



TEST PROJECT B / PROJET D'ÉPREUVE B

AUTOBODY REPAIR

CARROSSERIE

SECONDARY AND POST-SECONDARY /
NIVEAU SECONDAIRE ET POSTSECONDAIRE

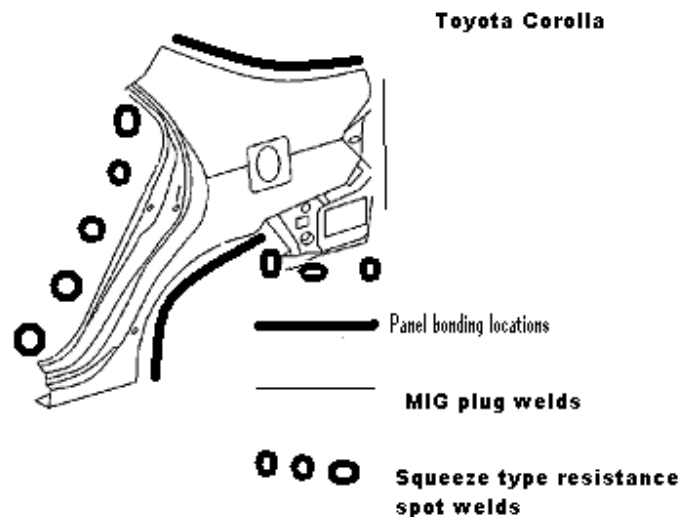
PROJECT B QUARTER PANEL-SECTIONING PROJECT TASK SHEET

Duration of project: 6 hours

Quarter Panel Sectioning Instruction Sheet

All procedures are evaluated to manufacturers' standards

The purpose of this project is to evaluate the students ability to follow instructions, measure, cut, fit, weld, bond and grind in the performance of a quarter panel section.
Note: If you chose to deviate from the procedure as outlined below, you **MUST** consult the judges.



IMPORTANT NOTE: AT EACH STOP HAVE THE JUDGES EVALUATE YOUR PROGRESS.

- 1) Perform MIG welder setup and testing of settings.
- 2) A) On the **body** and the **new quarter panel**, mark a line using a measuring device from the notch in the door opening flange across the sail panel.

B) Using a measuring device place a mark from the centre of the folded tab on the rocker panel flange. **STOP**
- 3) Remove the necessary spot welds in order to remove the quarter panel section from the vehicle body.

Note: You will be performing a butt joint at both sectioning locations (no reinforcing insert to be used).

- 4) Cut, trim and prepare vehicle body and replacement quarter panel for welding and full fitment for panel replacement procedures, according to the chart below.
- 5) Prepare your replacement quarter panel for adhesive bonding (3M procedures) and welding in the appropriate locations. (refer to picture) **STOP**
- 6) Apply 3M bonding adhesive on both the vehicle and the replacement quarter panel. **STOP**

QUARTER PANEL JOINT LOCATIONS	Adhesive bonding, spot welding or Plug welding
STRIKER PLATE MOUNT	Plug welds as required
SAIL PANEL	Butt weld
DOGLEG/ROCKER PANEL	Butt weld
WHEEL OPENING FLANGE	Adhesive bonding
WINDOW OPENING	Adhesive bonding
DOOR OPENING and LOWER QUARTER PANEL FLANGE	Squeeze type resistance spot welds as required
QUARTER PANEL TO REAR BODY PANEL JOINT	Plug welds as required

- 7) Perform bonding and welding operations. Perform the joint on the upper portion of the quarter panel first then the dogleg/rocker panel welding operation. **STOP**
- 8) When you have completed all the welding operations you must **grind the welds on the SAIL PANEL joint area only.** **STOP**