

# COLLISION REPAIR INFORMATION

## FOR THE TOYOTA DEALER

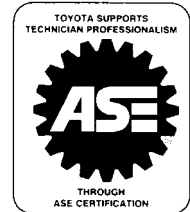
TITLE: FLOOR SILENCER SHEETS

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SECTION: STRUCTURAL REPAIR BULLETIN #43

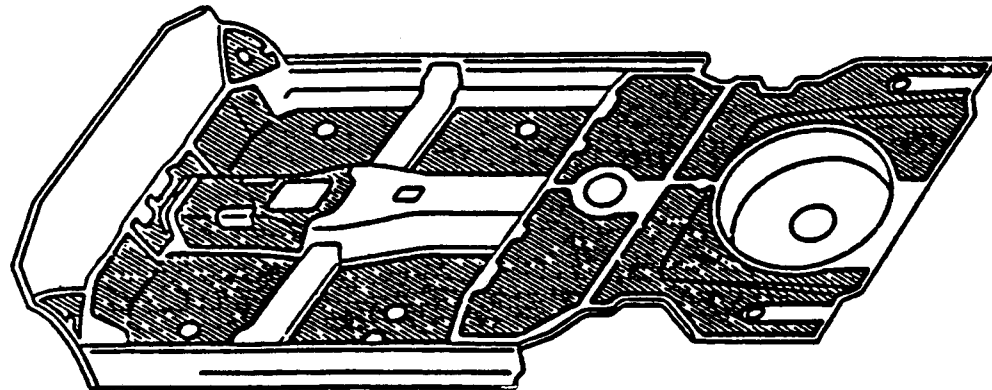
MODELS: ALL

DATE: APRIL 1991



When a vehicle sustains a severe side or rear impact, the sound silencers may become dislodged, torn, or broken. The silencer sheets are important to the quietness of the vehicle. Therefore, it is essential that the repaired areas have these silencers in place. Illustrations in this bulletin show where these silencers are located. Proper installation of these materials will eliminate unwanted noise that may be transmitted into the cabin.

### EXAMPLE OF FACTORY SILENCER SHEETS



### MATERIALS USED

<u>PART NAME</u>	<u>MAKE</u>	<u>SIZE</u>	<u>PART NO.</u>
Floor Silencer	Genuine	1,100 mm x 800 mm x 3 mm	58651-22H91
Sheet	Part	1,100 mm x 800 mm x 1.5 mm	58651-22H90

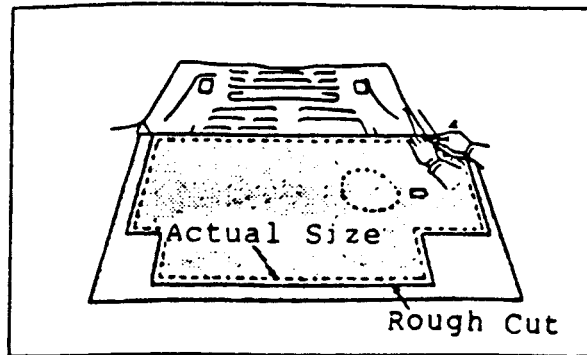
  

<u>PART NAME</u>	<u>MAKE</u>	<u>CONTAINER SIZE</u>	<u>PART NO.</u>
General Trim Adhesive (Spray)	3M	24 oz. aerosol	051135-08080

**PROCEDURE**

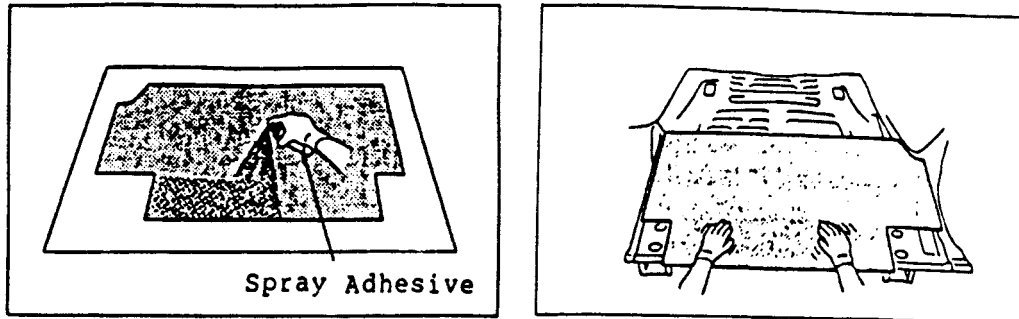
Use the original silencer sheet as template to make a new sheet. Use a heat gun to remove the original sheet. This operation is best performed when ambient temperatures are greater than 40° F. Cut the new sheet slightly larger than the original using scissors, box cutter, or other suitable device. Use caution with all cutters to avoid injury.

**CAUTION:** Too much heat will result in burning the material, rendering it useless.



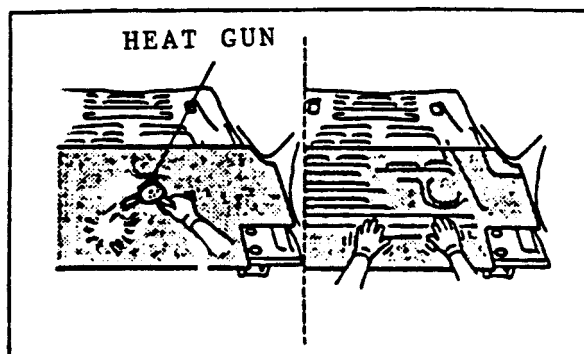
The floor pan MUST be cleaned properly for the new silencer sheet to remain permanently affixed to the metal. Remove all dirt, oil, grease, etc. Vacuum out the floor pan to remove the dust. Use a wax and grease remover to remove oil and grease.

Apply adhesive to the back side of the silencer sheet and sheet metal areas. Allow it to air dry for a short period of time. Press the silencer down into place by hand.

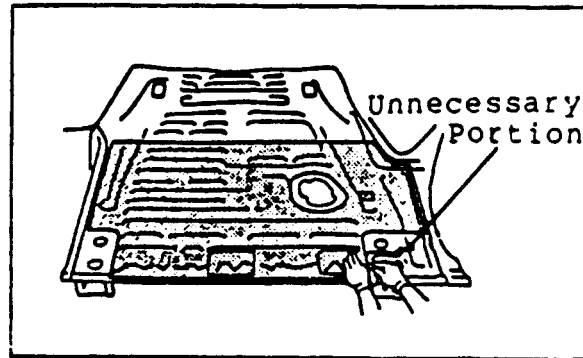


Use a heat gun to evenly heat the floor silencer sheet over the entire surface to a uniform temperature of approximately 180° to 240° F. Force the sheet down into the floor pan making sure to form it into ALL the recesses.

**CAUTION:** Do not over heat the silencer sheet material.



Trim excess material away from areas where the silencer material overlaps the original material. Use heat on the edges of the silencer sheet and force it into shape.



When the original silencer sheet material exceeds 3 mm in thickness, additional layers of replacement material may be necessary to match the original specification. Make sure the second floor silencer sheet is applied to a clean, dry surface.

EXAMPLE:

If the desired sheet thickness is 4.5 mm, use 1 sheet of 3 mm and the second sheet of 1.5 mm to obtain the original thickness. If the desired thickness is 6 mm, use 2 sheets of 3 mm silencer material.

