

## Replacement

### 1. Remove the related parts.

- Rear bumper
- Rear window
- Taillight
- Rear pillar trim panel
- Trunk side panel
- Rear seat
- Rear seat belt
- Fuel fill pipe (left side only)

**⚠ WARNING** Do not smoke while working near the fuel system. Keep open flame away from the fuel system. If necessary, remove the fuel tank and/or lines before welding nearby. Drain fuel into an approved container.

### 2. Pull out and straighten the damaged area.

NOTE: Carefully check the inner pillar and trunk gutter for position and damage. Pull out the inner panel by cutting the outer if necessary.

- Jack-up the body and place safety stands at the four designated support points.
- Pull out the damaged rear side outer panel with the frame straightener, then pull out and straighten the center pillar inner panel and rear wheelhouse.

NOTE: Be careful not to pull out more than necessary.

- After pulling, check the inner pillar and trunk gutter position using the body dimensional drawings (see [section 6](#)).

### 3. Cut and pry off the rear side outer panel.

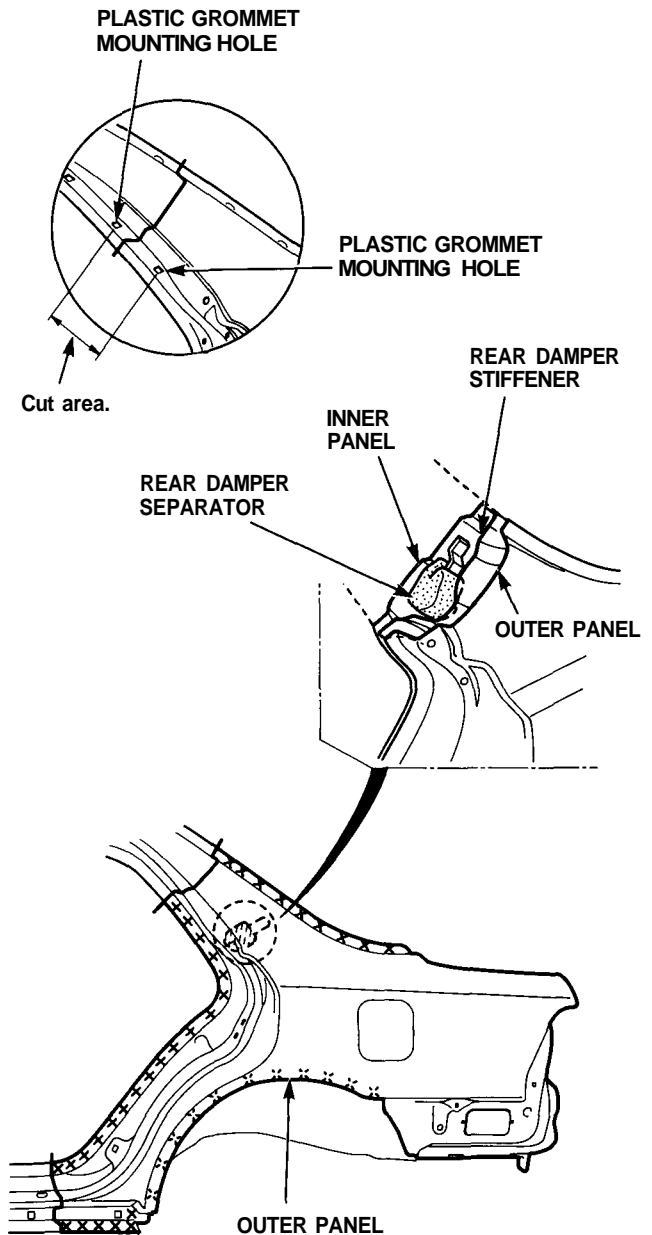
- Cut at the rear pillar and side sill with a handsaw.
- Cut the panel from the body with a chisel leaving the weld flange at the inner panel intact.

NOTE: Do not cut or damage the inner panel and rear damper stiffener.

- Cut at the side sill or wheel arch according to the extent of the damage.
- Center punch around the spot weld imprints on the remaining flange.
- Drill out the spot welds with the spot cutter.
- Pry off the welded flange sections using a chisel.

### ⚠ WARNING

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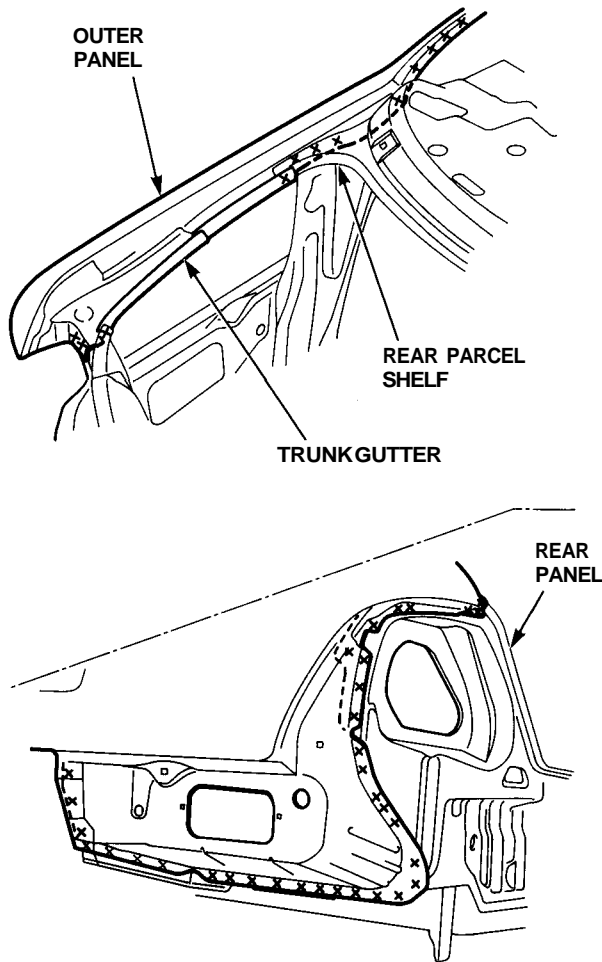


NOTE: Do not cut or damage the rear damper stiffener and rear damper separator.

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# Rear Side Outer Panel

## Replacement (cont'd)



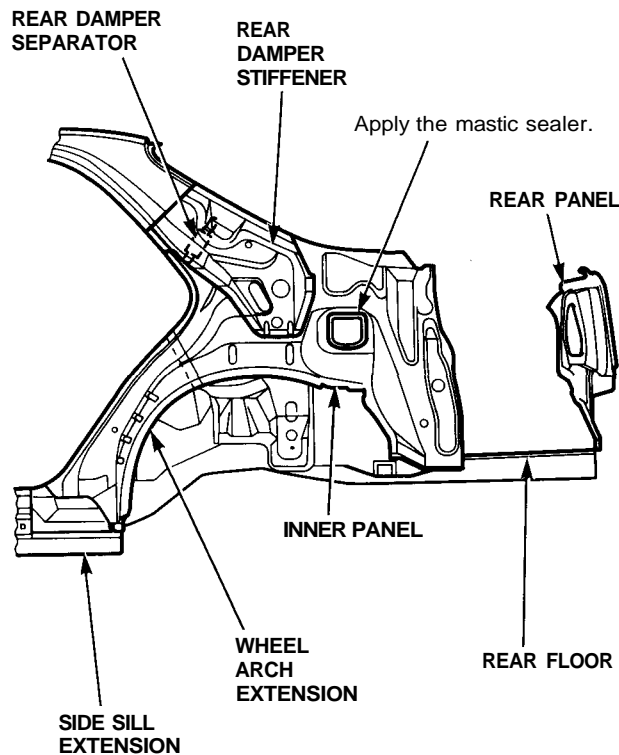
### 4. Mold the inner panel and related parts.

- Fill and holes drilled by MIG or gas welding.

**⚠ WARNING** To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Level and finish burrs, etc. with a disc sander.

**⚠ WARNING** To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

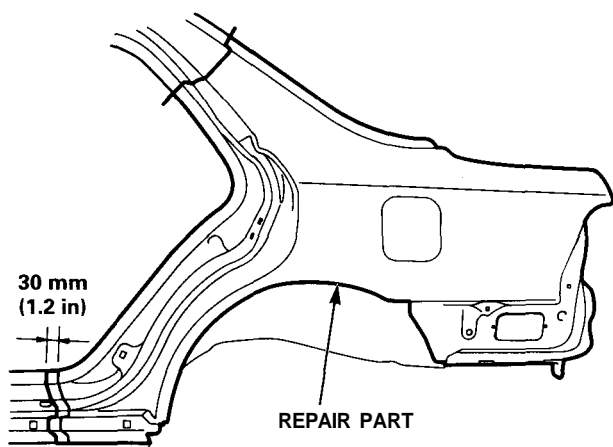


### 5. Cut the replacement part.

- Cut so that the repair part overlaps the side sill by 30 mm (1.2 in).
- Apply body paint to the back of the repair part.
- See Paint Repair section.

#### **⚠ WARNING**

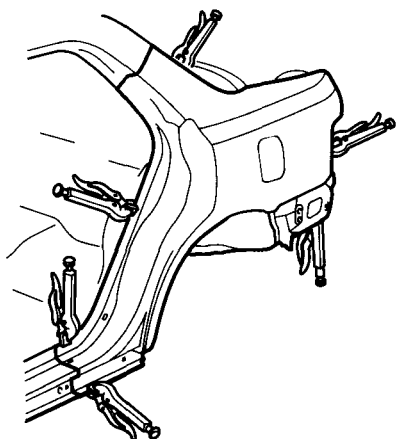
- **Ventilate when spraying paint.** Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.
- **Avoid contact with skin.** Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
- **Paint is flammable.** Store it in a safe place, and keep it away from sparks, flames or cigarettes.
- Remove the undercoat from both sides of the weld flange with a sander to expose the steel plate.



6. Set the repair part.

- Install the outer panel and clamp it with vise-grips.

NOTE: Apply the spot sealer to the welding surface when spot welding.



- Check the body dimensions (see [section 6](#)).

7. Tack weld the repair part.

**⚠ WARNING** To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

Temporarily spot weld the panel at the clamped positions.

8. Remove the vise-grips and check the alignment of the door and trunk lid.

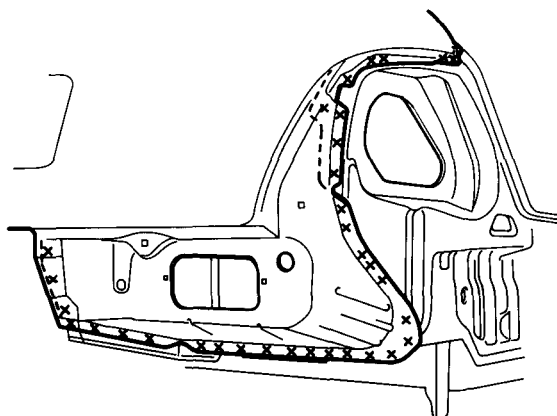
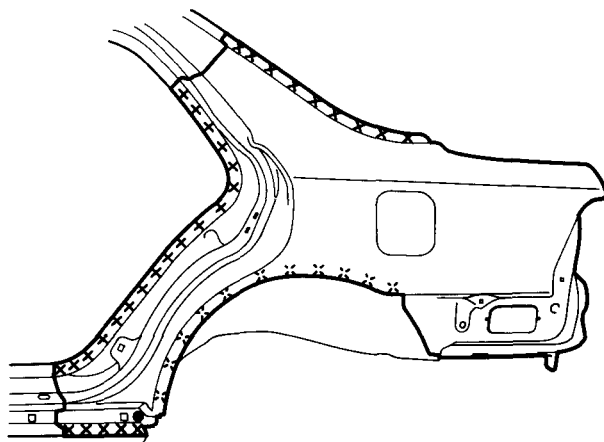
NOTE:

- Check for flushness of the front fender, door, and the rear fender and make sure the body lines flow smoothly.
- Check the rear window openings.

9. Perform the main welding.

**⚠ WARNING** To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

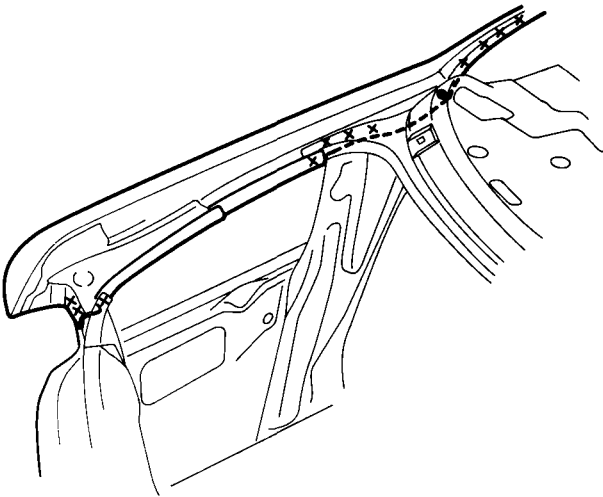
- Weld the outer panel at the rear pillar and side sill with a MIG welder.
- Make 20% to 30% more spot welds than there were holes drilled.
- Make 5 mm (0.2 in) hole in the MIG weld hole with the repair part, and the wheel arch extension with a MIG welder.



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# Rear Side Outer Panel

## Replacement (cont'd)



10. Finish the welded areas.

- Level the MIG welded areas with a disc sander.

**⚠ WARNING** To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

- Even out high areas with a hammer. Be careful not to deform them.
- Even out the spot welded flange areas with a hammer and dolly.
- Fill in deformations and level differences of the welded areas with solder or putty, then finish.

11. Apply the sealer (see [section 5](#)).

Apply sealer to the fuel fill section, trunk lid opening joint and around the taillight area of the rear panel.

12. Apply the paint.

See Paint Repair section.

**⚠ WARNING**

- Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.
- Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
- Paint is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.

13. Apply the undercoat.

Apply undercoat to the wheelhouse and apply anti-rust agent to the inside of the outer panel (see [section 7](#)).

14. Install the related parts.

Install in the reverse order in which they were removed.

15. Inspect, check, and clean.

- Adjust the clearance with the door and trunk lid, then adjust the level differences and fit. Check operation.
- Test for leaks in the trunk and passenger compartments.
- Clean the trunk floor.