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2020.0 DEFENDER (LE), 501-29

SIDE PANEL SHEET METAL REPAIRS

ROCKER PANEL INNER - 90 (G2452614)

mcx30.com

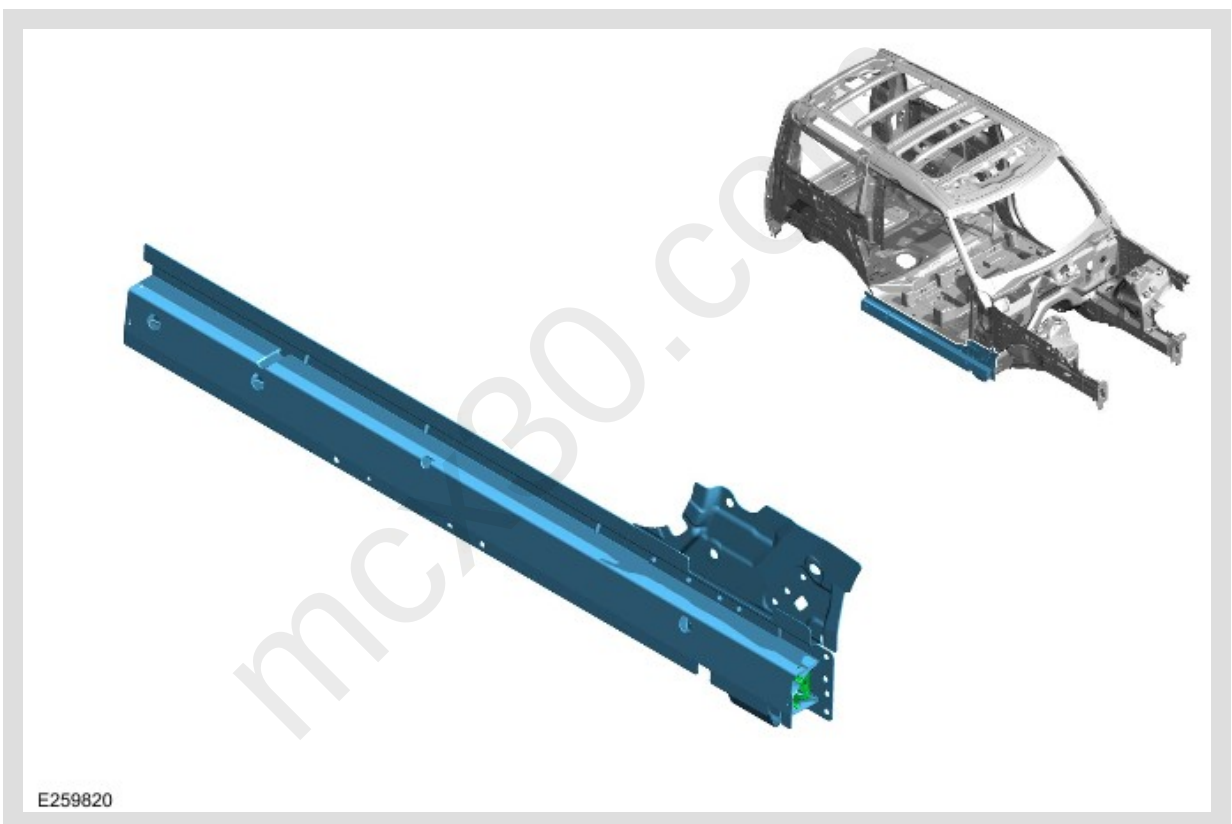
REMOVAL

 NOTE:

In this procedure the rocker panel inner assembly is installed in conjunction with:

- B-Pillar inner panel lower.

1.



The rocker panel inner assembly is serviced as indicated.

2.

Before commencing this procedure make sure that you are aware of all Health and Safety requirements. Refer to: [Health and Safety Precautions](#) (100-00 General Information, Description and Operation).

3.

NOTES:

- Where Breakstem Fastener (BSF) removal is instructed remove the fastener shaft with a 4 mm punch and remove the head with a 6.5 mm drill bit. Clean all the drilled holes to make sure they are free from debris.
- Where Self Piercing Rivet (SPR) removal is instructed use either the Jaguar Land Rover (JLR) approved SPR tool or a 5.3 mm drill bit. Clean all the drilled holes to make sure they are free from debris.
- Any joints sealed as part of vehicle manufacture must be sealed as part of the repair.
- To make sure that the vehicle is correctly aligned it must be placed on a JLR approved alignment jig.

When installing the rocker panel inner assembly make sure that you are aware of the methods, tools and fixings used in this procedure.

Refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).

Refer to: [Adhesives, Fixings and Consumables](#) (501-25A Body Repairs - General Information, Description and Operation).

4.

For additional information

Refer to: [Specifications - 110](#) (501-29 Side Panel Sheet Metal Repairs, Specifications).

5.

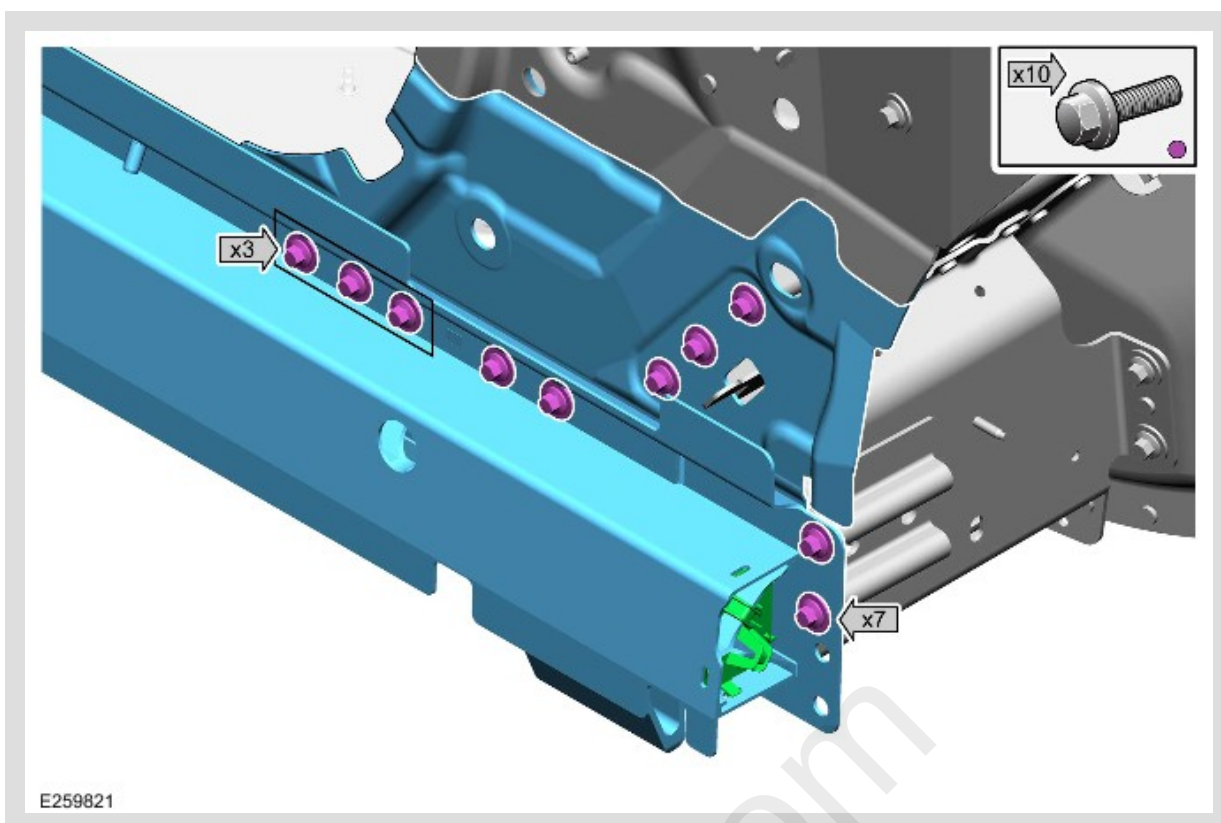
For additional removal information.

Refer to: [B-Pillar Inner Panel Lower - 90](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

6.

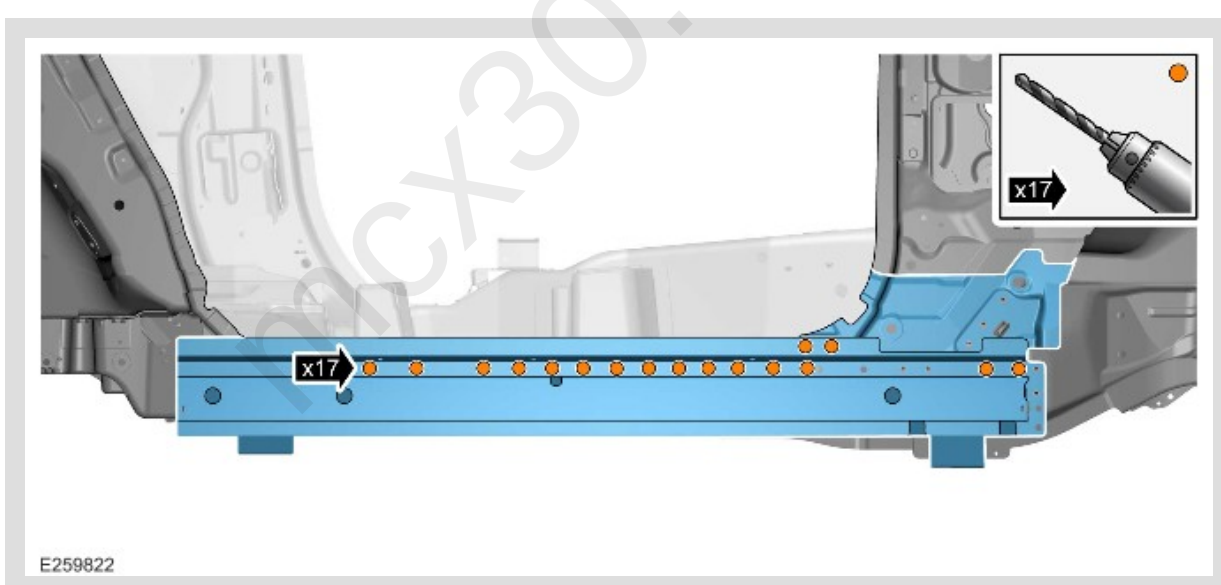
Release and position the wiring harness to one side.

7.



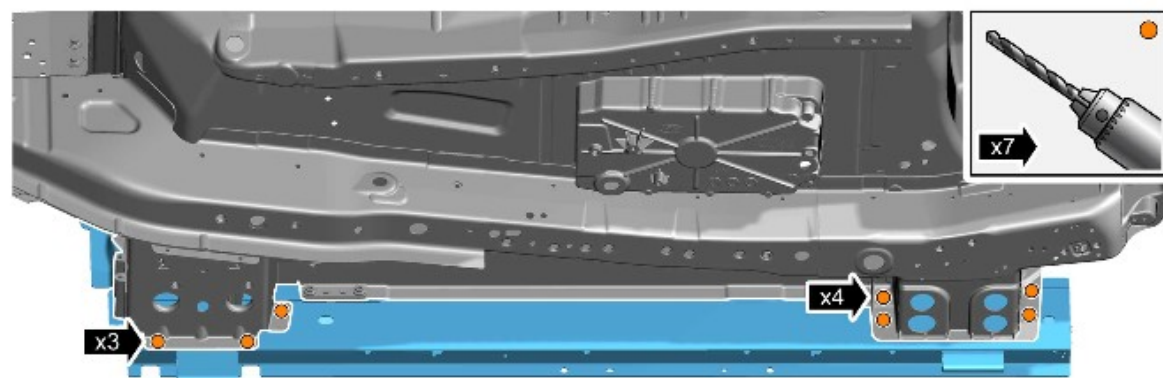
Remove the bolts as indicated.

8.



Remove the Self Piercing Rivets (SPRs) as indicated.

9.

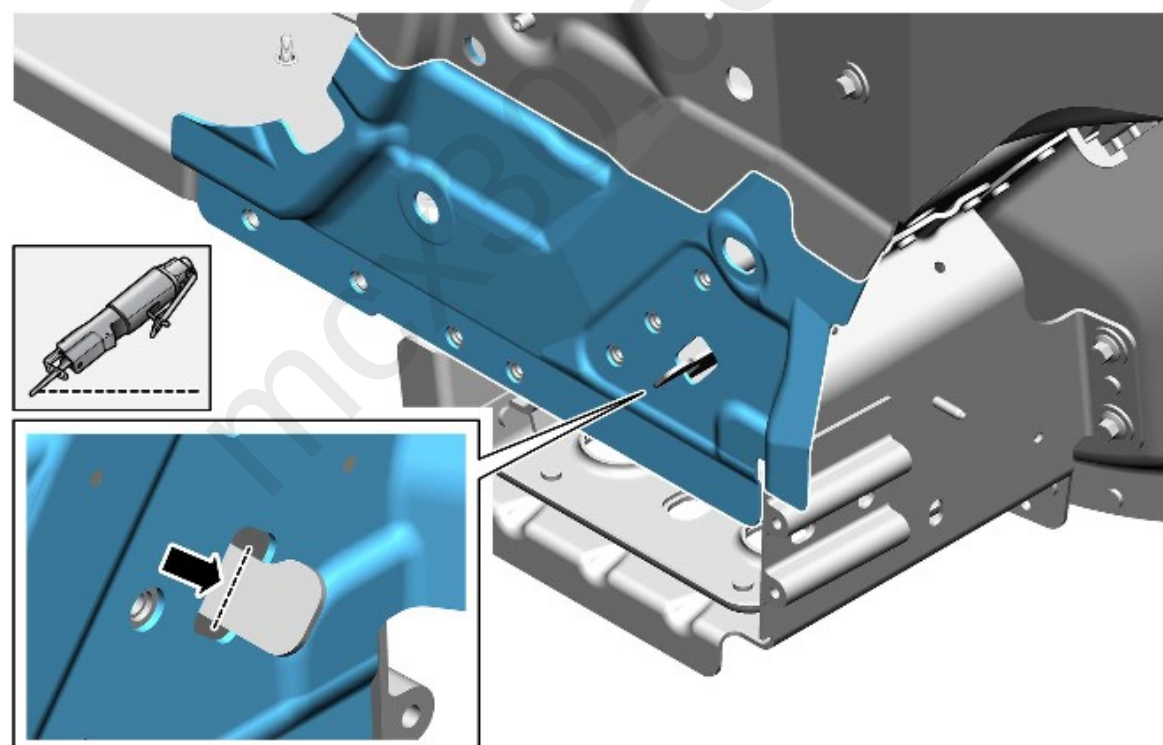


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Remove the SPRs as indicated.

10. Carefully separate the joints and remove the rocker panel inner.

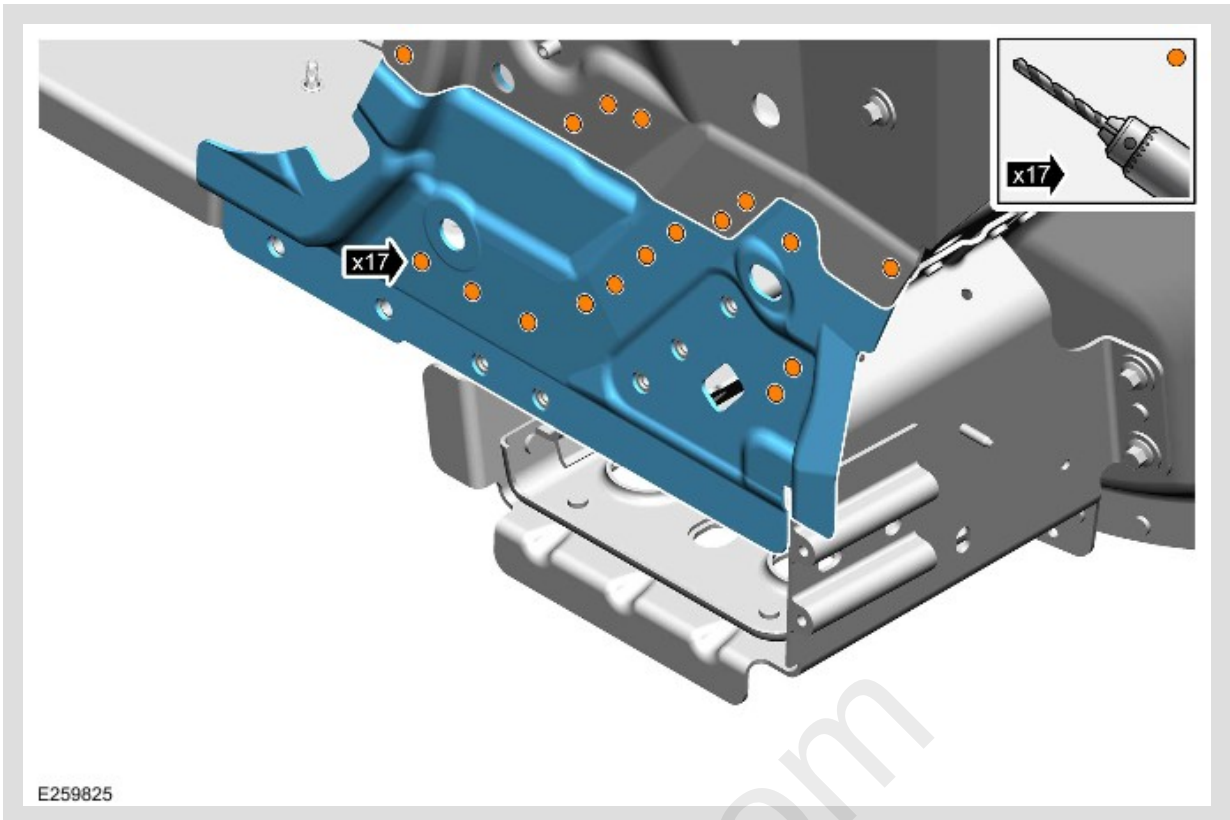
11.



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Mark and cut the location tab as indicated.

12.



Remove the SPRs as indicated.

13. Carefully separate the joints and remove the fender apron panel reinforcement lower.

INSTALLATION

⚠ CAUTION:

Where structural adhesive is to be applied between surfaces it is essential compression is applied to the joints during the curing period.

△ NOTES:

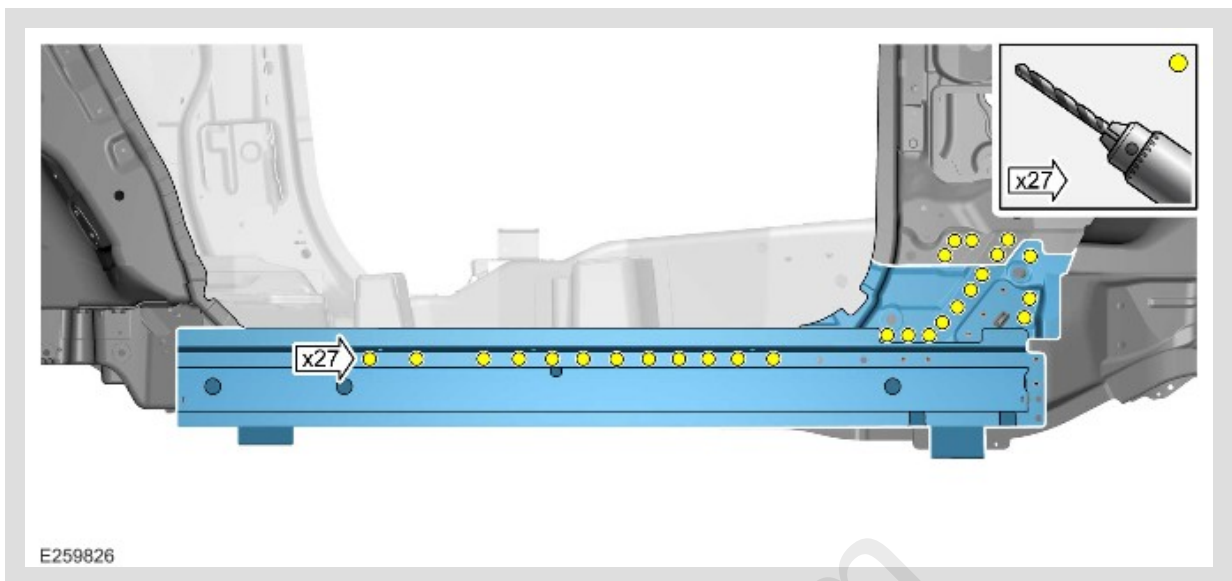
- Breakstem Fastener (BSF) installation involves using the JLR approved BSF installation tool and requires a hole diameter of 6.5 mm.
- Self Piercing Rivet (SPR) installation requires using the JLR approved SPR tool.

1. Remove the rivet remnants.

2. Dress the flanges where necessary.

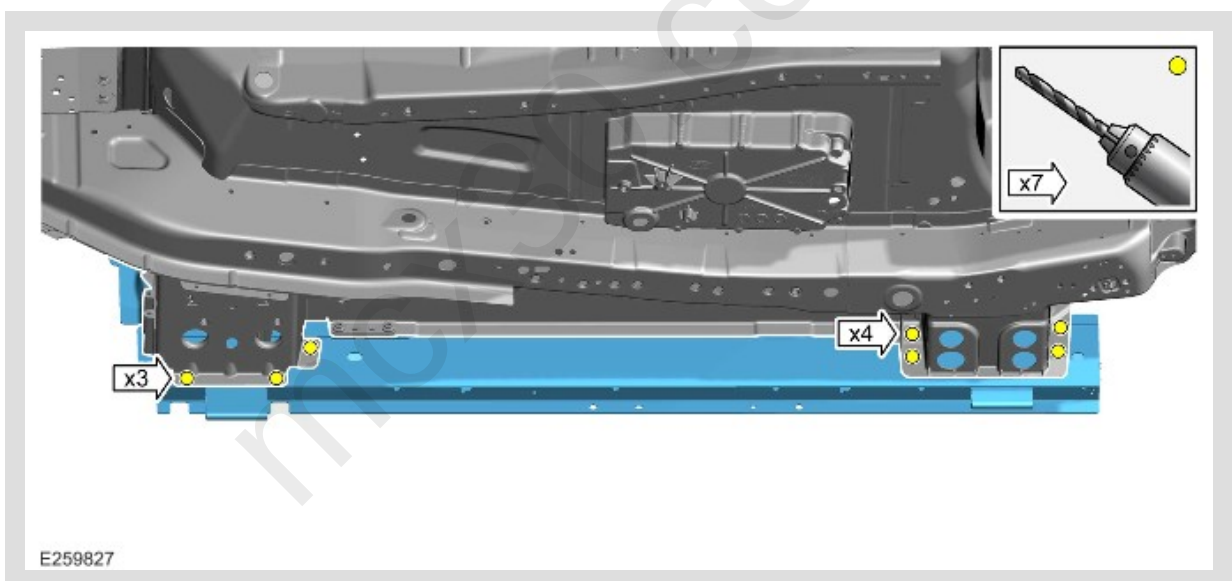
3. Offer up the new rocker panel inner assembly and clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

4.



Drill holes where the Breakstem Fasteners (BSFs) are to be installed as indicated.

5.



Drill holes where the BSFs are to be installed as indicated.

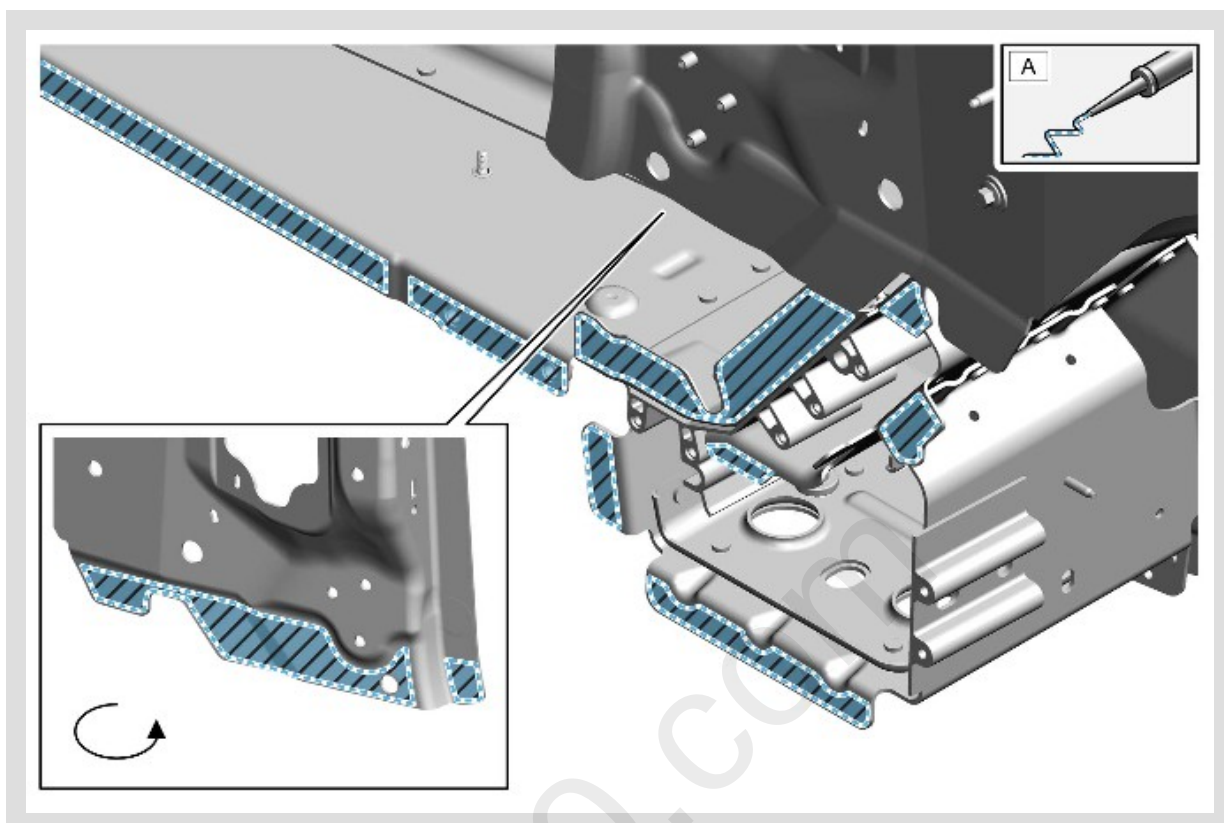
6. Remove the new rocker panel inner assembly.

7. Deburr the drilled holes.

8. Clean and prepare the panel surfaces.

NOTE:

Make sure a continuous bead of adhesive surrounds the fixing holes.

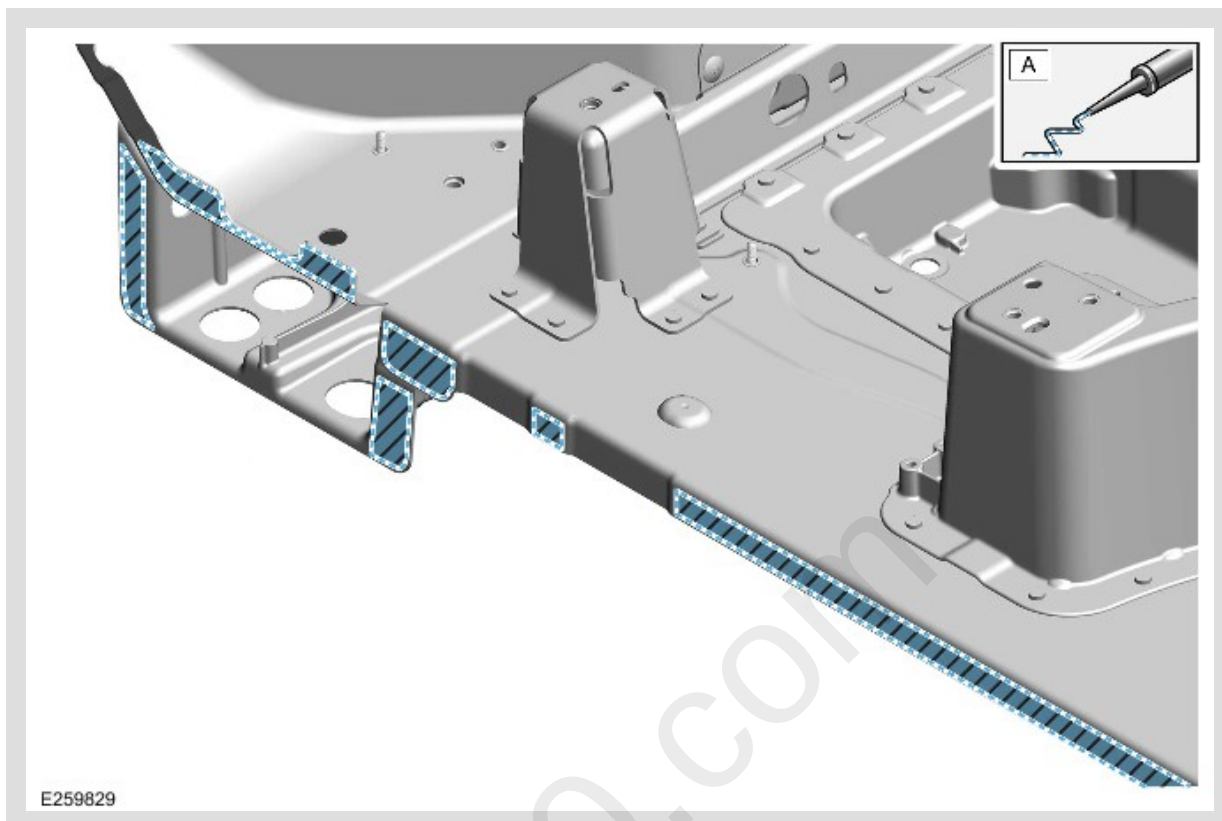


Apply a 5 mm zig zag bead of the JLR recommended bonding material as indicated.

10.

 NOTE:

Make sure a continuous bead of adhesive surrounds the fixing holes.



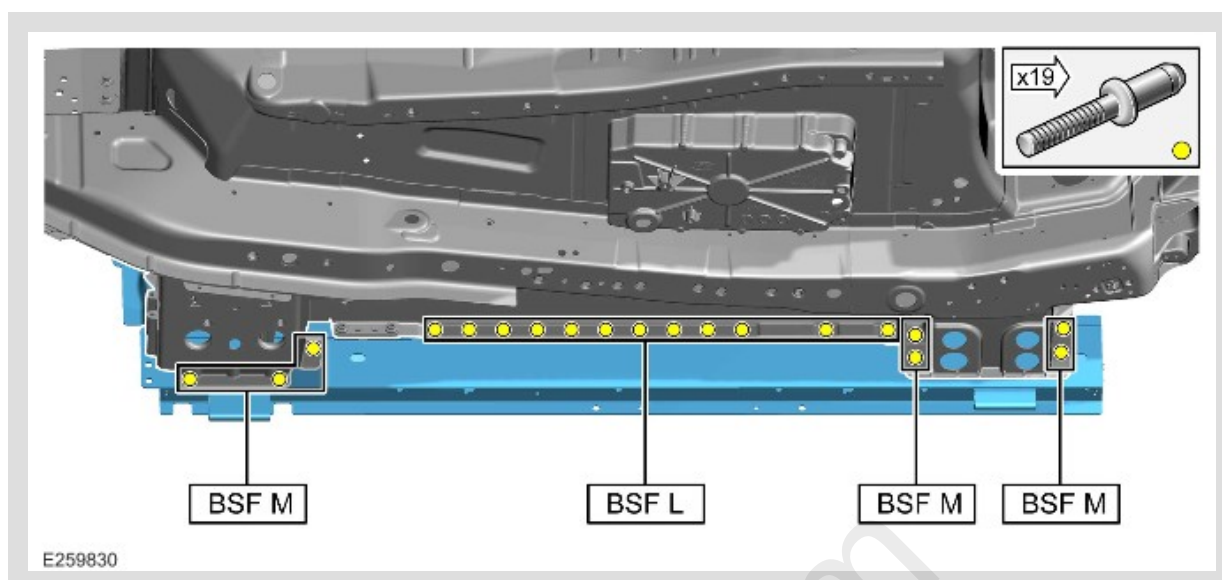
Apply a 5 mm zig zag bead of the JLR recommended bonding material as indicated.

11. Offer up the new rocker panel inner assembly and clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

12.

NOTE:

Make sure the Breakstem Fasteners (BSFs) are installed from the inside.

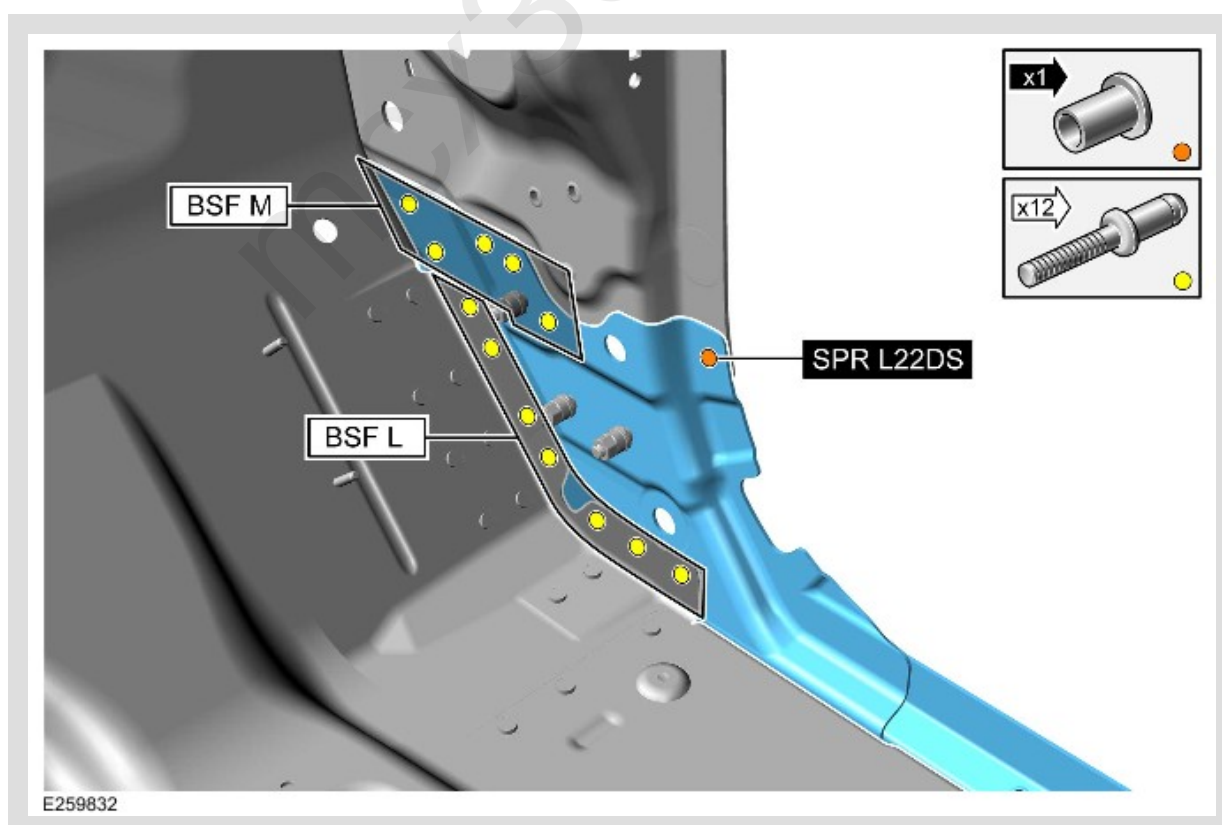


Install the BSFs as indicated.

13.

NOTE:

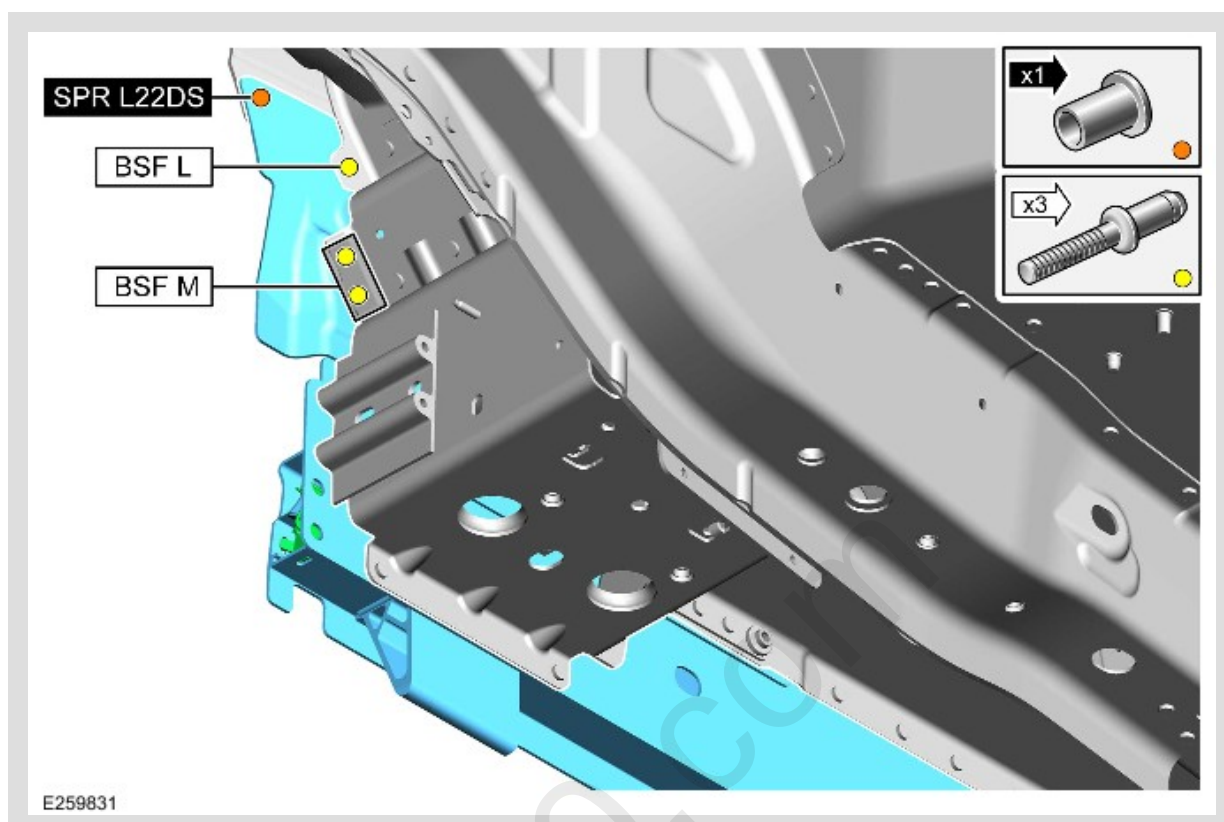
Make sure the Breakstem Fasteners (BSFs) are installed from the inside.



Install the BSFs and Self Piercing Rivet (SPR) as indicated.

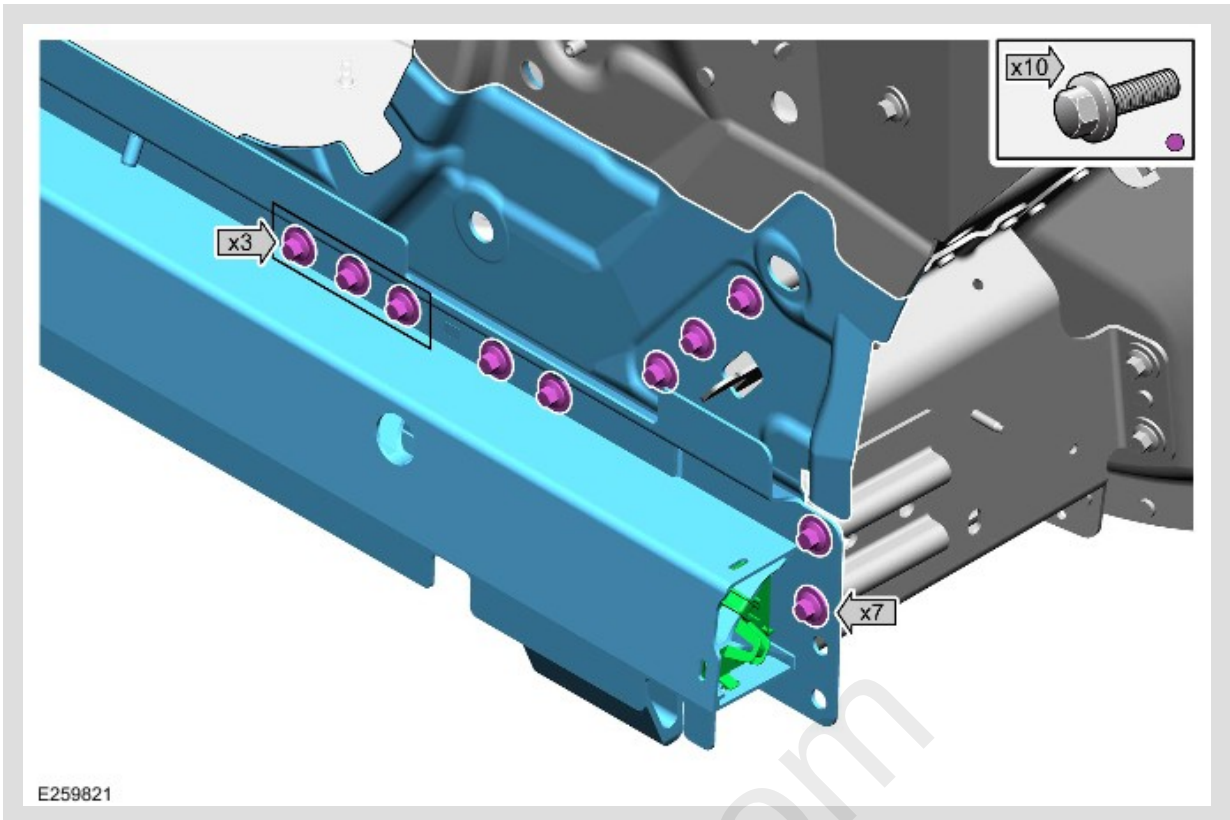
 NOTE:

Make sure the Breakstem Fasteners (BSFs) are installed from the inside.



Install the BSFs and SPR as indicated.

15.



Install the bolts and tighten.

Torque

M10 x 3: **60Nm**

M8 x 7: **25Nm**

16. Remove any excess adhesive.

17. Make sure that any open or exposed panel joints are correctly sealed.

18. Make sure corrosion protection is applied to all areas affected by the repair.

19. Make sure that all installed BSFs and SPRs are sealed using a JLR recommended sealer.

NOTE:

The installation of associated panels and components is the reversal of the removal procedure.

20. For additional installation information.

Refer to: [B-Pillar Inner Panel Lower - 90](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

