



*The Estimating Committee Presentation for  
April 2003 in Phoenix, Arizona on the*

**Preparation of a Recycled  
Quarter Panel  
with an outer wheelhouse**

# The recycled quarter panel is checked before it is unloaded



**Paint film thickness is measured to determine if additional paint labor is necessary.**





**All attached parts are removed.**



**More parts being removed.**

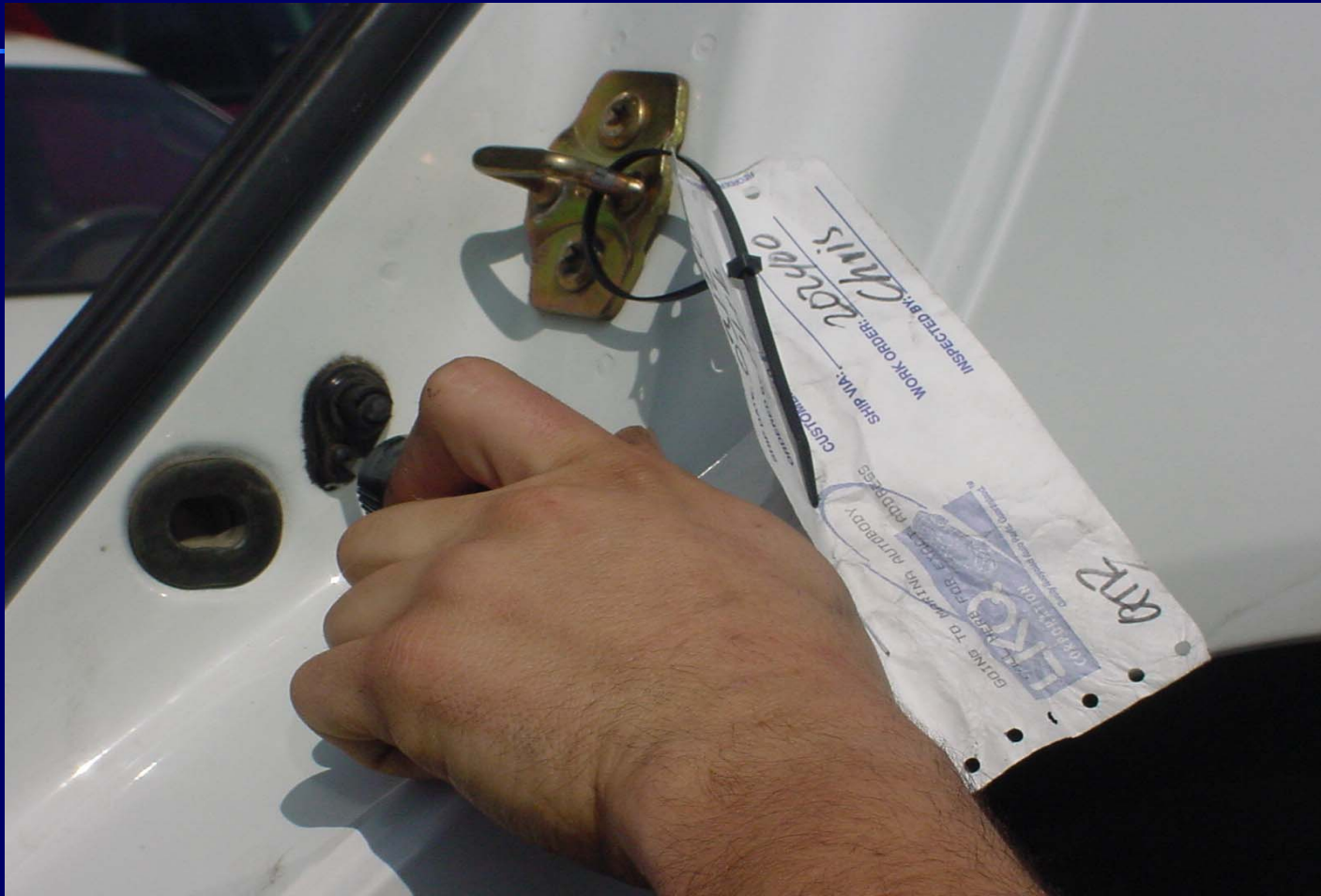


# More parts that need to be removed





**And the last of the parts are removed.**



# Recycled quarter panel assembly with all attached parts removed.





**Begin by removing all sealant & caulking to expose resistance spot welds that will be drilled out in order to separate the panels.**



# Remove rear glass reveal molding.





**Cut out urethane bed and broken glass to expose rear glass pinchweld.**





# Clean off remaining urethane sealant on rear window pinchweld.



**Remove paint from rear window pinchweld to expose bare metal & resistance spot welds.**



**Remove sealant & caulking to expose resistance spot welds where the quarter panel is attached to the rear body panel.**





**Remove remaining roof panel from quarter.**



**Remove undercoating from lip where the inner & outer wheelhouse panels are attached.**





**Separate quarter panel with wheelhouse from rear floor panel & trunk floor to gain access to the sport welds that hold inner & outer wheelhouse panels together.**





**Separate the package tray from quarter panel section for access.**



# Drill out factory resistance spot welds.



# Separate inner & outer panels with an air chisel.





**Separate quarter panel assembly from the rest of the rear body sheet metal.**



# Drill out the spot welds that secure the inner & outer wheelhouse panels together





**Separate the inner & outer wheelhouse panel  
with an air chisel.**





**Drill out remaining resistance spot welds  
(there is now total access).**



**Repair all mating flanges with a hammer & dolly.**



**Remove all remaining sealant, adhesive & caulking.**





**Clean up all mating surfaces with special plastic wheel.**



**Apply weld-thru primer to all mating surfaces.**



**The recycled quarter panel is now ready  
for installation on to the vehicle**



**A recycled quarter panel (with no attached panels) should not be considered as a repair option unless the following criteria exists:**

- An older vehicle where a recycled part is the only part available.
- A new quarter panel is on a major back order.
- The price on the recycled quarter panel including preparation time, is more economical than the price of a new quarter panel.

**Finally, when considering a quarter panel with attached panels as a repair option, study how they are attached together paying close attention if there are internal reinforcements and that there is total access for proper welding and access.**