

COLLISION REPAIR INFORMATION

FOR THE TOYOTA DEALER

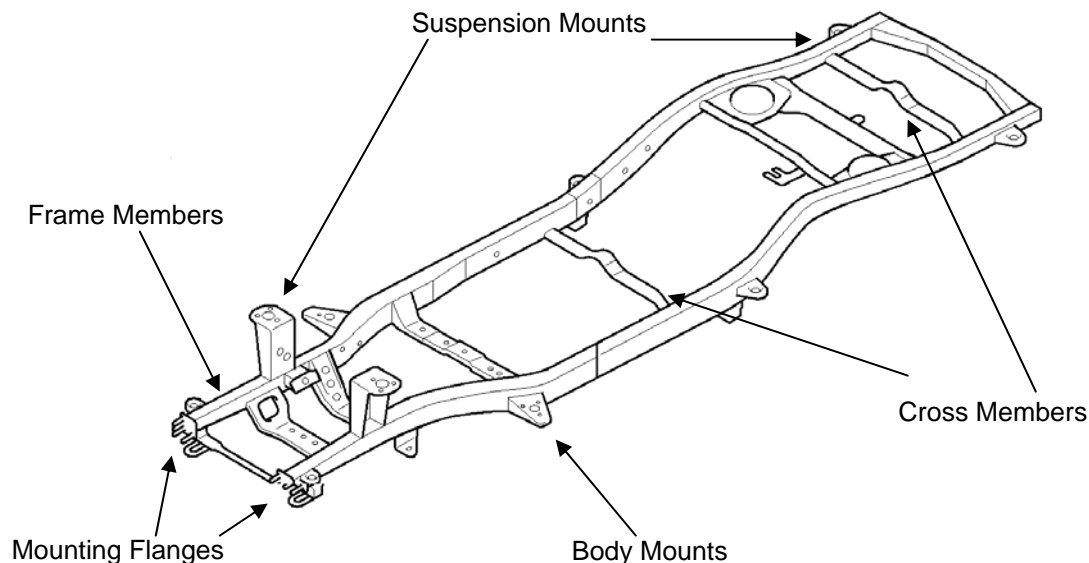
TITLE: FULL FRAME COMPONENTS PAGE 1 OF 2
SECTION: STRUCTURAL BULLETIN # 136
MODELS: ALL TOYOTA/LEXUS PERIMETER FRAME VEHICLES
DATE: SEPTEMBER 2003

Background

During a collision, components attached to the perimeter frame may be damaged and can be replaced individually when service parts are available. Serviceable parts include:

- **body mounts**
- **cross members**
- **mounting flanges**
- **suspension mounts**

Example: 2003 Lexus LX 470



Note: Sectioning of structural members on perimeter framed vehicles **is not** an approved repair procedure. Sectioning is defined as the partial replacement of welded on structural members or panels at a location other than the factory seam or joint.

**PLEASE ROUTE THIS BULLETIN TO YOUR COLLISION REPAIR CENTER MANAGER
AND COLLISION REPAIR TECHNICIANS**

Specified Models

Listed below are the current Toyota and Lexus models that feature a body over perimeter frame design:

Toyota

- 4Runner
- Land Cruiser
- Sequoia
- Tacoma
- Tundra

Lexus

- GX 470
- LX 470

Frame Repair Precautions

Since all Toyota and Lexus frames are made of High Strength Steel (HSS); Toyota does not approve of the use of open flame heating or any heating device to stress relieve HSS during the repair process. Heating HSS may alter the strength, durability, and quality of the steel.

“Cold straightening” (stress relieving) is the only repair method presently approved to repair perimeter frames. If the perimeter frame cannot be satisfactorily restored to original dimensions during this process, it should be replaced.

Do not overheat the steel when attaching welded components to the frame, as overheating can adversely affect the strength characteristics of the steel.

If crush rivets and installation equipment are not available, factory riveted components may be attached using SAE Grade 8 heat-treated shouldered bolts with a minimum tensile strength rating of 150,000 psi, washers, and self-locking nuts. Recommended torque is 73-97 Lb-Ft. Refer to I-CAR Universal Procedure for Collision Repair (UPCR) SP11S, 9.5 Riveted-On Part Replacement for more information on this topic.

Toyota/Lexus only support the use of genuine OEM replacement parts for collision repair.

For additional information, plan to attend a Toyota or Lexus collision repair training course. For training course schedule and registration, contact your Dealership Service Manager.