

870926

Rocker Panel Reinforcement Sectioning - Inner

Removal Procedure

Caution: To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

Caution: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

Caution: When performing service on or near the SIR components or the SIR wiring, the SIR system must be disabled. Refer to SIR Disabling and Enabling Zones. Failure to observe the correct procedure could cause deployment of the SIR components, personal injury, or unnecessary SIR system repairs.

1. Disable the SIR system.

Caution: Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect the negative battery cable. Failure to follow these precautions may cause personal injury and/or damage to the vehicle or its components.

2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damaged area as possible. Refer to *Dimensions - Body* on page 3-7.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.

Important: Do NOT section through any holes in the inner rocker panel.

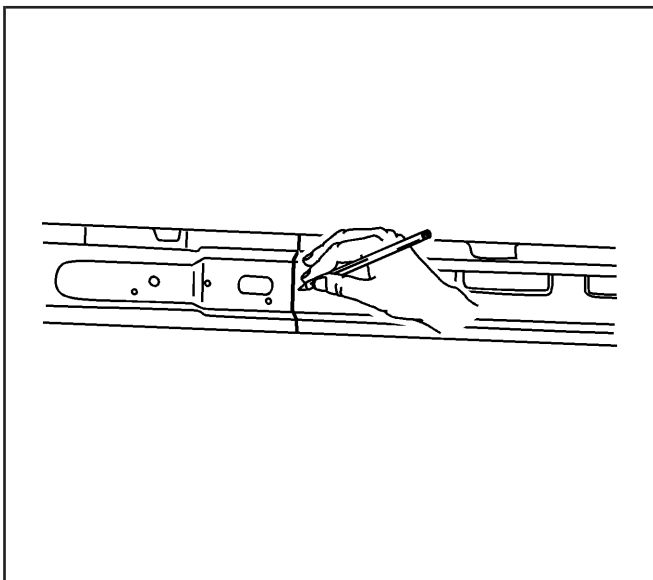
6. Measure from any key feature on the panel. Lay out the cut line location on the inner rocker panel reinforcement.

Important: Note the number and location of the factory welds for installation of the inner rocker panel reinforcement.

7. Locate and drill out all the necessary factory welds.

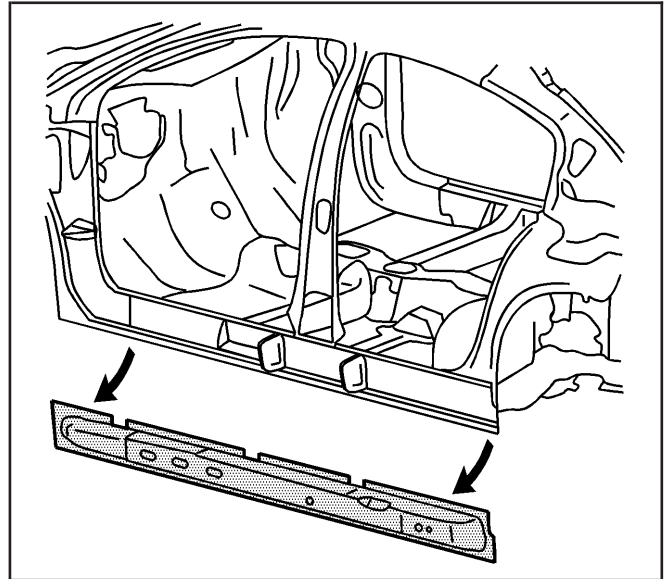
Important: When you multi-layer sectioning areas in 2 or more panels, place the sectioning cut lines at least 100 mm (4 in) apart.

8. Cut at the laid out cut line location.



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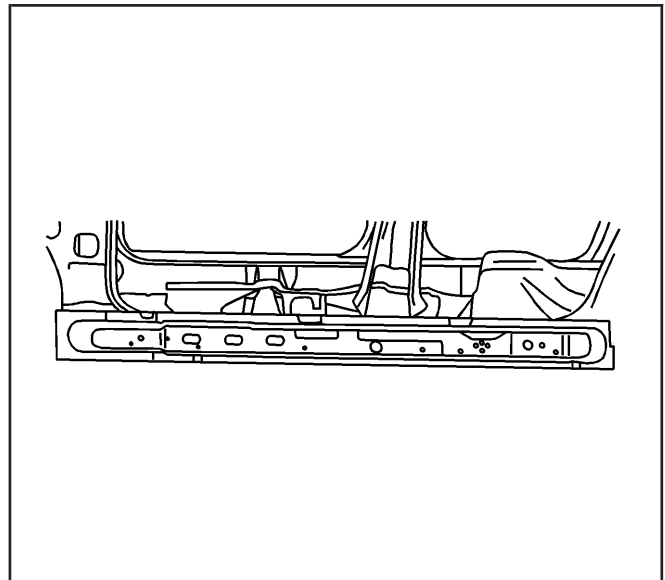
9. Remove the damaged portion of the inner rocker panel reinforcement.



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Installation Procedure

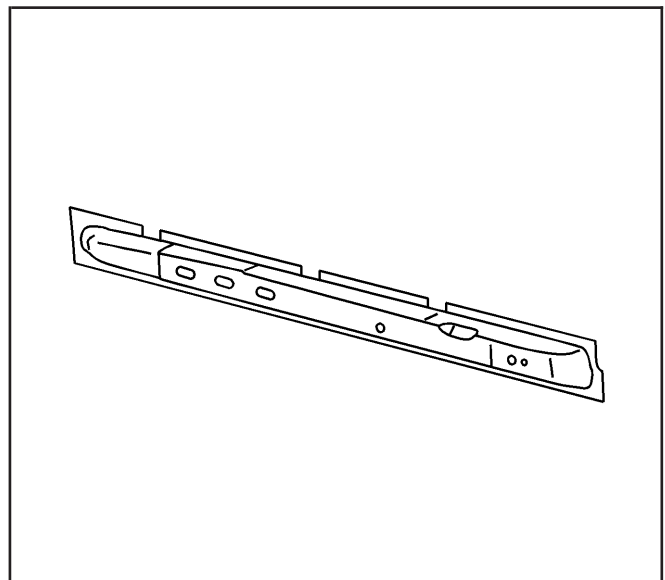
1. Measure and lay out the cut line on the service panel in the same location as the original panel.
2. Cut the panel at the lines laid out in the previous step.



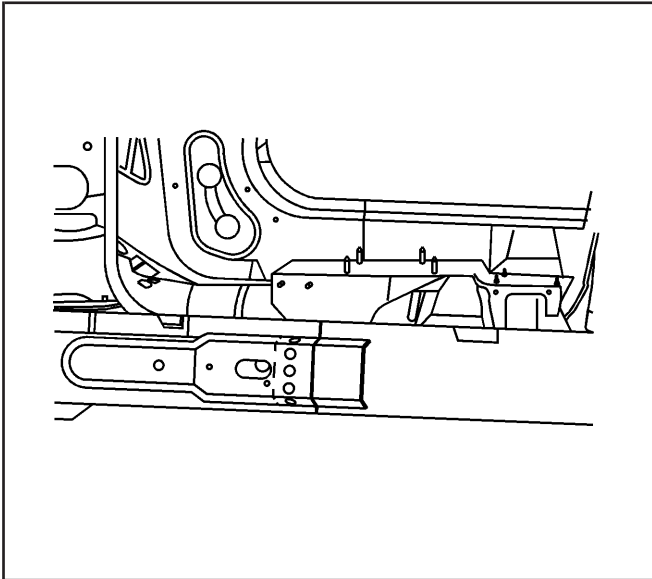
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Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart.

3. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the corresponding locations noted on the original panel.
4. Prepare all mating surfaces for welding as necessary.
5. Apply 3M[®] Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.
6. Drill 8 mm (5/16 in) plug weld holes in the inner rocker panel reinforcement at the cut line location and 10 mm (0.4 in) rearward of the edge of the panel.
7. Cut a 100 mm (4 in) section of reinforcement from the unused section of the service part to be used as a welding backer. Trim as necessary to ensure a snug fit.

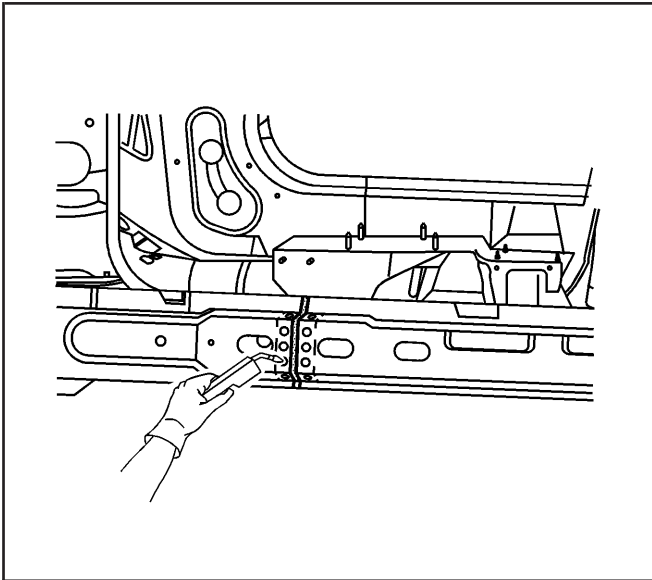


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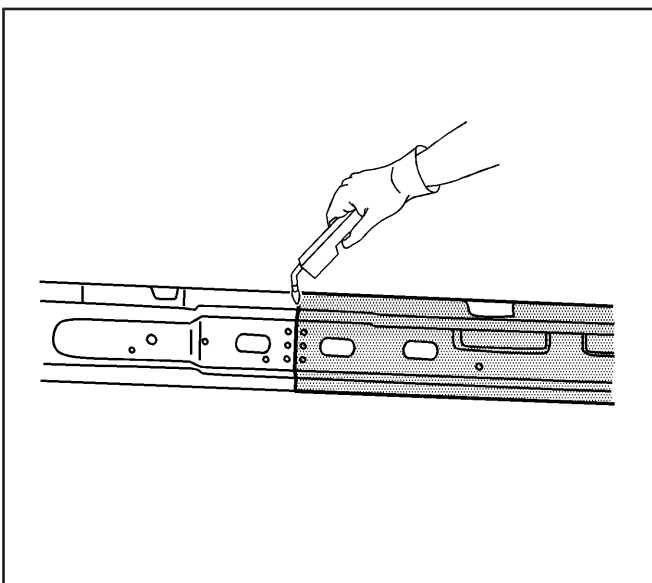
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8. Place the welding backer into the rocker panel backer reinforcement. Insert the welding backer about 50 mm (2 in), or about half-way.
9. Clamp the welding backer in place and weld at the plug weld locations.



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10. Cut the outer center pillar in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of $1\frac{1}{2}$ times the metal thickness at the sectioning joint.
11. Position the reinforcement to the vehicle. Clamp the reinforcement in place.
12. Stitch weld along the sectioning area at the butt weld location. Make 25 mm (1 in) stitch welds with 25 mm (1 in) between each weld. Complete the stitch weld.



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13. Plug weld accordingly.
14. Clean and prepare all of the welded surfaces.
15. Install all of the related panels and components.
16. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
17. Paint the repaired area.
18. Connect the negative battery cable.
19. Enable the SIR system.