

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](#)).

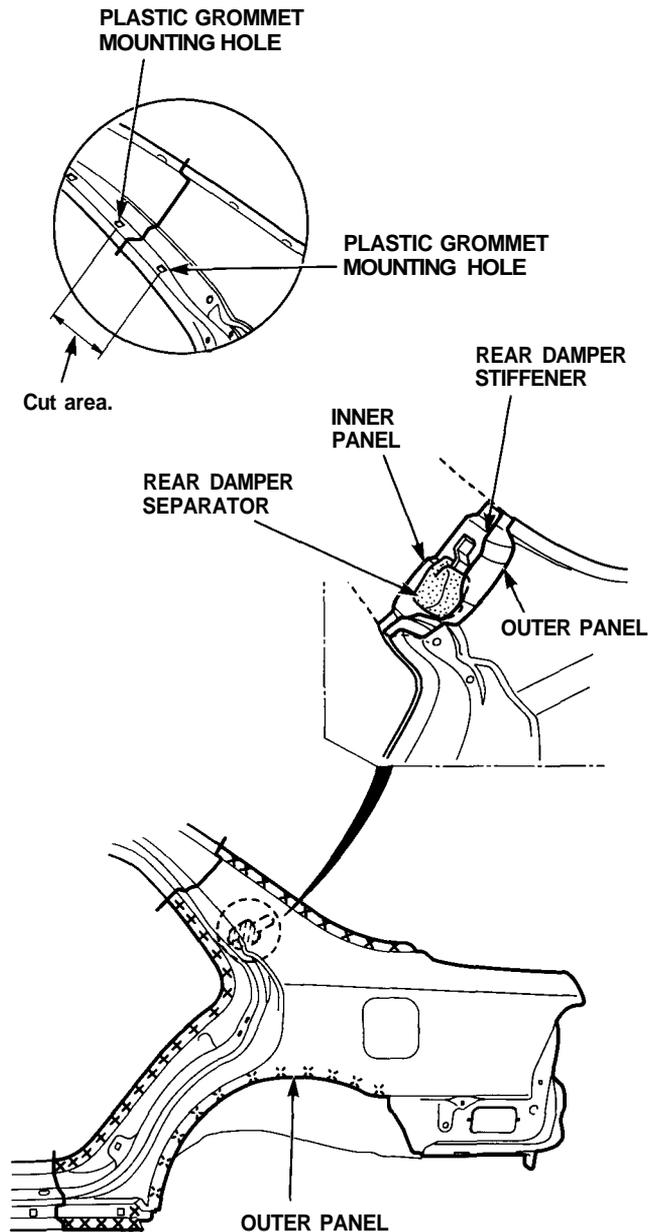
3. Cut and pry off the rear side outer panel.

- 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.

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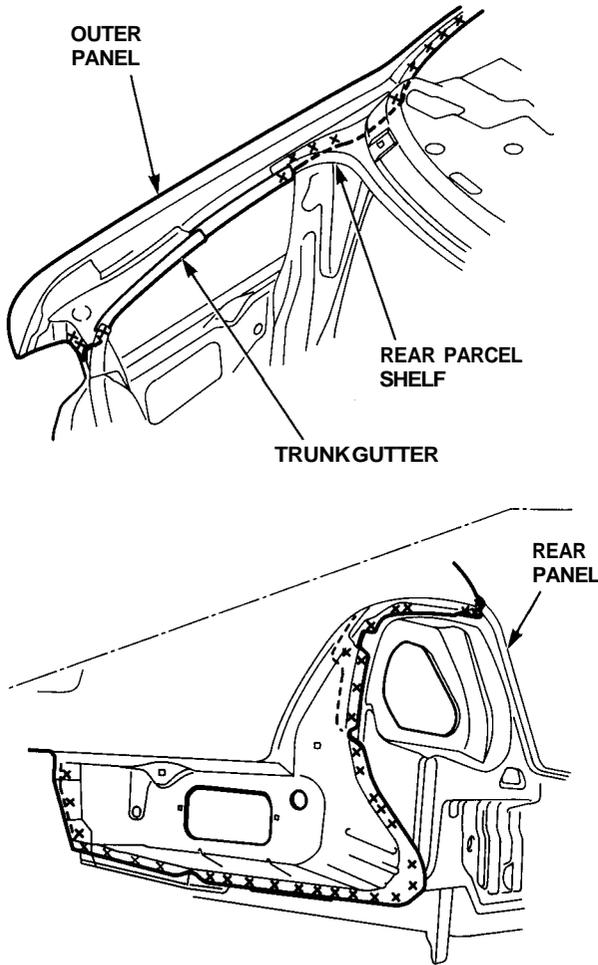


NOTE: Do not cut or damage the rear damper stiffener and rear damper separator.

(cont'd)

Rear Side Outer Panel

Replacement (cont'd)



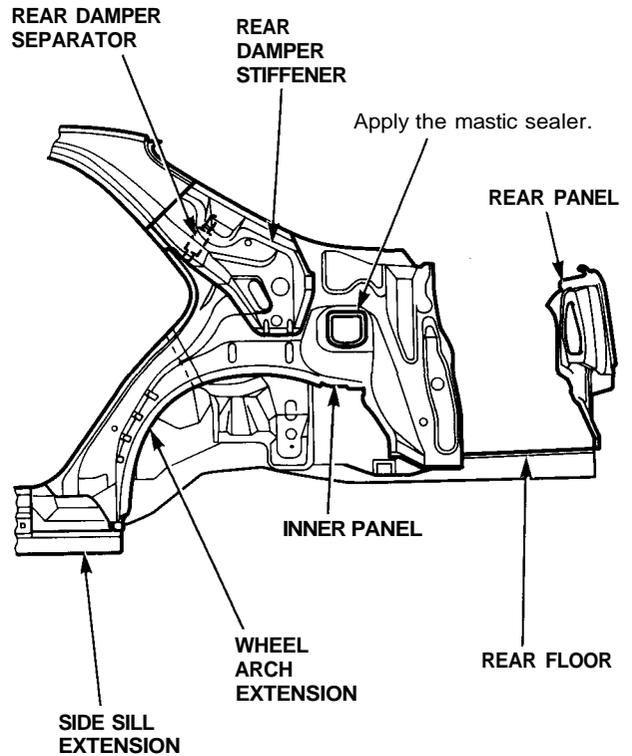
4. Mold the inner panel and related parts.

- 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.

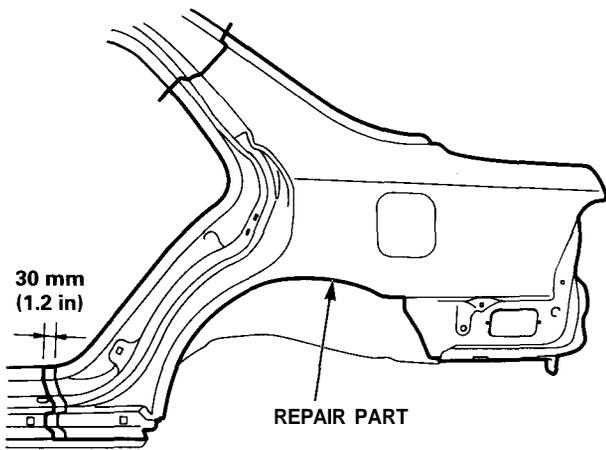


5. Cut the replacement part.

- 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.

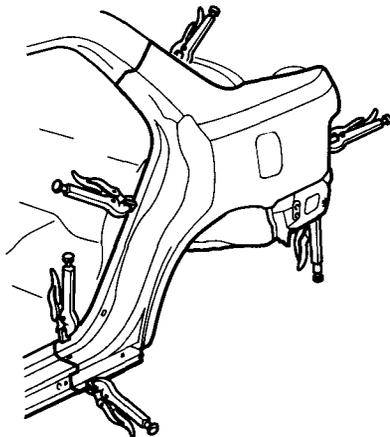
▲ WARNING

- **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.

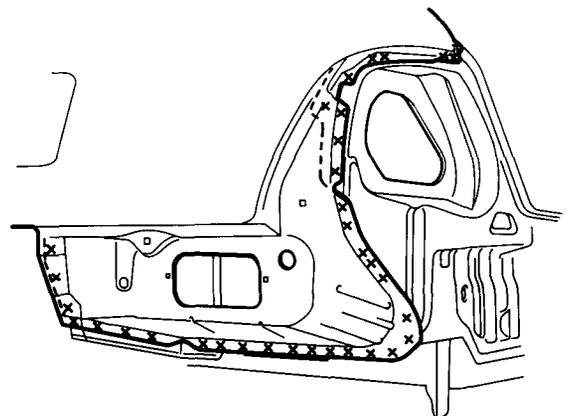
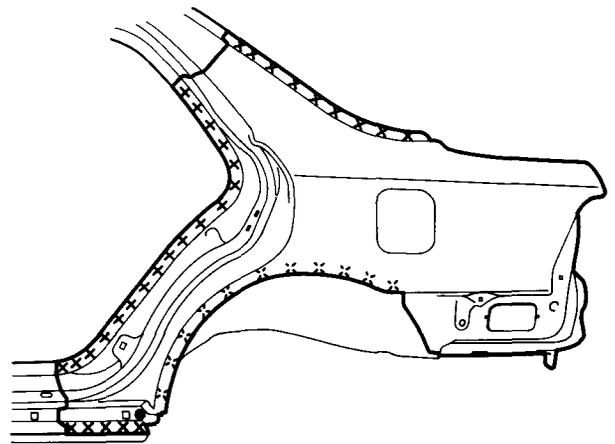
NOTE:

- 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.

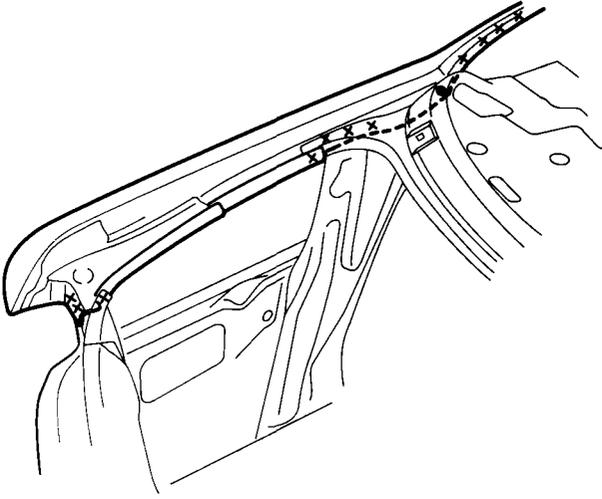
- Weld the outer panel at the rear pillar and side sill with a MIG welder.
- Make 20% to 30% more spot welds than there were holes drilled.
- Make 5 mm (0.2 in) hole in the MIG weld hole with the repair part, and the wheel arch extension with a MIG welder.



(cont'd)

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.

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- **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.