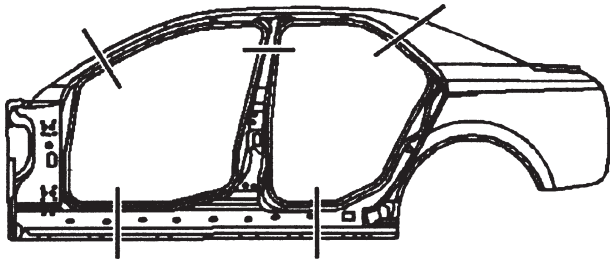


Quarter Panel Replacement

The full body-side outer panel comes as a complete assembly and can be replaced at factory seams after the removal of the fixed glass and roof. Any one of these service procedures can be performed separately or in any combination, dependent upon the extent of damage to the vehicle. Sectioning must take place in specified areas only.

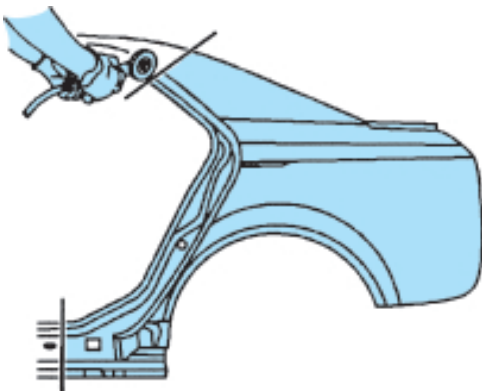
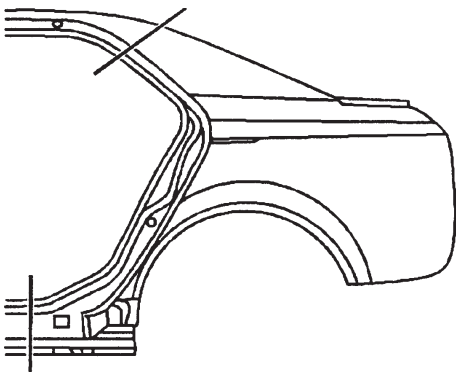


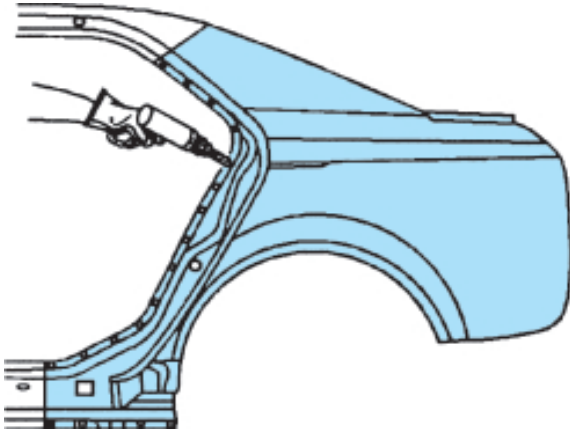
Removal Procedure

CAUTION: Refer to Glass and Sheet Metal Handling in Cautions and Notices.

IMPORTANT: When replacing panels that involve servicing of stationary glass, refer to service bulletin 43-10-45 before performing any priming or refinishing. Sectioning Should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle

1. Disable the SIR system. Refer to Disabling the SIR System in Cautions and Notices.
2. Disconnect the negative battery cable. Refer to Negative Cable Disconnect/Connect Procedure in Cautions and Notices.
3. Remove the rear window. Refer to Rear Window Replacement in Stationary Windows.
4. Remove all related panels and components.
5. Restore as much of the damage as possible.
6. Remove sound deadeners as necessary and note their location.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Cautions and Notices.
8. Create cut lines on the rocker panel within the approved sectioning locations.
9. In the back-glass opening, measure down 150 mm (6 in) from the rear edge of the roof.
10. Mark a cut line to the door opening.



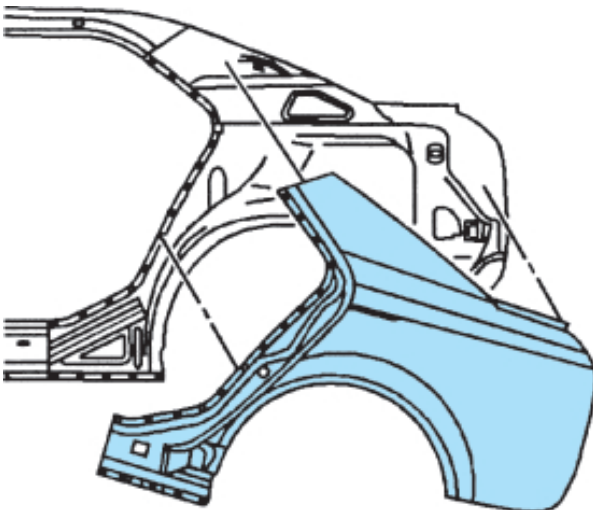


IMPORTANT: Do not damage any inner panels or reinforcements.

11. Cut the panel where sectioning is to be performed.

IMPORTANT: Note the number and location of the factory welds for installation of the quarter panel.

12. Locate, mark, and drill out all the necessary factory welds.

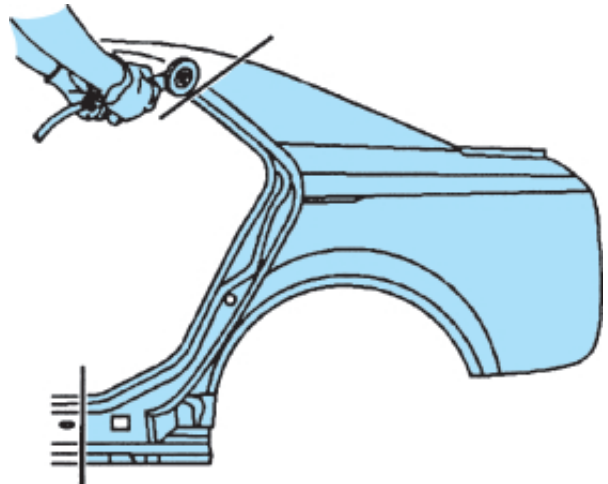


13. Remove the damaged quarter panel.

Installation Procedure

IMPORTANT: This part has structural weld-thru adhesive in the joint areas. It is necessary to replace this with additional spot welds at the attachments points. This can be accomplished by adding an additional weld between each factory weld in all areas.

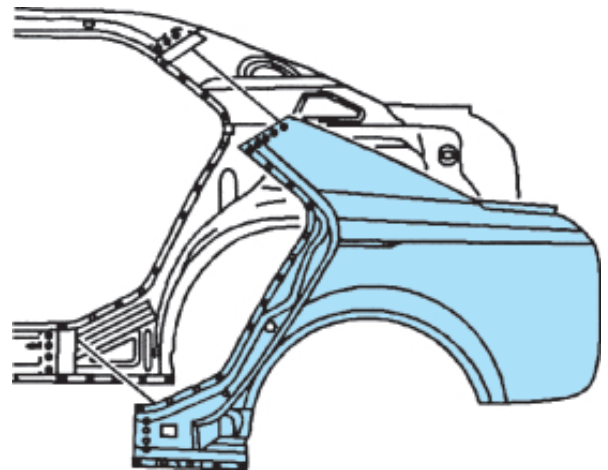
1. Cut the body side assembly in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.



2. Create a 50 mm (2 in.) backing plate from the unused portion of the service part for the back glass area. Create a 100 mm (4 in.) backing plate from the unused portion of the service part for the rocker area. Trim the backing plates as necessary to fit behind the sectioning joints

IMPORTANT: In any area damaged beyond recognition, space the plug weld holes every 40 mm (1-1/2 in.) apart.

3. Drill 8 mm (5/16 in.) along the sectioning cut on the remaining original part. Locate these holes 13 mm (1/2 in) from the edge of part and spaced 40 mm (1-1/2 in) apart. Drill 8 mm (5/16 in.) plug weld holes in the service part as necessary in the locations noted from the original panel and along the sectioning cut.
4. Prepare all attachment surfaces as necessary.
5. Apply weld-thru primer to all bare metal surfaces.
6. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.
7. Align quarter panel using 3-dimensional measuring equipment.



8. Plug weld accordingly.
9. To create a solid weld with minimum heat distortion, make 25 mm (1 in.) stichwelds along the seam with 25 mm (1 in.) mm gaps between them. Then go back and complete the stitch weld.
10. Clean and prepare all of the welded surfaces.
11. Apply sound deadening materials as necessary.
12. Paint the repaired area. Refer to Basecoat//Clearcoat Paint Systems in Cautions and Notices.
13. Install the rear window. Refer to Rear Window Replacement Stationary Windows.
14. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Paint and Coatings
15. Connect the negative battery cable. Refer to Negative Cable Disconnect/Connect Procedure in Cautions and Notices.
16. Enable the SIR system. Refer to Enabling the SIR System.

