

Rear Outer Wheelhouse

— REMOVE OR DISCONNECT —

- 1 Remove all panels and components as necessary for access, including the quarter panel.
- 2 Restore as much of the damage to factory specifications as possible.
- 3 Remove sealers, sound deadeners, and anti-corrosion materials as necessary.
- 4 After removing the quarter panel, locate, mark, and drill out the spot-welds attaching the reinforcement panel to the outer wheelhouse and the inner reinforcements.
- 5 Cut the wheelhouse along the corner of the bend (Fig. 4.30). If necessary, apply a strip of masking tape as above and cut along the inboard edge.
- 6 Remove the damaged section of the wheelhouse.

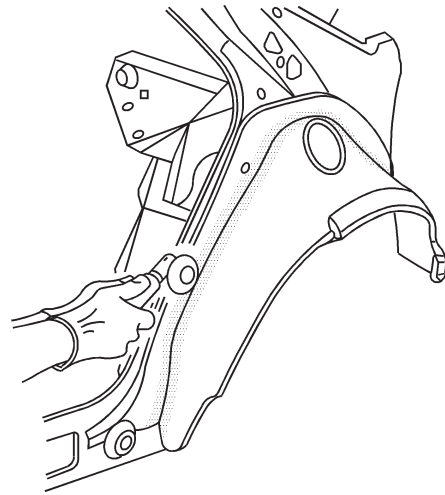


Fig. 4.30 — Cut Location

— INSTALL OR CONNECT —

- 1 Trim the service part to leave approximately 25mm (1 inch) vertical flange (Fig. 4.31).
- 2 Drill 8mm (5/16 inch) plug weld holes every 40mm (1-1/2 inches) along the vertical flange.
- 3 Prepare mating surfaces and position the service part. Check for proper fit and plug weld accordingly (Fig. 4.32). Take care not to warp or distort the metal.
- 4 Repair or replace the outer wheelhouse reinforcement as necessary. Position the reinforcement panel as noted from the original panel location and plug weld accordingly.
- 5 Clean and prepare all bare metal surfaces. Apply as necessary:
 - sealers and anti-corrosion materials
 - two-part catalyzed primer
 - top-coat
- 6 Install all the panels and components previously removed for access.

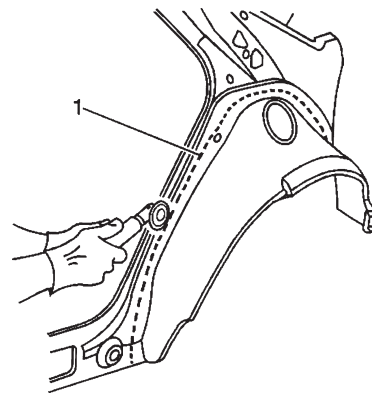


Fig. 4.31 — Create Service Part

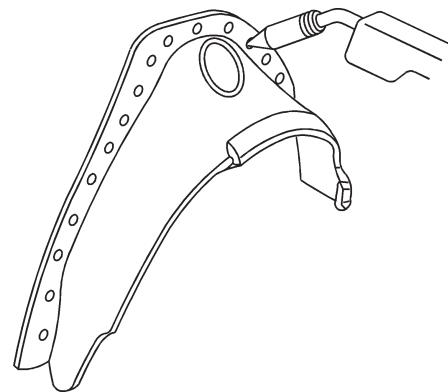


Fig. 4.32 — Plug Weld