

Frame Repair & Component Replacement

Introduction This chapter will clarify Toyota's position on key frame repair and frame component replacement topics. As we discussed in chapter 4, following structural repair precautions and specifications will help repairers make the best decisions about frame repairs. Toyota establishes high repair standards and precautions to address safety and quality issues for frames just as they do with unibodies. Compromising on a repair because of cost or cycle time is not the right decision for the vehicle, the customer, or the repair shop.

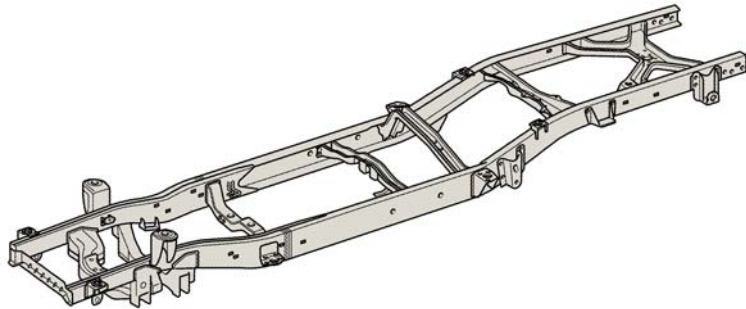


Figure 7-1
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Frame Repair Precautions

Toyota strongly believes that equipment provider training is a necessary component of repairing frames and recognize those training programs as expert information on the use of their respective products. However, we caution that they are not a vehicle manufacturer and may not always be aware of or endorse vehicle manufacturer repair precautions. The following is an overview of documented frame repair precautions:

- Do not use heat to stress relieve frame components.
- Do not repair frame kinks.
- Do not use used/salvage replacement components.
- Do not section frame components by methods other than those specified.

Remember to use common sense and exercise good judgment when performing frame repairs. Avoid extended welding operations that produce heat spread, and grinding that reduces weld strength. Weld-through primer is not usually necessary when welding frame components, but be sure to clean the area and apply corrosion protection in the form of epoxy primer or paint when repairs are complete.

Frame Component Replacement

When it becomes necessary to replace frame components, they should be installed by approved procedures. If component specific procedures are not available and a new genuine Toyota service part is, follow recommendations from Collision Repair Information Bulletin (CRIB) # 136. Toyota recommends the use of only new Toyota Genuine service parts for frame component replacement. Typical frame components that may require replacement are Body Mounts, Cross Members, Mounting Flanges, and Suspension Mounts.

- Welded components can be attached using GMAW methods.
- Riveted components can be replaced or reattached with bolts.

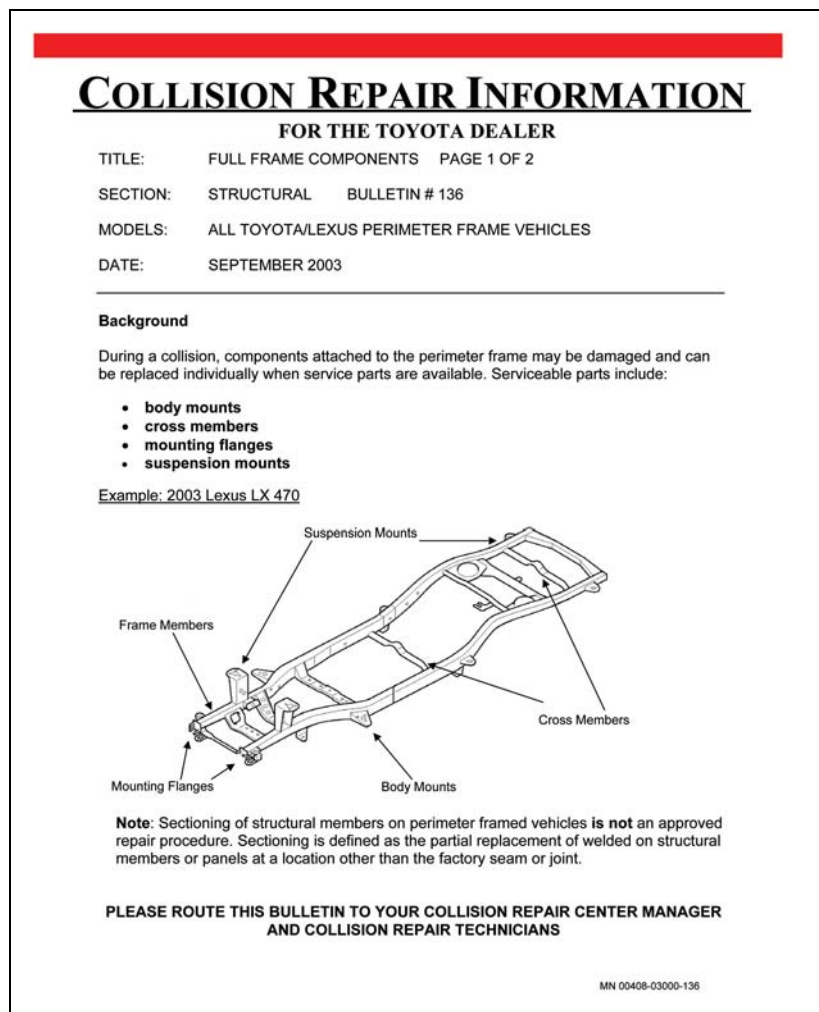


Figure 7-2
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Note For more information on riveted frame component attachment refer to CRIB #136 and to I-CAR Uniform Procedures for Collision Repair (UPCR) SPS11S, 9.5

Summary & Key Point Review

All Toyota frames are made from High Strength Steel and have specific repair and component replacement requirements. Collision repair professionals must be knowledgeable in all aspects of approved Toyota frame repair and component replacement procedures to make the right repair decisions.

Chapter Review Questions

1. Frame components should be installed by _____ procedures.
2. Toyota recommends the use of only _____ Toyota Genuine service parts for frame component replacement.
3. Do not _____ frame components by methods other than those specified.
4. Common frame components that require replacement are body mounts, crossmembers, _____ and suspension mounts.
5. More information on riveted frame component attachment can be found in I-CAR Uniform Procedures for Collision Repair (UPCR) _____ .