

SIDE SILL PANEL INSTALLATION [PANEL REPLACEMENT]

id098008615200

Symbol Mark

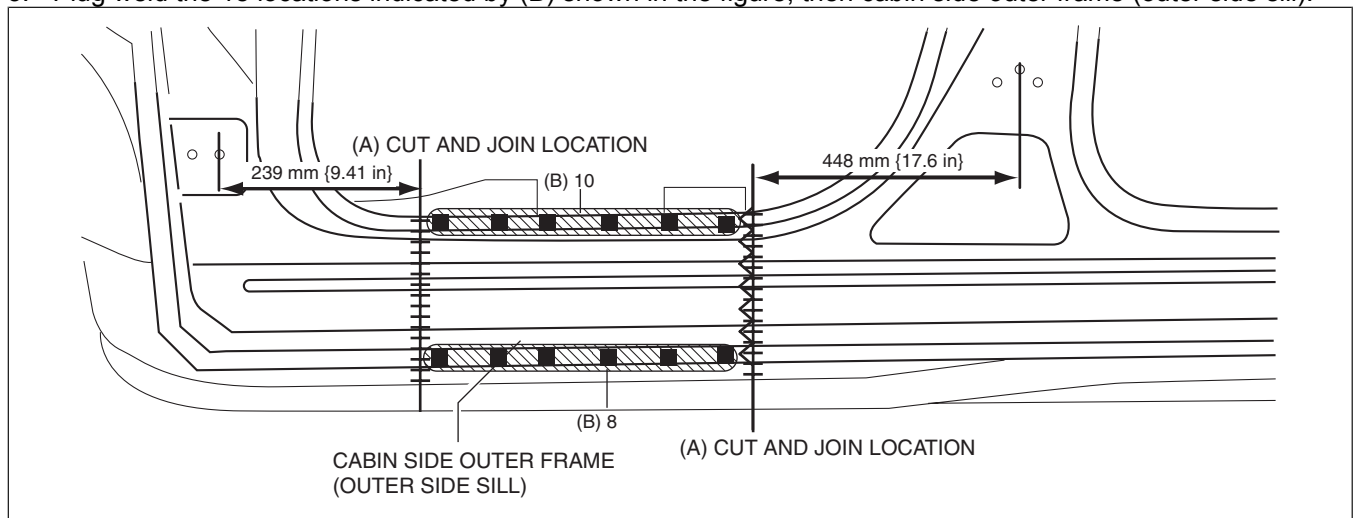
SYMBOL MARK	MEANING
■	PLUG WELDING (ARC WELDING)
●	SPOT WELDING
— —	CONTINUOUS ARC WELDING (CUT-AND-JOIN LOCATION)

ac5uub00000043

Installation Procedure

Side sill (front side)

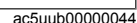
1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for the plug welding before installing the new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.
4. Cut and join the 2 locations indicated by (A) shown in the figure.
5. Plug weld the 18 locations indicated by (B) shown in the figure, then cabin side outer frame (outer side sill).



ac5wzb000000267

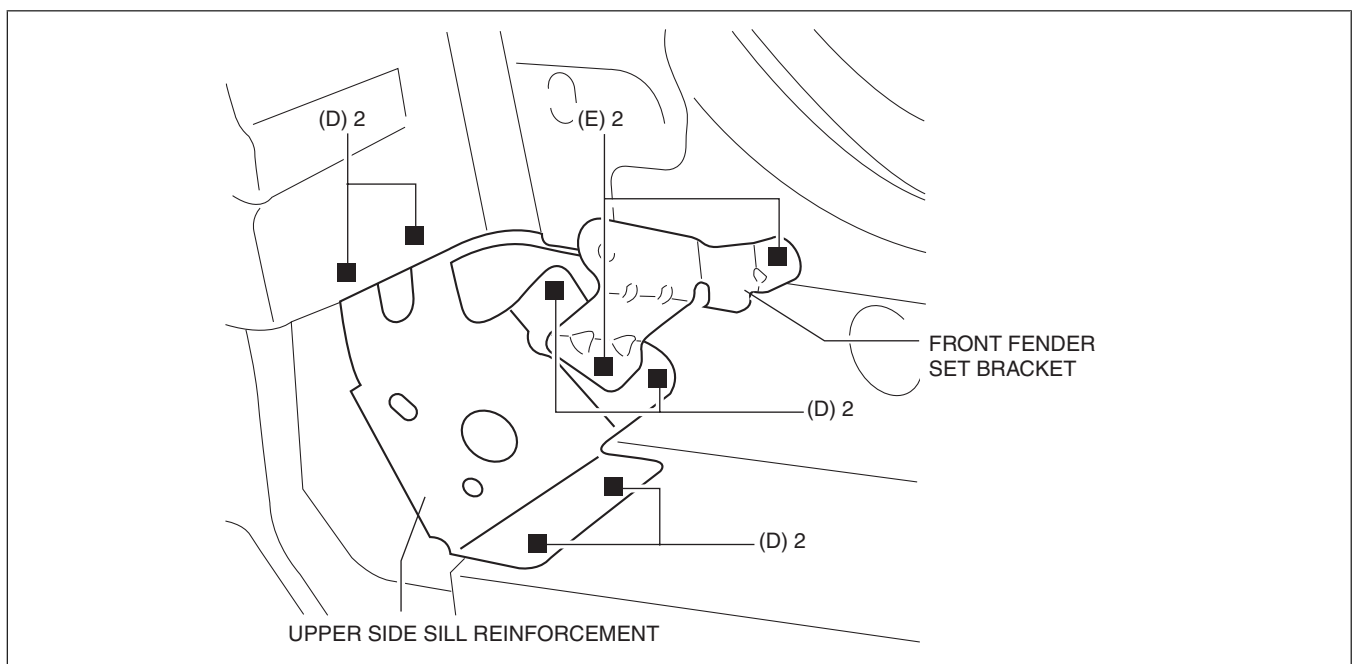
Side sill (component)

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for the plug welding before installing the new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.
4. Drill the 4 locations indicated by (A) shown in the figure, then remove the upper side sill reinforcement from the new side sill reinforcement.



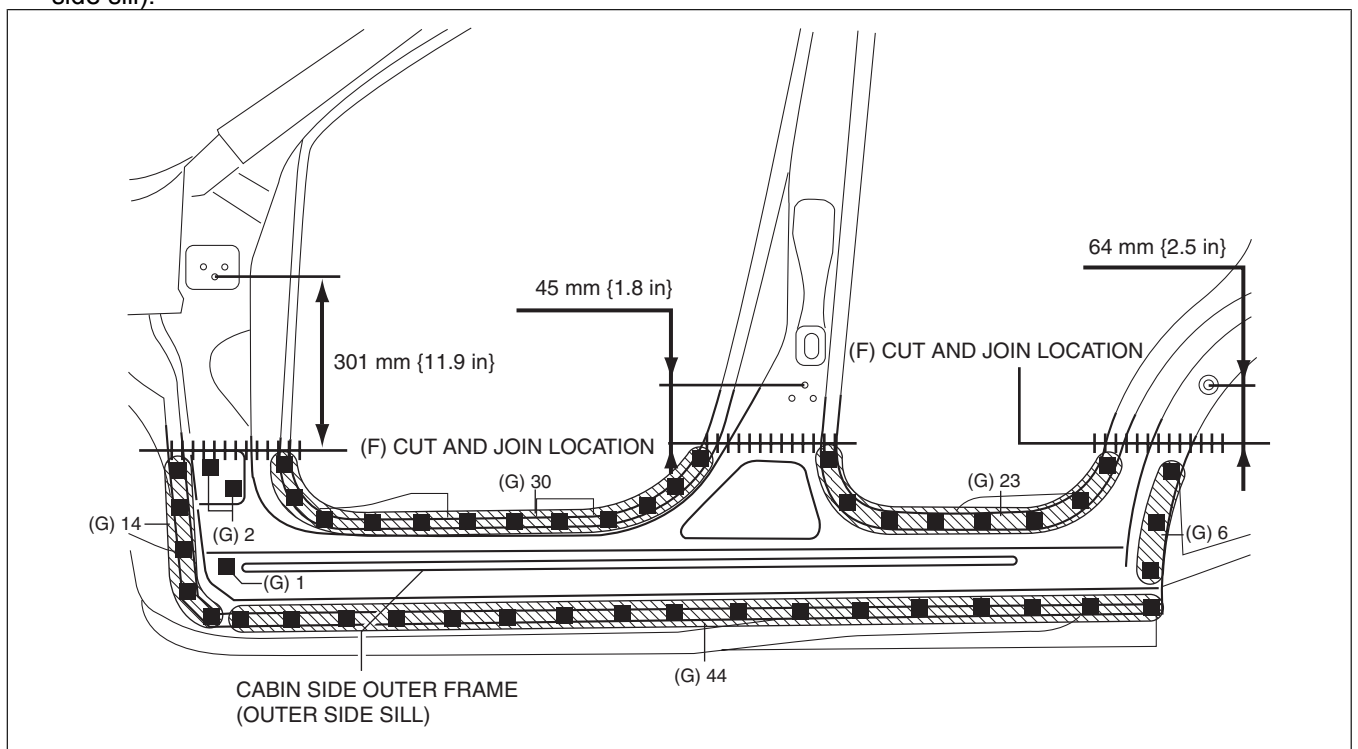
-
- Figure 1 is a technical diagram illustrating the installation of side sill reinforcement. The main diagram shows a side view of a vehicle chassis with the reinforcement being installed. Callouts include (B) 2 for the reinforcement plate, (B) 5 for the front bracket, (B) 20 for the main reinforcement plate, and (C) 3 for the rear bracket. An inset shows a detail of the reinforcement plate being secured with bolts.

- ac5wzb00000197



ac5uub00000045

9. Cut and join the 3 locations indicated by (F) shown in the figure.
10. Plug weld the 120 locations indicated by (G) shown in the figure, then install the cabin side outer frame (outer side sill).



ac5wzb00000269