

Rocker Panel - Regular Cab

Special Tool(s) / General Equipment

6.5 mm Drill Bit
Scraper for Straight Edges
Polydrive Bit Socket
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Hot Air Gun
Locking Pliers

Materials

Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M [®] , 08115, LORD Fusor [®] 108B	-
Seam Sealer TA-2-B, 3M [®] , 08308, LORD Fusor [®] 805DTM	-

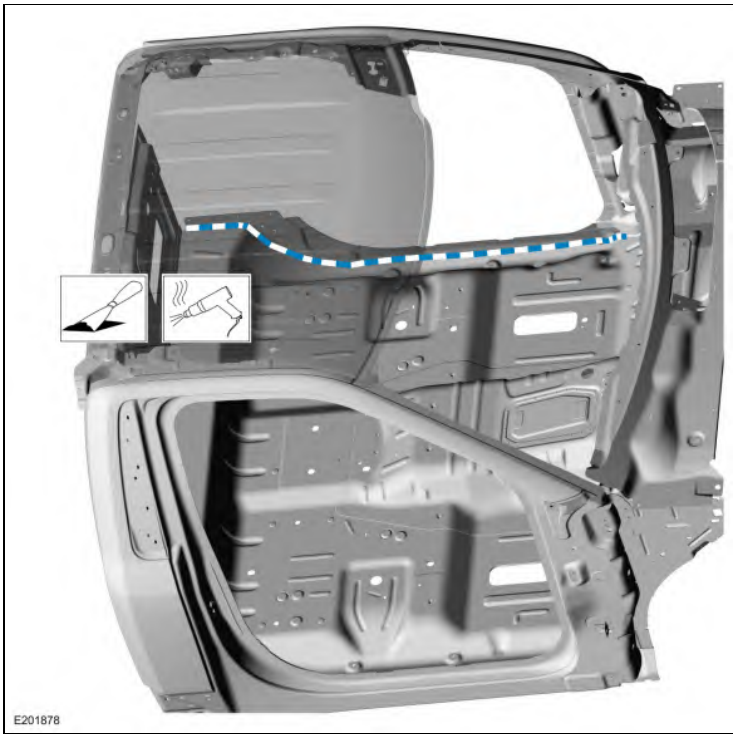
Removal

NOTICE: Body side sectioning is prohibited within 50 mm of door hinge, door striker and restraints anchoring points.

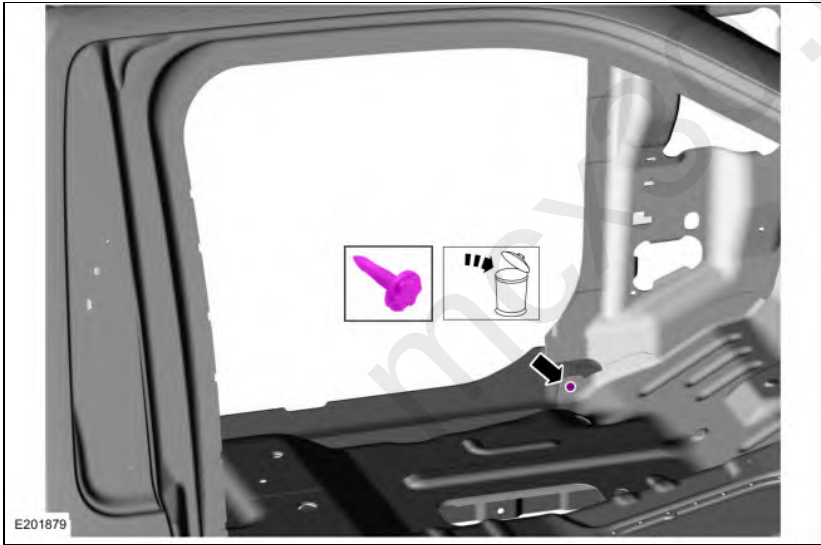
NOTE: Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425.4° F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

NOTE: The rocker panel may be sectioned at any point providing restraints, door hinge and door striker restrictions are met. Adjust sectioning point to meet repair requirements. The following procedure assumes full component replacement.

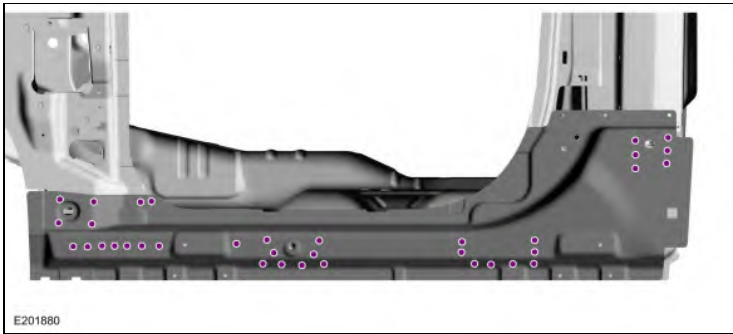
1. Remove the rocker panel reinforcement.
Refer to: Rocker Panel Inner Reinforcement - Regular Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
2. Remove the safety belt and shoulder height adjuster.
Refer to: Front Seatbelt Retractor and Pretensioner - Regular Cab (501-20A Seatbelt Systems, Removal and Installation).
Refer to: Seatbelt Shoulder Height Adjuster - Regular Cab (501-20A Seatbelt Systems, Removal and Installation).
3. Remove the C-pillar.
Refer to: C-Pillar Reinforcement (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
4. Remove the seat.
Refer to: Front Seat (501-10A Front Seats, Removal and Installation).
5. Position aside the carpet and wiring harness.
6. Remove the floor pan to rocker panel seam sealer.
Use the General Equipment: Scraper for Straight Edges
Use the General Equipment: Hot Air Gun



7. Remove and discard the rocker panel to A-pillar FDS fastener.
Use the General Equipment: Polydrive Bit Socket



8. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander

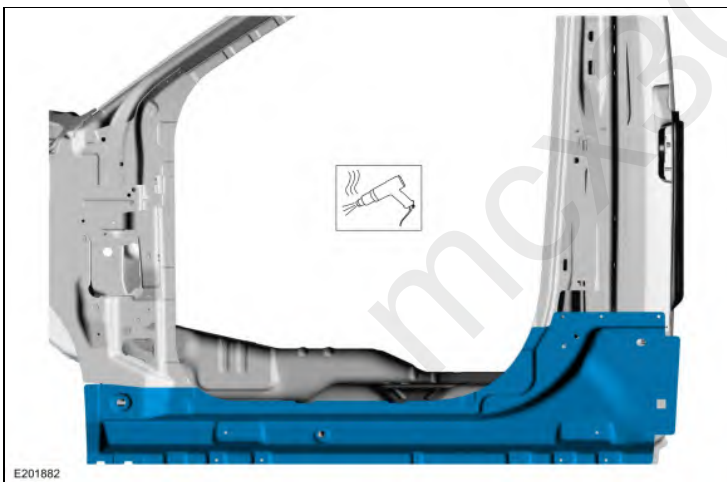


9. Remove the floor pan to rocker panel SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



10. **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425°F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

Break the adhesive bond and remove the rocker panel.
Use the General Equipment: Hot Air Gun



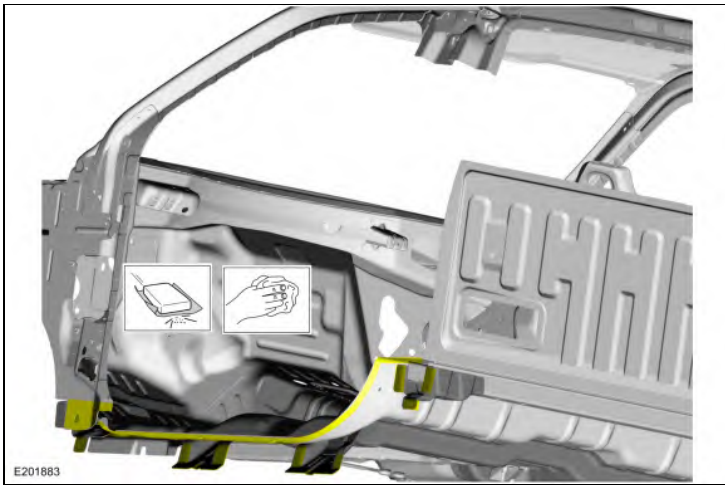
Installation

NOTICE: Body side sectioning is prohibited within 50 mm of door hinge, door striker and restraints anchoring points.

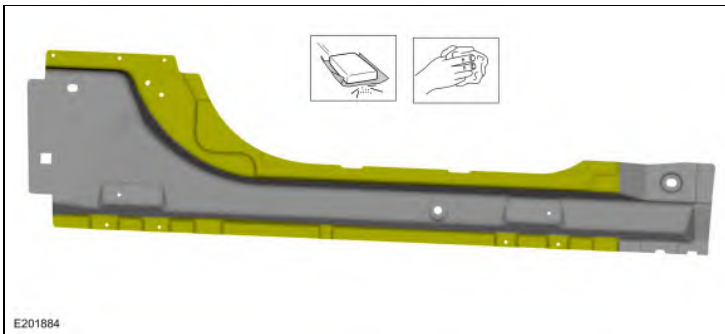
NOTE: SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

NOTE: Blind rivet or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

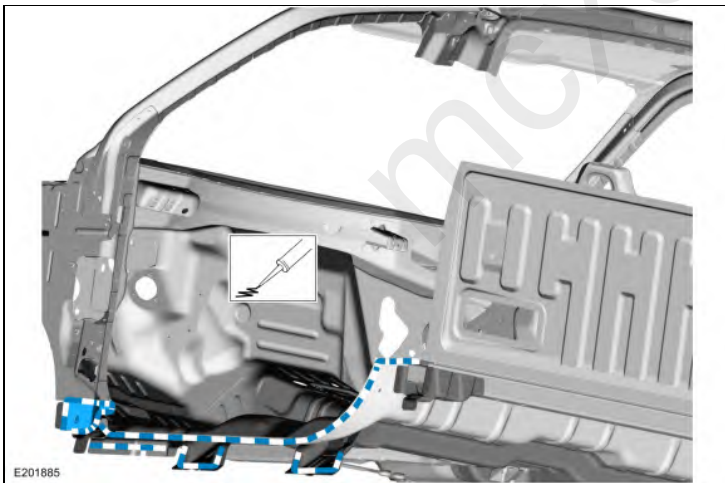
- 80-120 grit sand paper.
Sand to remove old adhesive and clean.



2. 80-120 grit sand paper.
Sand to remove e-coat on the mating surface and clean.

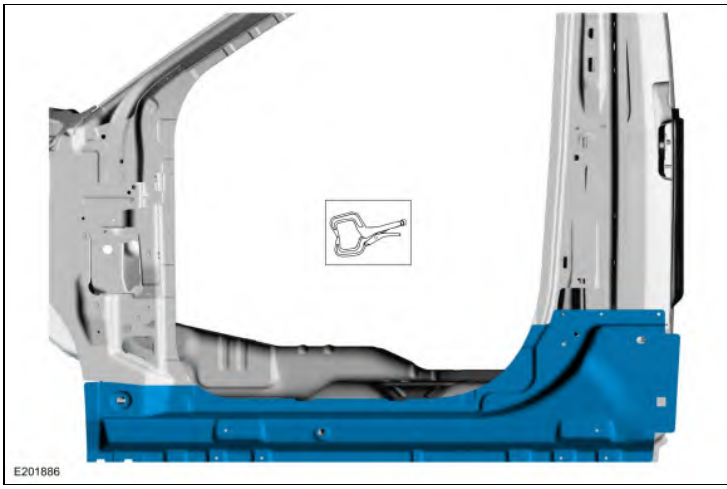


3. Apply adhesive.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M[®] 08115, LORD Fusor[®] 108B



4. Install the rocker panel and clamp in position.
Use the General Equipment: Locking Pliers





5. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



6. **NOTE:** Blind rivet or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Install fasteners.

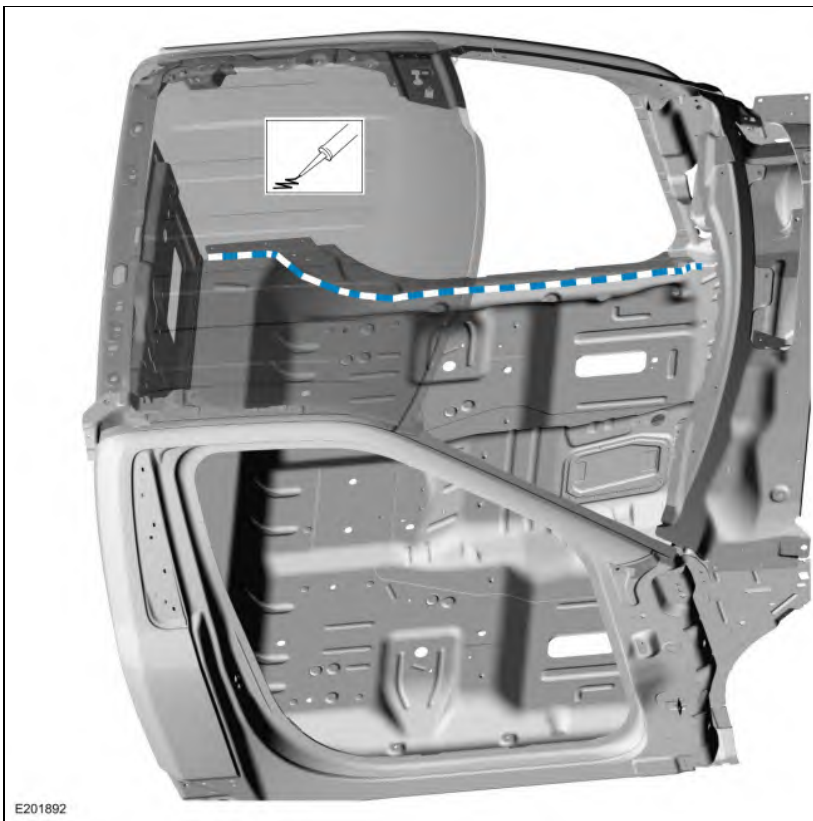
Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W702554-S900C	-	-

Use the General Equipment: Blind Rivet Gun



7. Install the C-pillar reinforcement.
Refer to: C-Pillar Reinforcement (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
8. Sealing work:
All areas must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M, 08308, LORD Fusor® 805DTM

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9. Install the rocker panel reinforcement.
Refer to: Rocker Panel Inner Reinforcement - Regular Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
10. Install the C-pillar outer panel.
Refer to: C-Pillar Reinforcement (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
11. Install the safety belt and shoulder height adjuster.
Refer to: Front Seatbelt Retractor and Pretensioner - Regular Cab (501-20A Seatbelt Systems, Removal and Installation).
Refer to: Seatbelt Shoulder Height Adjuster - Regular Cab (501-20A Seatbelt Systems, Removal and Installation).
12. Reposition the wiring harness and carpeting.
13. Install the seat.
Refer to: Front Seat (501-10A Front Seats, Removal and Installation).

