HOW TO USE THIS MANUAL

1. BODY PANEL REPLACEMENT THIS MANUAL
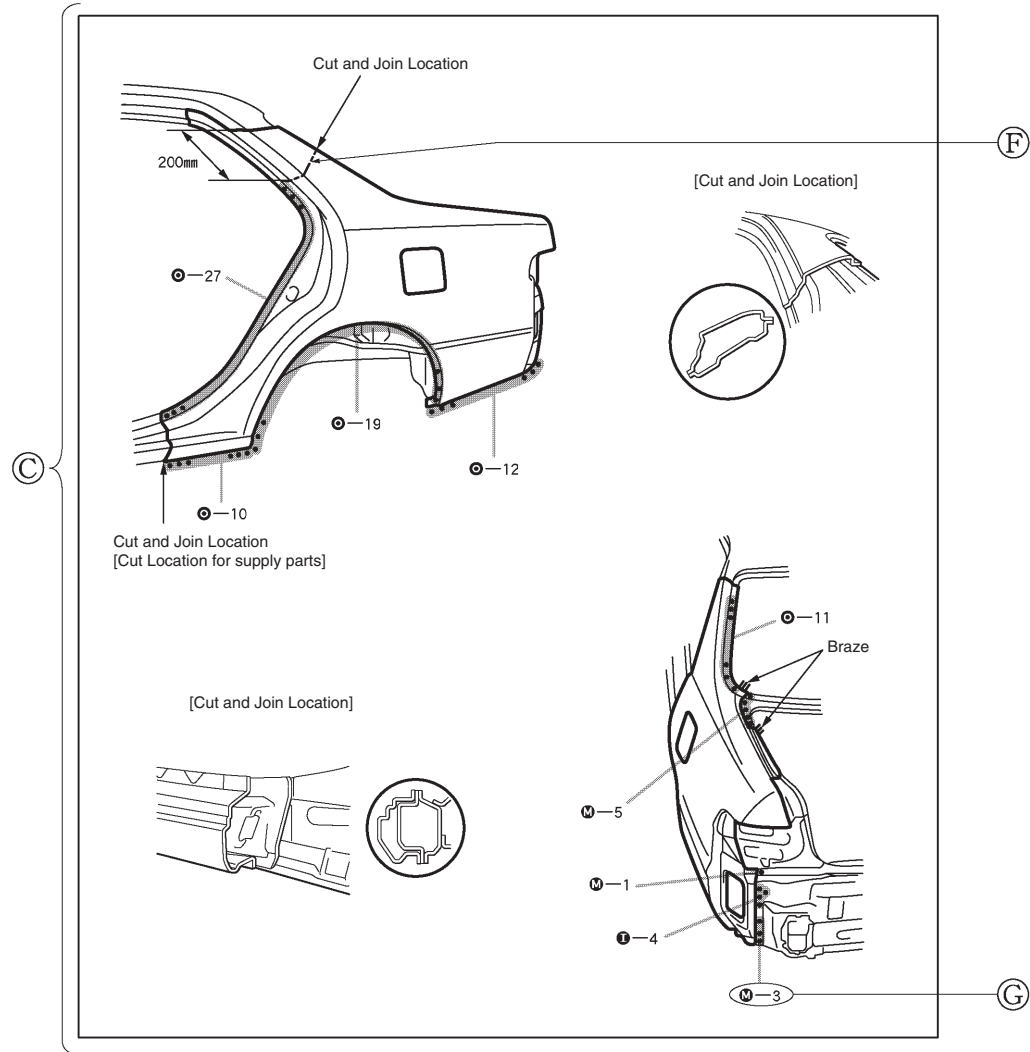
BP-34   **BODY PANEL REPLACEMENT**

Ⓐ —— **QUARTER PANEL (CUT)**
REPLACEMENT

Ⓑ —— 1. REMOVE QUARTER PANEL
(a) Cut and join the part at the location as shown below.

Cut and Join Location

200mm

Ⓕ

[Cut and Join Location]

●—27

Ⓒ

●—19

●—12

●—10

Cut and Join Location
[Cut Location for supply parts]

●—11

Braze

[Cut and Join Location]

Ⓜ—5

Ⓜ—1

❶—4

Ⓜ—3

Ⓖ

Ⓐ : **REPLACEMENT PARTS**
QUARTER PANEL (CUT)

Replacement method
(ASSY) . . . . Assembly replacement
(CUT) . . . . . Major cutting (less than 1/2 of parts used)
(CUT-H) . . . Half cutting (about 1/2 of parts used)
(CUT-P) . . . Partial cutting (most of parts used)
Replacement Parts

Ⓑ : **REMOVAL DIAGRAM**
Describes in detail removal of the damaged parts involving repair by cutting.

Ⓒ : **REMOVAL GUIDE**
Provides additional information to more efficiently help you perform the removal.

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BODY PANEL REPLACEMENT   BP-35

2. INSTALL QUARTER PANEL

HINT:
Inspect the fitting of the rear door, luggage compartment door and rear combination light, etc., before welding, since this affects the appearance of the finish, (a) Before temporarily installing the new parts, apply body sealer to the wheel arch.

HINT:
• Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.

• Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.

• For other sealing points, refer to section PC.
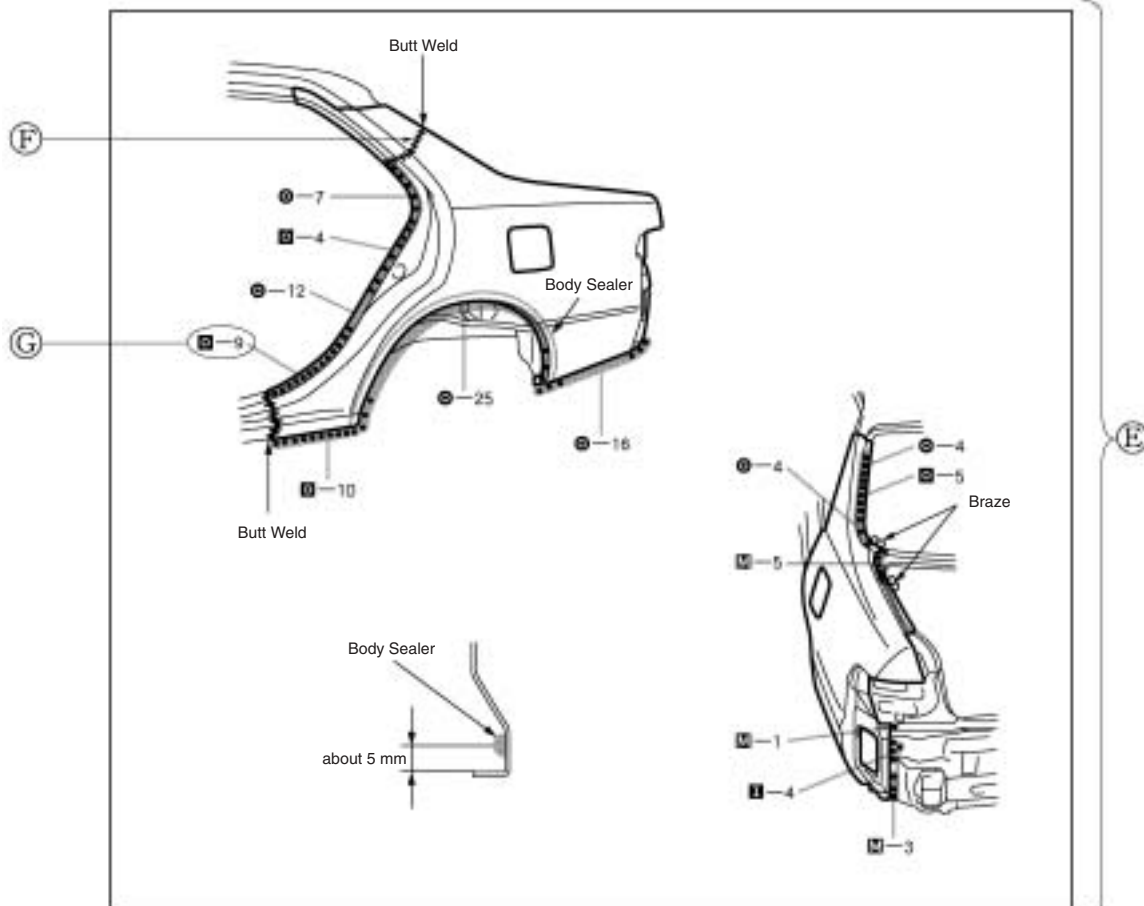
3. MEASURING THE OPENING PORTION DIMENSIONS (See page BP-XX)
4. APPLYING SEALER TO THE INSIDE OF THE VEHICLE (See page PC-XX)
5. APPLYING SEALER TO THE REAR, LUGGAGE COMPARTMENT (See page PC-XX)
6. CHARGING THE POLYURETHANE FOAM (See page PC-XX)
7. APPLYING ANTI-RUST AGENT
(a) After applying the top coat layer, apply the anti-rust agent to the inside of the necked section structural weld spots.

INSTALLATION GUIDE
Provides additional information to more efficiently help you perform the installation.

INSTALLATION DIAGRAM
Describes in detail installation of the new parts involving repair by welding and/or cutting, but excluding painting.
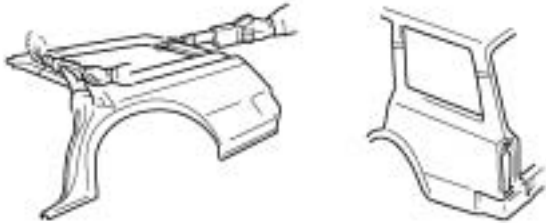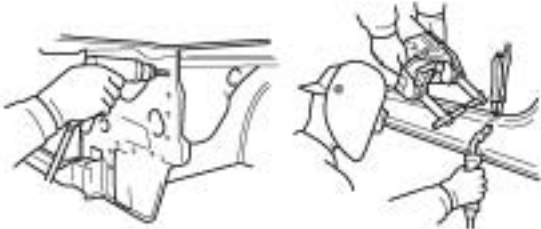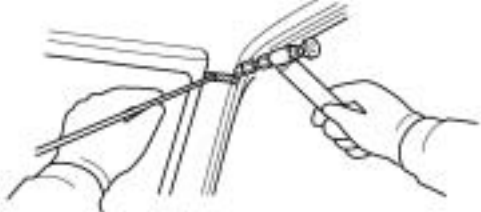
SYMBOLS
See page SS-7.

ILLUSTRATION OF WELD POINTS
Weld method and panel position symbols.
See page SS-8.

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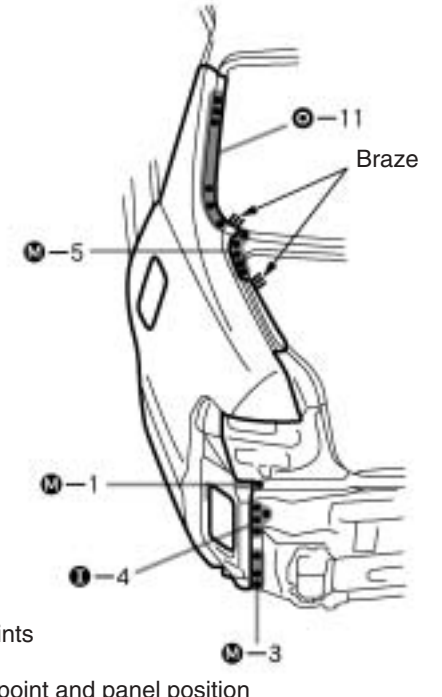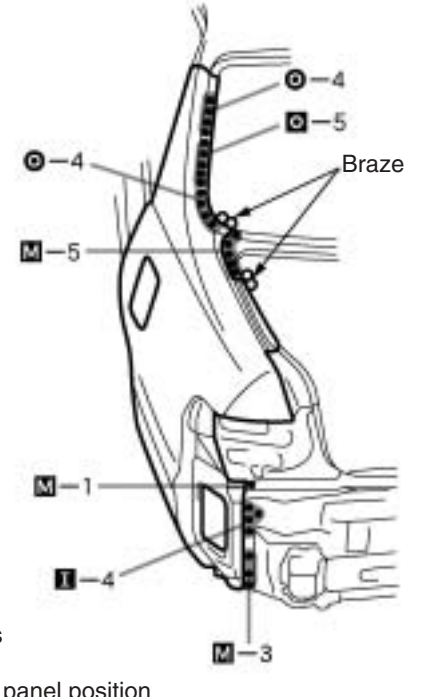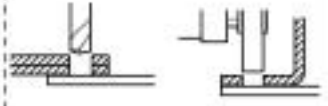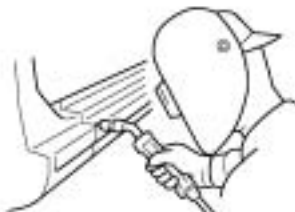
2. SYMBOLS

The following symbols are used in the welding diagrams in section BP of this manual to indicate cutting areas and the types of weld required.

SYMBOLS	MEANING	ILLUSTRATION
— — — — —	SAW CUT OR ROUGH CUT	
//////	REMOVE BRAZE	
••••••	WELD POINTS	
⊙ Ⓜ ① ▣ M I	SPOT WELD OR MIG PLUG WELD (See Page SS-8)	
╫╫╫╫╫	CONTINUOUS MIG WELD (BUTT WELD OR TACK WELD)	
OOOO	BRAZE	
▬	BODY SEALER	

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3. ILLUSTRATION OF WELD POINT SYMBOLS
EXAMPLE:

REMOVAL

Braze

Ⓞ—11
Ⓜ—5
Ⓜ—1
Ⓜ—3
❶—4
Ⓜ—3

Weld points

Remove weld point and panel position

INSTALLATION

Braze

Ⓞ—4
Ⓞ—5
Ⓞ—4
Ⓜ—5
Ⓜ—1
Ⓜ—3
❚—4
Ⓜ—3

Weld points

Weld method and panel position

SYMBOL	MEANING	ILLUSTRATION	SYMBOL	MEANING	ILLUSTRATION
Ⓞ Ⓜ ❶	Remove Weld Points		Ⓞ Ⓜ ❶	Spot Weld	
Ⓞ	(Outside)		▣ Ⓜ ❚	MIG Plug Weld	
Ⓜ	(Middle)				
❶	(Inside)		+	Spot MIG Weld	

HINT: Panel position symbols are as seen from the working posture.

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