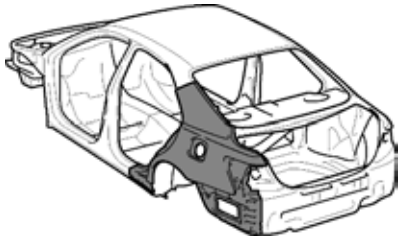
QUARTER PANEL (CUT)


F25735A

Quarter Panel Replacement Using Adhesive

Work Procedure		Precaution	
1	Cut the wheel arch portion.		
2	Heat the quarter panel adhesive area and remove the quarter panel.	(1)	Using an industrial dryer or oxygen acetylene burner, heat the quarter panel to 110 to 140°C. Make sure the quarter panel does not warp.
3	Clean off any adhesive that remains on the vehicle.	(1)	Using 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.
4	Using a disc grinder or belt sander, scuff and sand any adhesive that remains on the vehicle.	(1)	Scuff at a width of approximately 10 mm over the previous adhesive coating.
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 #60-240 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.	(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)

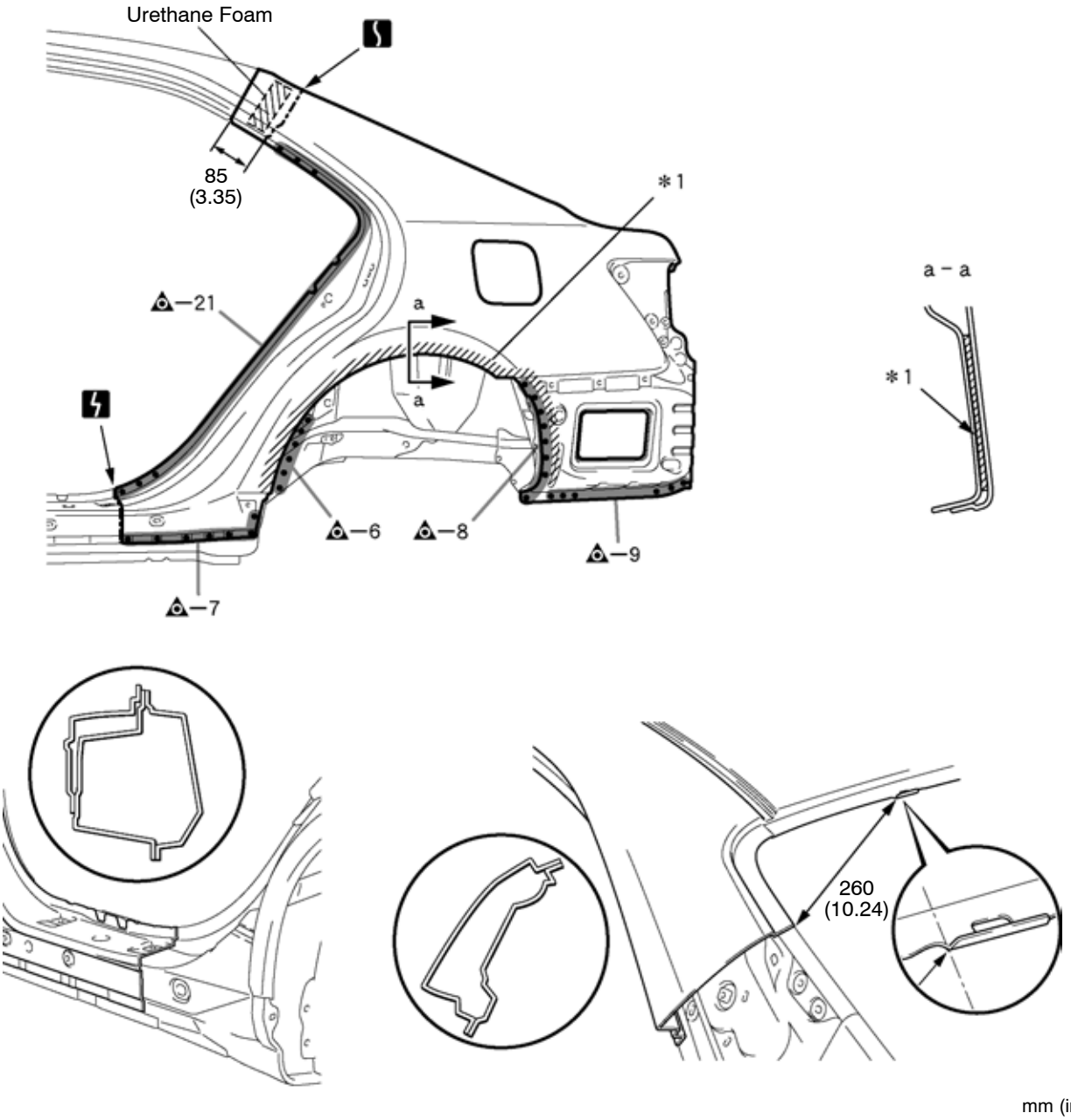
Symbol meaning

: Remove Weld Points : Cut with disc sander, etc. : Cut Location for Supply Parts

: Cut and Join Location : Braze

F25735B

REMOVAL



mm (in.)

F25735

REMOVAL POINT

1 *1 in illustration above indicates where the adhesive is located.

2 Roughly cut open the wheel arch of the panel so that the adhesive can be reached. Cut through the adhesive with a cut chisel to remove the panel.

HINT:

1) If the cut chisel cannot reach the adhesive, heat the adhesive with a heat gun, oxygen-acetylene burner. When heating, do not deform the quarter housing outer panel.

Symbol meaning

: Remove Weld Points

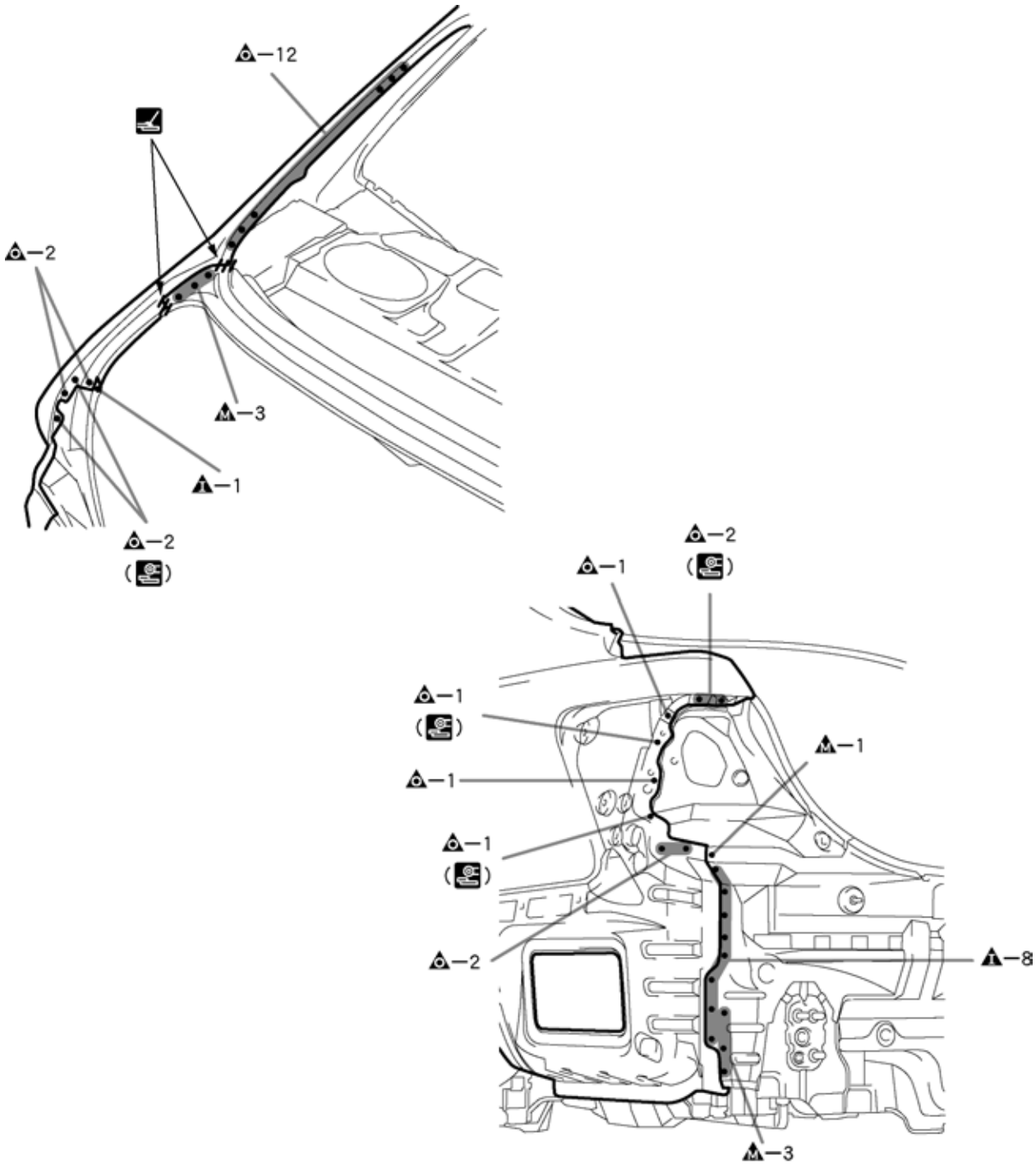
: Cut with disc sander, etc.

: Cut and Join Location

: Cut Location for Supply Parts

: Braze

F25735B



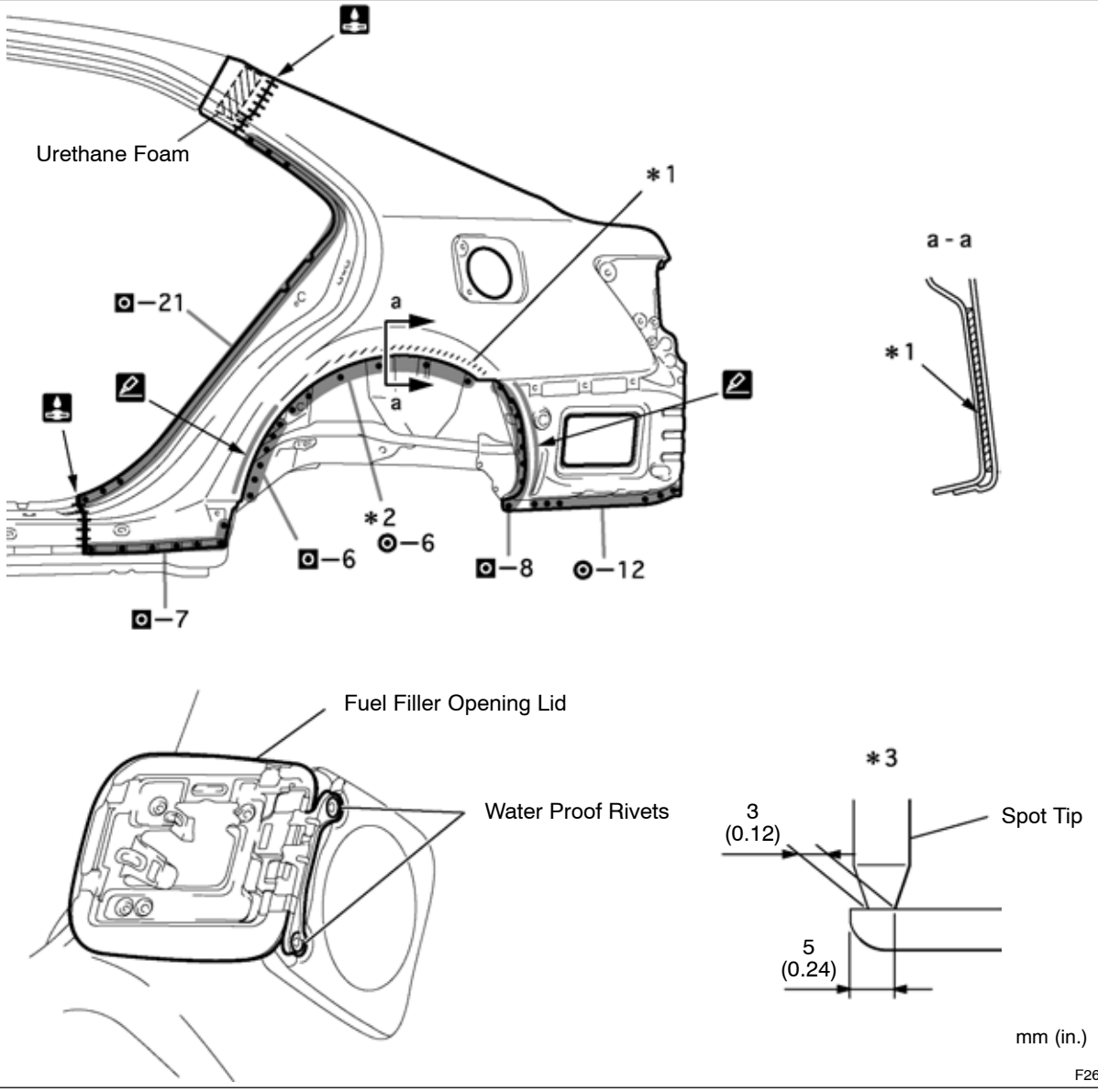
F25736

Symbol meaning

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

F25737B

INSTALLATION



F26354

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

2 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)

3 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.

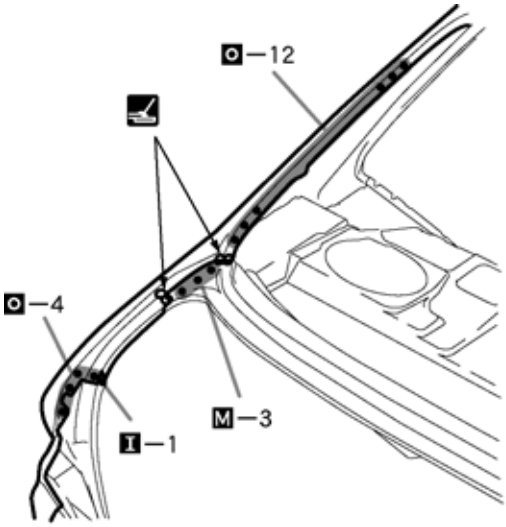
4 Perform spot-welding on the flange indicated by *2 in the illustration. Modify/cut the spot tip as shown in the illustration (*3) so that it can fit in to the narrow flange.

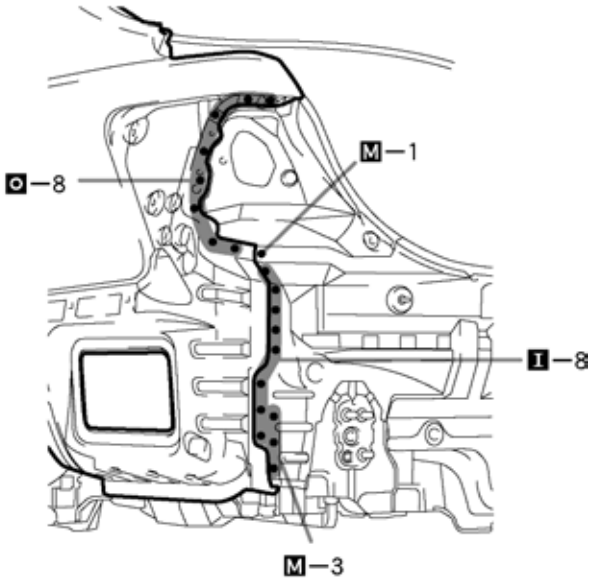
5 Before installing a new part, apply body sealer.
HINT:
1) Apply sealer in an even, continuous bead.

Symbol meaning

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

F25737B





F25738

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 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)
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.