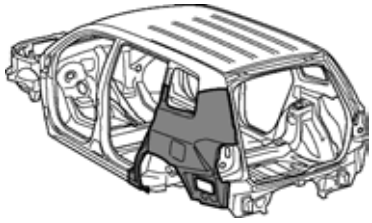
# QUARTER PANEL (CUT)


F28410A

Quarter Panel Replacement Using Adhesive

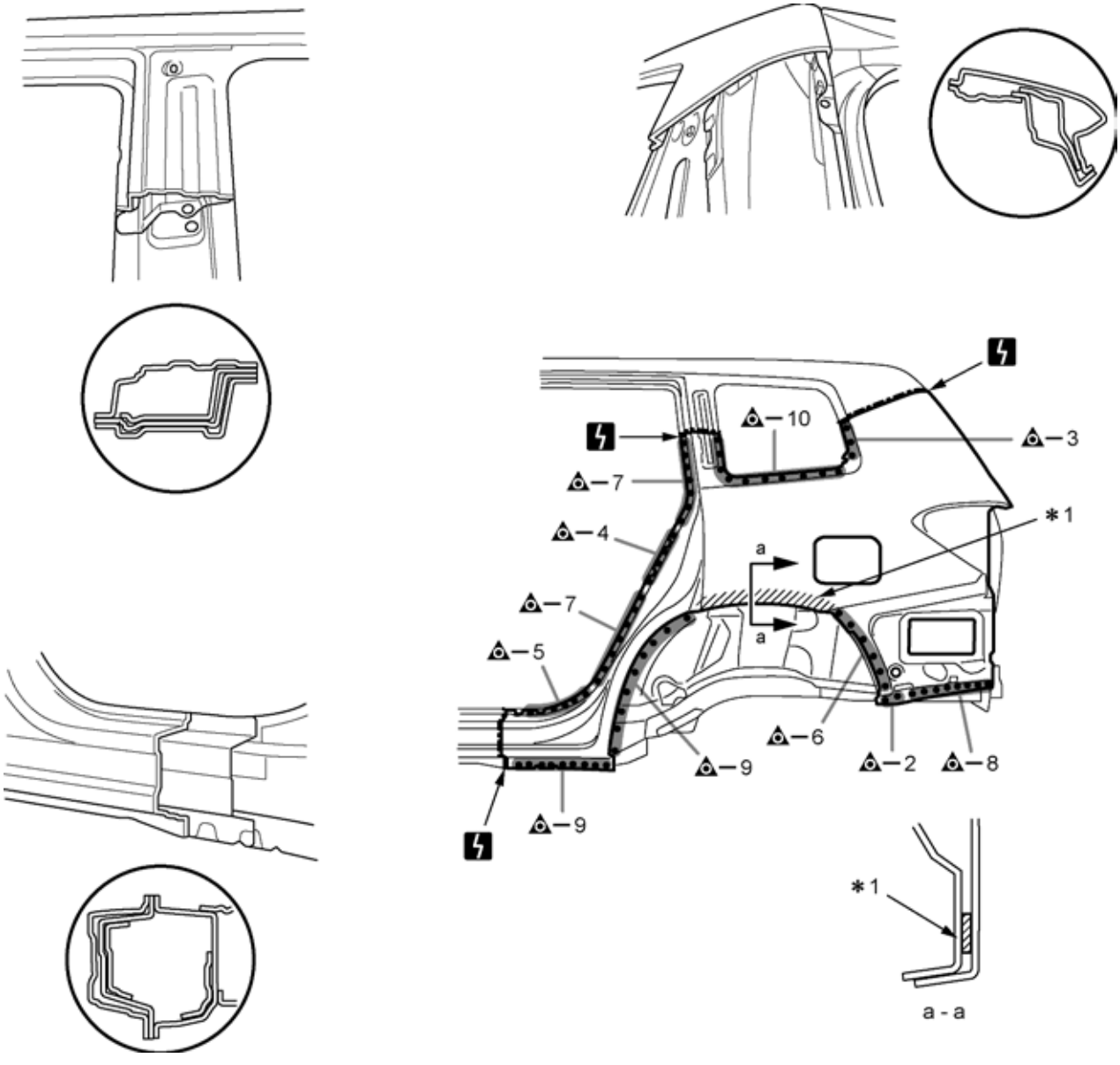
| Work Procedure | | Precaution | |
|---|---|---|---|
| 1 | Cut the wheel arch portion. | | |
| 2 | Heat the quarter panel adhesive area and remove the quarter panel. | (1) | Using an industrial heater gun or gas burner, heat the quarter panel to 110 to 140°C. Make sure the quarter panel does not warp. |
| 3 | Clean off any adhesive that remains on the vehicle. | (1) | Using an industrial heater gun or 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 (0.39 in.) 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 #60-120 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 grip 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 Location for Supply Parts

F28410B

**REMOVAL**




F28410

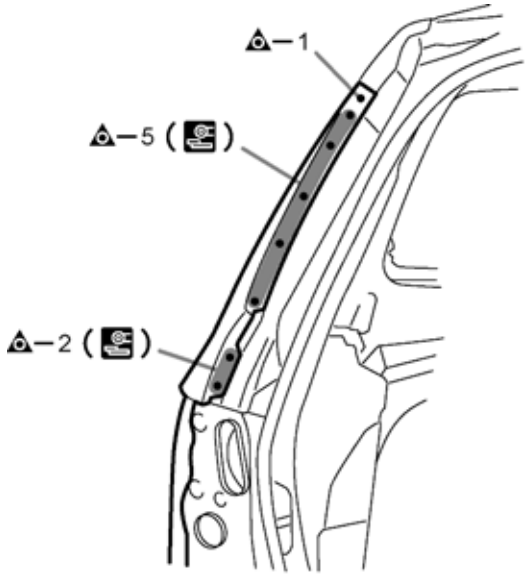
**REMOVAL POINT**

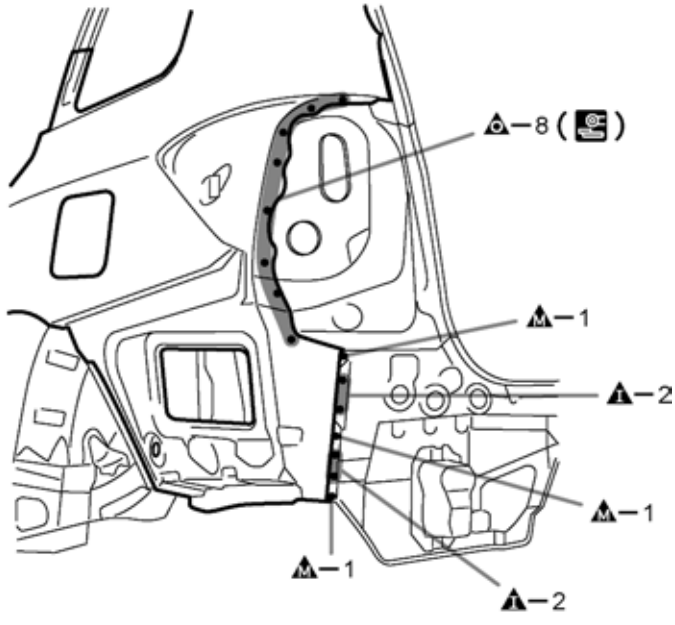
1 *1 in illustration above indicates where the adhesive is located.

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

*HINT:*

*1) In cases where the adhesive cannot be removed with a cut chisel, heat the adhesive with an industrial heater gun or gas burner taking care not to cause panel deformation by overheating.*



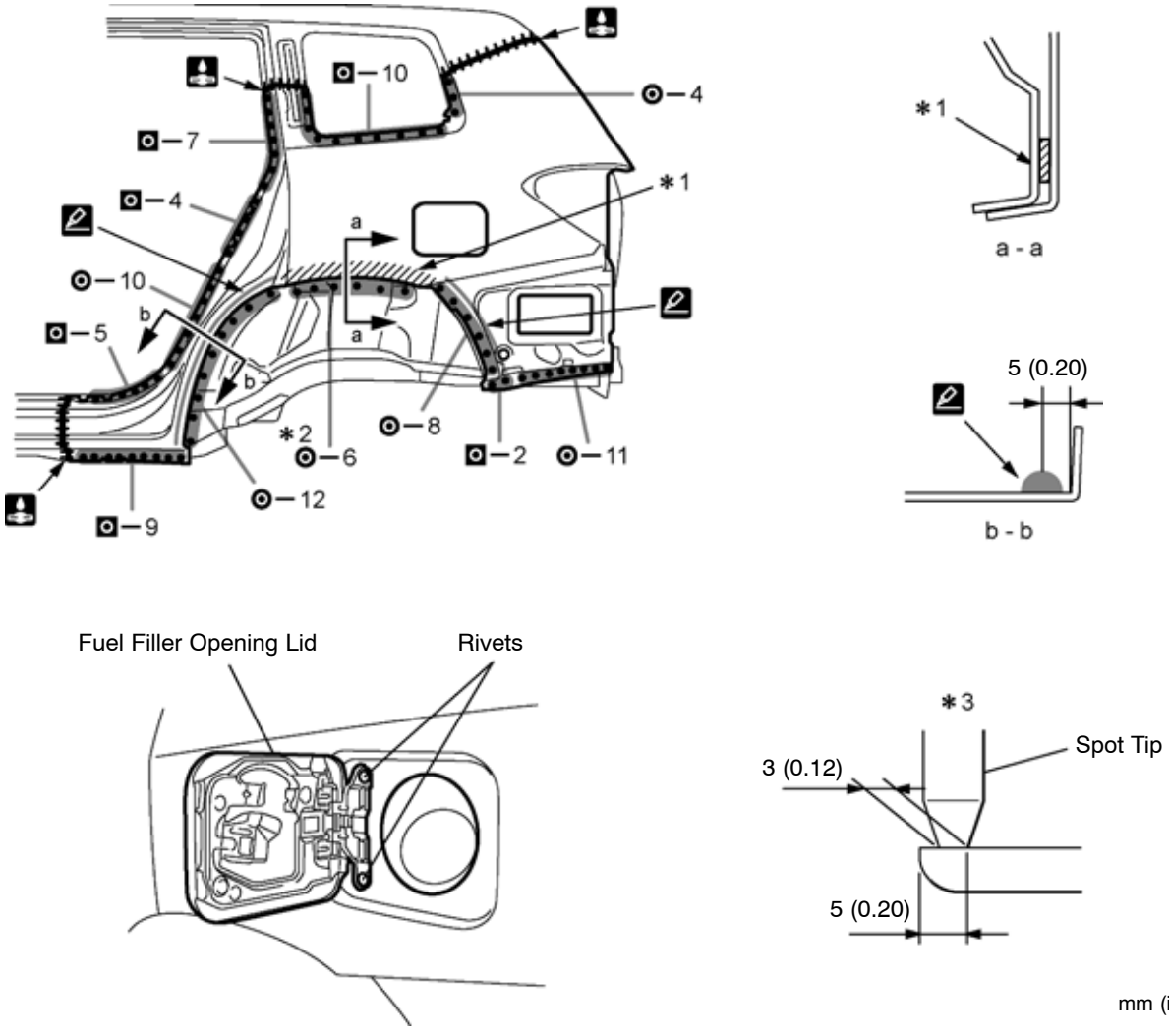

F28411

Symbol meaning

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

F28412B

**INSTALLATION**




F28412

**INSTALLATION POINT**

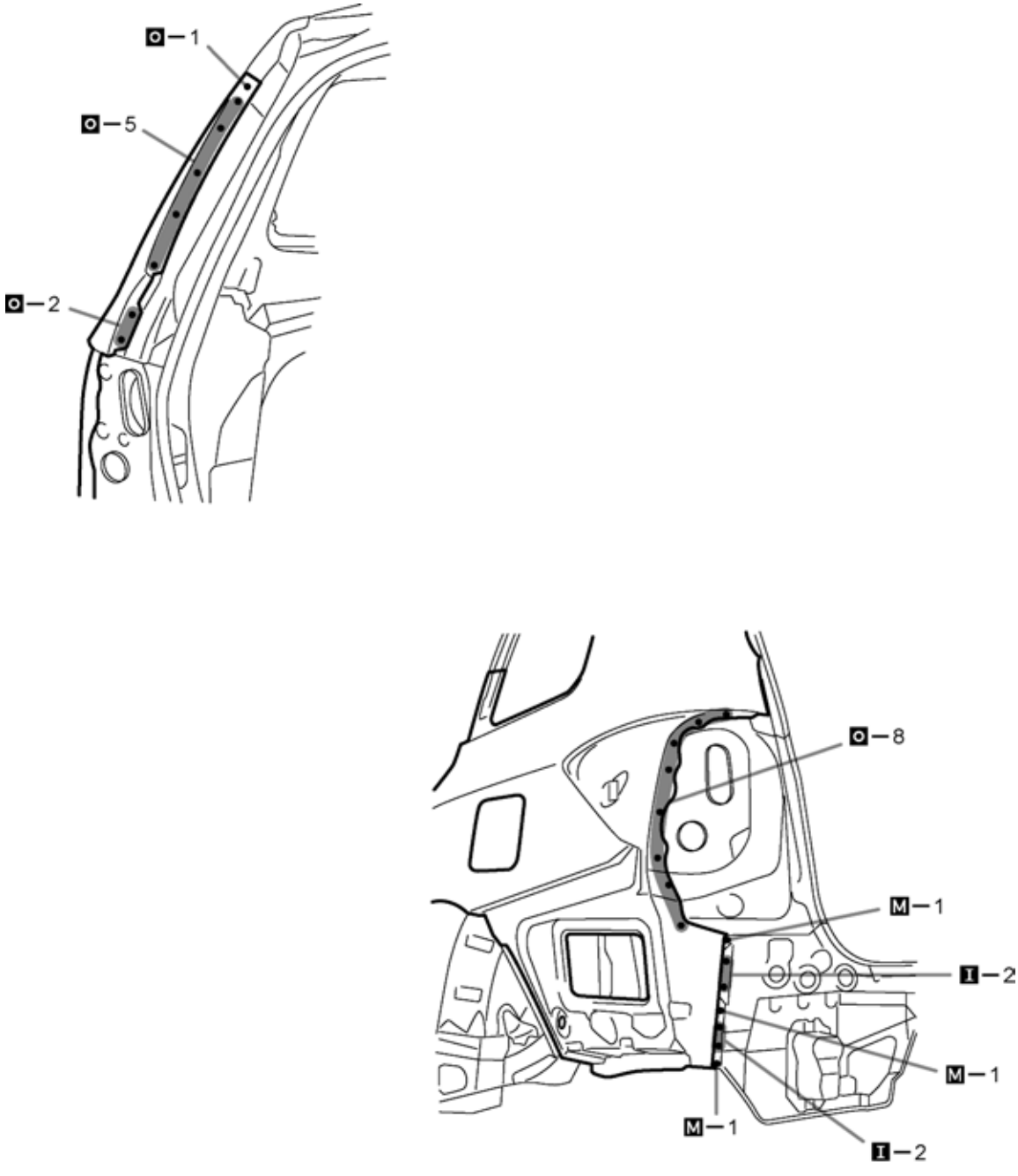
1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

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 Before temporarily installing the new parts, apply body sealer to the wheel arch.
*HINT:*
*1) Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.*
*2) Apply sealer evenly, about 3 – 4mm (0.12 – 0.16 in.) in diameter.*

4 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.*

5 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.




F28413

**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 foamed sealing material to the corresponding parts. (See the paint·coating)
4 After welding, apply body sealer 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.