

# Replacement

1. Remove the related parts.
  - Front seat
  - Carpet
  - Refer to the front side frame (see page 4-16).
2. Pull out and straighten the damaged area.
  - The front side outrigger receives impact through the front side frame or side sill. Such impact generally requires replacement of all these parts.
  - Before cutting off the front side outrigger or side sill, pull out the damaged area with the frame straightener and correct the related parts such as the front floor and dashboard. Check the clearance and level differences of the front doors.
  - Jack up the body and place safety stands at the four designated places of the side sills. If necessary, place safety stands at the rear of the frame.
3. Peel off the undercoat.
 

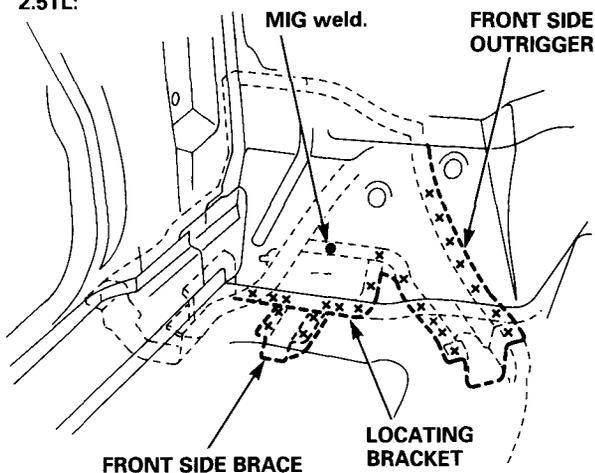
Heat the undercoat at the weld areas of the front side outrigger and side frame with a gas torch and peel off the undercoat with a metal spatula.

**CAUTION: Be careful not to burn the fittings inside the passenger compartment when heating.**

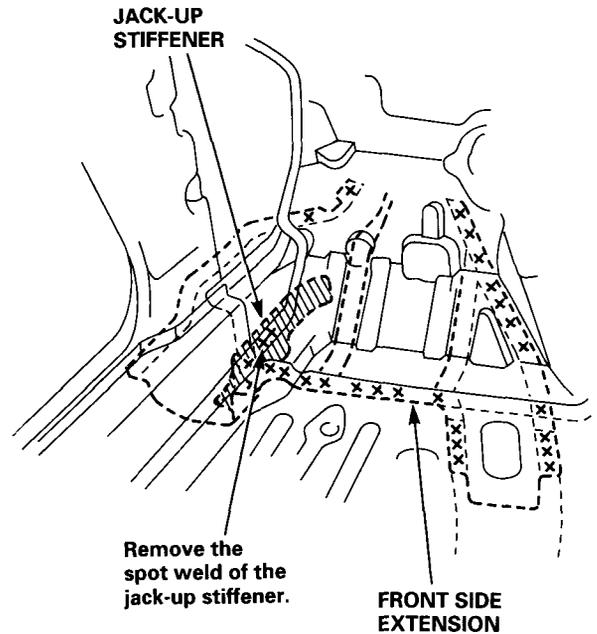
4. Remove the front side outrigger.
  - Center punch around the spot weld imprints on the front side outrigger from inside the passenger compartment.
  - Drill holes in the spot welded areas with a 5 mm (0.2 in) drill.
  - Remove the MIG welds with a disc sander.

NOTE: Drill holes through the parts completely since the replacement front side outrigger will be welded by MIG welding.

2.5TL:



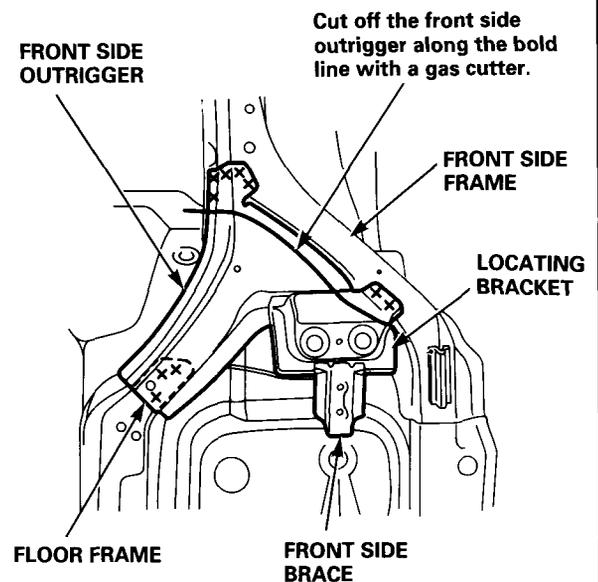
3.2TL:



- Center punch around the spot weld imprints on the front side frame, floor frame and inside sill.
- Drill holes using a spot cutter.

NOTE: When drilling holes be careful not to drill down to the front side frame, floor frame and inside sill.

2.5TL:

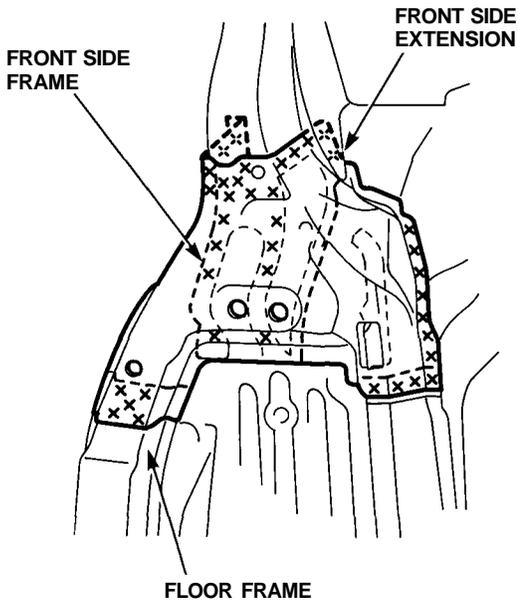


(cont'd)

# Front Side Outrigger/Front Side Extension

## Replacement (cont'd)

3.2TL:



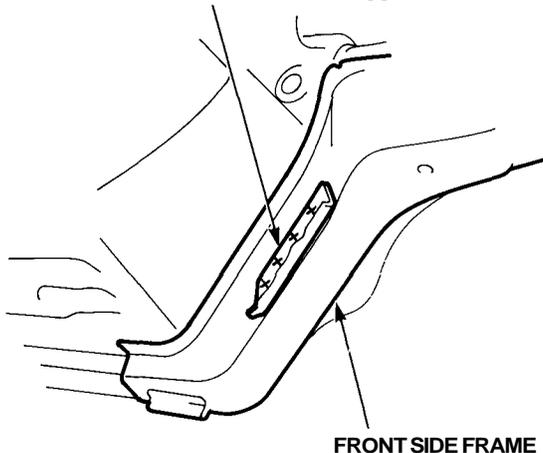
- Level off and finish the burrs of the pried off spot welds with a disc sander.

**⚠ WARNING** To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

5. Mold the related parts.  
Reshape the lower dashboard, front side frame, front floor, inside sill and side sill inner joint using a hammer and dolly.

2.5TL:

Remove the remains of the front side outrigger.



6. Set the new front side outrigger.

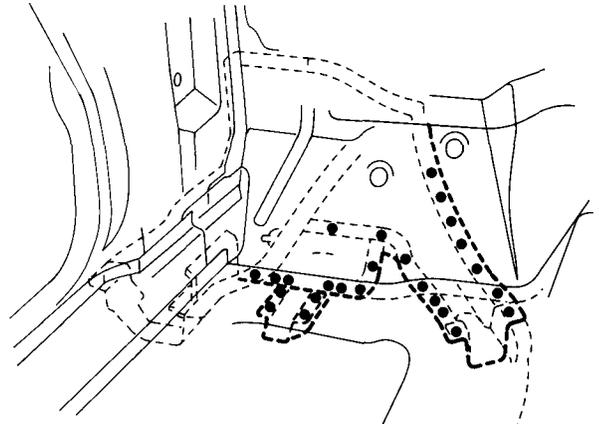
- Remove the undercoat from both sides of the areas to be spot welded with a sander to expose the steel plate.
- Clamp the weld flanges with the side sill using the vise-grip pliers. Set the front side outrigger on the side frame using a jack.
- Drill 3 mm (0.12 in) holes, and screw 5 mm self-tapping screws into the drilled holes at the areas where the front side outrigger does not fit closely.
- Even out the welded flange and damaged area with a hammer and dolly.

7. Perform the main welding.

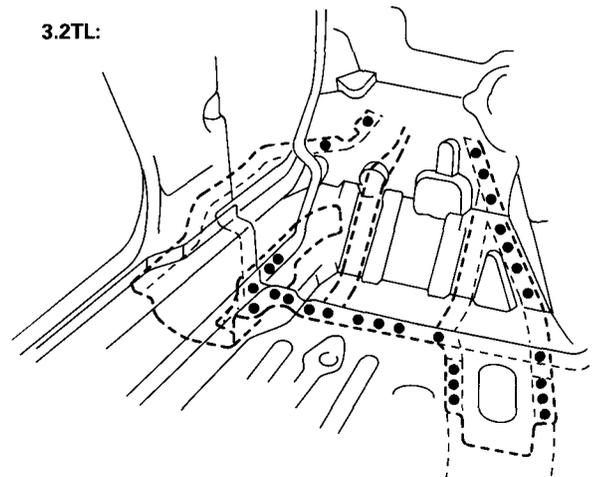
**⚠ WARNING** To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- From the passenger compartment side, weld the holes in the lower dashboard, front floor and floor frame with a MIG welder.
- Weld the front side frame and front side outrigger using MIG welds.

2.5TL:



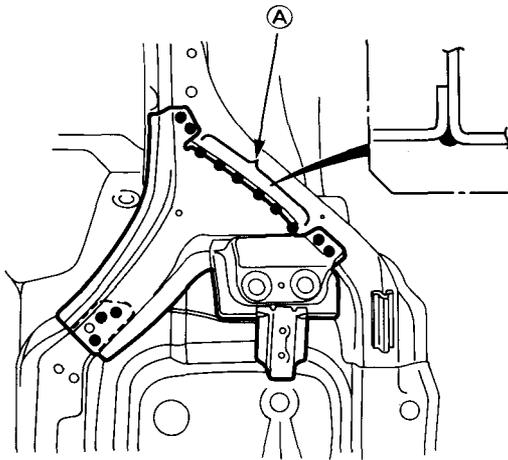
3.2TL:



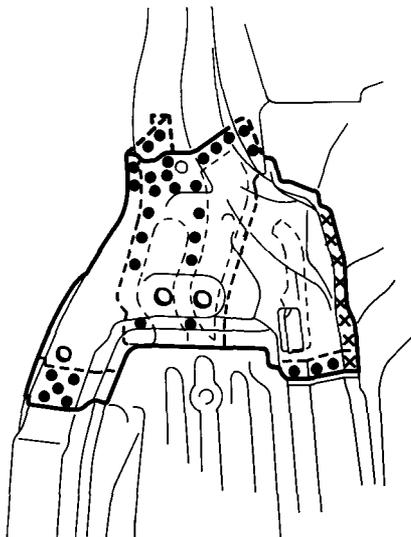
- Make 5 mm (0.2 in) holes in the MIG weld holes with the outrigger or front side extension, and weld the front side frame, floor frame and inside sill with a MIG welder.

**2.5TL:**

- Ⓐ: 6 point of MIG welding the bending angle of a flange.  
Welding pitch=30 mm (1.2 in)



**3.2TL:**



8. Apply the sealer (see [section 5](#)).  
Apply sealer to the mating surface of the lower dashboard and front floor.
9. Apply the paint.  
See Paint Repair section.

**▲ WARNING**

- **Ventilate when spraying paint.** Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.
  - **Avoid contact with skin.** Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
  - **Paint is flammable.** Store it in a safe place, and keep it away from sparks, flames or cigarettes.
10. Apply the undercoat.  
Undercoat the front floor, etc, and apply anti-rust agent to the inside of the front side outrigger and side sill (see [section 7](#)).