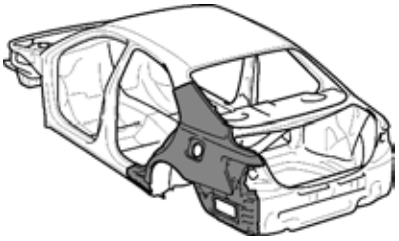
# QUARTER PANEL (CUT)


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<br>With dryer or equivalent (60°C)<br>: 60 minutes (complete hardening: 90 minutes)<br>Ambient temperature (25°C)<br>: 12 hours (complete hardening: 24 hours) |

Symbol meaning

: Remove Weld Points

: Cut with disc sander, etc.

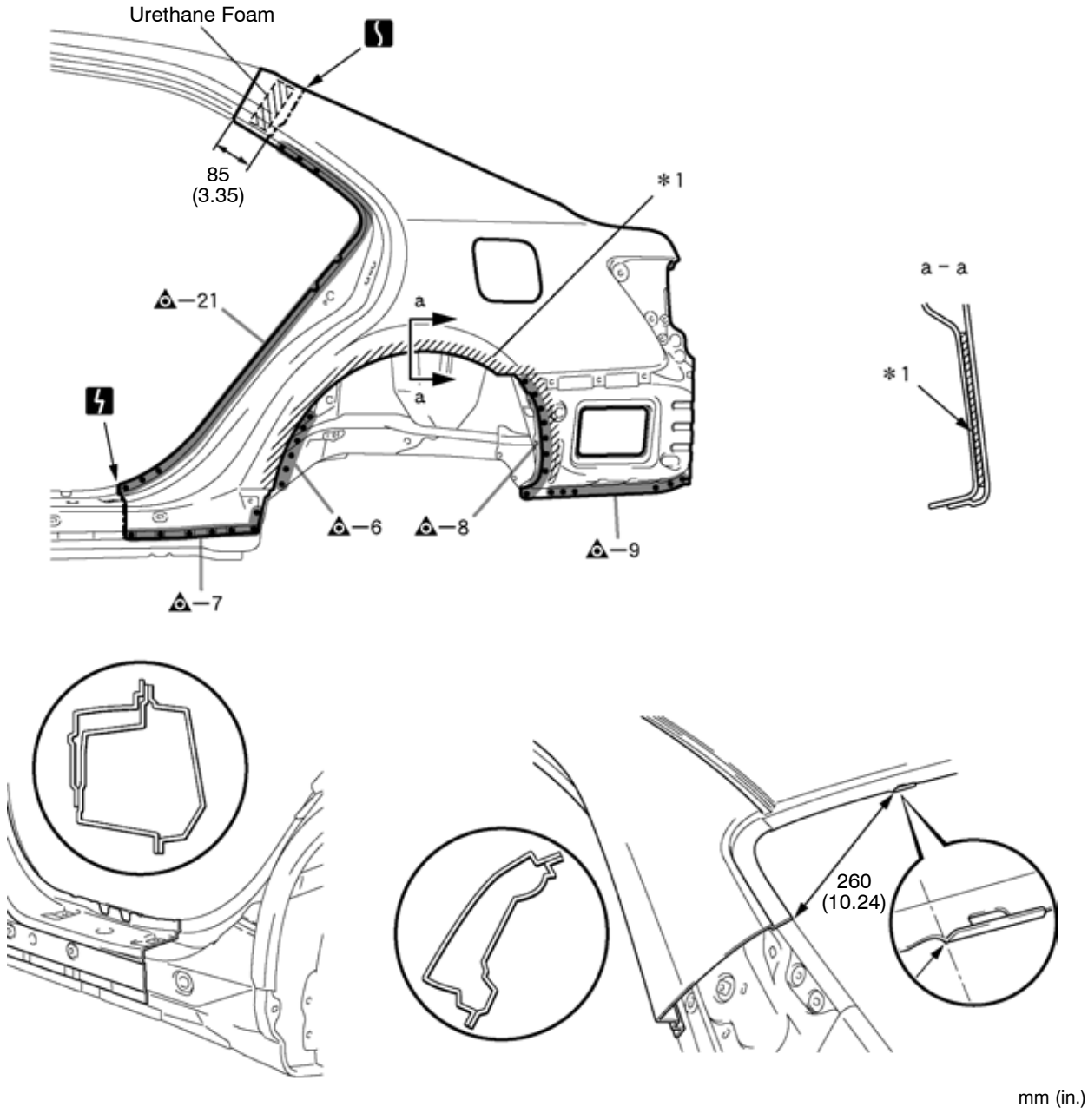
: Cut and Join Location

: Cut Location for Supply Parts

: Braze

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## REMOVAL




mm (in.)

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### REMOVAL POINT

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

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

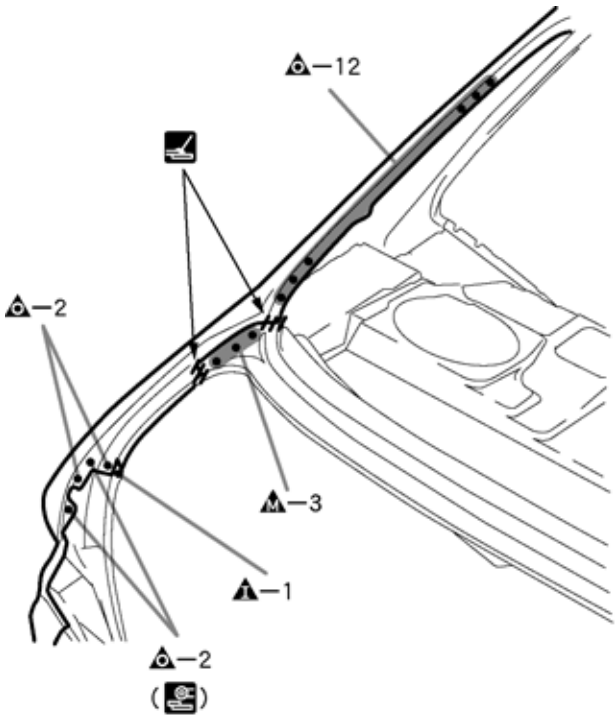
: Cut with disc sander, etc.

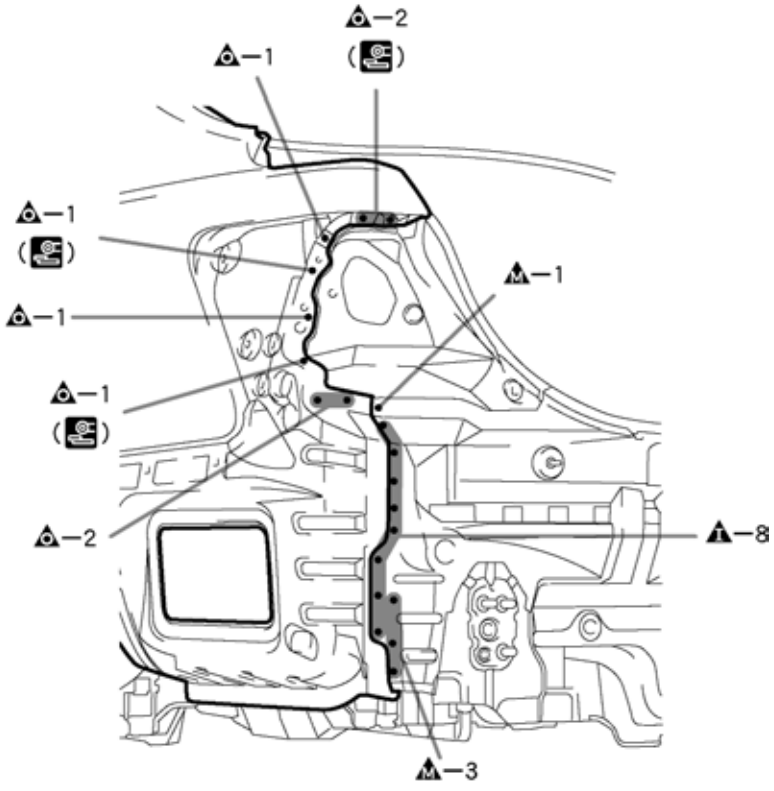
: Cut and Join Location

: Cut Location for Supply Parts

: Braze

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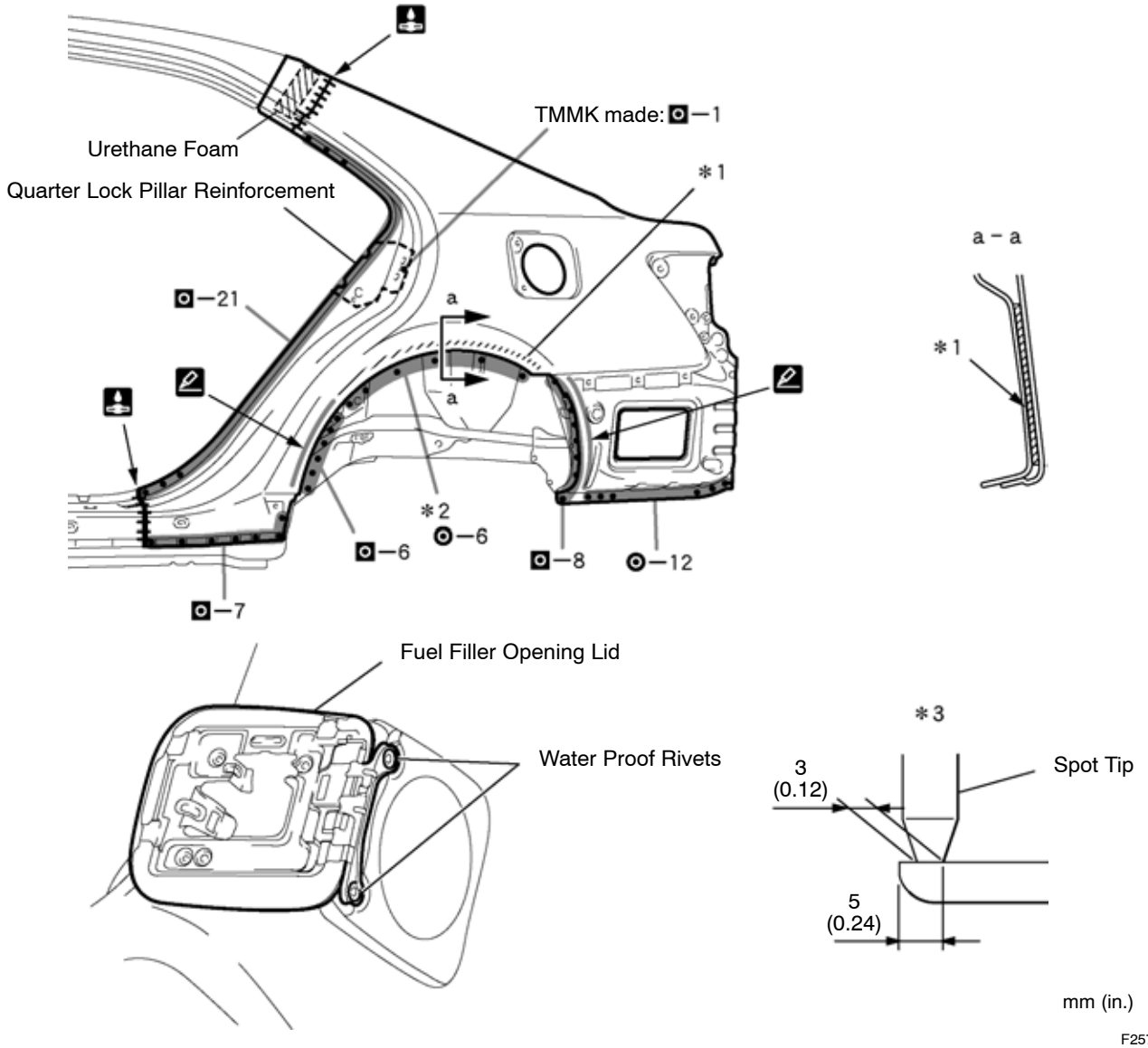

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Symbol meaning

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

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## INSTALLATION




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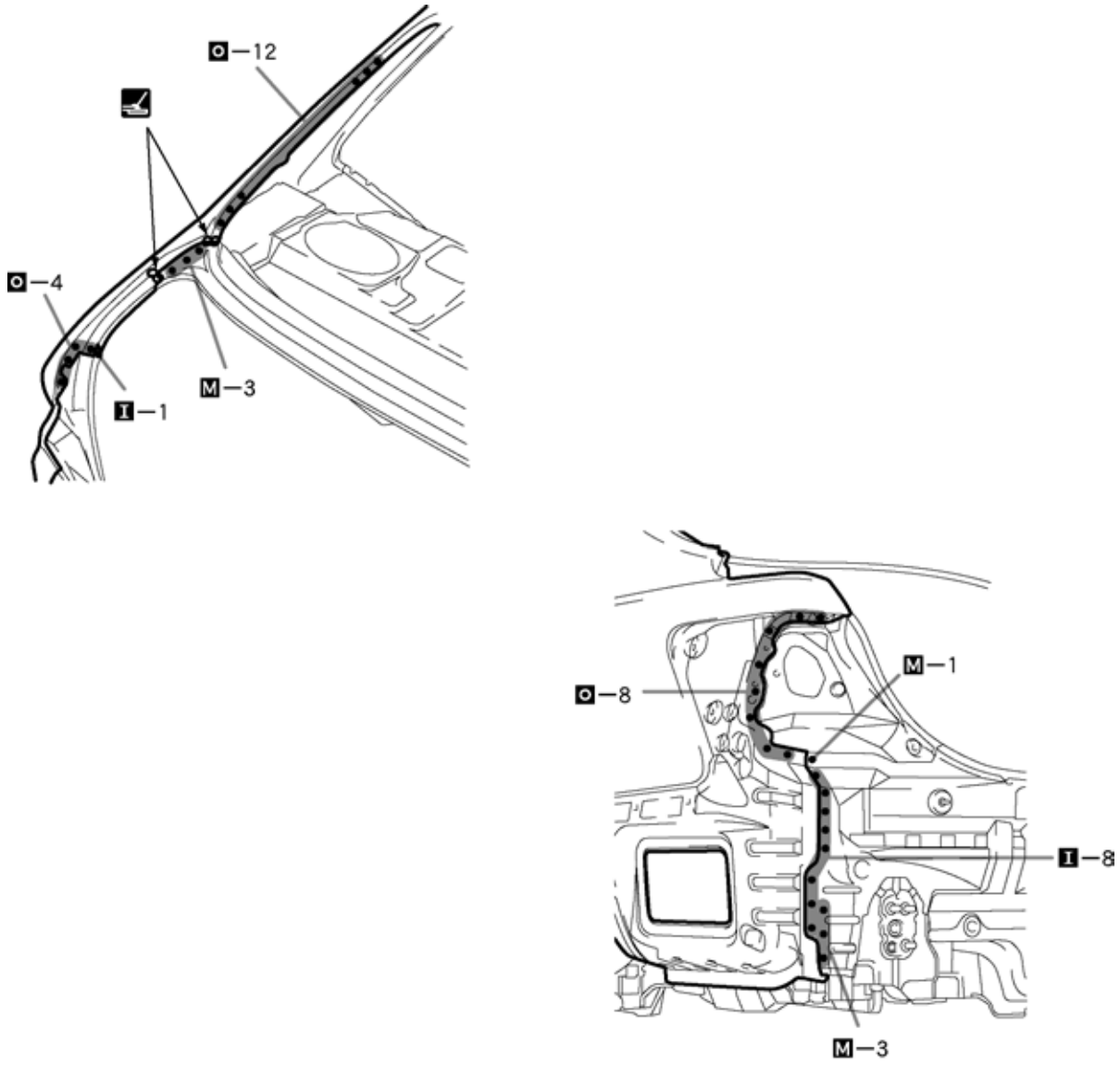
## INSTALLATION POINT

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 sick 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 ana 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 the 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.