HOW TO USE THIS MANUAL

1. BODY PANEL REPLACEMENT THIS MANUAL

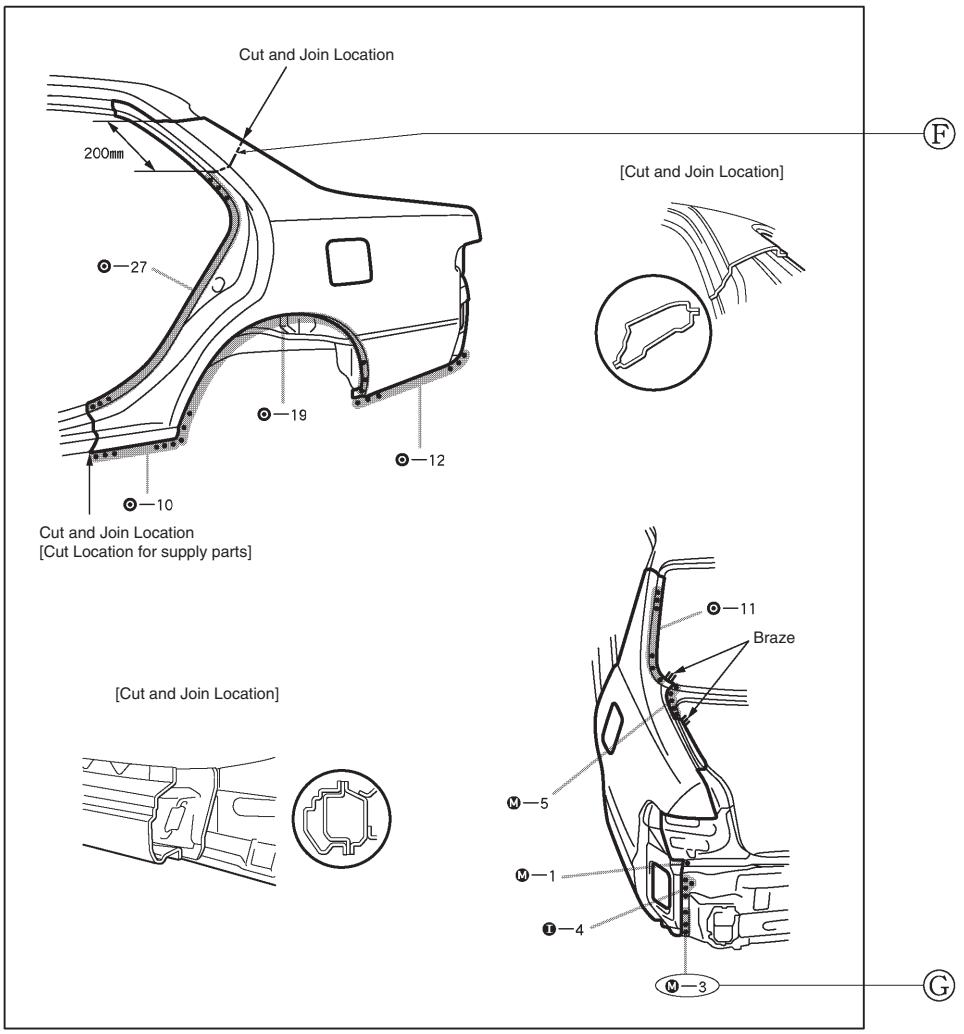
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BODY PANEL REPLACEMENT

Ⓐ **QUARTER PANEL (CUT)**
REPLACEMENT

Ⓑ 1. REMOVE QUARTER PANEL
(a) Cut and join the part at the location as shown below.

Ⓒ



Ⓐ : **REPLACEMENT PARTS**
QUARTER PANEL (CUT)

Replacement method
(ASSY) . . . . Assembly replacement
(CUT) . . . . . Major cutting (less than 1/2 of parts used)
(CUT-H) . . . Half cutting (about 1/2 of parts used)
(CUT-P) . . . Partial cutting (most of parts used)

Replacement Parts

Ⓑ : **REMOVAL DIAGRAM**
Describes in detail removal of the damaged parts involving repair by cutting.

Ⓒ : **REMOVAL GUIDE**
Provides additional information to more efficiently help you perform the removal.

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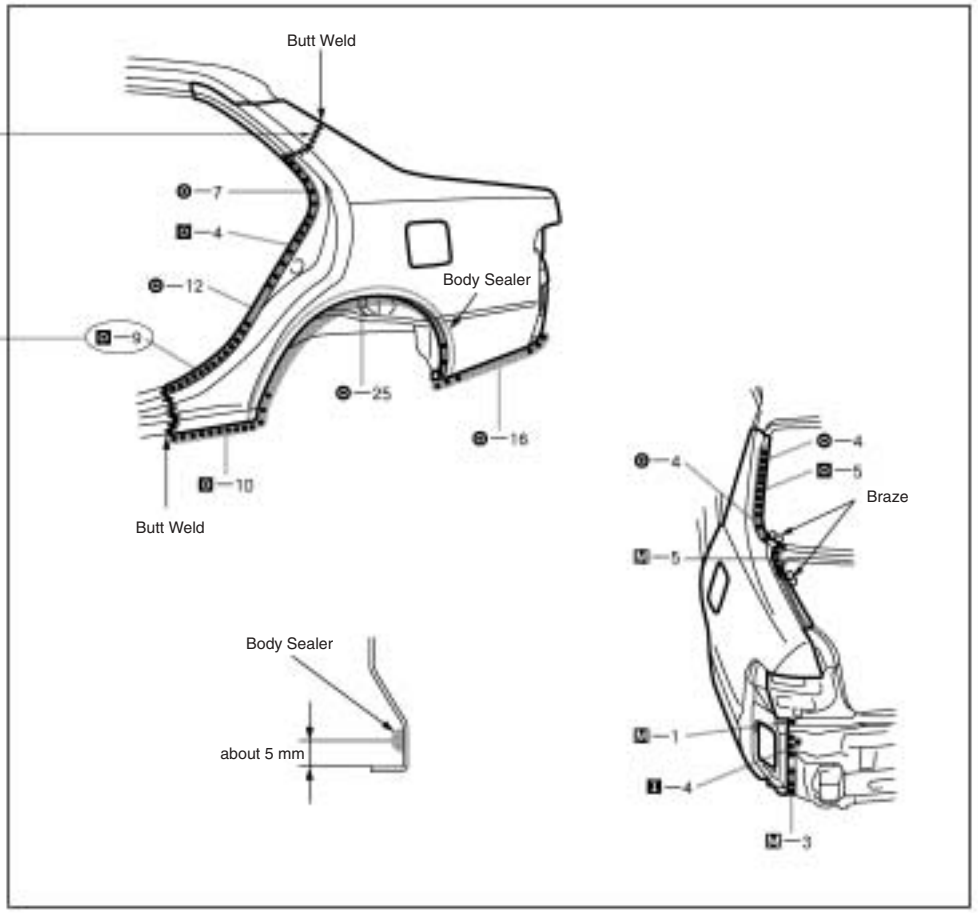
BODY PANEL REPLACEMENT

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2. INSTALL QUARTER PANEL

HINT:
Inspect the fitting of the rear door, luggage compartment door and rear combination light, etc., before welding, since this affects the appearance of the finish, (a) Before temporarily installing the new parts, apply body sealer to the wheel arch.

HINT:
• Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.
• Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
• For other sealing points, refer to section PC.



3. MEASURING THE OPENING PORTION DIMENSIONS (See page BP-XX)
4. APPLYING SEALER TO THE INSIDE OF THE VEHICLE (See page PC-XX)
5. APPLYING SEALER TO THE REAR, LUGGAGE COMPARTMENT (See page PC-XX)
6. CHARGING THE POLYURETHANE FOAM (See page PC-XX)
7. APPLYING ANTI-RUST AGENT

(a) After applying the top coat layer, apply the anti-rust agent to the inside of the necked section structural weld spots.

Ⓓ : **INSTALLATION GUIDE**
Provides additional information to more efficiently help you perform the installation.

Ⓔ : **INSTALLATION DIAGRAM**
Describes in detail installation of the new parts involving repair by welding and/or cutting, but excluding painting.

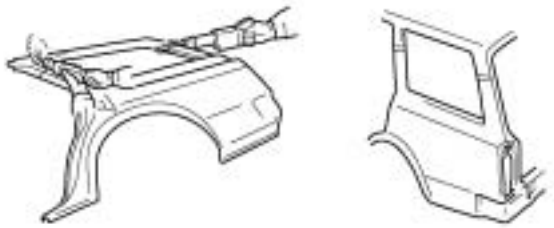
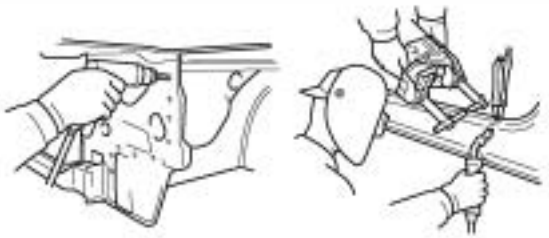
Ⓕ : **SYMBOLS**
See page SS-7.

Ⓖ : **ILLUSTRATION OF WELD POINTS**
Weld method and panel position symbols.
See page SS-8.

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2. SYMBOLS

The following symbols are used in the welding diagrams in section BP of this manual to indicate cutting areas and the types of weld required.

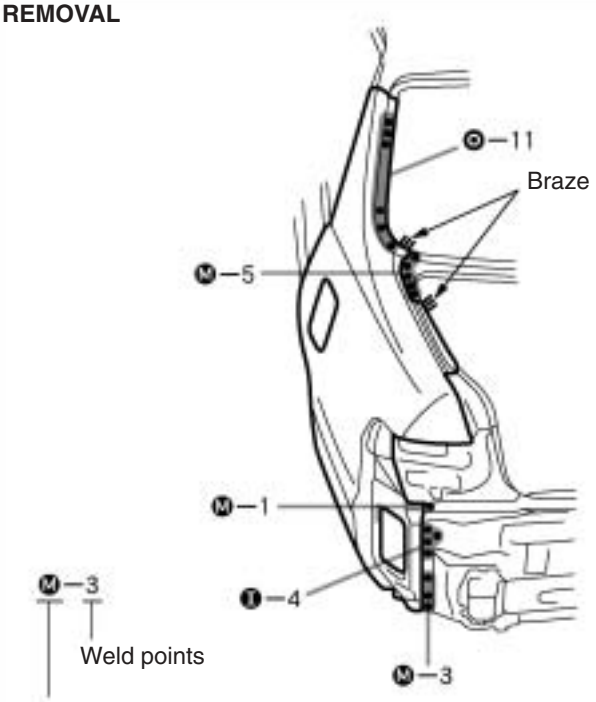
SYMBOLS	MEANING	ILLUSTRATION
	SAW CUT OR ROUGH CUT	
	REMOVE BRAZE	
	WELD POINTS	
O M I O M I	SPOT WELD OR MIG PLUG WELD (See Page SS-8)	
	CONTINUOUS MIG WELD (BUTT WELD OR TACK WELD)	
	BRAZE	
	BODY SEALER	

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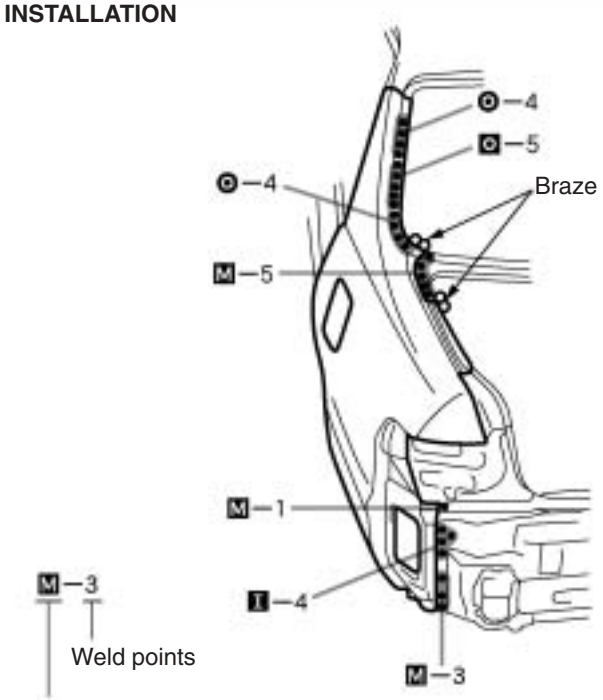
3. ILLUSTRATION OF WELD POINT SYMBOLS

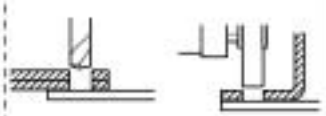
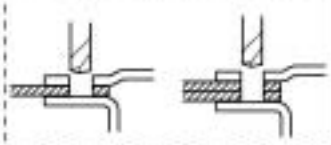
EXAMPLE:

REMOVAL

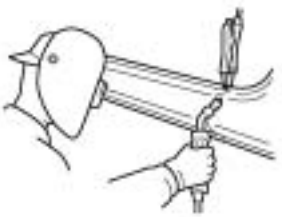
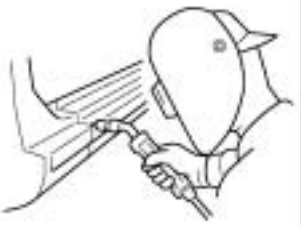


INSTALLATION



SYMBOL	MEANING	ILLUSTRATION
O M I	Remove Weld Points	
O	(Outside)	
M	(Middle)	
I	(Inside)	

HINT: Panel position symbols are as seen from the working posture.

SYMBOL	MEANING	ILLUSTRATION
O M I	Spot Weld	
O M I	MIG Plug Weld	
+	Spot MIG Weld	

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