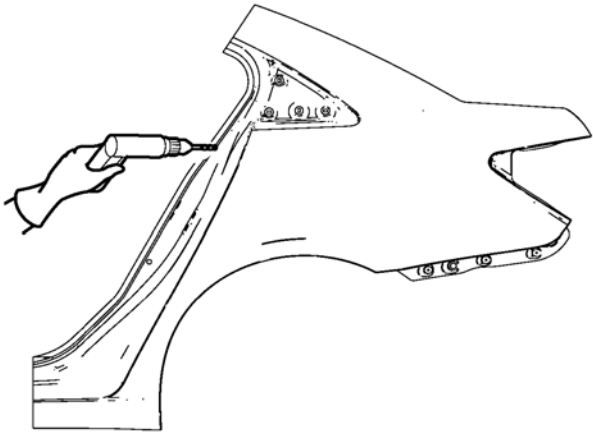
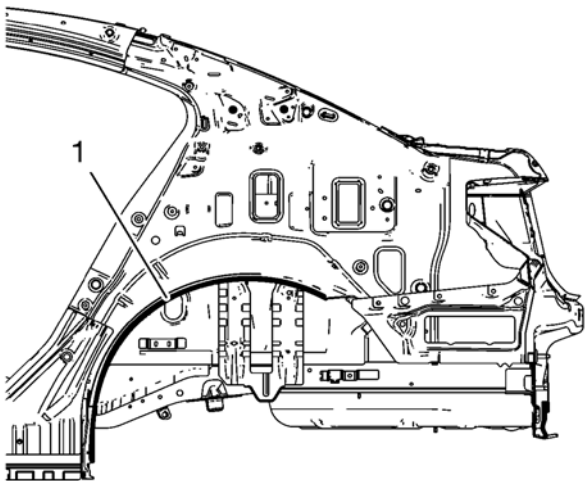


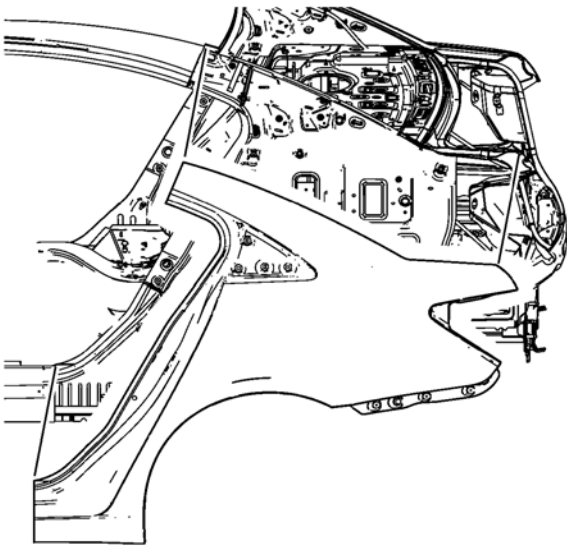
1. Cut the quarter outer panel in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
2. Create a 50 mm (2 in) backing plate from the unused portion of the service part.
3. Drill 8 mm (5/16 in) along the sectioning cut on the remaining original part. Locate these holes 13 mm (1/2 in) from the edge of part and spaced 40 mm (1 1/2 in) apart.
4. Prepare all mating surfaces as necessary.
5. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.
6. Align the quarter outer panel.



7. Drill 8 mm (5/16 in) for plug welding along the edges of the quarter outer panel as noted from the original panel.
8. Clean and prepare the attaching surfaces for welding.



9. Apply one-part windshield urethane adhesive (1) as noted from the original panel.



10. Position the quarter outer panel on the vehicle.
11. Verify the fit of the quarter outer panel.
12. Clamp the quarter outer panel into position.