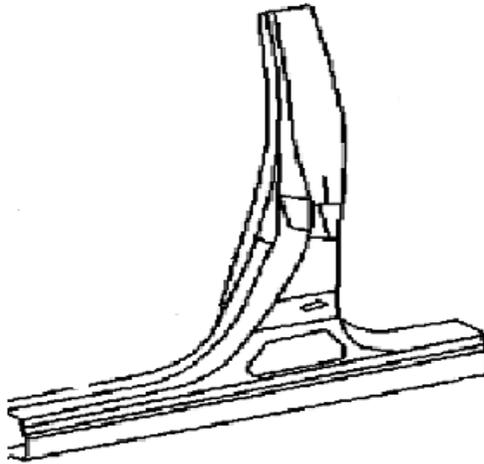


Rocker Panel Structural Sectioning Instruction Sheet
All procedures are evaluated to I-CAR standards

The purpose of this project is to evaluate the students ability to follow instructions, measure, cut, fit, weld and grind in the performance of a structural section of a rocker panel.



IMPORTANT NOTE: AT EACH STOP HAVE THE JUDGES EVALUATE YOUR PROGRESS.

- 1) Obtain a side aperture assembly from the parts pile and set it up in your work area. Make sure you have the correct panel, you are on the correct side of the body and that you have the correct instruction sheet.
- 2) On the body and the aperture assembly measure from the near edge of the front sill plate hole towards the front XX mm (XX") and from the rear sill plate hole back XX mm (X") and mark a cut line in both locations. On the center post measure up from the near edge of the top upper hinge bolt location XXX mm (XX ") and mark a cut line on both the body and the aperture. **STOP**
- 3) Cut and remove the aperture section on the body. From the removed piece create and fit two inserts XX mm (XX "). **STOP**
Note: You will be performing a butt joint without a backer on the center post joint.

- 4) Cut your aperture replacement piece out of the aperture from the parts pile and check it for fit. **STOP**
- 5) Cut, trim and prepare all the pieces for welding according to the chart below. **STOP**

| ROCKER FACE | LEFT SIDE OF CUT LINE (MIG PLUG WELDS) | RIGHT SIDE OF CUT LINE (MIG PLUG WELDS) | CENTER POST AND LOWER ROCKER FLANGE |
|--------------|--|---|-------------------------------------|
| TOP | XX WELDS | XX WELDS | N/A |
| FRONT | XX WELDS | XX WELDS | N/A |
| BOTTOM | XX WELDS | XX WELDS | N/A |
| LOWER FLANGE | N/A | N/A | Replace existing welds |
| CENTER POST | N/A | N/A | Replace existing welds |

- 6) Perform your welding operations performing the rocker panel welding operations first then the center post welding operation. **STOP**
- 7) When you have completed all the welding operations you must **grind the welds on the top of the rocker panel joints only.** **STOP**