



SCNC SKILLS CANADA NATIONAL COMPETITION



OCMT OLYMPIADES CANADIENNES DES MÉTIERS ET DES TECHNOLOGIES



SkillsCompétences
Canada
Halifax2019

TEST PROJECT B / PROJET D'ÉPREUVE B

AUTOBODY REPAIR CARROSSERIE

SECONDARY AND POST-SECONDARY /
NIVEAUX SECONDAIRE ET POSTSECONDAIRE



PROJECT B QUARTER PANEL-SECTIONING PROJECT TASK SHEET

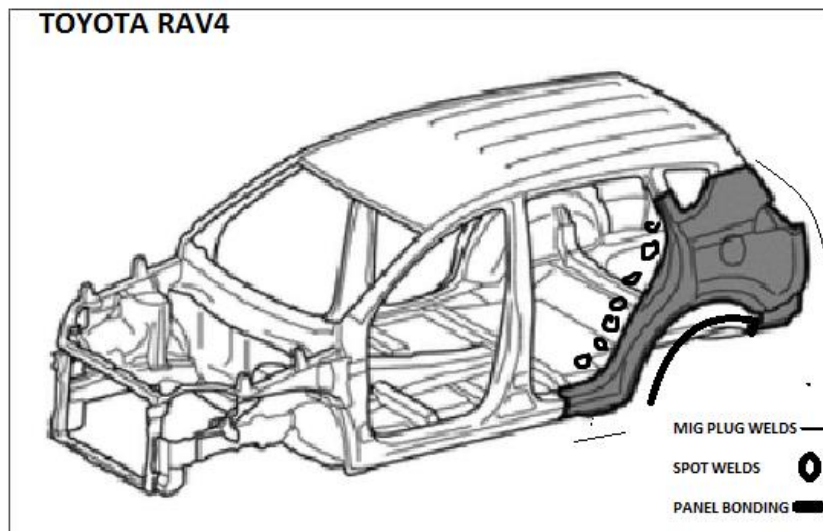
Duration of project: 6 hours

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 cut lines following the attached Toyota collision repair manual instructions.
B) Once you have completed marking your cut locations, **STOP**
- 3) Remove the necessary spot welds in order to remove the quarter panel section from the vehicle body.

Note: You will be performing an open butt joint at two 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 at the locations in the above diagram **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 | 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/DOGLEG joint area only.** **STOP**