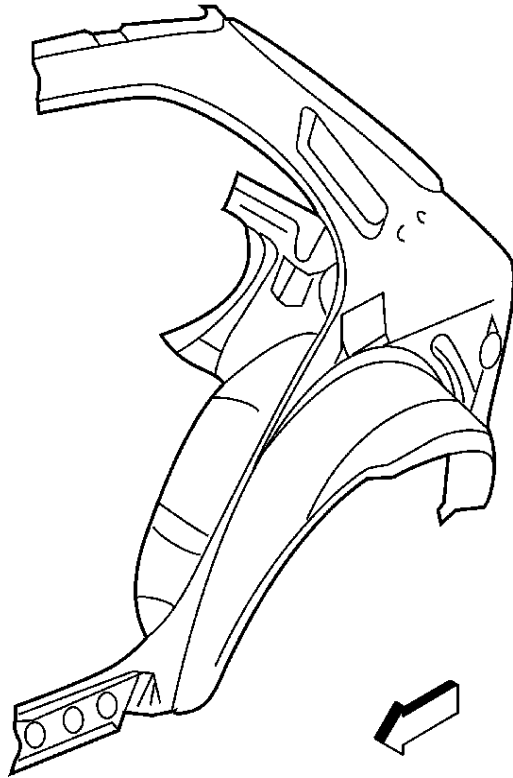


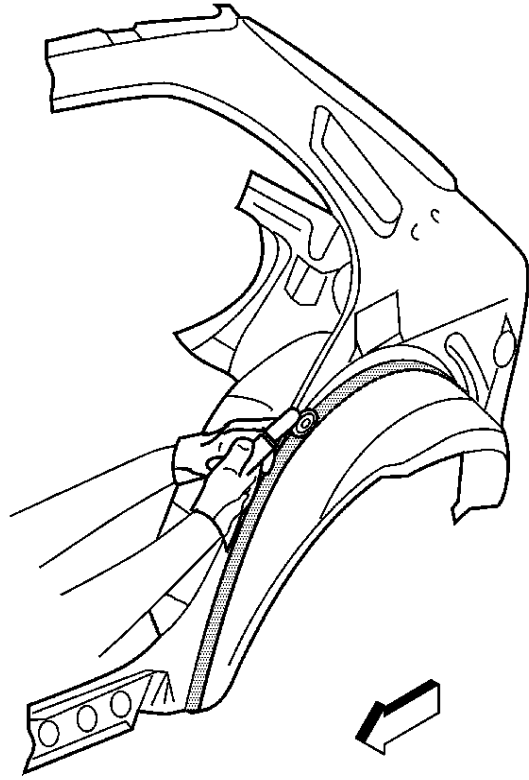
Rear Wheelhouse Replacement

It is not necessary to make a full panel replacement whenever the sectioning procedure can be used.

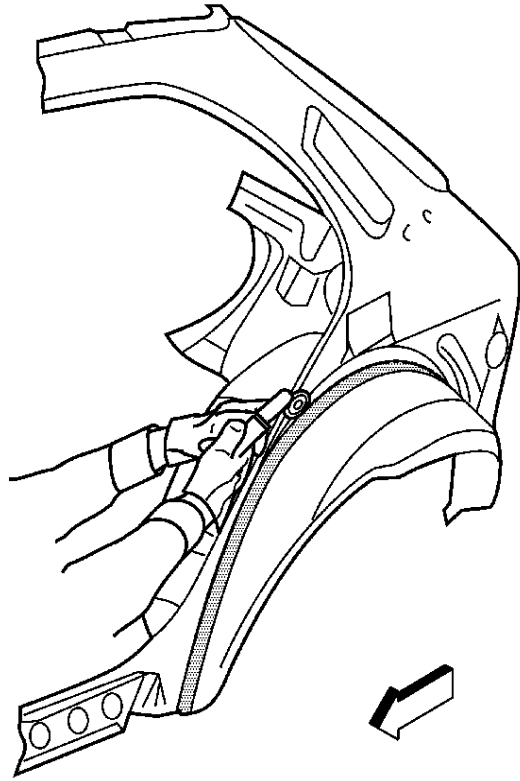
Removal Procedure



1. Remove all related panels and components including the quarter panel.
2. Visually inspect the damaged area.
3. Restore as much of the damage as possible to factory specifications.
4. Remove the sealers, sound deadeners and corrosion materials as necessary.
5. Apply a strip of 25 mm (1 in) wide masking tape along the horizontal surface of the bend in the wheelhouse.



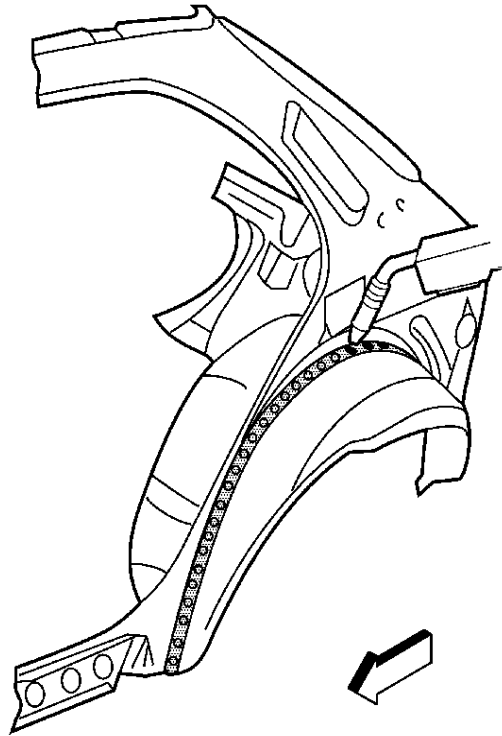
6. Cut along the outboard side of the masking tape to create a 25 mm (1 in) flange.



7. Remove the damaged section of the wheelhouse.

Installation Procedure

Important: If necessary, apply a strip of 25 mm (1 in) wide masking tape along the horizontal surface of the bend in the wheelhouse.



1. Cut the new wheelhouse along the corner of the bend.
2. Remove the unused section of the wheelhouse.
3. Drill 8 mm (0.31 in) holes for plug welding every 40 mm (1.5 in) along the cut edge on the new wheelhouse.
4. Prepare the mating surfaces.
5. Position the service part.
6. Check for proper fit.
7. Plug the weld wheelhouse.
8. Clean and prepare welded surfaces.
9. Apply the sealers and anti-corrosion materials as necessary.

Important: Do not combine paint systems. Refer to the manufacture's recommendations.

10. Prime with two-part catalyzed primer.
11. Install all related panels and components.