

Quarter Outer Panel Sectioning (SS Bond-On)

Removal Procedure

Tools Required

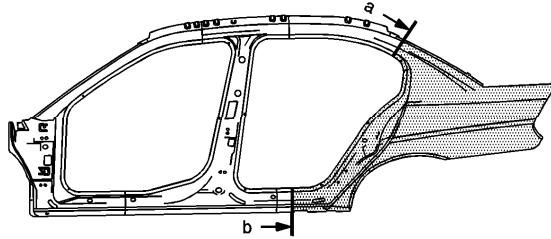
Fender Flanging Tool

Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

Important: This adhesive bonding procedure represents one manufacturer's installation application. Other manufacturers' procedures may vary, including MIG welding in some areas of the repair. Always follow the system manufacturer's instructions for application, handling, and curing.

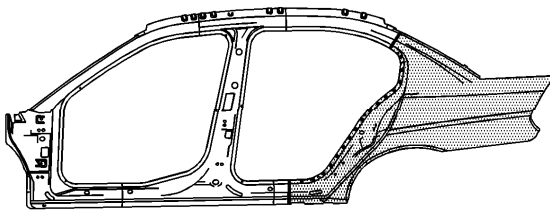
Important: Before beginning the repair, refer to [Metal Panel Bonding](#) for proper adhesive preparations and general information.

1. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
2. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) .
3. Restore as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .
4. Remove all related panels and components.
5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .



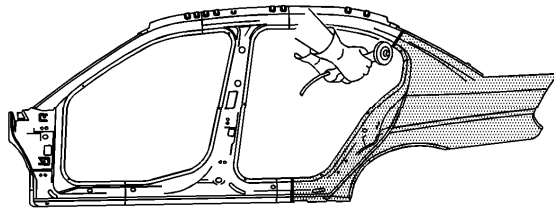
6. Section the sail panel (a) and the rocker panel (b).

- At the sail panel, measure from the back glass opening down 120 mm (4 3/4 in). Scribe a line.
- At the rocker panel, measure 70 mm (2 3/4 in) rearward from the rocker panel locating hole. Scribe a line.

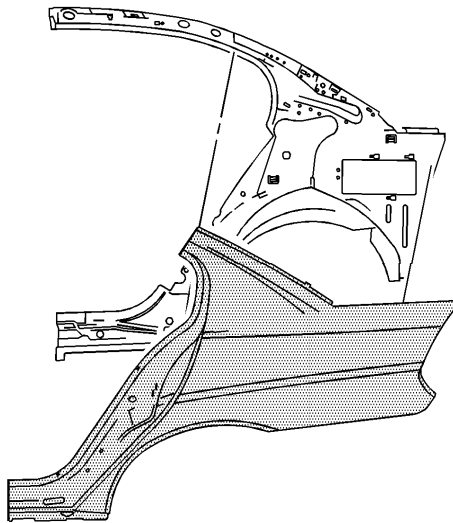


8. Locate and drill out all factory welds.

Important: Do not damage any other panel or reinforcements when cutting at the marked locations.

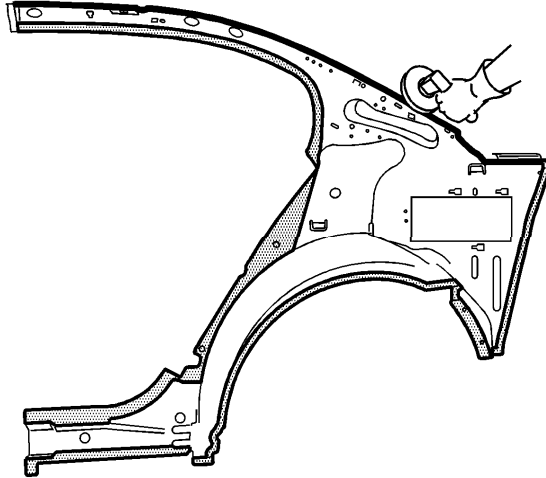


9. Cut the panel at the marked locations.

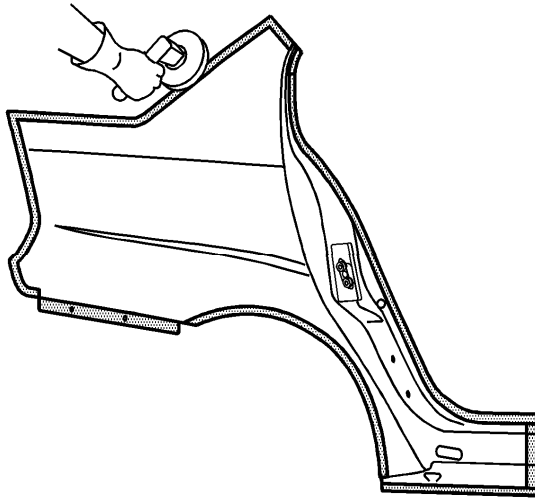


10. Remove the lower quarter panel.

Installation Procedure

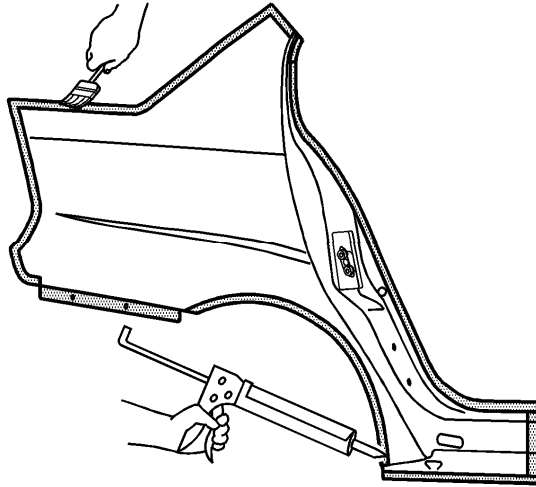


1. Grind the surface of the body mating flanges to bare steel.



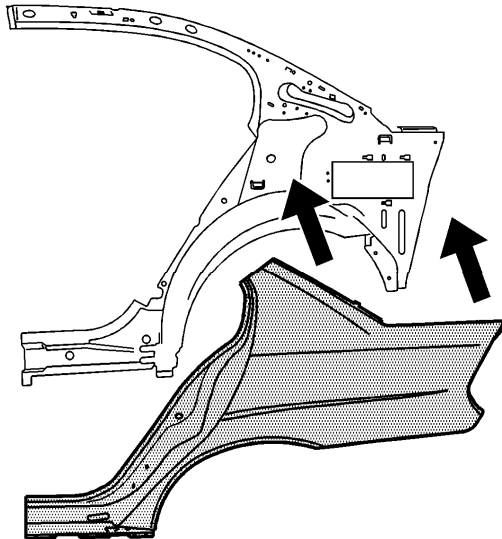
2. Grind the quarter panel mating flanges to bare steel. Take care not to damage the corners or thin the metal during the grinding operation.
3. Clean the mating surfaces.

4. Perform the sectioning procedure. Refer to [Overlap/Backing Plate Sectioning](#) .



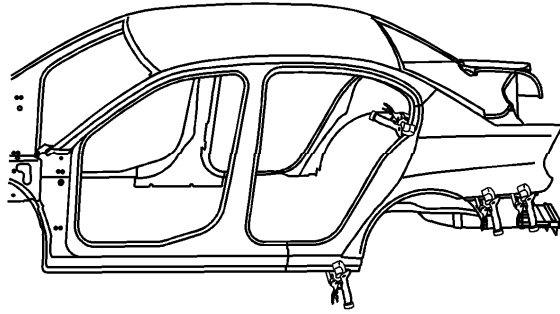
Important: The adhesive has a 40-50 minute working time. Do not allow the adhesive to totally cure before flanging the wheelhouse weld flange

5. Apply a 3-6 mm (1/8-1/4 in) bead of metal panel bonding adhesive to both of the mating surfaces.
6. Using a small acid brush, spread a coat of adhesive to cover all the bare metal surfaces to ensure corrosion protection.
7. Apply a 9-13 mm (3/8-1/2 in) bead of metal panel bonding adhesive to the service part mating surface.

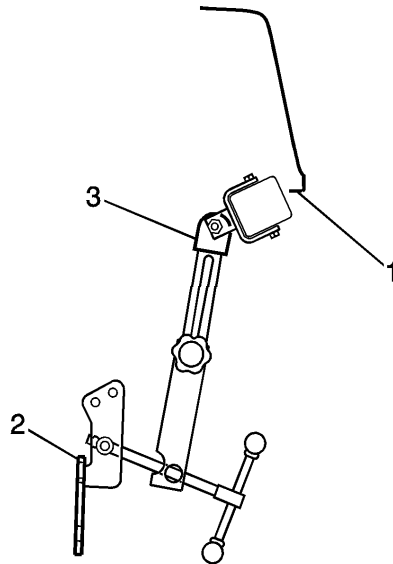


Important: DO NOT pull the panels apart after joined together. Slide the panels against each other to realign the panels.

8. Install the quarter panel to the body.

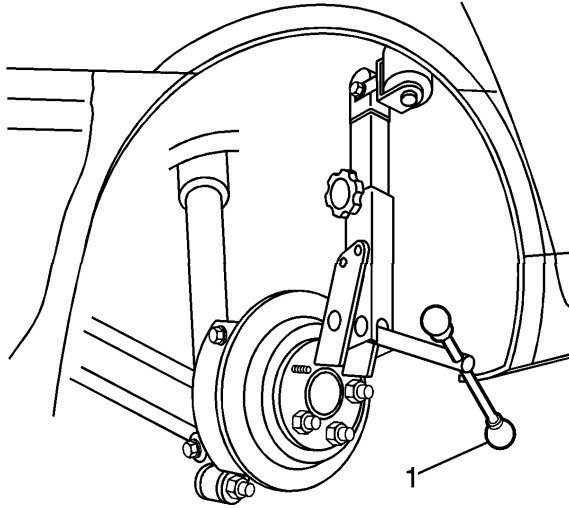


9. Clamp the quarter panel into position as required, except in the wheelhouse area.

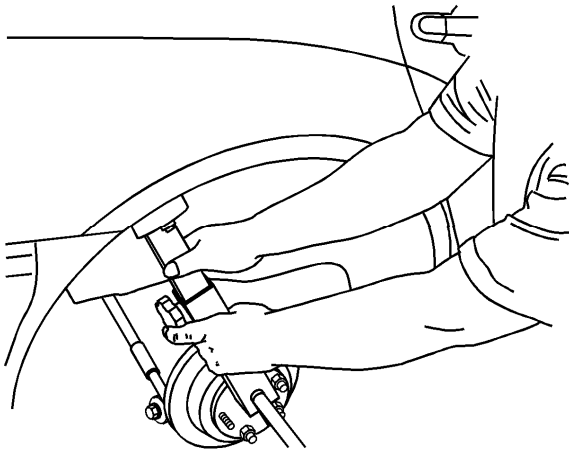


10. Raise the rear of the vehicle. Safely secure the vehicle on a jack stand.
11. Remove the rear wheel when the flange needs to be bent (1).
12. Place the tool hub dish flange onto the wheel hub. Tighten the lugs to snug (2).
13. Adjust the arm length so that the center of the roller is aligned with the inboard flange of the outer wheelhouse.

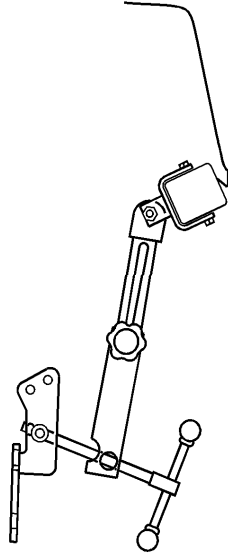
14. Adjust the roller to achieve the desired angle to wheelhouse lip (3).



15. Tighten the hand wheel located on the tool (1) to apply slight pressure.



16. Hold the tool firmly. Swing the tool in an arcing motion to reform the inner quarter panel to the wheelhouse flange.



17. Adjust the tool as necessary by adding pressure to the rollers to redirect the flange to the desired location.
18. Remove the flanging tool.
19. Clamp the quarter panel to the wheelhouse flange.
20. Using lacquer thinner remove the excess adhesive from the lower quarter panel area.
21. Apply body filler, following the adhesive manufacturer's recommendations.
22. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
23. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
24. Install all related panels and components.
25. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .
26. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .