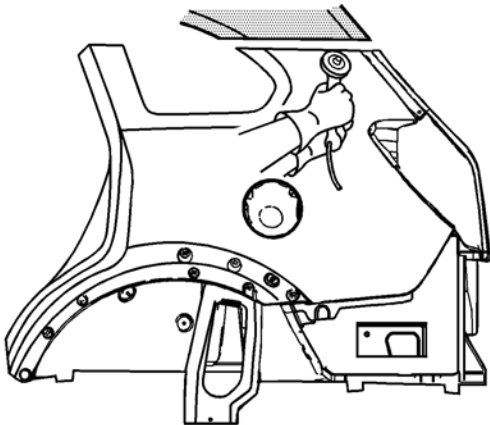
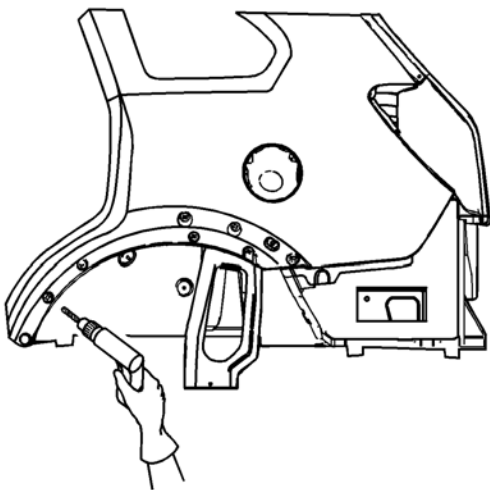


Installation Procedure

1. Cut the replacement quarter panel in corresponding locations to fit the original panel. The sectioning joint should be trimmed to allow 1½ times the metal thickness at the sectioning joint.

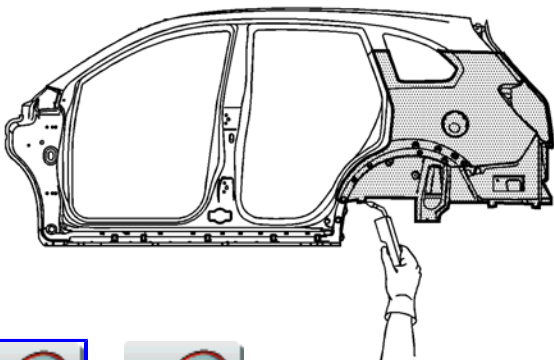


2. Create two 50-mm (2-in) backing plates and one 100-mm (4-in) backing plate from the unused portion of the service part. Trim the backing plates as necessary to fit behind the sectioning joints where no reinforcements exist.
3. Drill 8-mm (5/16-in) plug weld holes along the sectioning cut on the remaining original part. Locate these holes 13 mm (1/2 in) from the edge and spaced 40 mm (1½ in) apart.



**Important:** In any area damaged beyond recognition, or if structural Weld-Thru adhesive is present, space the plug weld holes 40 mm (1½ in) apart.

4. Drill 8-mm (5/16-in) plug weld holes in the service part as necessary in the locations noted from the original panel and along the sectioning cut.
5. Prepare all mating surfaces, as necessary.
6. Apply 3M® Weld-Thru coating P/N 05916 or equivalent, to all mating surfaces.
7. Fit the backing plates halfway into the sectioning joints, clamp and plug weld to the vehicle.
8. Position the quarter panel.



9. **Important:** To create a solid weld with minimum heat distortion make 25-mm (1-in) stitch welds along the seam with 25-mm (1-in) gaps between. Then go back and complete the stitch weld.

10. Stitch the weld sectioning joint.
11. Clean and prepare all welded surfaces.
12. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
13. Paint and repair the area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
14. Install all related panels and components.
15. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
16. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .