

10. Rear Outer Wheelhouse

Rear Outer Wheelhouse Sectioning Procedure

Although full replacement can be performed, sectioning procedures have been developed for use when damage permits.

Remove or Disconnect

1. Remove all related panels and components including the quarter panel.
2. Visually inspect and restore as much of the damage 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. Apply a strip of 25mm (1 inch) masking tape along the horizontal surface of the bend in the wheelhouse (figure 10-1).
6. Cut along the outboard side of the masking tape to create a 25mm (1 inch) tab (figure 10-1).
7. Remove the damaged section of the wheelhouse.

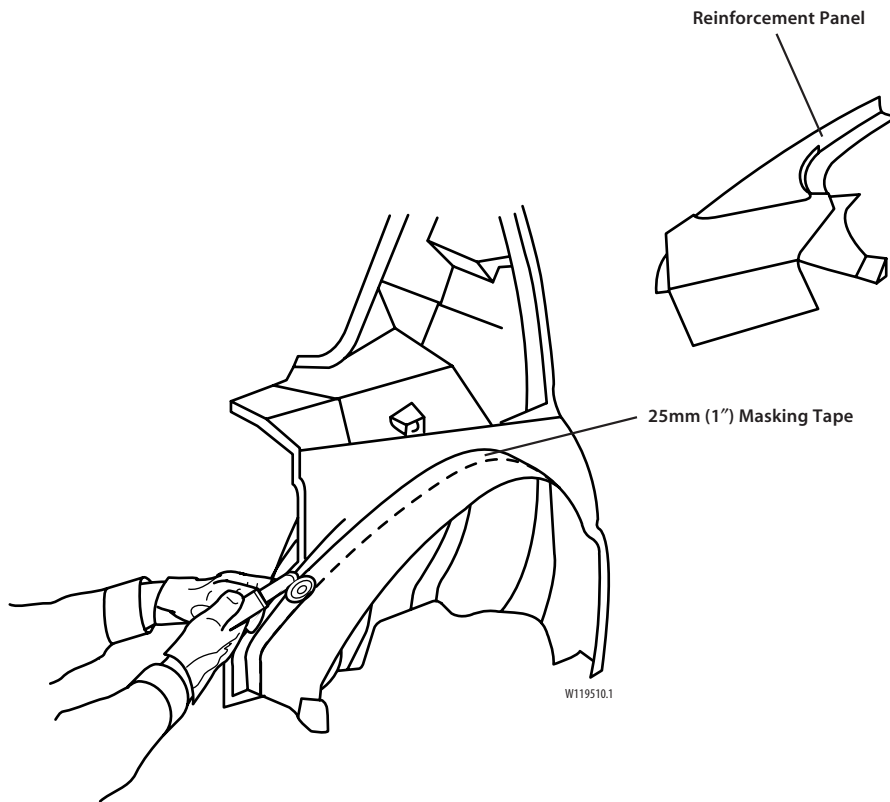


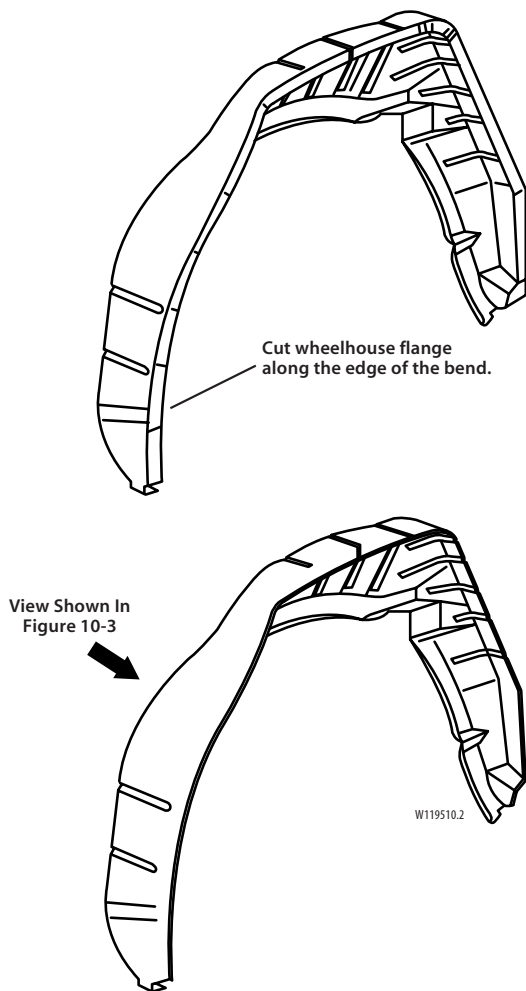
Figure 10-1:
Apply Masking Tape Along Wheelhouse

**Rear Outer Wheelhouse
Sectioning Procedure (cont'd)**

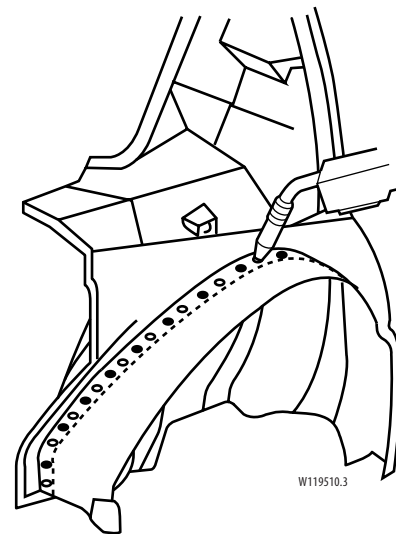
Install or Connect

1. Cut the wheelhouse service part along the edge of the bend (figure 10-2). If necessary, apply a strip of masking tape as above and cut along the inboard edge. Remove and discard the unused section of the wheelhouse.
2. On the service part, drill 8mm ($\frac{5}{16}$ inch) plug weld holes every 40mm (1½ inches) along the cut.

3. Prepare mating surfaces and position the service part. Check for proper fit and plug weld accordingly (figure 10-3). 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 welded surfaces. Prime with two-part catalyzed primer. Apply sealers and corrosion protection materials, as necessary. Do not combine paint systems. Refer to paint manufacturer's recommendations.
6. Install all related panels and components.



**Figure 10-2:
Wheelhouse Service Part
Before (top) and After (bottom) Cutting the Flange**



**Figure 10-3:
Plug Weld the Service Part**