Uniform Procedures For Collision Repair

FR21P–Fender

 v.2.3

1. Description

This procedure describes the repair and complete replacement of a bolted-on plastic fender. Inspection and evaluation requirements are also included.

2. Purpose

The purpose of this procedure is to provide industry-accepted requirements for performing high-quality repair of bolted-on plastic fenders. This procedure is intended for use by professionals who are qualified through training and experience.

3. Referenced Documents

The following documents are considered part of this procedure by reference.

3.1 Procedures

PR01 Plastic Repair, Welding
PR11 Plastic Repair, Adhesive
PS01 Personnel Safety
RF01P Surface Preparation

3.2 Other Information

Product-specific information
Recycled parts information
Vehicle-specific repair information

4. Equipment And Material Requirements

4.1 Plastic Welding Materials

Use plastic welding materials as described in **PR01**.

4.2 Adhesive Repair Materials

Use plastic adhesive materials as described in **PR11**.

5. Damage Analysis

5.1 General Damage

Inspect bolted-on plastic fenders for these types of damage:

- ❏ visible damage
- ❏ improper previous repairs
- ❏ misalignment with adjacent panels
- ❏ damaged finish

Determine whether the bolted-on plastic fender should be repaired or replaced. Fender removal may be required to properly assess underside damage.

6. Personnel Safety

6.1 General Safety

General safety information is in **PS01**.

6.2 Plastic Repair Safety

Plastic repair safety information is in **PR01** or **PR11**.

7. Environmental Safety

Does not apply.

8. Vehicle Protection

8.1 Adjacent Areas

Protect glass, upholstery, and other adjacent cosmetic surfaces, as necessary during repairs, removal, or installation.

8.2 Anti-Theft Label

Protect the anti-theft label, or other labels, during repair and refinishing operations.

9. Repair Procedure

9.1 Fender Repair

Select the repair method and perform the repairs.

Before proceeding, decide whether plastic repairs can be made with the fender installed on the vehicle. For removal see **9.2**. For installation see **9.3**.

To repair a bolted-on plastic fender:

❑ 1. Repair damage using plastic repair welding or adhesive repair procedures.
❑ 2. Replace trim mounting studs or holes, if necessary.
❑ 3. Prime all interior and exterior surfaces and other areas damaged by the collision or repairs.
❑ 4. Apply seam sealers as necessary to seal the joints and restore the appearance. Reprime if required by the product maker.
❑ 5. Refinish areas damaged by the collision, repairs, or anchoring, as required to restore the appearance. Refinish cosmetic surfaces after all body repairs are complete.
❑ 6. Install inner splash panels and other parts as required.
❑ 7. Continue vehicle reassembly.

9.2 Fender Removal

To remove a bolted-on plastic fender:

❑ 1. Protect adjacent panels.
❑ 2. Loosen or remove the inner splash panel.
❑ 3. Reposition or remove any attached mechanical parts or wiring.

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❑ 4. Loosen and remove the mounting fasteners. Discard any damaged fasteners.
❑ 5. Remove the shims, if necessary. Note the placement and number of shims.
❑ 6. Remove the plastic fender.
❑ 7. Make the necessary repairs according to the type of damage, if necessary. See **9.1**.

9.3 Fender Installation

To install a bolted-on plastic fender:

❑ 1. Prepare the fender for vehicle options such as antenna, trim, etc., if necessary.
❑ 2. Install trim mounting studs or drill holes, if necessary.
❑ 3. Prime all interior and exterior surfaces, if necessary.
❑ 4. Apply topcoat to panel edges to restore appearance.
❑ 5. Position and hold the repaired or replacement fender in place.
❑ 6. Install the fasteners. If the fasteners are being replaced, use fasteners that are the same size, type, and strength as the original fasteners.
❑ 7. Install the shims, if necessary.
❑ 8. Adjust the fender to obtain proper alignment to attached and adjacent parts.
❑ 9. Torque all fasteners in the proper sequence, to the vehicle maker's recommendations.
❑ 10. Install the inner splash panel and other parts that were removed or repositioned, as required.
❑ 11. Continue vehicle reassembly.

10. Use Of Recycled (Salvage) Parts

10.1 Condition Of Salvage Parts

Inspect a salvage bolted-on plastic fender for these defects:

- ❏ unrepairable damage
- ❏ improper previous repairs

Plan to transfer or replace any required bodyside moldings, stripes, decals, emblems, or other exterior trim.

10.2 Preparation Of Salvage Parts

To prepare a salvage, bolted-on plastic fender for installation:

- ❏ Remove any trim or moldings that are to be reused or replaced.
- ❏ Make any necessary repairs.
- ❏ Clean the part to remove dirt, wax, grease, etc.
- ❏ Remove excessive paint film thickness.
- ❏ Remove or install trim-mounting studs and drill or fill trim-attachment holes, as required.
- ❏ Refinish panel edges before installation, to restore appearance.

11. Inspection And Testing

11.1 Inspection Of A Repaired Or Replaced Fender

After installation, inspect a bolted-on plastic fender for these conditions:

- ❏ proper alignment with attached and adjacent parts
- ❏ proper operation of adjacent hinged parts
- ❏ proper installation of all fasteners
- ❏ proper finish appearance and film thickness
- ❏ proper operation of attached electrical and electronic parts

Correct any defects.