



**Miata Side Sill
Repair Information
(2 piece small type, 2AP)**

Tools needed:

8mm socket / ratchet
Trim panel fastener removal tool
Plastic scraper
Terry cloth

Materials needed:

Adhesive removal solvent (Paint & clear coat safe)
Double sided tape 3M-4211 (Tape size 1.2mm x 10mm)
Adhesion promoter 3M-6396
Rich-zinc primer
Rust prevention spray - ValuGard #VG-101-A (800) 543-7156
Sand paper / scotch bright pads
Mazda side sill hardware kit p/n N053-V4-919F

Side sill panel removal

Note: *Removal, cleaning & inspection is to be performed on driver's side only unless specified in installation inspection report.*

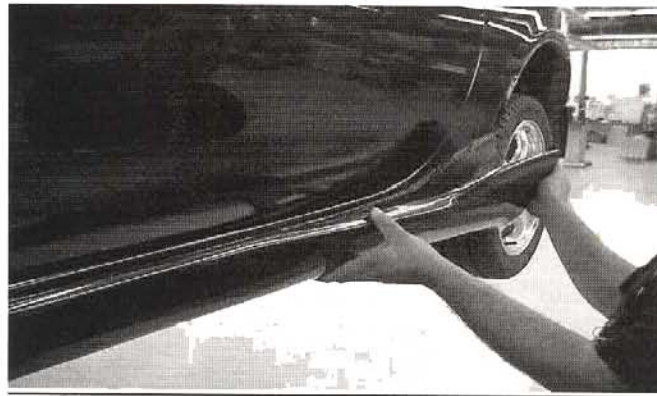
- 1) Safely lift vehicle on hoist to proper working height.
- 2) Inspect for proper fitment (excessive gaps, unevenness, etc..) of side sill panels to vehicle body. (At this time, make notes on inspection report, **side sill general appearance**)



3) Remove & discard the 5 lower christmas tree fasteners from sill panel using a trim panel fastener removal tool. (Tool may be positioned between side sill panel & body of vehicle for ease of removal)

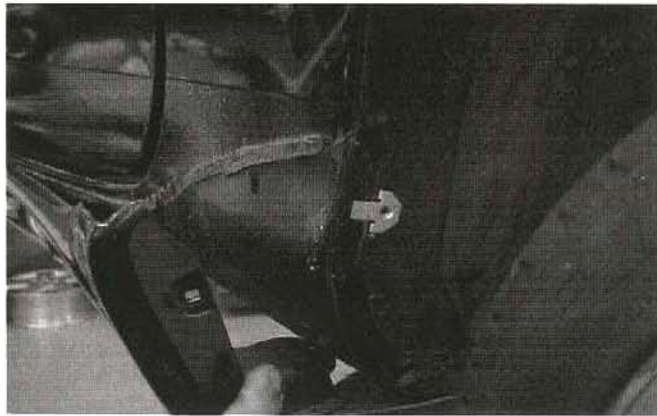
4) Remove & discard M5 X 16mm bolt from rear of side sill. (Located on rear wheel opening)

5) Starting at the rear of sill panel, detach side sill panel by gently pulling away from vehicle body. Pull panel until the double-sided tape is no longer visible.



Note: Do not bend or flex panel to avoid damage to paint.

Note: Do not remove or disturb the original position of the e-clip located in rear wheel opening.



6) Grasp inside of side sill panel, gently pull panel in upward motion. This will detach side sill panel from inner support rail.

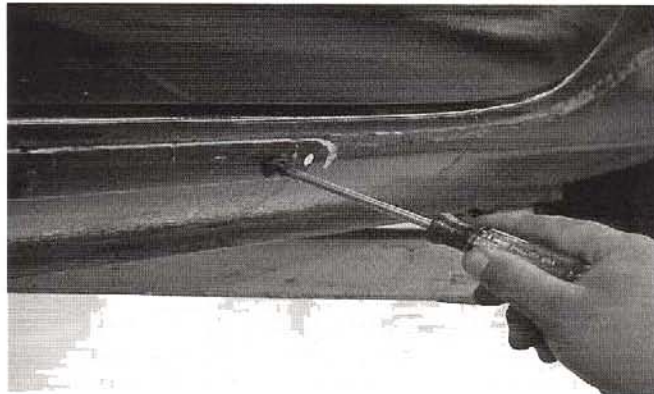


7) Remove side sill panel from vehicle & place in a safe location to avoid scratching.

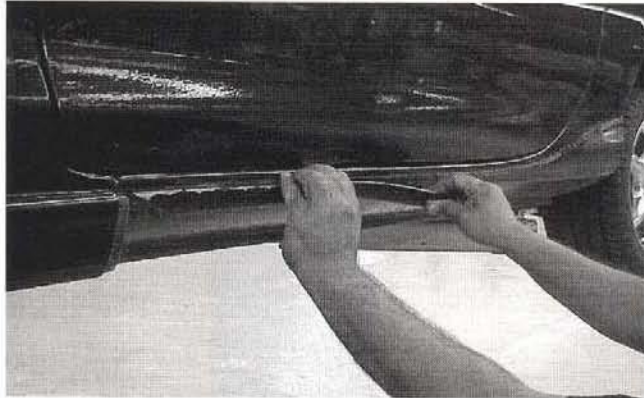
8) Remove & discard the packings that may be stuck to body of the vehicle.



9) Remove & discard the rivets from the side sill rail.



10) Remove & discard the side sill rail.



11) Remove & discard the packings that may be stuck to the body of the car.



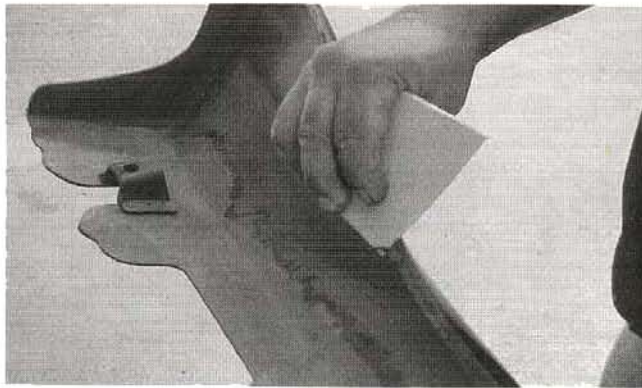
Cleaning

- 1) Apply adhesive removal solvent to double-sided tape residue on vehicle body. Carefully scrape residue using suitable plastic scraper.



Note: Use caution not to scratch paint. Area with adhesive has "rock-chip" paint, which can scratch easily.

- Note:** Use suitable adhesive solvent safe for paint & clear coats.
- 2) Apply adhesive removal solvent to double-sided tape residue that may be stuck to inner section of side sill panel. Scrape off all residue using a suitable plastic scraper.



At this time, please complete Side Sill Inspection Report!

Repair procedures

Only perform repairs necessary per inspection report.

A) Repair of “extra” support rail holes (If necessary)

- 1) Record radio station presets.
- 2) Disconnect negative side battery terminal.
- 3) Plug hole using MIG welder.
- 4) Grind & sand excessive material.
- 5) Prime & paint area. (Apply rock guard paint to match original finish.)
- 6) Reconnect battery terminal.
- 7) Restore customer's radio station presets

B) Repair rust in support rail holes (If necessary)

- 1) Remove rust using scotch bright brush or sand paper.
- 2) Apply rich-zinc primer.

C) Repair lack of rich-zinc primer to support rail holes (If necessary)

- 1) Apply rich-zinc primer to support rail holes.

D) Repair of “extra” lower sill mounting holes (If necessary)

- 1) Record radio station presets.
- 2) Disconnect negative side battery terminal.
- 3) Plug hole using MIG welder.
- 4) Grind & sand excessive material.
- 5) Prime & paint area. (Apply rock guard paint to match original finish.)
- 6) Reconnect battery terminal.
- 7) Restore customer's radio station presets

E) Repair rust in lower sill mounting holes (If necessary)

- 1) Remove rust using scotch bright brush or sand paper.
- 2) Apply rich-zinc primer.

F) Repair lack of rich-zinc primer to lower sill mounting holes (If necessary)

- 1) Apply rich-zinc primer to support rail holes.

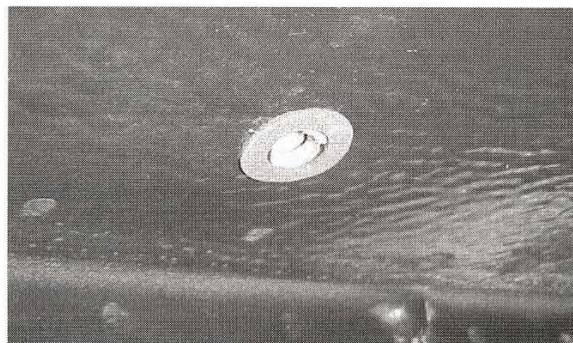
G) Repair of inner side sill panel (If necessary)

- 1) Spray affected areas with rust prevention solution.

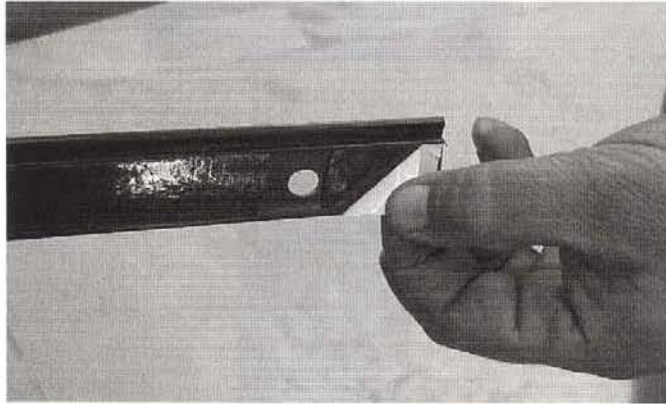


Re-installation of side sill panels

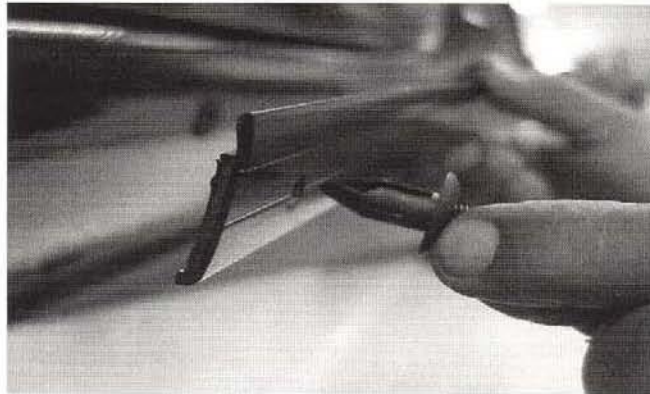
- 1) Ensure surface is dry & clean.
- 2) Remove plastic backing from new packings & apply to all drilled holes.



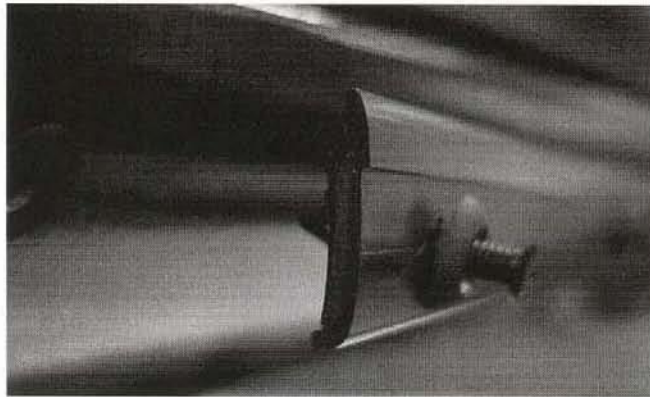
- 3) Remove plastic backing from new packings & apply to front side of support rail holes.
- 4) Remove plastic backing from support rail adhesive tape.



- 5) Pre-install rivets into support rail before mounting onto vehicle.



6) Position rail with mounting ridge in up position & install onto vehicle.



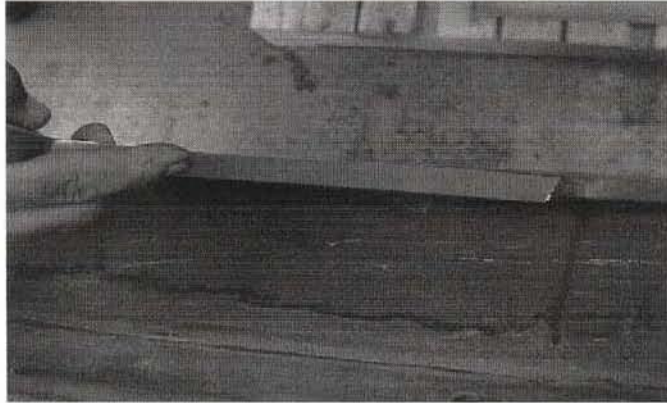
7) Push in rivet heads & firmly press rail onto body of vehicle to ensure proper adhesion.



8) Apply adhesion promoter to double-sided tape area of side sill.



9) Apply double-sided tape to back of sill.



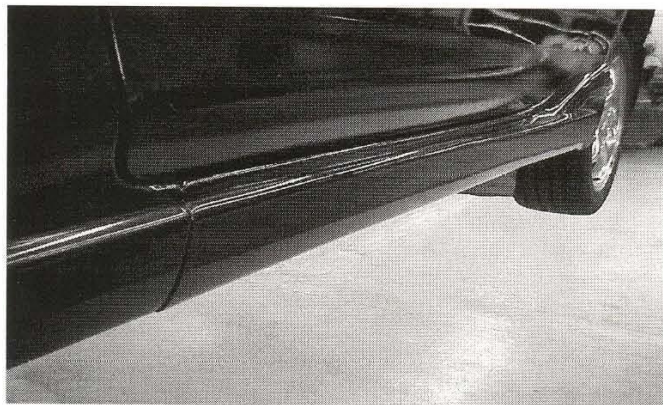
10) Apply adhesive agent to inside ridge of side sill panel area that contacts rail. Do not apply adhesive to area that double-sided tape will contact.



11) Install side sill panel onto vehicle, start by hooking ridge of side sill to upper ridge of side sill rail.



Slide side sill forward until flush with forward section of front sill. Make sure height is even between front & rear sections.



12) To ensure proper alignment of sill panel, loosely install the M5 X 16mm bolt to rear of panel.



13) Gradually pull plastic backing off of double-sided tape at the same time pushing sill onto body of car.



14) Apply pressure to panel at areas with double-sided tape.

15) Apply packing to 3 small & 2 large christmas tree clips.



16) Install clips by pushing through side sill & into holes in body.

Note: *The 3 small clips are installed in the front half & 2 large clips in the rear half of sill.*



17) Tighten the M5 X 16mm bolt in rear of sill, near front of rear wheel opening.

Note: Warranty information will be forwarded at a later date.