COLLISION REPAIR INFORMATION

FOR THE COLLISION REPAIR PROFESSIONAL

TITLE: APPROVED COLLISION REPAIR METHODS

SECTION: STRUCTURAL BULLETIN # 176

MODELS: ALL TOYOTA, LEXUS, and SCION

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Background

During collision repair straightening operations it is often necessary to stress-relieve metal being repaired or realigned to attach new components. It is also often necessary to replace or section damaged weld-on components. The following information is intended to provide an overview of Toyota approved and non-approved repair methods for these operations. This information also reinforces specific precautions published in Collision Repair Information Bulletins (CRIBs), and those covered in instructor-led hands-on training.

APPROVED REPAIR METHODS	METHODS NOT APPROVED
Cold Straightening: Pushing-Pulling Hammering	Stress Relief: Heating HSS and UHSS
Weld-On Pulling Aids	Stress Relief: Holes or Access Windows
Sectioning at Specified Locations	Sectioning at Non-Specified Locations
Open Butt Joint	Butt Joint With Backing (Sleeve)
Installing Genuine OEM Parts	Installing Aftermarket and Recycled Parts
Adhesive & Weld Bonding at Specified Locations	Substituting Adhesive for Welds

Instructor-led hands-on training information is available at **www.crrtraining.com**. For in-depth collision specific repair topics plan to attend the following training courses:

- Course #300 Welding Techniques for Collision Repair
- Course #301 Non-Structural Body Repair Training
- Course #460 Structural Body Repair Training

Collision Repair Information Bulletins can be accessed at TIS or **www.techinfo.toyota.com**. Refer to the following bulletins for more detailed information and precautions:

- CRIB #122 Body Sectioning
- CRIB #155 Body & Frame Component Sectioning
- CRIB #158 Panel Bonding Adhesive
- CRIB #161 Collision Damage Repair Precautions
- CRIB #172 Bumper Component Repair
- CRIB #174 Welding UHSS
- CRIB #175 HSS & UHSS Cabin Reinforcement Repair & Replacement
- CRIB #181 Welding Specifications & Substitutions

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