Quarter Panel

The quarter panel is attached to the roof panel by a silicon-bronze welded joint. To maintain the integrityof this joint, sail panel sectioning of the quarterpanel will be performed about 100mm (4 inches) below this factory joint (Fig. 4.28).

— REMOVE OR DISCONNECT —

1. Remove all panels and components necessary for access, including the back glass.
2. Restore as much of the damage as possible to the factory specifications.
3. Remove all sealers, sound deadeners, and anti-corrosion materials as necessary.
4. Measure from the roof panel rear edge, down the sail panel 150mm (6 inches), and scribe a line for the sectioning cut.
5. Locate, mark, and drill out the factory welds, note the location and number of welds.
6. Remove the damaged quarter panel.

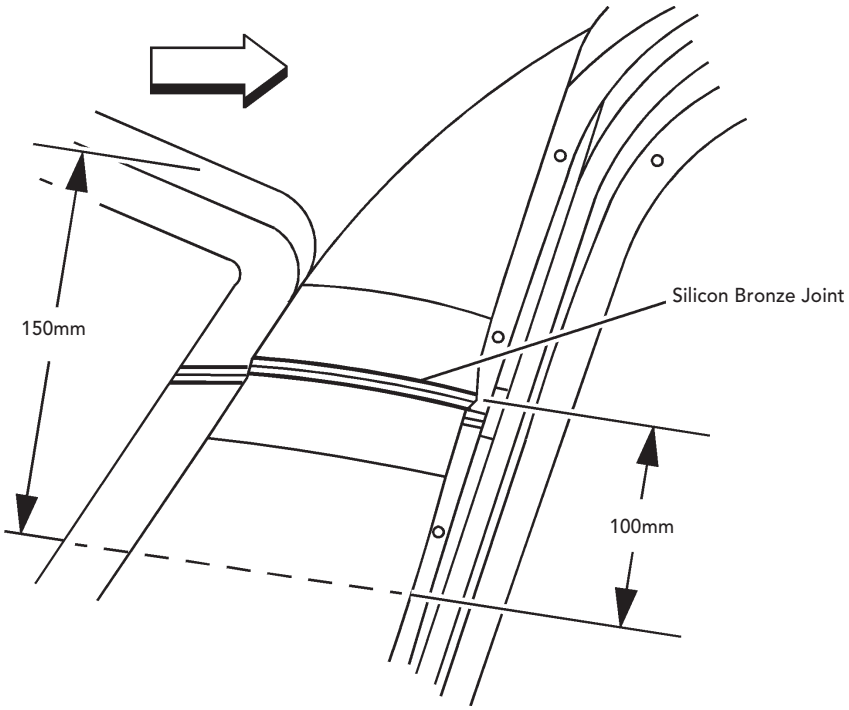

Fig. 4.28 — Quarter Panel Section Line

— INSTALL OR CONNECT —

1. On the service part, mark a horizontal line to leave a gap of one and one-half times the thickness of the metal at the sectioning joint. Cut the quarter panel service part along this line (Fig. 4.29).
2. Cut a 100mm (4 inch) piece from the unused portion of the service part for a backing plate. Remove the flange on each side of the backing plate so that it will fit behind the sectioning joint.
3. Drill 8mm (5/16 inch) holes for plug welding in the service part in the locations noted from the original panel. Also, drill holes for plug welding along the sectioning cuts on both the service part and the original panel. *Locate these holes approximately 25mm (1 inch) from the edge of the sectioning cuts.*
4. Prepare the mating surfaces and position the backing plates with 50mm (2 inches) of the backing plate exposed, and plug weld.
5. Position the service part to overlap the exposed 50mm (2 inches) of the backing plate, check fit using three-dimensional measuring equipment, and plug weld accordingly.
6. Stitch weld along the sectioning joint. Make 25mm (1 inch) welds along the seam with 25mm (1 inch) gaps between. Then go back and complete the stitch weld. This will create a solid joint with minimal heat distortion.
7. Clean and prepare all bare metal surfaces. Apply as necessary:
   - sealers and anti-corrosion materials
   - sound deadeners
   - two-part catalyzed primer
   - top-coat

   Important: Do not combine paint systems. Refer to paint manufacturer's recommendations.
8. Install the panels and components previously removed for access.

Fuel Filler Neck

Notice: Care must be taken to ensure that the fuel filler neck is properly sealed when replacing the quarter panel. Use SPO Sealing Strip (Part #12399117) between the quarter panel and the fuel filler neck. Install according to the instructions provided.

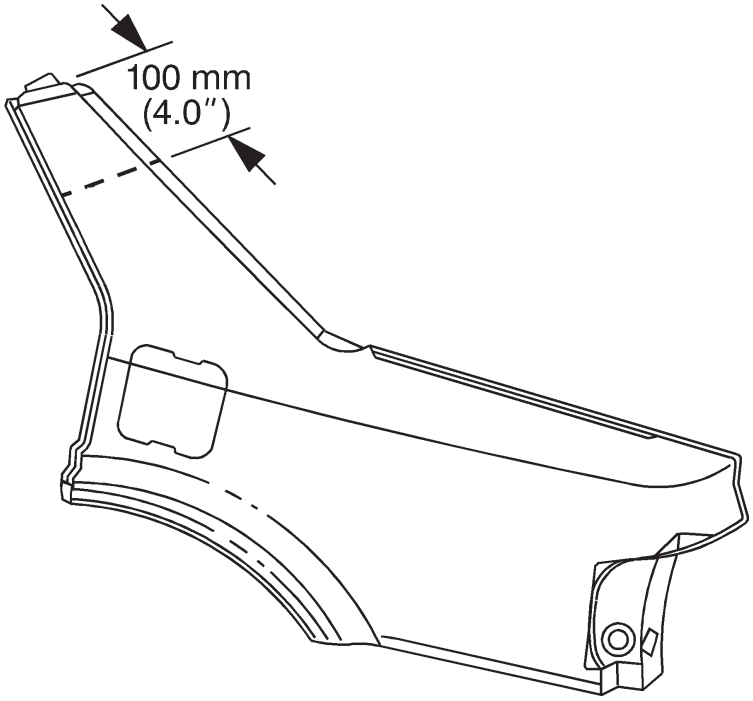

Fig. 4.29 — Service Part Cut Location