side inner lower reinforcement.
18. Conduct resistance spot weld and plug weld.
19. Fill the openings between the side inner lower reinforcement and the rocker reinforcement with the sponge in the original baffle plate position.



1. Apply body sealer
2. Rocker reinforcement
3. Side inner lower reinforcement

20. Install the front pillar outer panel to vehicle body and cut in stacked condition.
21. Conduct resistance spot weld and plug weld.
22. Conduct continuous weld.
23. Apply anti-corrosion wax to back side of continuous weld part.


1
1
a
2
3
b


1
c

1. Cutout
2. Tab
3. Apply body sealer

a. 290 mm {11.42 in}
b. 90 mm {3.54 in}
c. 120 mm {4.72 in}