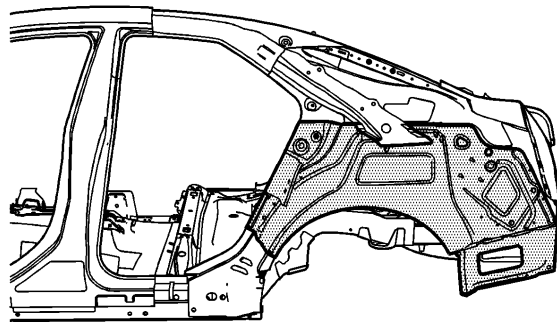


Rear Outer Wheelhouse Replacement

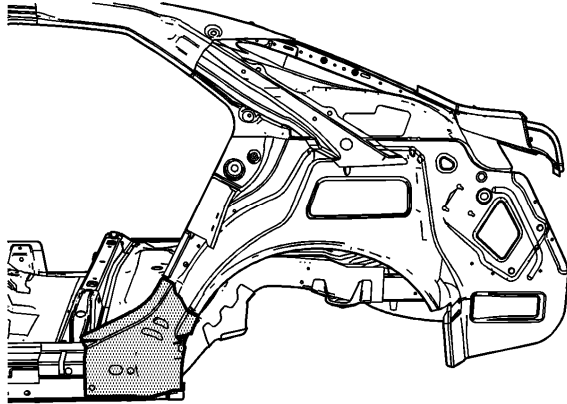
Removal Procedure

Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in the Preface section.

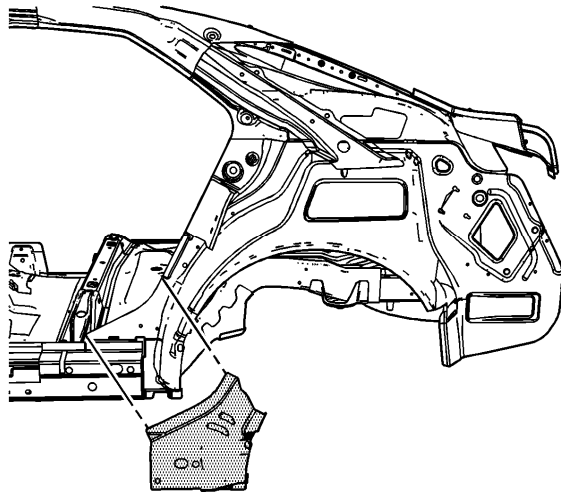
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) .
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .



3. Remove all related panels and components.
4. Restore as much of the damage as possible.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .



6. Remove the body inner reinforcement.

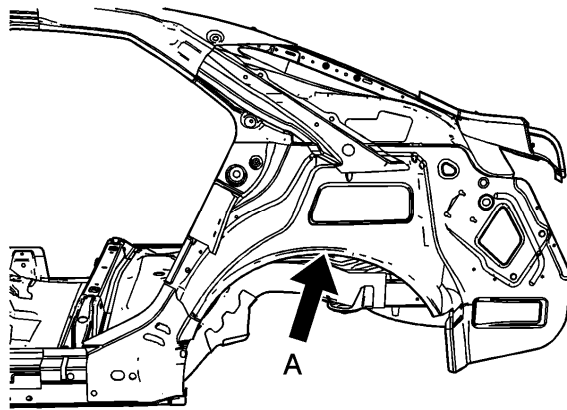


Important: Do not damage any inner panels or reinforcements.

Important: Note the number and location of the factory welds for installation of the inner quarter panel.

7. Locate, mark, and drill out all the necessary factory welds.

Use a panel cutter to remove the three hidden welds under the upper reinforcement. These welds connect the outer wheelhouse to the inner wheelhouse (A).

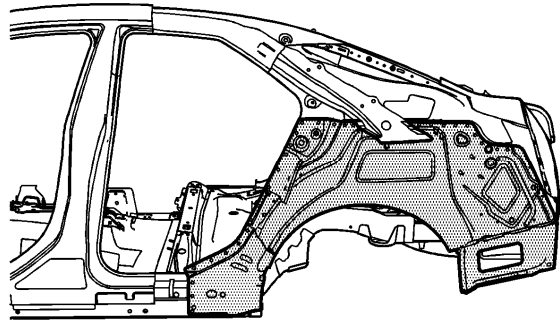


8. Remove the damaged wheelhouse.

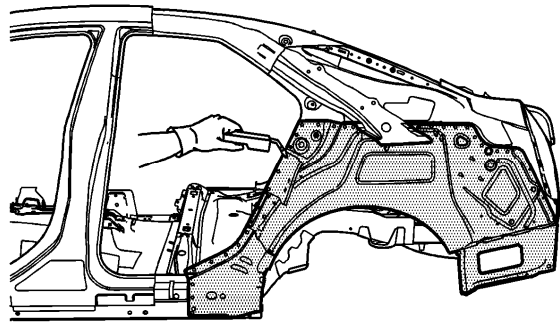
Installation Procedure

Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart.

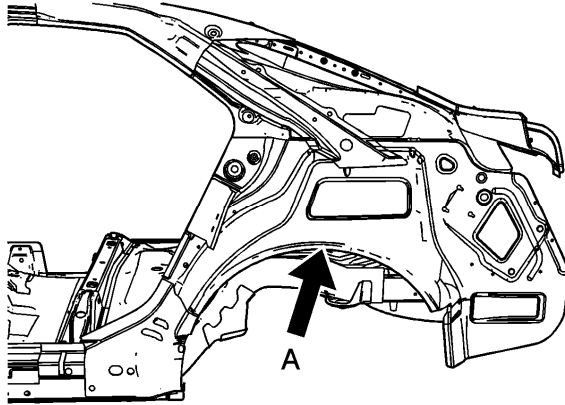
1. Drill 8 mm (5/16 in) plug weld holes in the service wheelhouse as necessary in the locations noted from the original panel.
2. Prepare all mating surfaces as necessary.
3. Apply Weld-Thru Coating to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#)



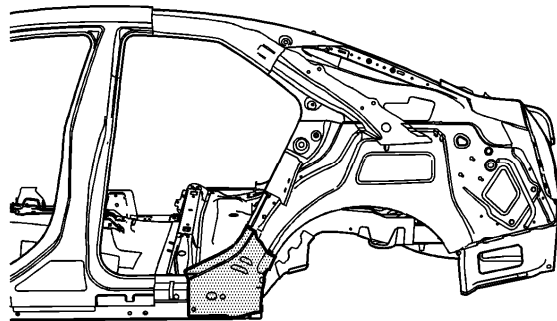
4. Align the service part on the vehicle using 3-dimensional measuring equipment.



5. Plug weld accordingly.



6. In the upper reinforcement area replace the three hidden spot welds with three 25 mm (1 in) stitch welds (A).



7. Install the body inner reinforcement.
8. Clean and prepare all of the welded surfaces.
9. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
10. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
11. Install all of the related panels and components.
12. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
13. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .

