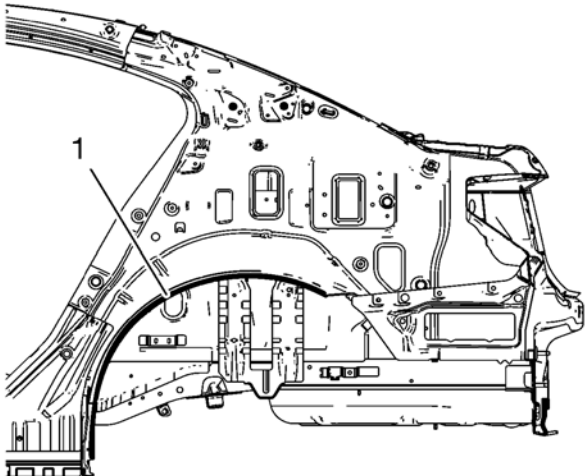
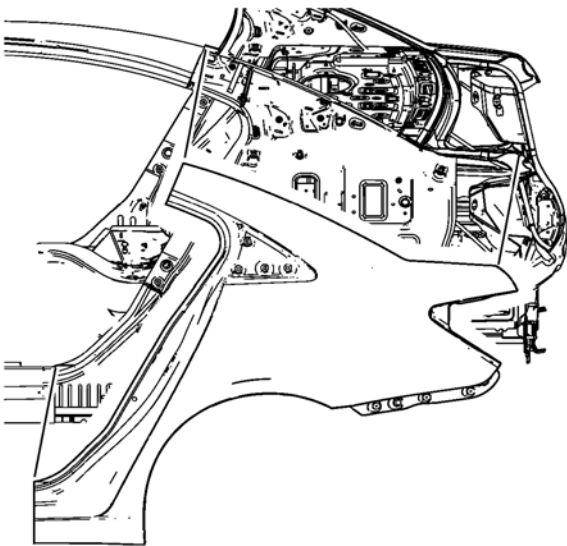


1. Cut the quarter outer panel in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
2. Create a 50 mm (2 in) backing plate from the unused portion of the service part.
3. Create 5 x 18 mm (4/16 x 11/16 in) slots for MIG-brazing 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 braze to the vehicle.
6. Align the quarter outer panel.
7. Clean and prepare the attaching surfaces for spot welding.

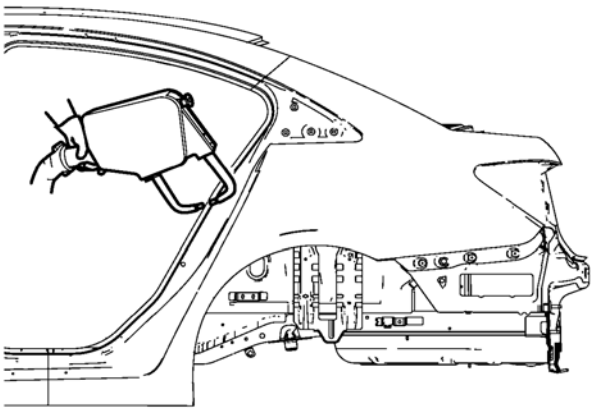


Note: In MIG-brazing areas 50 mm (2 in) must be kept clear of structural adhesive.

8. Apply structural adhesive in the wheelhouse area (1) as noted from the original panel and to all attaching surfaces.



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



12. Spot weld accordingly.