# COLLISION REPAIR INFORMATION

## FOR THE TOYOTA DEALER

TITLE: OUTER QUARTER PANEL WHEEL WELL REPLACEMENT



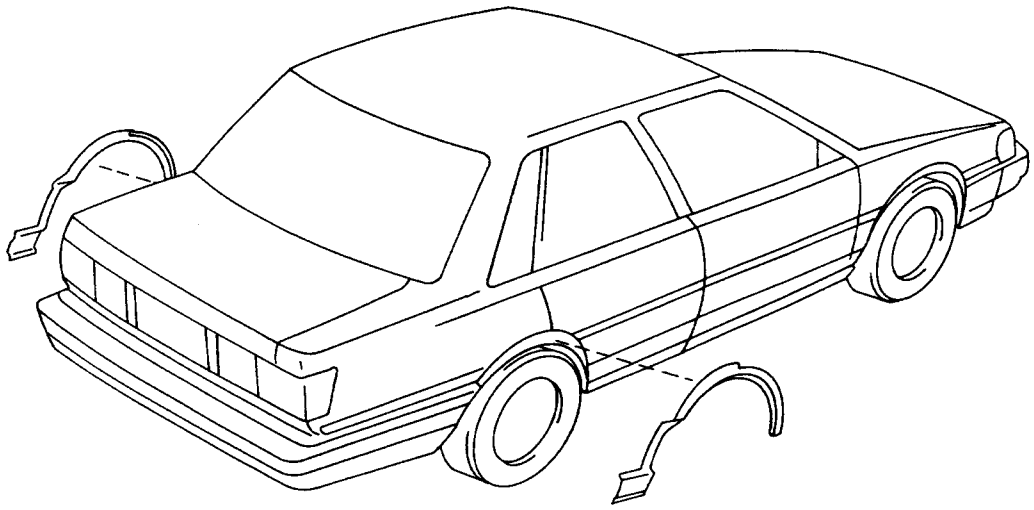
SECTION: EXTERIOR BULLETIN #50

MODELS: CAMRY SEDAN (SV21, SV24 AND VZV21)

DATE: NOVEMBER 1993

TOYOTA SUPPORTS TECHNICIAN PROFESSIONALISM
ASE
THROUGH ASE CERTIFICATION

Toyota offers a rear quarter repair panel (partial) for 1987–91 Camry. The part number, part name, procedures, materials and tools are as follows:



| PART NUMBER | PART NAME | QUANTITY |
|---|---|---|
| 61621–32060 | EXTENSION, QUARTER PANEL LOWER RH | 1 |
| 61622–32060 | EXTENSION, QUARTER PANEL LOWER LH | 1 |

**PROCEDURE**

First, pressure wash the quarter panel (and inner wheel house), then rinse. Dry the exterior panel. Use compressed air to remove the water in the inner wheel house. Lift the vehicle (use jack stands for safety if a floor jack is used). Remove rear seat, trim and trunk panels as necessary. Remove the antenna, fuel tank (for safety), rear bumper, rocker panel molding and rear wheel.

**CAUTION:** Protect the interior and exterior (glass) from sparks off the grinding wheel or plasma cutter.

Using the replacement panel as a template, mark the body for a rough cut.
See illustration A.

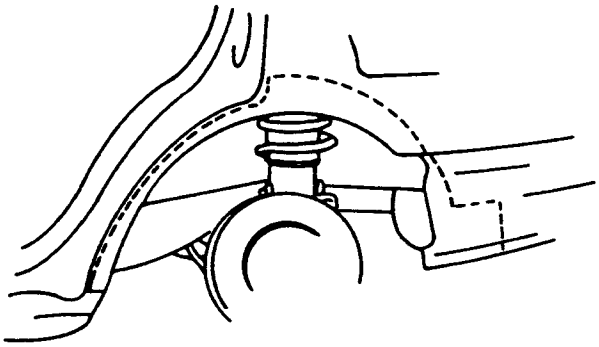


Illustration A.

Make a cut on the body panel, approximately 1/2" below the mark line, using a cut–off wheel. Take care not to cut through the wheel house on the outer panel. Next, using a spot weld cutter with the appropriate size bit, drill out the spot welds (see Body Collision Damage Repair Manual for Camry part number 00400–BRM01–0E indicating 20 weld sites). Remove the old panel. Remove the rust buildup that may accumulate using a "Clean 'N Strip" (3M part number 07466) wheel or equivalent on a high speed drill. Neutralize any remaining surface rust that exists on the outer wheel house with metal conditioner and conversion coating. Drill or punch holes (1/4" diameter) in the new panel for MIG (GMAW) welding. Apply weld through primer on both the outer wheel house and repair panel at the mating surfaces. Repair any dents or damage to the outer wheel house prior to installation.

Next, make a final cut on the body panel. See illustration B.

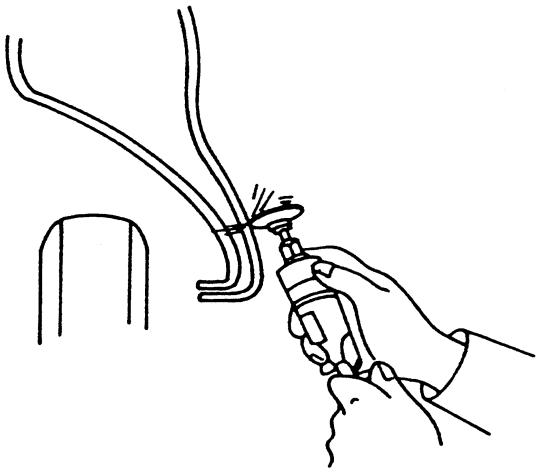


Illustration B.

TIP: Use the original number of welds in the wheel arch if MIG welding (20). However, if compression resistance welding is employed, the formula for replacement welding is 1.3 x original number (i.e. 20 original = 26 replacement). For additional information see Toyota Fundamental Body Repair Procedures Manual part number 00400–BRM 01–0E on pages 3–1 to 3–26.

Apply body sealer (non–flammable) to the outer wheel house and replacement panel. See illustration C.

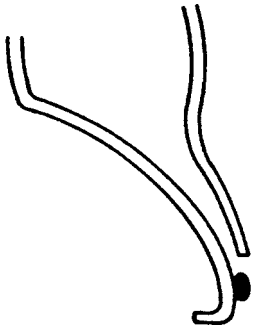


Illustration C.

Hold the new panel in place using vise grips or self tapping screws. See illustrations D–1 and D–2.

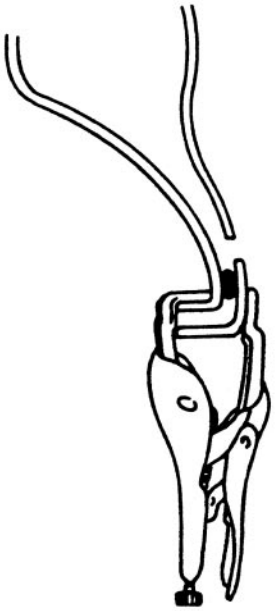


Illustration D-1.

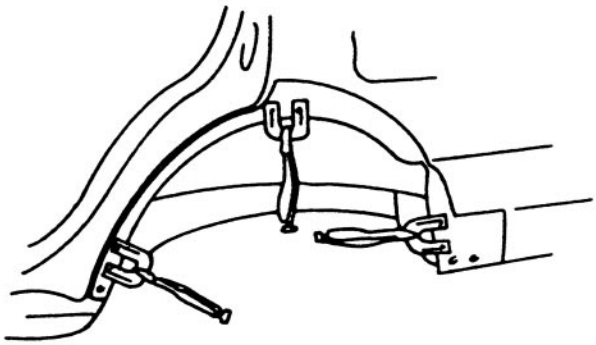


Illustration D-2.

Begin spot welding the panel at opposite ends to reduce warpage. Weld in short intervals (GMAW stitch mode) not longer than 5 mm as in illustration D–3. Welding is complete on the exterior body panel when the weld is continuous. Alternate between plug welding the wheel opening and stitch welding the exterior body panel. Grind the exterior welds as necessary.

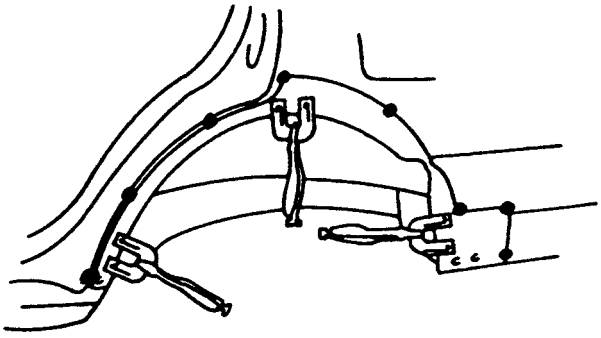


Illustration D-3.

TIP: Do NOT over–grind the weld sites, this will reduce the strength of the welds.

Apply anti–corrosion protection (body sealer, epoxy primer and cavity wax) to the panel. See illustrations E–1, E–2 and E–3.

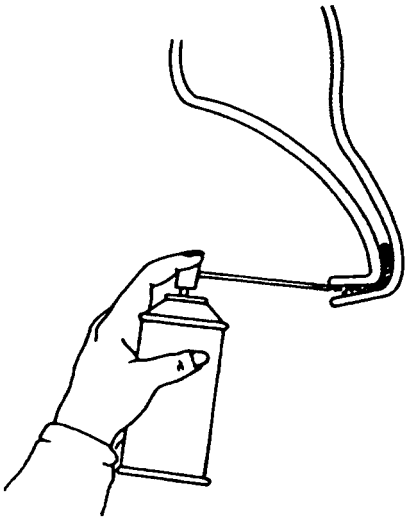


Illustration E-1.

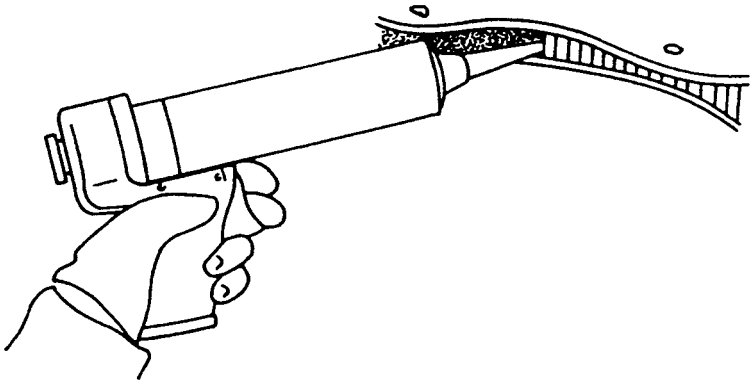


Illustration E-2.

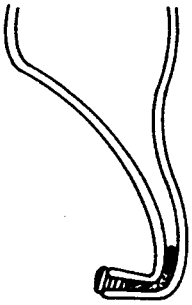


Illustration E-3.

The inspection holes in the interior compartment for the wheel well and trunk provide easy access. See illustration F.

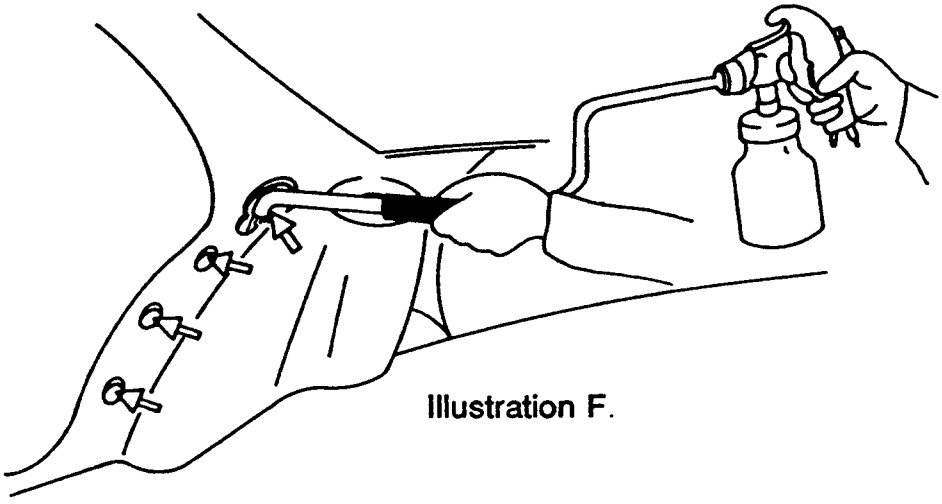


Illustration F.

Apply PVC undercoating in the wheel opening. Reinstall the parts removed. Finally, refinish as necessary using urethane refinishing materials.

**MATERIALS AND TOOLS**

Anti–rust corrosion wax
Assortment of hand tools
Assortment of vise grips
Body sealer (non–flammable)
Compression resistance welder
Conversion coating
Die grinder with cut off wheel attachment
Disc grinder
Drill
Epoxy primer
Eye protection
Fire extinguisher
Gloves
Hammers and dollies
Jack stands
Metal shears
Metal conditioner
MIG welder or GMAW
Nibbler
Plasma cutter
Pressure washer
Protective welding blanket
PVC applicating gun
PVC undercoating
Respiratory protection mask (welding)
Safety equipment
Seam and joint sealers (urethane)
Self starting screws
Spot weld cutting bit
Steel toe shoes
Urethane refinishing materials
Vehicle lift
Vise grips
Weld through primer (Zinc–rich)