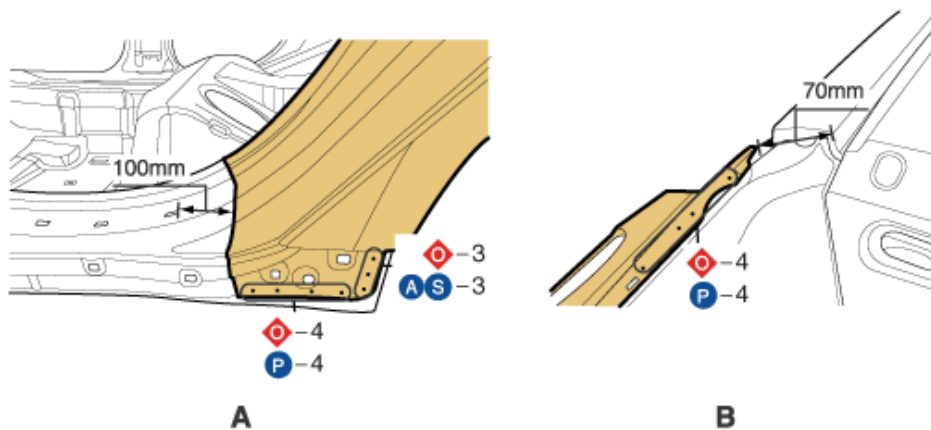
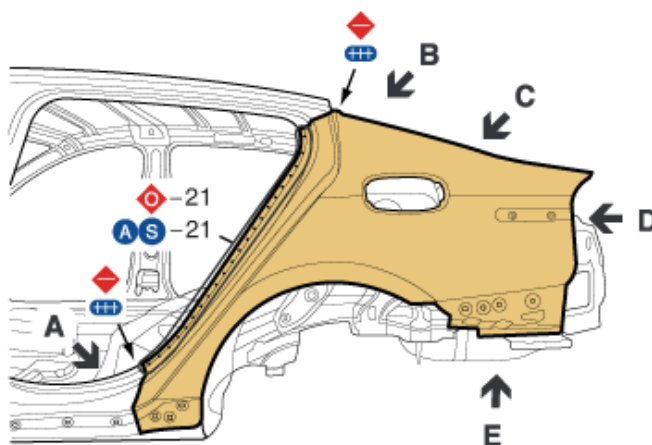




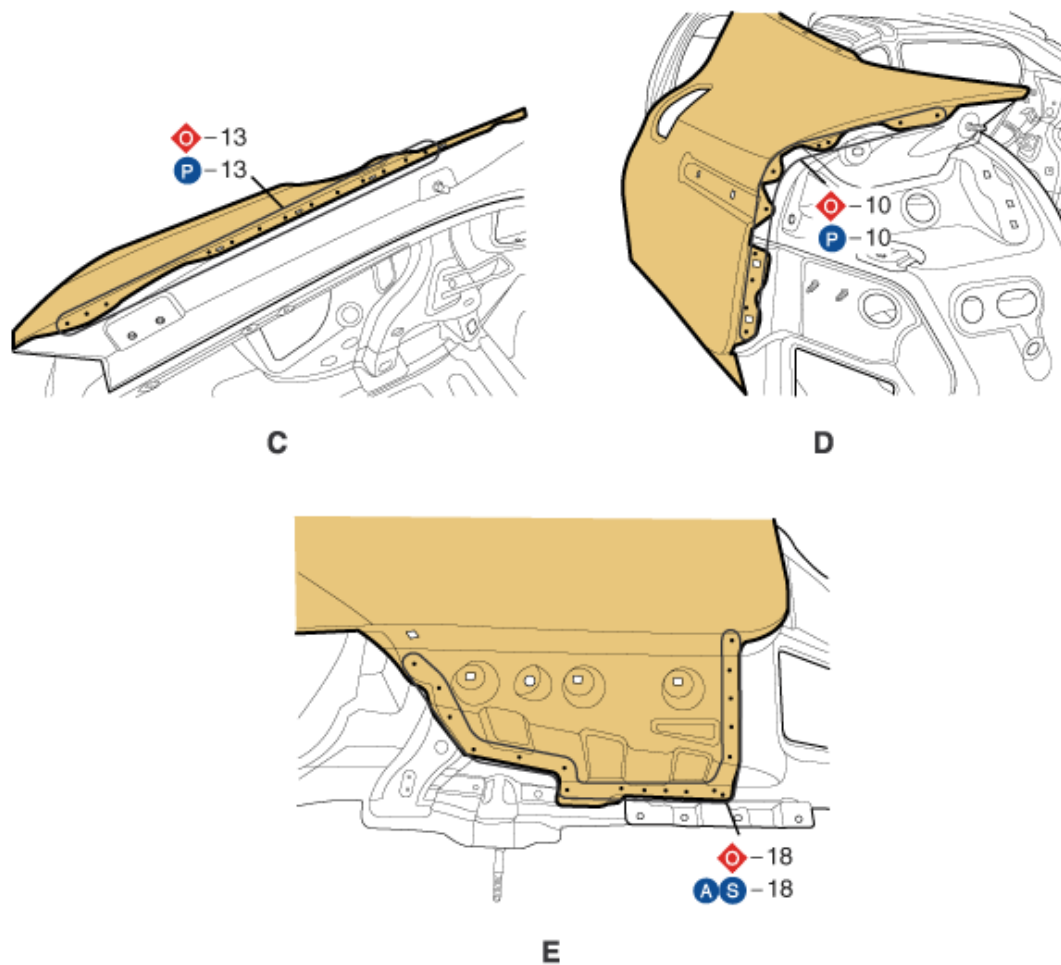
Symbol Meaning

REMOVAL	: Outside	: Middle	: Inside	: Cut	: Hidden weld point
INSTALLATION	: Spot welding	: Plug welding	: Lap welding	: Epoxy adhesive	: Butt welding



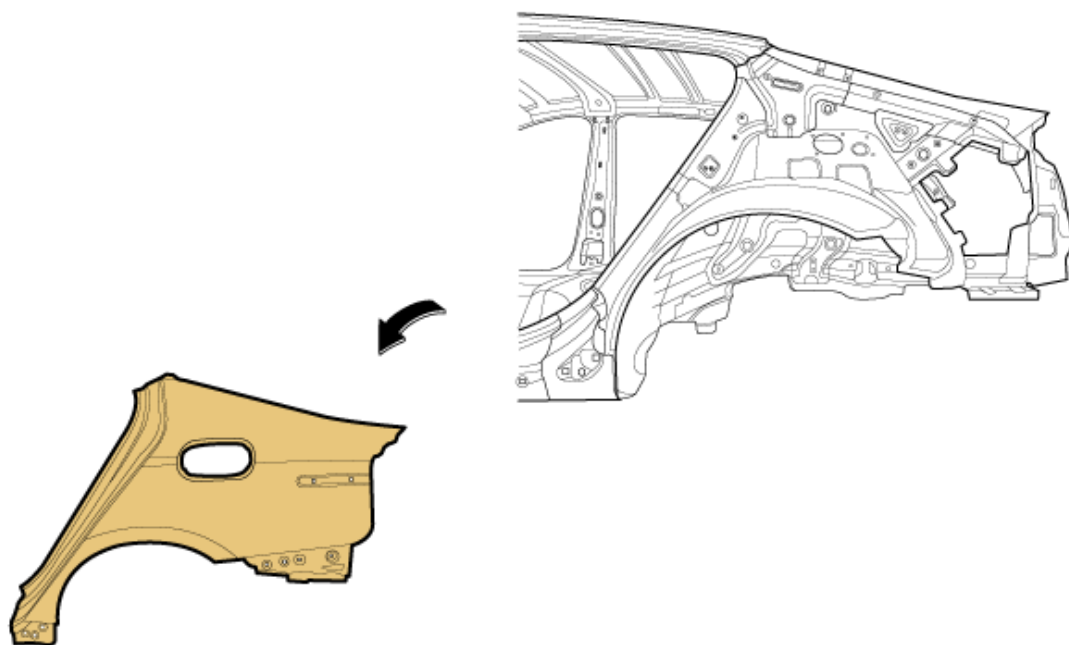
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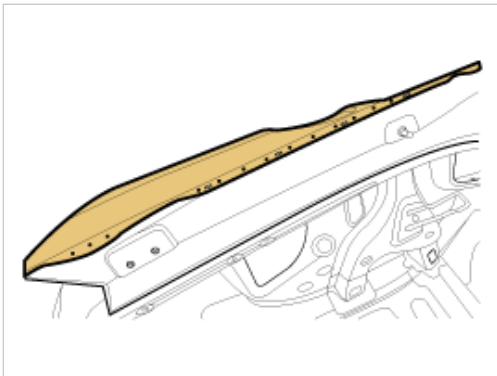
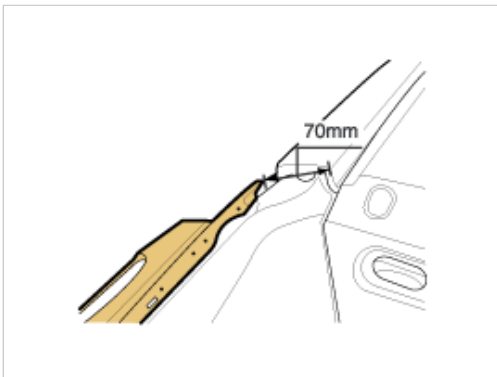
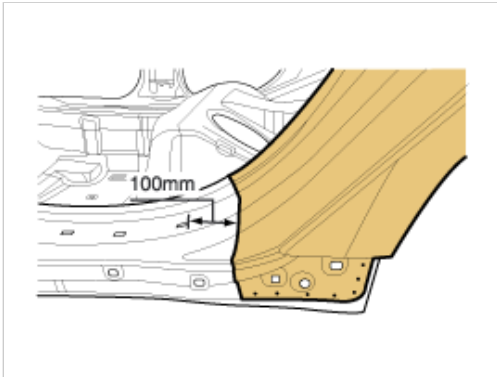
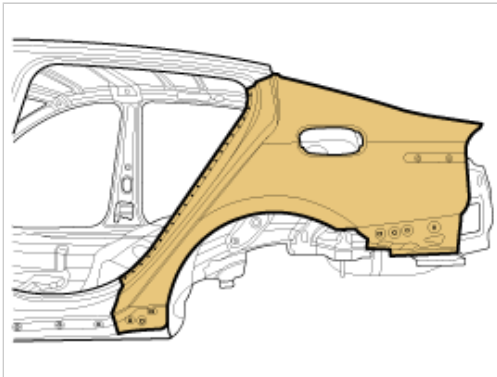
Removal

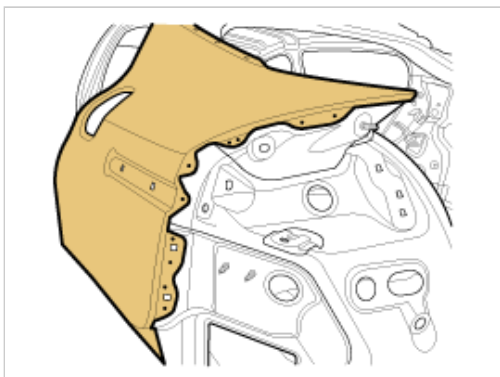
1. Measure and mark the cutlines on the quarter outer panel.
 - a. Cut the quarter outer panel along the cutlines.

NOTICE

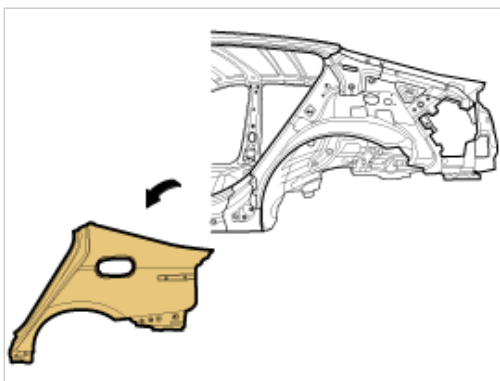
When cutting the quarter outer panel, be careful not to cut through the mating flanges or the quarter inner panel.

- b. Drill out all welding points of the quarter outer panel.





2. Remove the quarter outer panel.



3. After removal, remove broken panel parts from welding area.
4. Apply zinc corrosion inhibitor for welding.

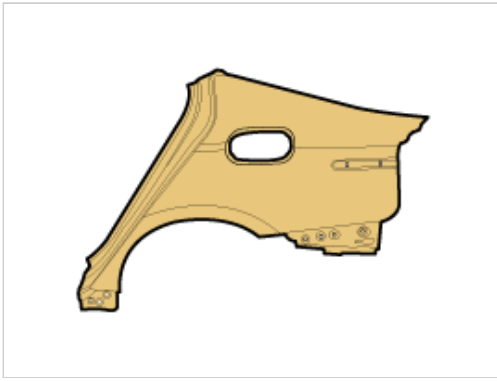
Installation

NOTICE

In case of welding during panel installation, perform spot welding on all parts except instructed otherwise in this manual.

For panels that cannot be spot welded (e.g. parts with holes, parts blocked by panel, parts inaccessible by spot welding arm, etc.), perform MIG PLUG welding.

1. Cut and process new panel before installing on body.
2. Apply zinc corrosion inhibitor for welding.



3. Using a clamp, fix the new panel on body.
 - The application point of epoxy adhesive differs according to panel installation area. The panel must be installed to the body before epoxy adhesive dries.
4. Check the dimensions of the new panel that has been fixed. If the dimensions differ, adjust again.
5. After confirming all dimensions, perform welding on the panel.
 - After performing temporary welding (tack welding), double check the dimensions, and then perform welding.
 - Spot welding after epoxy adhesive has dried may cause weld defects; at all times, complete all spot welding operations before epoxy adhesive dries.
 - If epoxy adhesive is applied on the MIG PLUG welding point, perform MIG PLUG welding after removing epoxy adhesive.

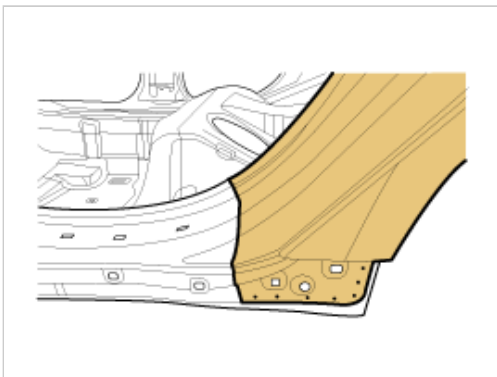
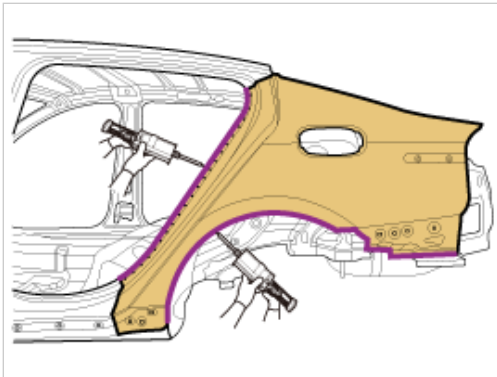
NOTICE

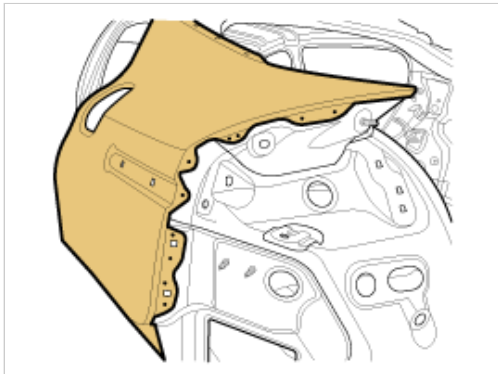
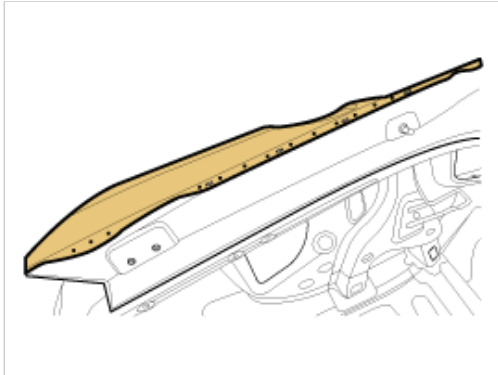
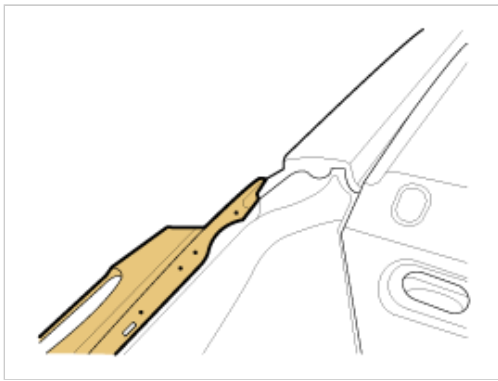
If spot welding is impossible, MIG plug weld all holes.

Apply epoxy adhesive to the weld points of new panel or body panel.

Be sure to use the recommended epoxy adhesive below.

Mobis part number :MMMPB07333, HENBS05065 or equivalent.





6. For plug welding, remove welding bead with a grinder and clean the welding area.
7. Apply urethane sealer on contacting surface of each panel. (Refer to the Body Sealing Location)
8. After painting, apply cavity wax inside the repaired panel.