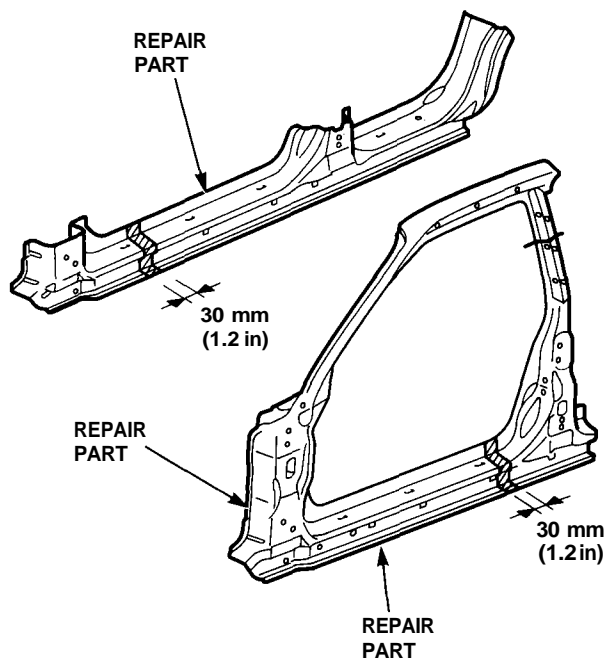


Replacement

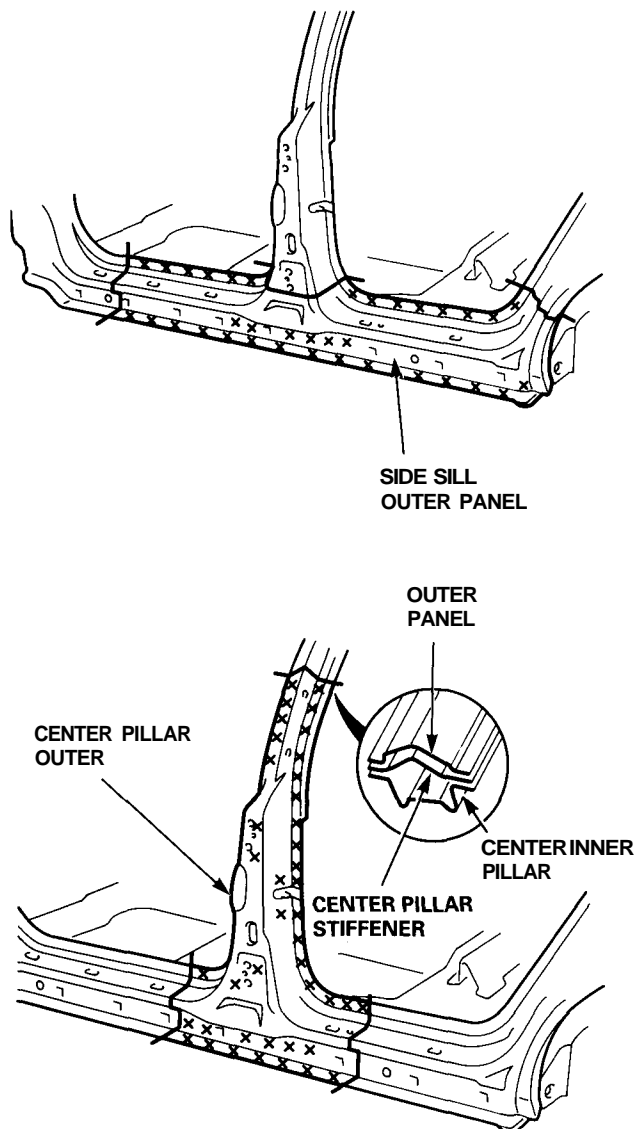
1. Remove the related parts.
 - Front and rear doors
(remove according to part damaged)
 - Side and center pillar trim
 - Door opening trim
 - Carpet
 - Door switch
 - Seat belt
2. Pull out and straighten the damaged area.
Damage may extend to the inner pillar, the inside sill and floor. Determine the extent of the damage first, so that the frame can be pulled out properly.
3. Cut and pry off the side sill.
 - Check the damage on the outer side sill, then cut the repair outer side sill so it will overlap by 30 mm (1.2 in) in the front and back.
 - Cut the side sill with a handsaw along the bold line shown in the figure to the right.

NOTE: Be careful not to cut the inside sill. This could result in extensive repair.



- If the damage involves part of the center pillar and rear wheel arch, cut them as shown with a handsaw.
- Cut the side sill with a chisel leaving the weld flanges intact.
- Center punch around the spot weld imprints on the welded flange.
- Drill holes using the spot cutter.
- Pry off the welded flange with a chisel.

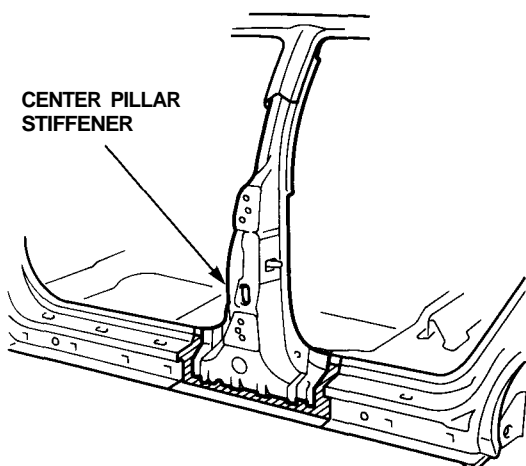
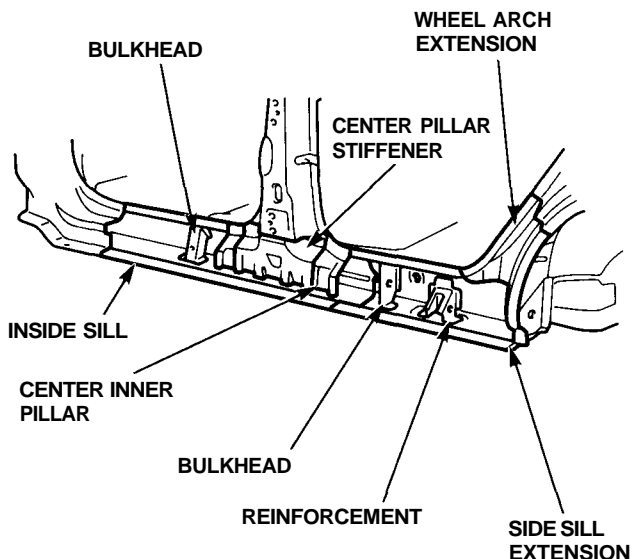
NOTE: Be careful not to let the holes penetrate down to the inner section.



(cont'd)

Side Sill (Outer Panel)

Replacement (cont'd)



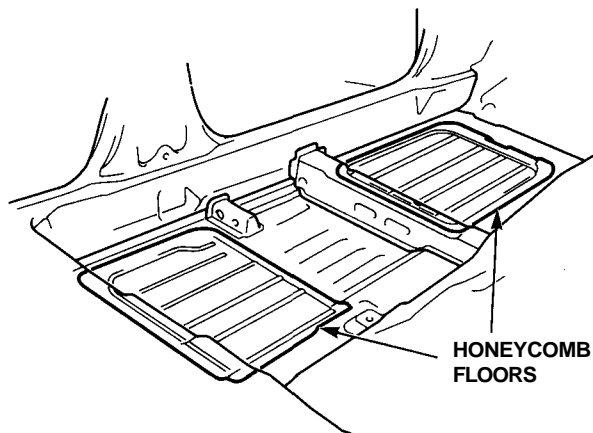
4. Mold the related parts.
 - Fill any holed areas by MIG or gas welding.

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

- Level and finish burrs at welded areas with a disc sander, then even them out with a hammer and dolly.
- Sand off the undercoat from both sides of the flange to be welded.

2.5TL:

NOTE: Check the damage of the honeycomb floors and if necessary replace it (see page 4-58).



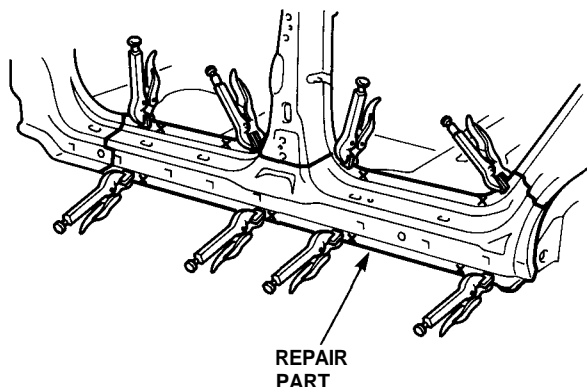
5. Set the repair part.
 - Sand off the undercoat from both sides of the welded flange on the repair part.
 - Clamp the repair part in place with vise-grips.

NOTE: Apply the spot sealer to the welding surface when spot welding.

- Check the body dimensions (see section 6).

6. Tack weld the repair part.

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

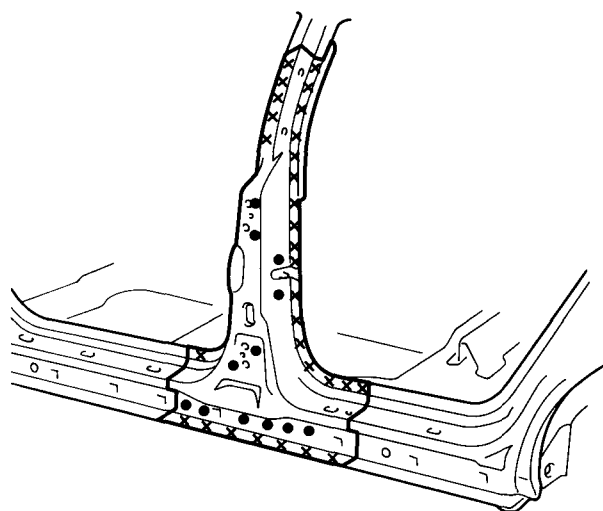
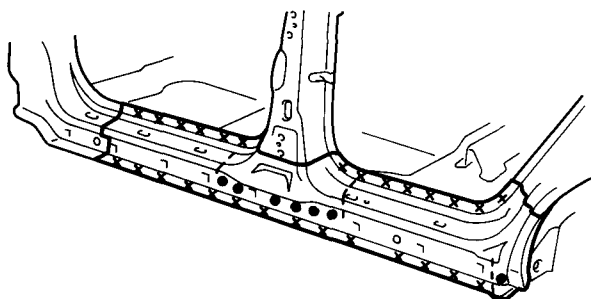


- Remove the vise-grips and install the fender and doors. Check for differences in level and clearance.

7. Perform main welding.

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

- Weld the side sill and rear side outer joints with a MIG welder.
- Spot weld the side sill flanges.
- Make 20% to 30% more spot welds than there were holes drilled.
- Make 5 mm (0.2 in) holes in the MIG weld holes with the repair part, and weld the center pillar stiffener and wheel arch extension with a MIG welder.
- Level the weld beads at the front and rear with a disc sander. Hammer down the projections, then fill with solder or putty to finish it.



8. Apply the sealer.

Apply sealer to the mating surfaces of the floor and inside sill (see [section 5](#)).

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, and apply an anti-rust agent to the inside of the side sill and center pillar (see [section 7](#)).

11. Install the related parts.

- Install in the reverse order of removal.
- Check the door for proper installation and level differences from the fenders.

12. Clean and check.

Clean the passenger compartment and check for water leaks.