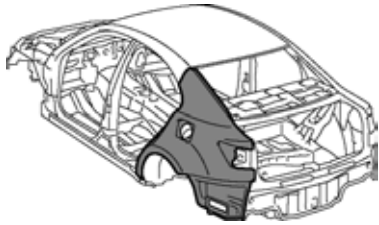


QUARTER PANEL (CUT)









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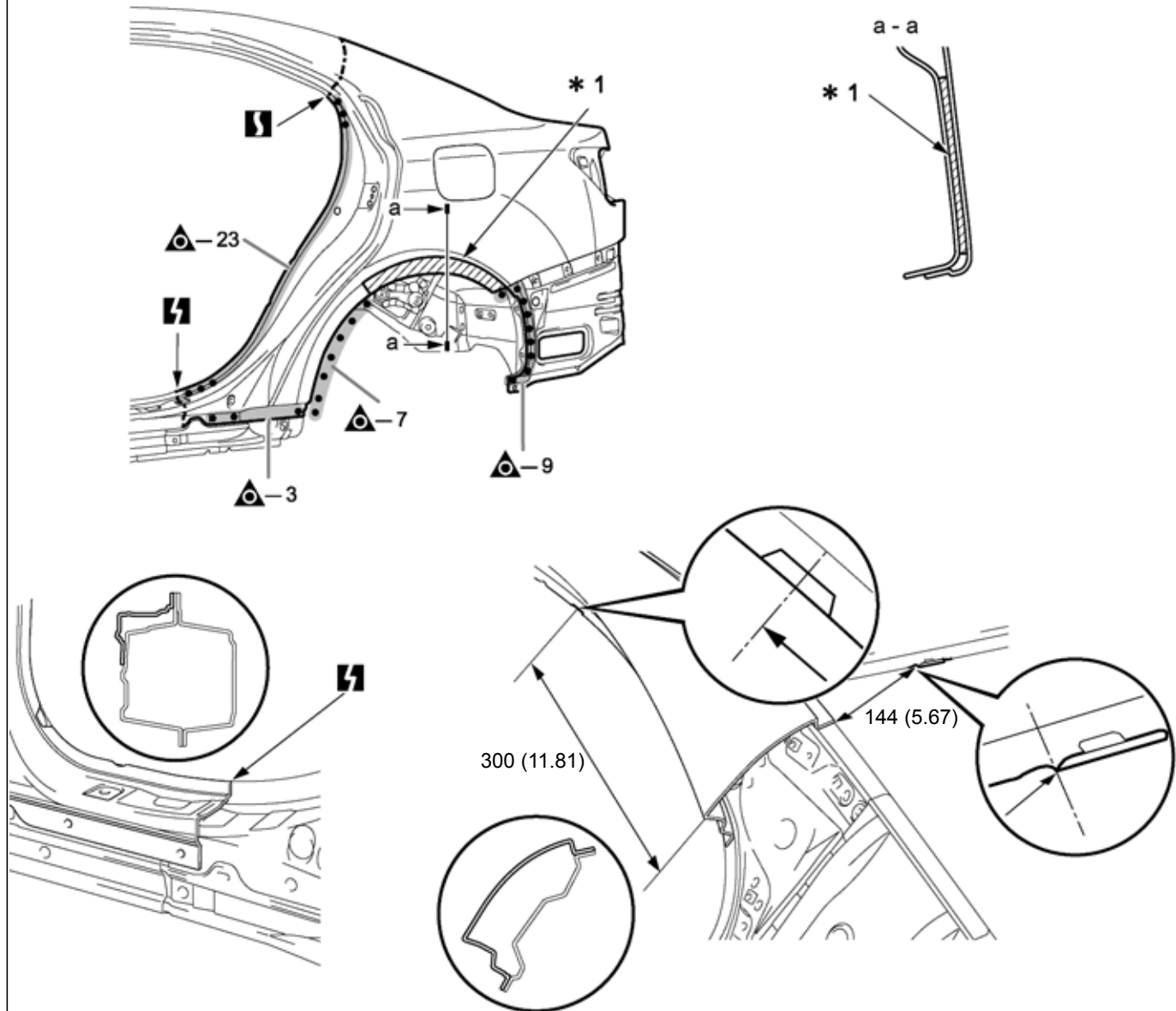
Quarter Panel Replacement Using Adhesive

Work Procedure	Precaution
<ol style="list-style-type: none"> 1. Cut the wheel arch portion. 2. Heat the quarter panel adhesive area and remove the quarter panel. 3. Clean off any adhesive that remains on the vehicle. 4. Using a disc grinder or belt sander, scuff and sand any adhesive that remains on the vehicle. 5. Apply adhesive to the exposed metal areas on the vehicle. Using a spatula, spread the adhesive evenly. 6. Apply adhesive to the vehicle again. 7. Using #60-120 grit sandpaper, scuff the adhesive application area on the new quarter panel. 8. Apply adhesive to the new quarter panel. Using a spatula, spread the adhesive evenly. 9. Using a vise or the palms of your hands, press the quarter panel so that the thickness of the adhesive is even. 10. Complete installation the new quarter panel. 11. Dry the adhesive areas of the new quarter panel. 	<ol style="list-style-type: none"> (1) Using a heater gan or gas burner, heat the quarter panel to 110 to 140_C. Make sure the quarter panel does not warp. (1) Using a heater gan or a gas burner, heat the adhesive to 110 to 140_C. (2) Using a scraper, scrape away the adhesive. (3) If adhesive remains, the strength of any subsequently applied adhesive will be weak. (1) Scuff at a width of approximately 10 mm over the previous adhesive coating. (1) Hardening Time Estimation With dryer or equivalent (60_C) : 60 minutes (complete hardening: 90 minutes) Ambient temperature (25_C) : 12 hours (complete hardening: 24 hours)

Symbol meaning

-    : Remove Weld Points
  : Cut Location for Supply Parts
  : Cut and Join Location
 : Cut with Disc Sander etc.

REMOVAL



mm (in.)

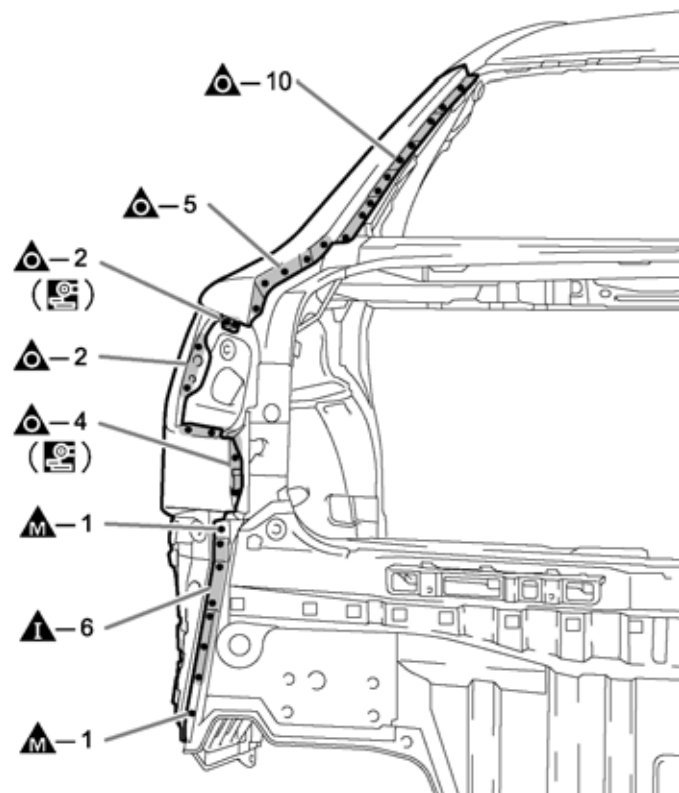
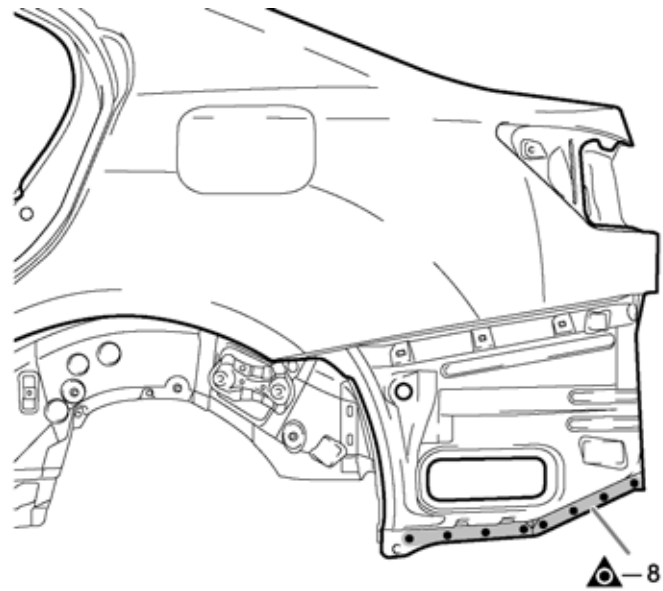
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REMOVAL POINT

- 1 *1 in illustration above indicates where the adhesive is.
- 2 Remove the adhesive application area by heating.

HINT:

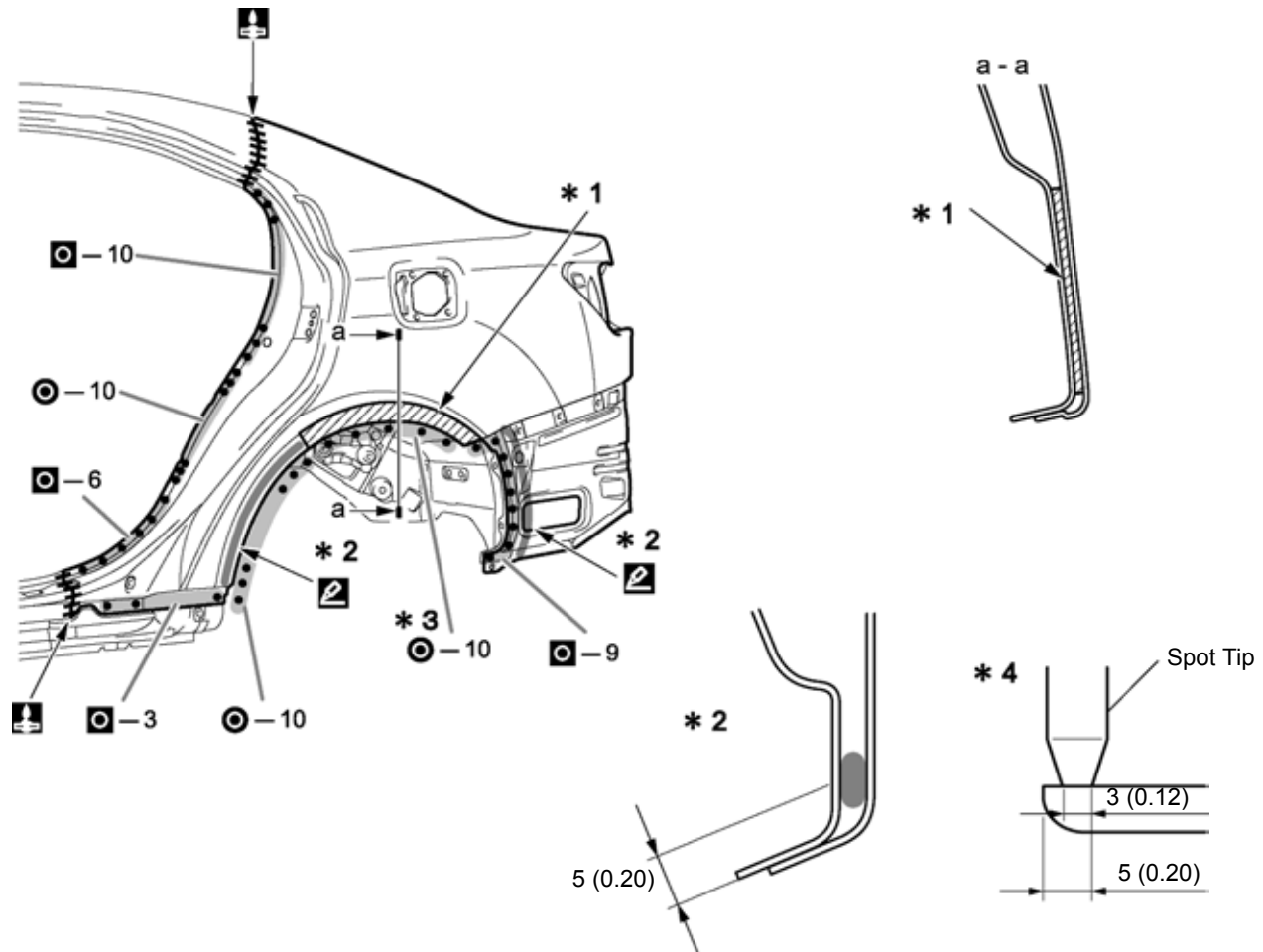
- 1) Heat the adhesive with a heater gun or an gas burner. When heating, do not deform the quarter housing outer panel.



Symbol meaning

 : MIG Plug Weld
  : Spot MIG Weld
  : Butt Weld
  : Body Sealer

INSTALLATION

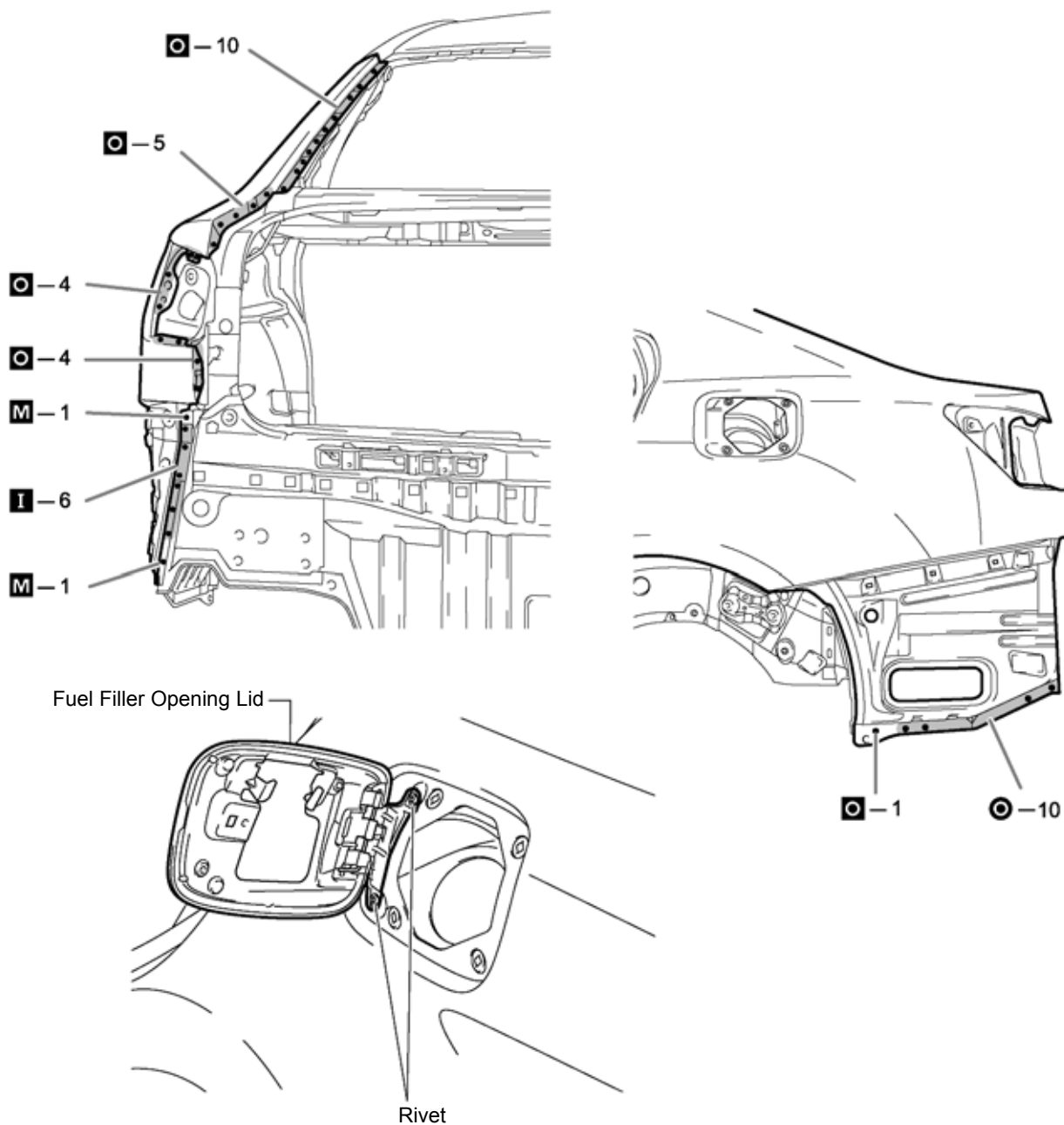


mm (in.)

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INSTALLATION POINT

- 1 Apply adhesive (3M™ Automix™ Panel Bonding Adhesive #8115) to the area indicated by *1 in illustration.
 HINT:
 1) Apply enough adhesive for the panels to stick to each other.
- 2 Before temporarily installing the new parts, apply body sealer to the wheel arch. (*2).
 HINT:
 1) Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
- 3 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 4 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 5 Perform spot-welding on the flange indicated by *3 in the illustration. Modify/cut the spot tip as shown in the illustration (*4) so that it can fit in to the narrow flange.



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INSTALLATION POINT

- 1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 2 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 3 After welding, apply polyurethane foam to the corresponding parts. (See the paint-coating)
- 4 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.