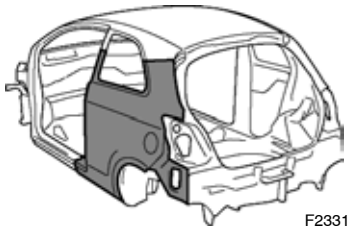
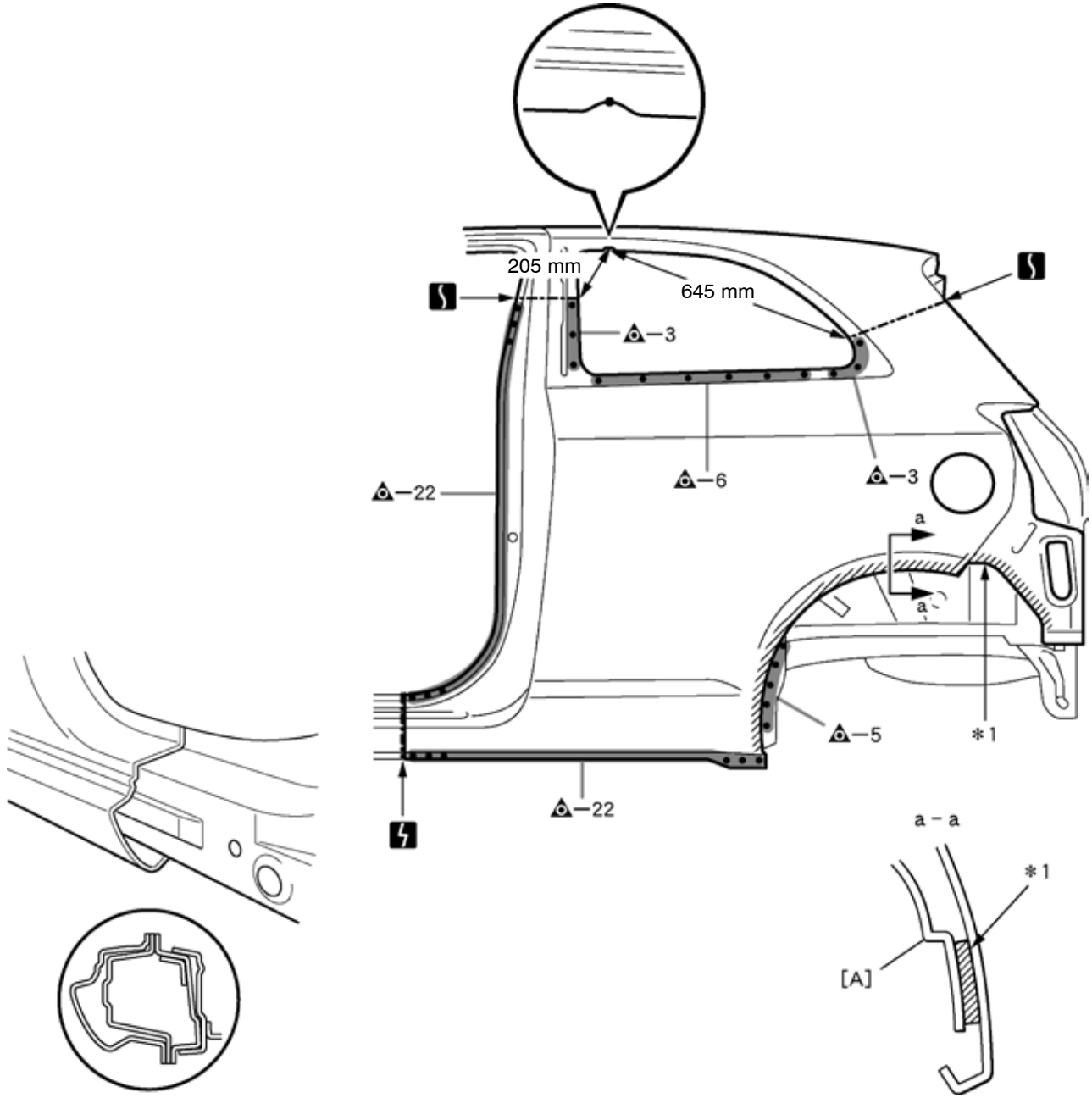
QUARTER PANEL (CUT): Hatchback 3 Door


F23313A

REPLACEMENT

REMOVAL



F23313

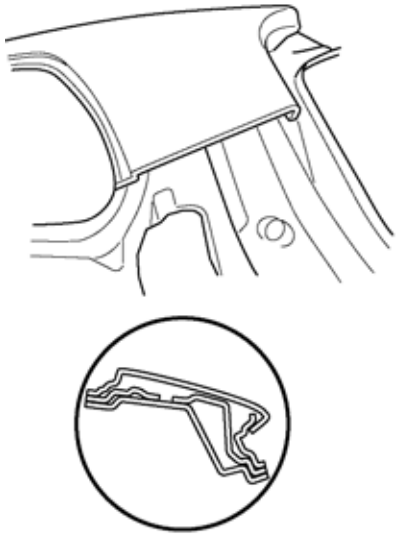
POINT

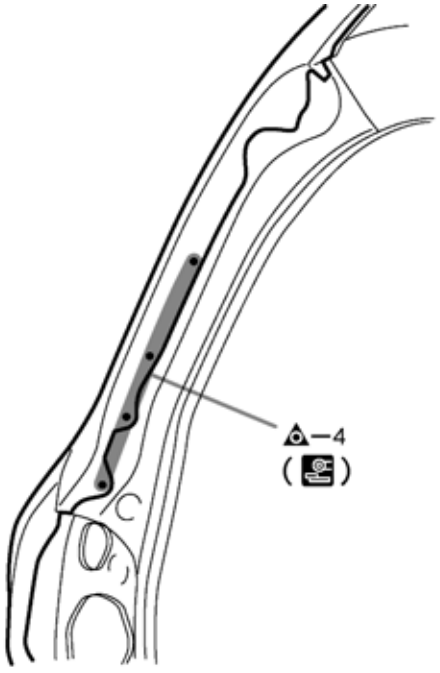
1 *1: The hatched area indicates the adhesive application area.

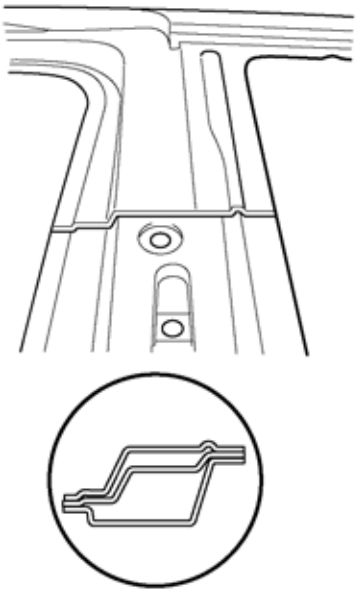
PART NAME

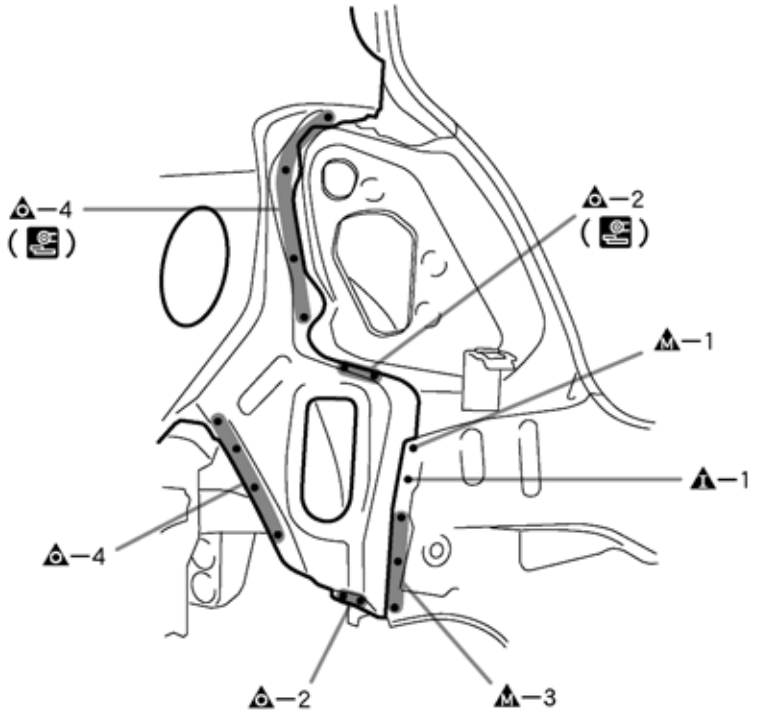
[A] Quarter Wheel Housing Outer Panel

205 mm (8.07 in.) 645 mm (25.39 in.)





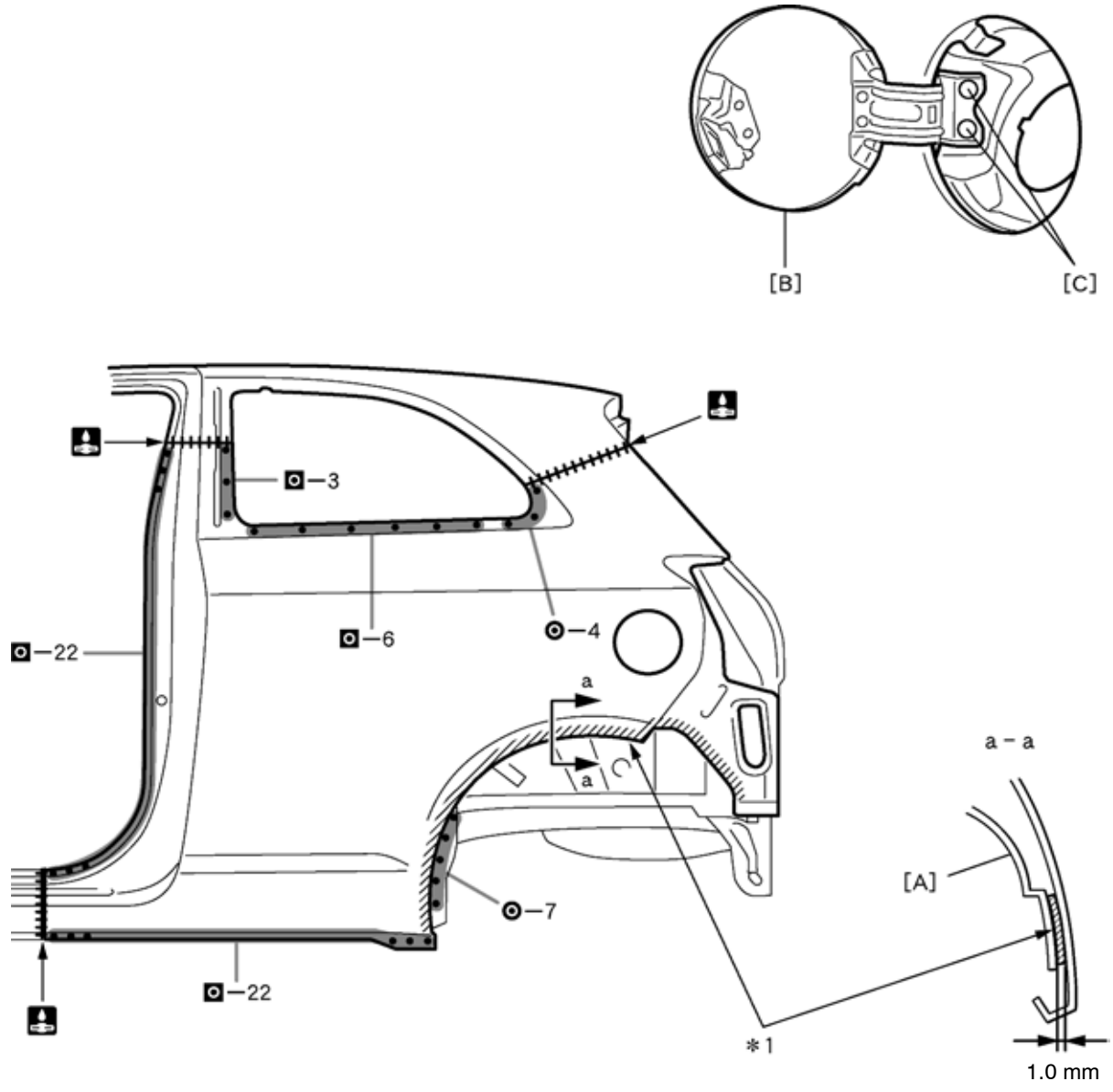




F23314

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply polyurethane foam to the corresponding parts.
- After welding, apply body sealer and undercoating to the corresponding parts.
- After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



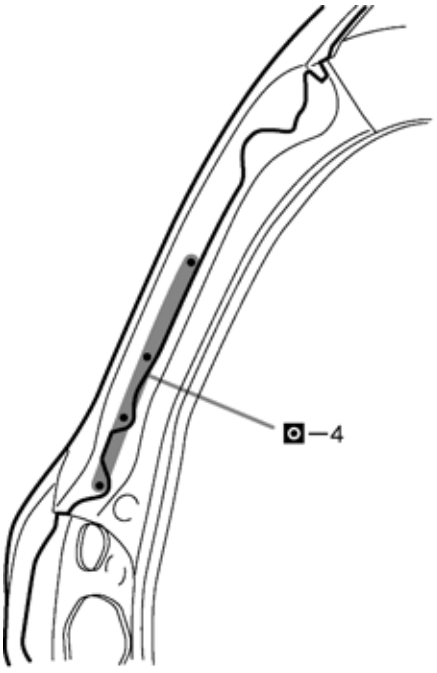
POINT

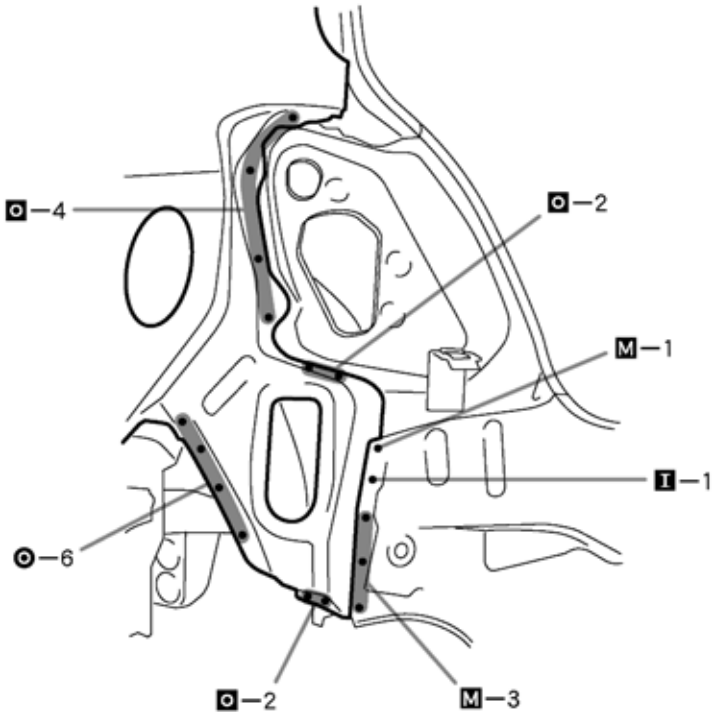
1 *1: The hatched area indicates the adhesive application area.

PART NAME

[A] Quarter Wheel Housing Outer Panel [B] Fuel Filler Opening Lid [C] Rivet

1.0 mm (0.04 in.)



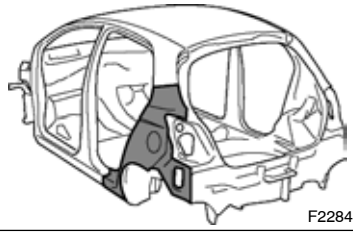


F23316

POINT

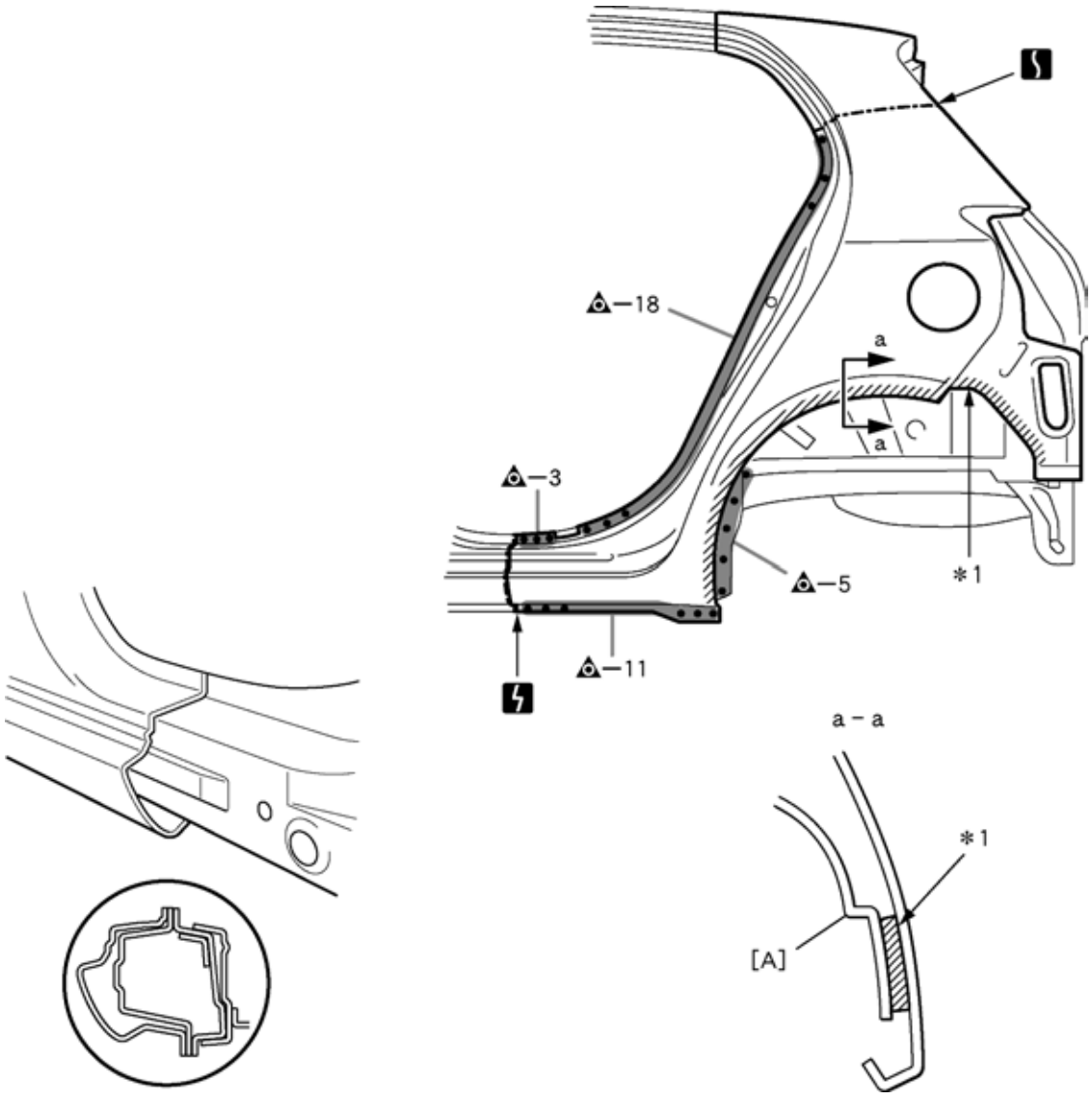
1 Inspect the front door, back door, rear combination light and other related parts before welding as this affects the appearance of the finish.

QUARTER PANEL (CUT): Hatchback 5 Door


F22847A

REPLACEMENT

REMOVAL



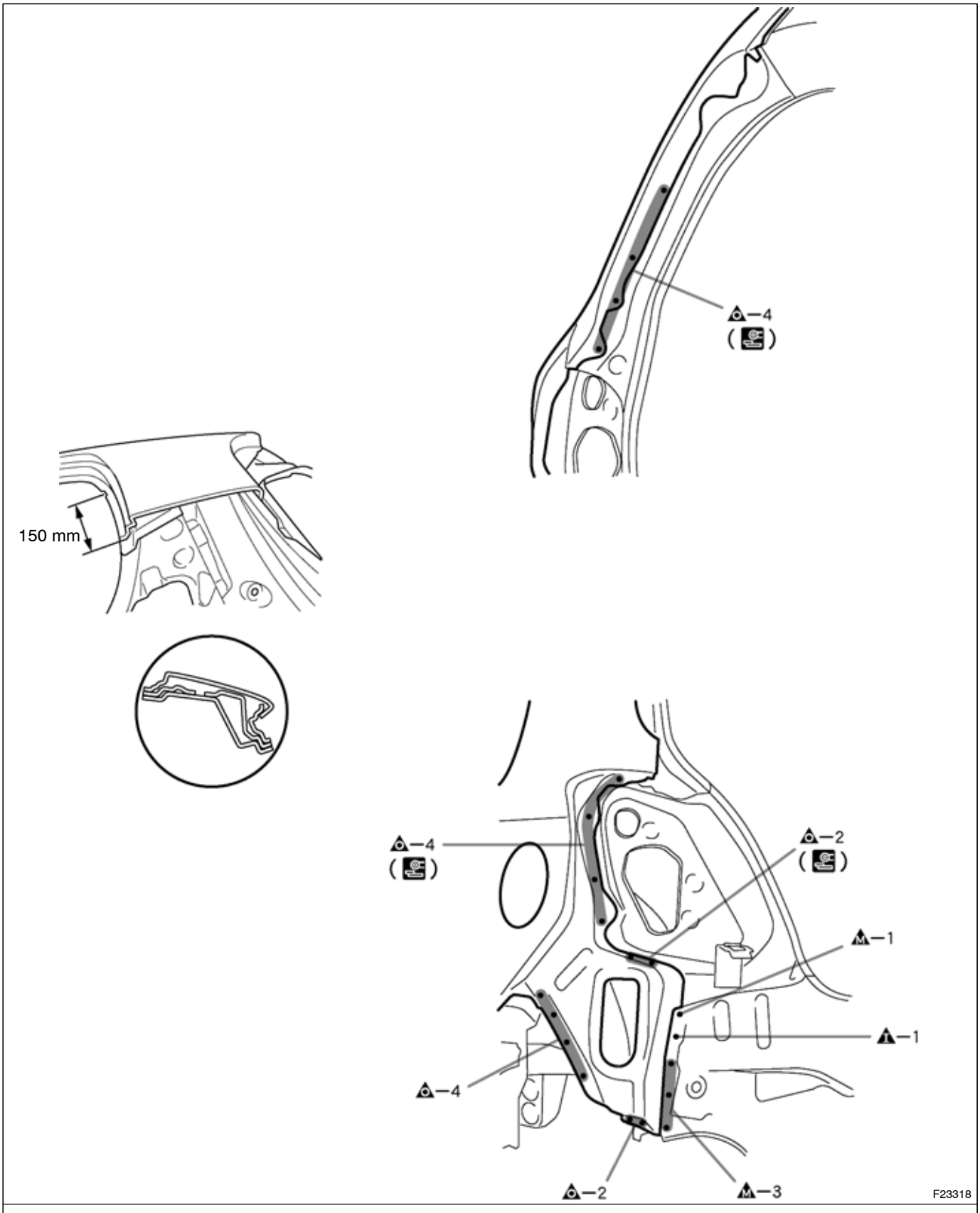
F23317

POINT

1 *1: The hatched area indicates the adhesive application area.

PART NAME

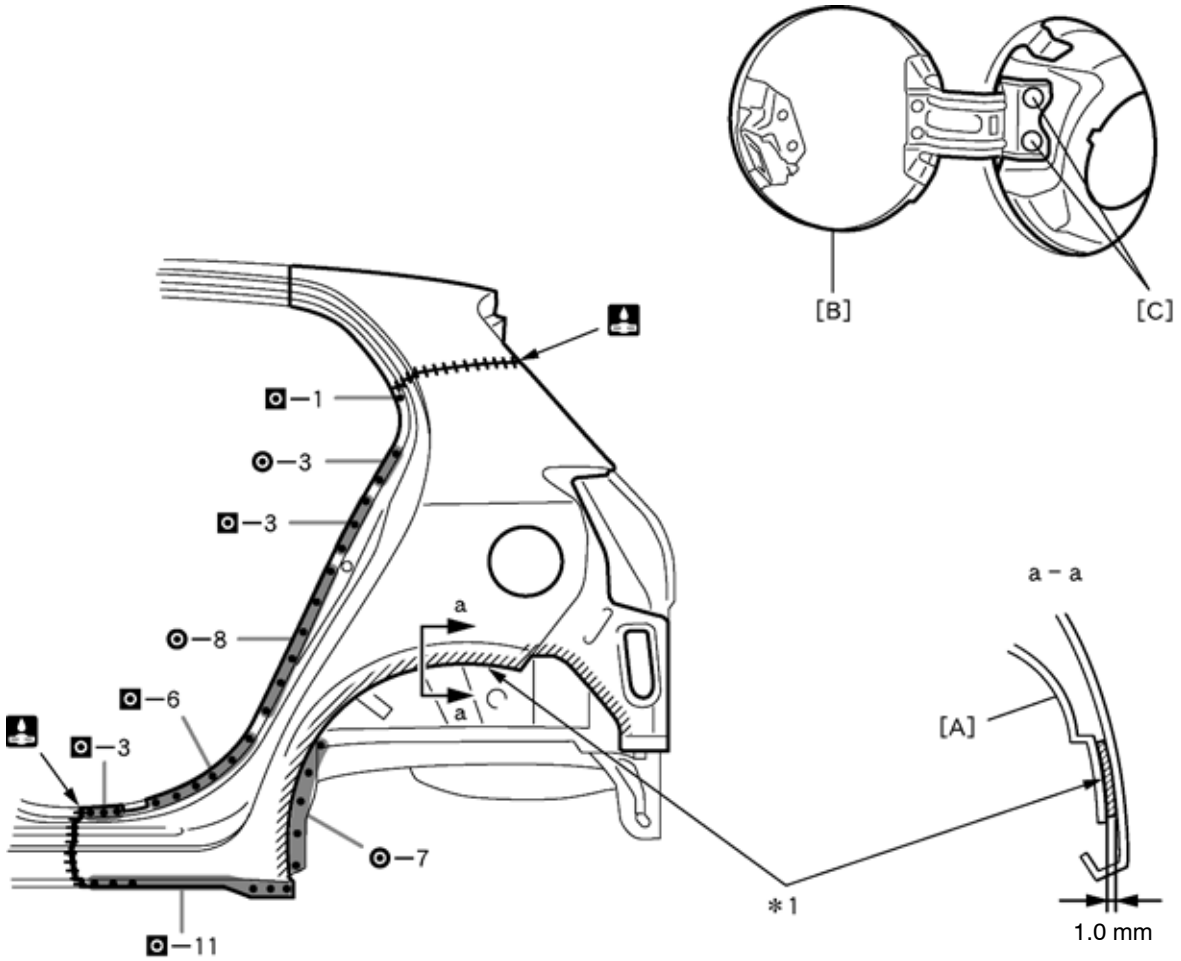
[A] Quarter Wheel Housing Outer Panel



150 mm (5.91in.)

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply polyurethane foam to the corresponding parts.
- After welding, apply body sealer and undercoating to the corresponding parts.
- After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



F23319

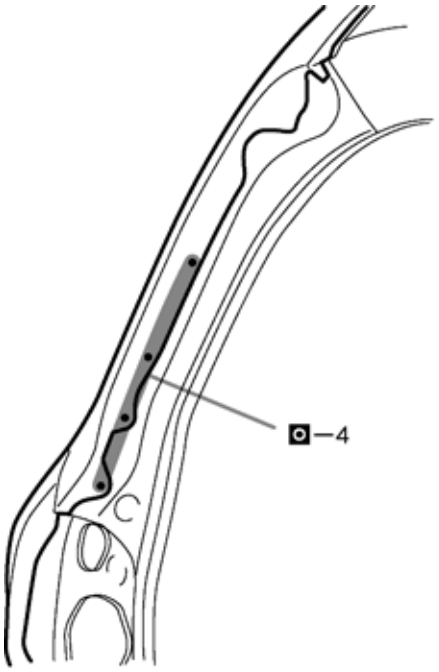
POINT

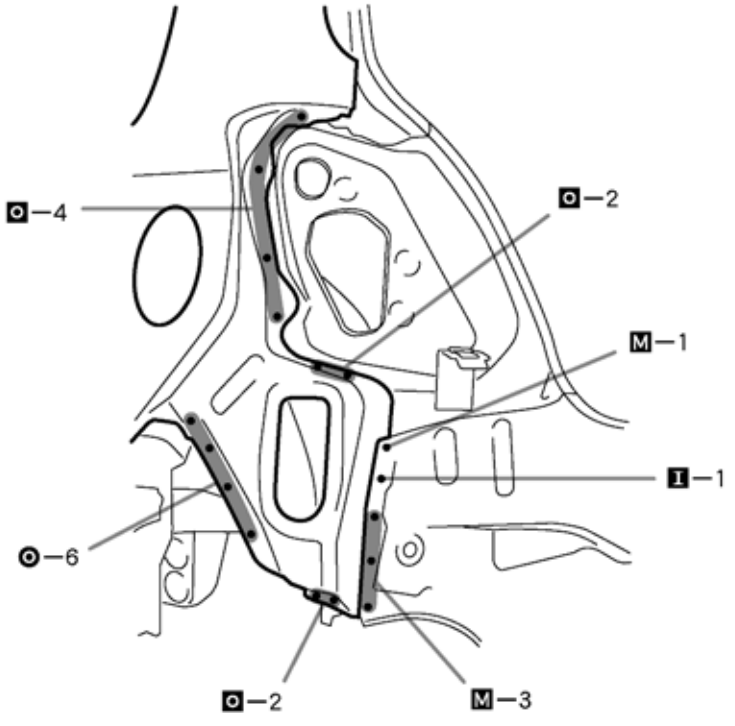
1 *1: The hatched area indicates the adhesive application area.

PART NAME

[A] Quarter Wheel Housing Outer Panel [B] Fuel Filler Opening Lid [C] Rivet

1.0 mm (0.04 in.)





F23320

POINT

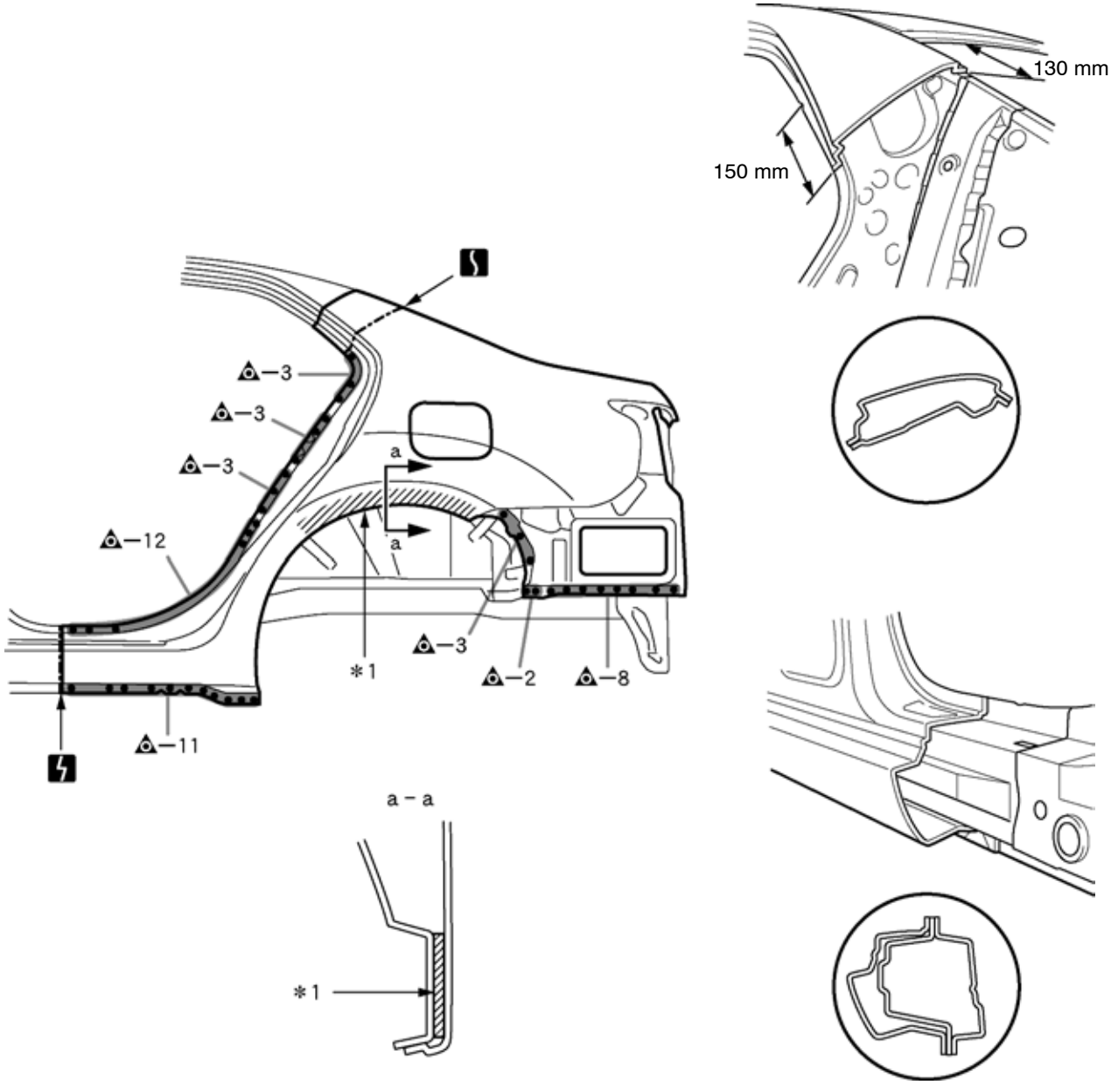
1 Inspect the front door, back door, rear combination light and other related parts before welding as this affects the appearance of the finish.

QUARTER PANEL (CUT): Sedan


F24834A

REPLACEMENT

REMOVAL



F24834-1

POINT

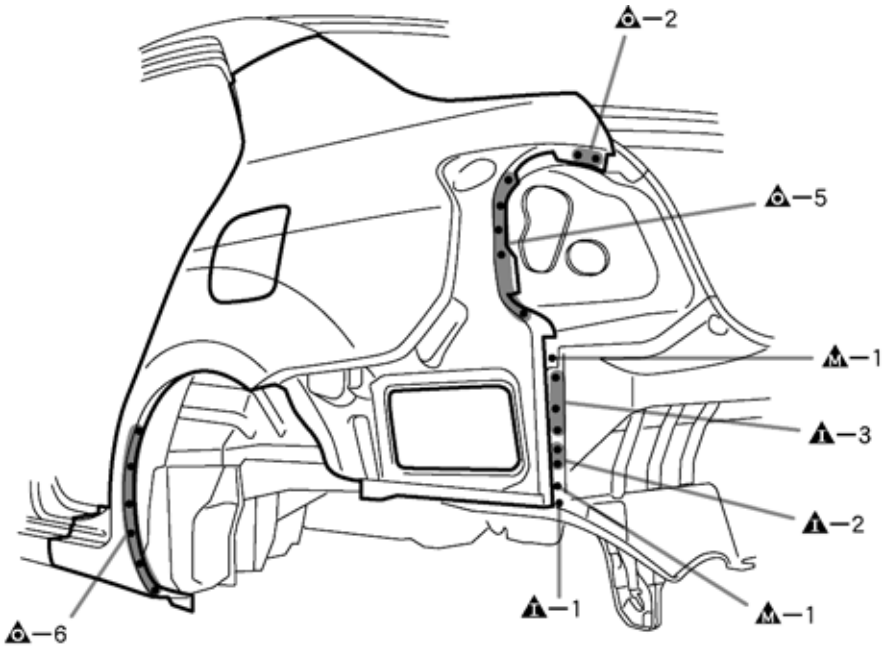
1 *1: in illustration above indicates where the adhesive is.

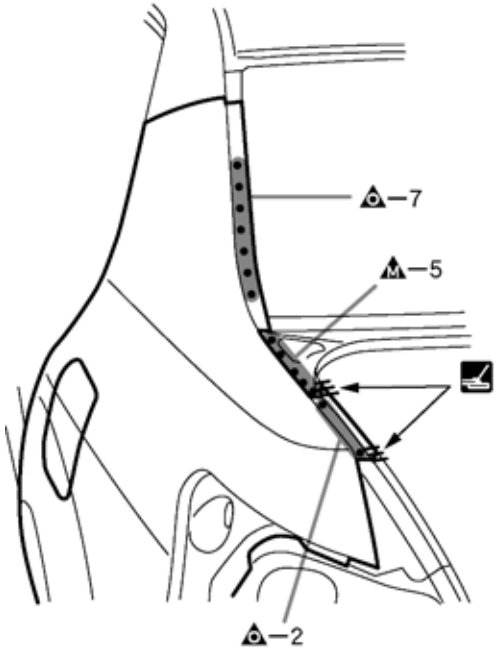
2 Roughly cut open the wheel arch of the panel so that the adhesive can be reached. Cut through the adhesive with a cut chisel to remove the panel.

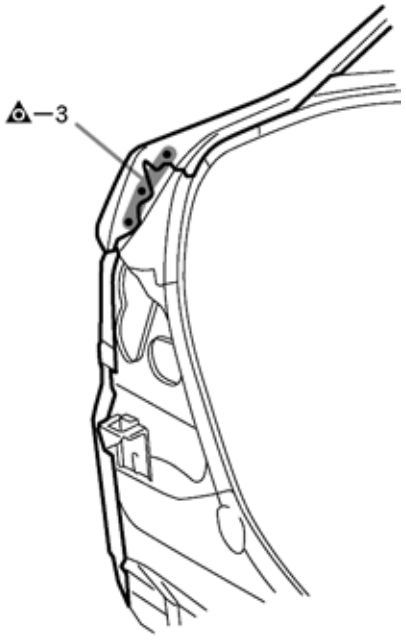
HINT:

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.

130 mm (5.12 in.) 150 mm (5.91 in.)



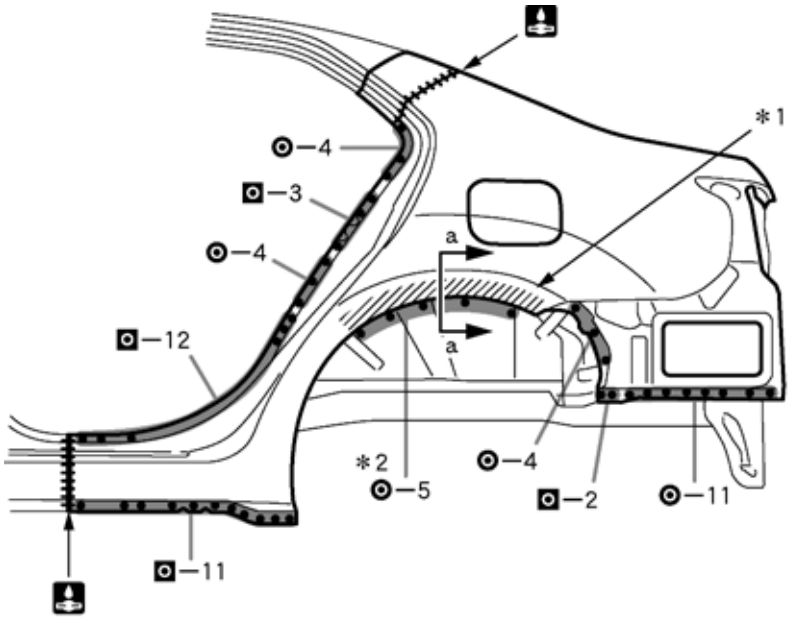


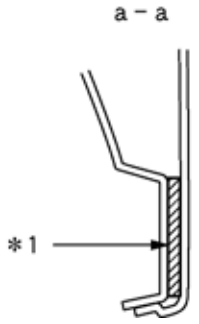


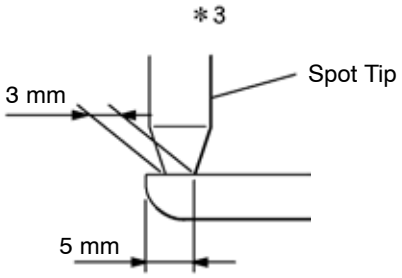
F24835

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply polyurethane foam to the corresponding parts.
- After welding, apply body sealer and undercoating to the corresponding parts.
- After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.







F24836-1

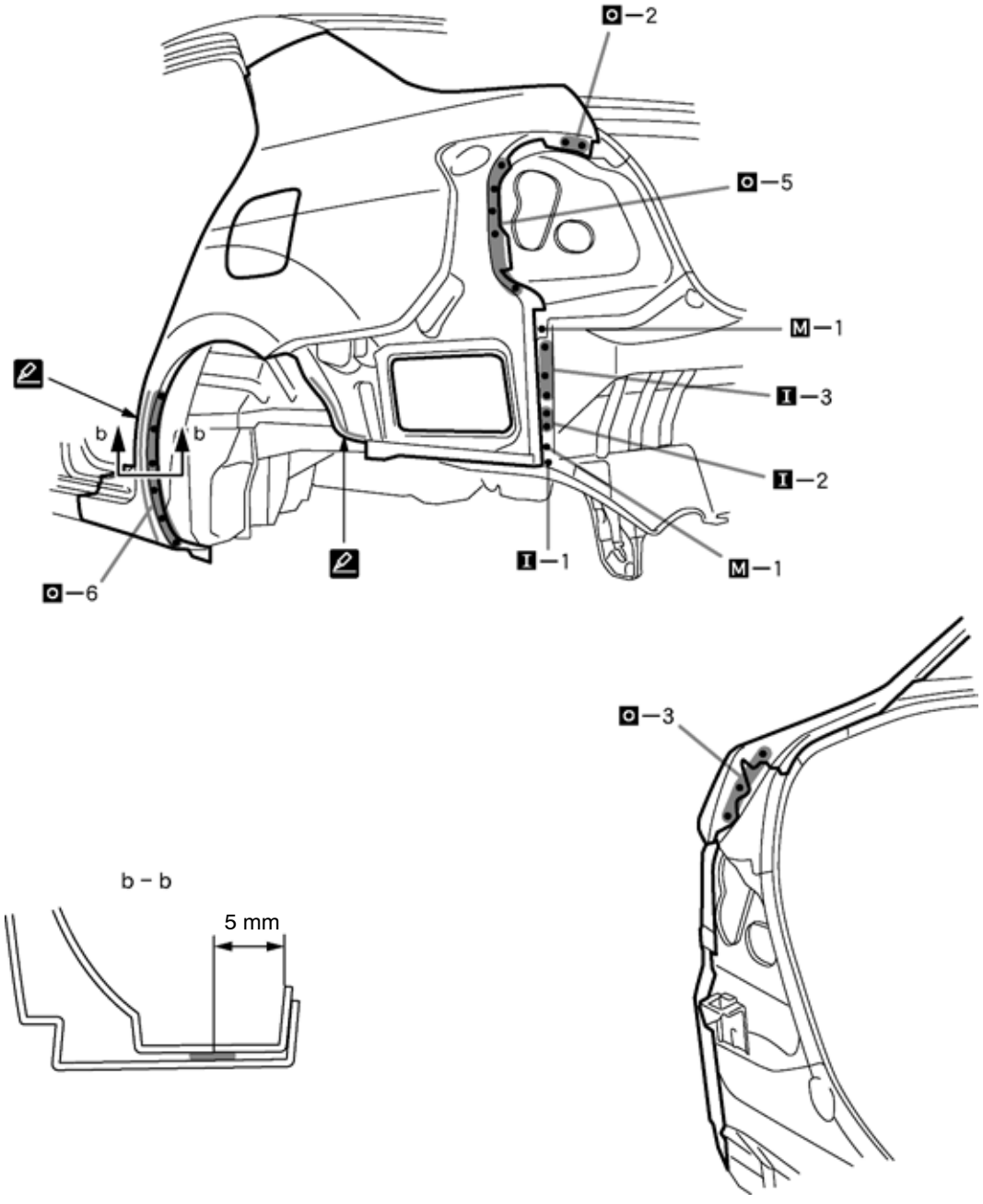
POINT

1 Inspect the fitting of the rear door, luggage compartment door, rear combination light and other related parts before welding as this affects the appearance of the finish.

2 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.

3 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 into the narrow flange.

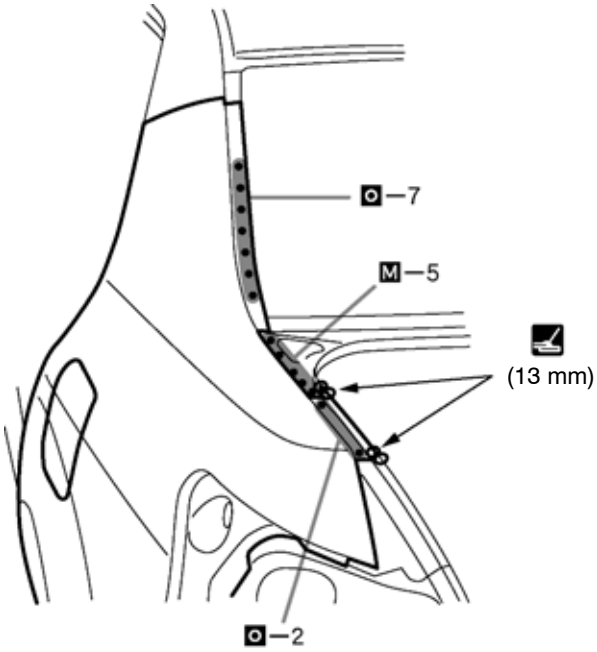
3 mm (0.12 in.) 5 mm (0.20 in.)

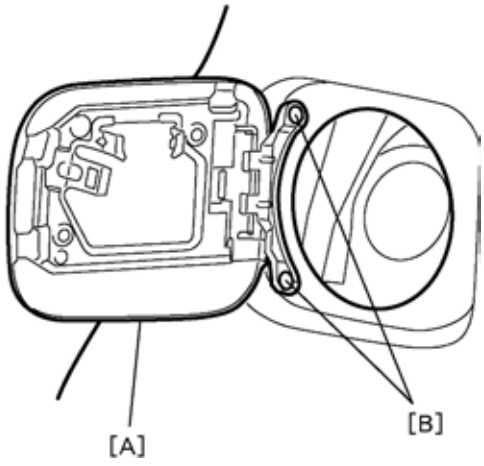


POINT

1 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.) form the flange, avoiding any oozing.
2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.

5 mm (0.20 in.)





F24838-1

PART NAME

[A] Fuel Filler Opening Lid [B] Rivets

13 mm (0.51 in.)