

Quarter Panel Sectioning - Outer

Removal Procedure

Caution: To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

Caution: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

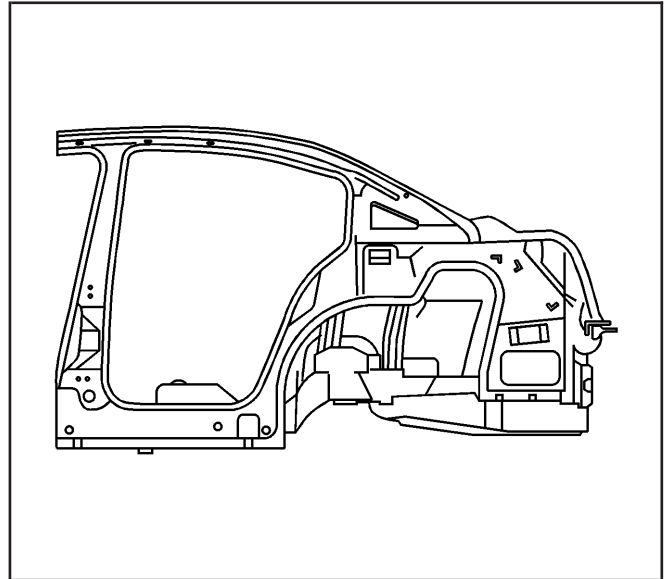
The body side outer panel is available either in one piece or in front or rear portions. The front and the rear halves are cut about half way across the rear door opening. You can perform any one of these replacement procedures separately or in any combination, depending upon the extent of damage to the vehicle. Sectioning must take place in specified areas only. Stay away from the door and window opening radius areas. Section only in straight areas of the openings.

Caution: Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect the negative battery cable. Failure to follow these precautions may cause personal injury and/or damage to the vehicle or its components.

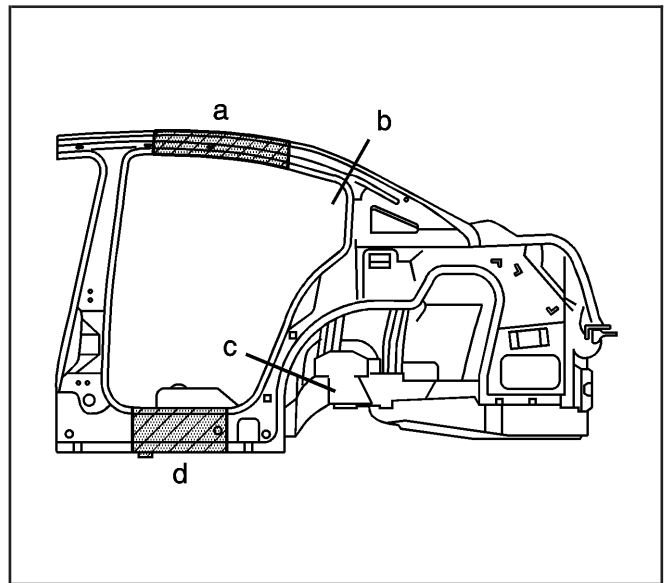
1. Disconnect the negative battery cable.
2. Remove all related panels and components.
3. Repair as much of the damaged area as possible. Refer to *Dimensions - Body* on page 3-7.
4. Remove the sound deadeners as necessary. Note their location.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.

Important: Sectioning can only be done in the recommended areas of the rocker panel, dog leg, sail panel, and upper roof rail area of the body side panel as necessary.

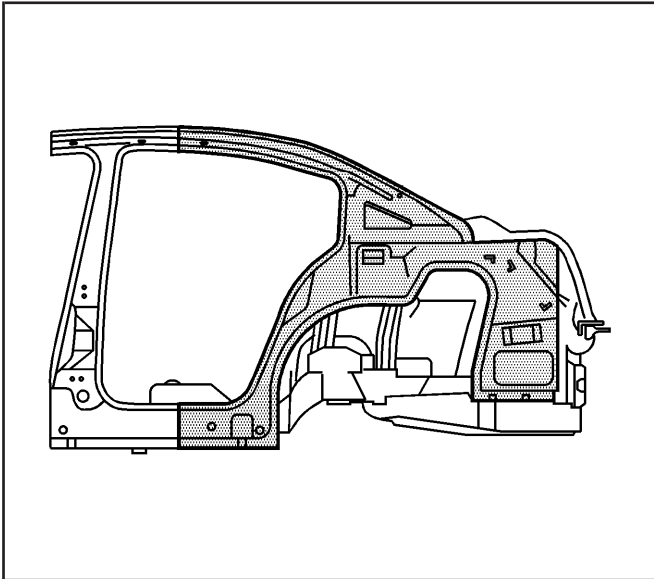
6. Locate the area on the panel where sectioning will be performed.
 - (a) – Any straight area along the rocker panel away from the door opening lower front and rear radius on the body side panel.
 - (b) – 10 mm (3/8 in) rearward of the last upper trim attachment slot.
 - (c) – 75 mm (3 in) down from the quarter panel exterior panel attachment square hole.



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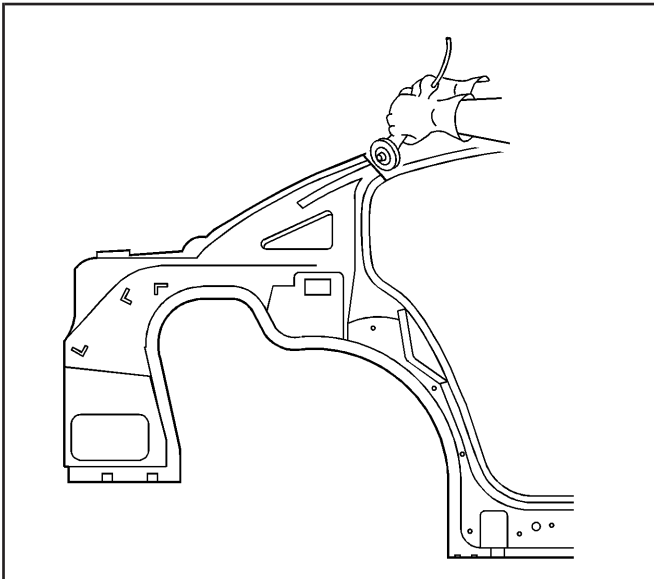


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7. Within the recommended sectioning areas, mark the location of the sectioning cut lines on the vehicle.

Important: Note the number and location of the factory welds for installation of the quart panel.

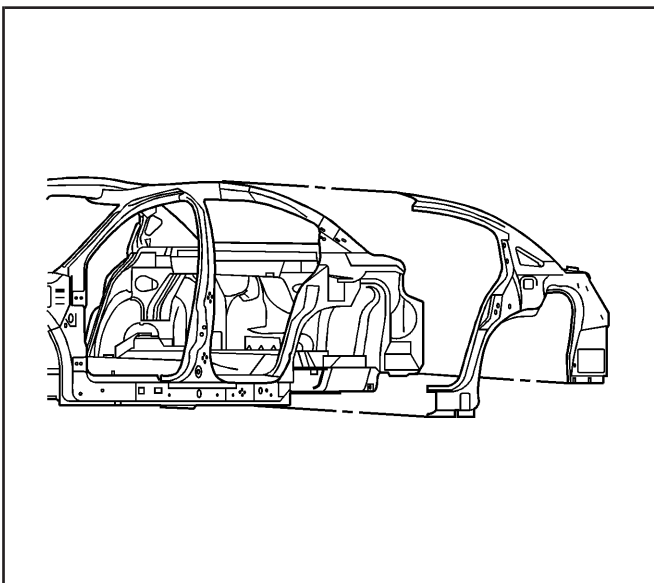
8. Locate and drill out all factory welds.



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Important: Do NOT damage any other panels or reinforcements when cutting at the marked locations.

9. Cut the panel at the location laid out in the previous steps.



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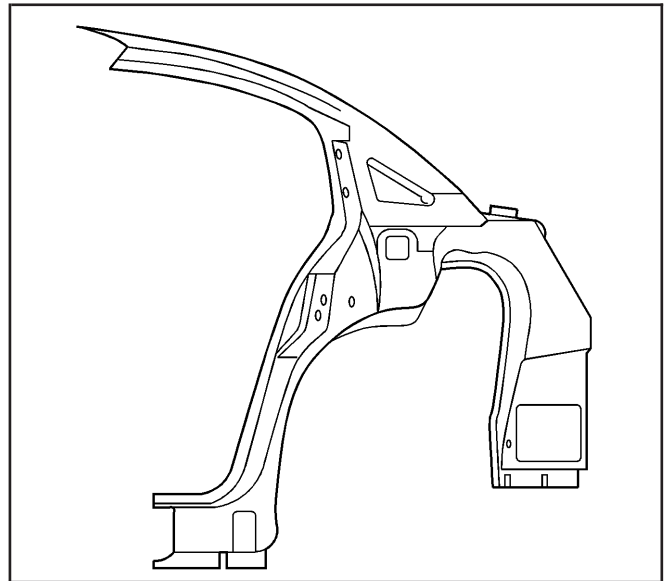
10. Remove the damaged quarter panel.

Installation Procedure

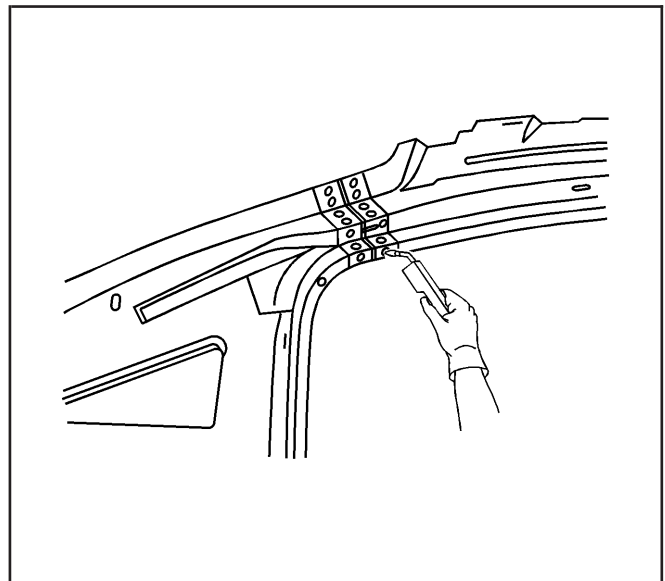
1. Locate the area on the service panel where you will perform sectioning.
2. Measure and mark the cut line location on the service part at the same location as on the vehicle layout.
3. Cut the service panel in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of 1½ times the metal thickness at the sectioning joint.
4. Create 100 mm (4 in) backing plates from the unused portion of the service part for the sectioned areas.
5. Trim the backing plates as necessary to fit behind the panel at the sectioning joints.

Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart.

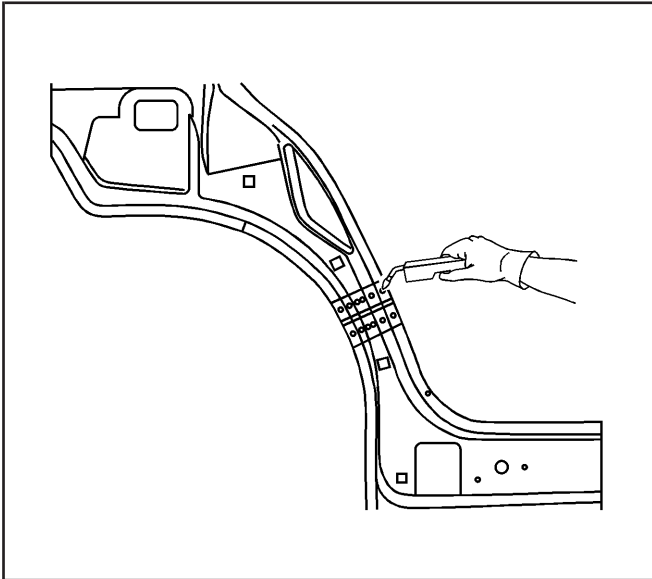
6. Drill 8 mm (5/16 in) plug weld holes along the sectioning areas in the service part, and along the sectioning areas on the vehicle. Drill the plug weld holes 15 mm (5/8 in) from the edges.
7. Drill 8 mm (5/16 in) plug weld holes at the locations noted from the original panel.
8. Prepare all mating surfaces as necessary.
9. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.
10. Fit the backing plates 50 mm (2 in) into the sectioning joints on the vehicle. Clamp the plates in place, and plug weld to the section joint.
11. Weld the plug weld holes on the vehicle half of the backing plates.
12. Position the outer front pillar to the vehicle using 3-dimensional measuring equipment. Clamp the quarter panel in place.



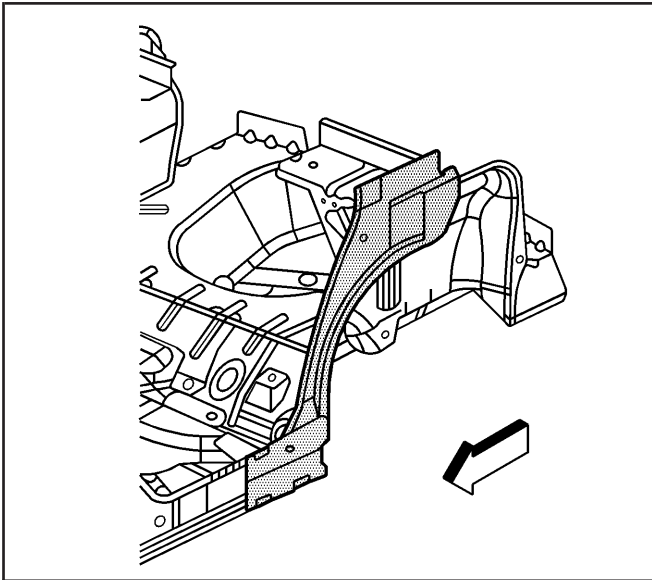
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Important: The dogleg illustration is shown. The rocker panel section joint is similar.

13. Plug weld accordingly.
14. To create a solid weld with minimum heat distortion, make a 25 mm (1 in) stitch weld along the seam with gaps of 25 mm (1 in). Go back and complete the stitch weld.
15. Clean and prepare all of the welded surfaces.
16. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
17. Paint the repaired area.
18. Install all of the related panels and components.
19. Connect the negative battery cable.
20. Enable the SIR system.

Quarter Panel Replacement - Inner

Removal Procedure

Caution: To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

Caution: When performing service on or near the SIR components or the SIR wiring, the SIR system must be disabled. Refer to SIR Disabling and Enabling Zones. Failure to observe the correct procedure could cause deployment of the SIR components, personal injury, or unnecessary SIR system repairs.

1. Disable the SIR system.

Caution: Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect the negative battery cable. Failure to follow these precautions may cause personal injury and/or damage to the vehicle or its components.

2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible. Refer to *Dimensions - Body* on page 3-7.
5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary.