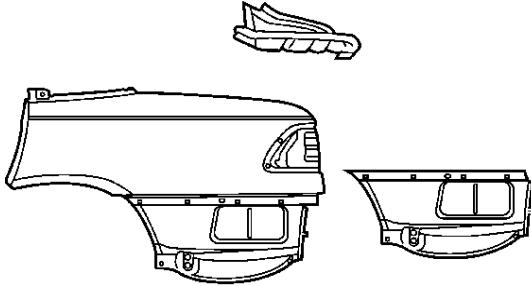
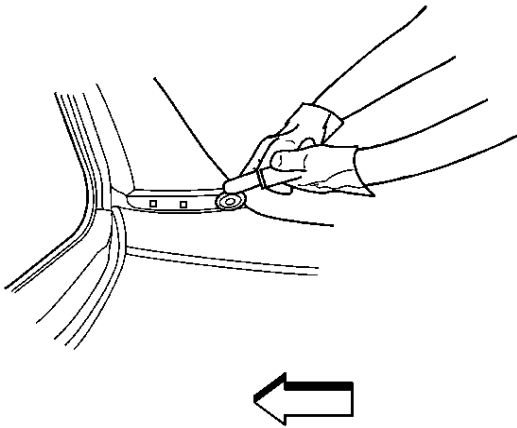


Quarter Panel Replacement



This service procedure has been developed to simplify quarter panel replacement because the roof panel overlaps the quarter panel. The service quarter panel is supplied with the lower quarter extension and the tail-lamp mounting panel. The lower quarter extensions and tail-lamp panels are available separately. The quarter panel gusset (trunk gutter) must be purchased separately.

Removal Procedure



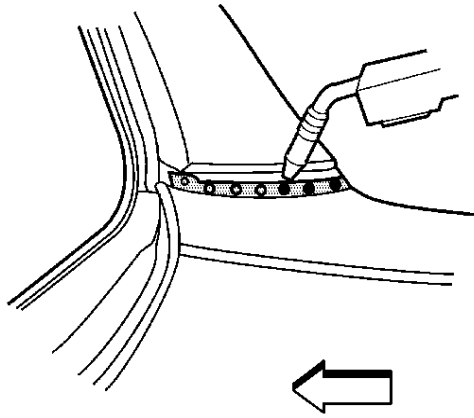
1. Remove all related panels and components.
2. Visually inspect the damaged area.
3. Restore as much of the damage as possible to factory specifications.
4. Remove sealers and anti-corrosion materials as necessary.

Important

Note the number and location of welds for installation of the service assembly.

5. Locate all factory welds.
6. Mark all factory welds.
7. Drill out all factory welds.
8. Cut the quarter panel at the lower edge of the rear pillar.
9. Remove the damaged quarter panel assembly.

Installation Procedure



Important

Locate holes for plug welding 40 mm (1.5 in) apart if the original locations are damaged beyond recognition, or a new weld flange is created.

1. Drill 8 mm (0.31 in) holes for plug welding in the locations noted from the original quarter panel.
2. Prepare the mating surfaces.
3. Position the new quarter panel to overlap the roof panel at the pillar.
4. Check for proper fit.

Important

Take care not to warp or distort the metal when welding.

5. Weld the new quarter panel into place.
6. Clean and prepare all welded surfaces.
7. Prime with two-part catalyzed primer.

Important

Do not combine paint systems. Refer to paint manufacturer's recommendations.

8. Apply sealers and anti-corrosion materials as necessary.

Important

When you replace the quarter panel ensure that the fuel filler neck is properly sealed. Use SPO Sealing Strip (Part # 312399117) between the quarter panel and the filler neck. Install using the provided instructions.

9. Install all related panels and components.