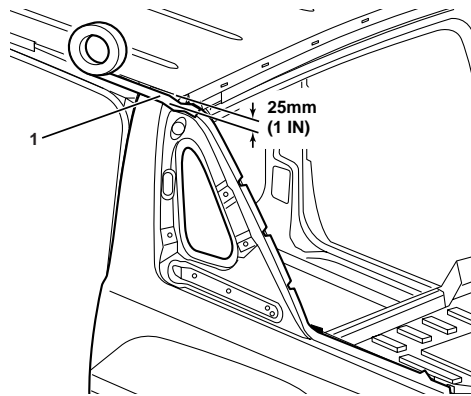
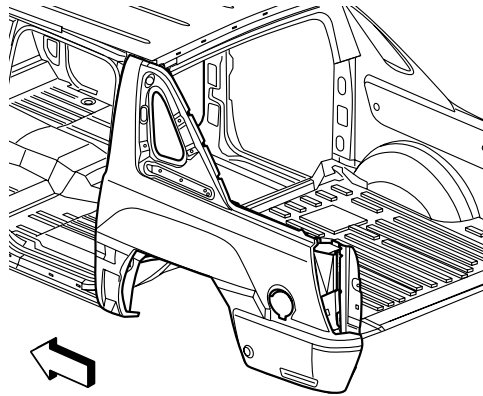


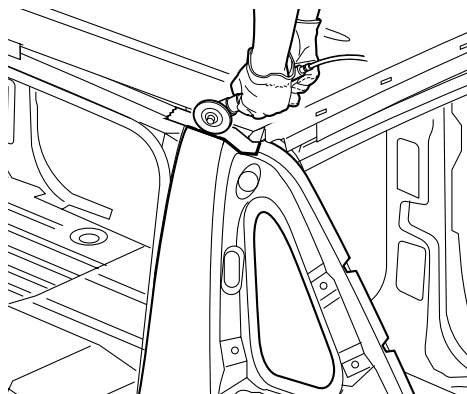
# Quarter Panel

## Removal Procedure

1. Remove all related panels and components.
2. Restore as much of the damage as possible to factory specifications.
3. Note the location and remove the following as necessary:
  - Sealers
  - Sound deadeners
  - Anti-corrosion materials



4. Apply 25 mm (1 in.) wide tape (1) along the upper edge of the Quarter Panel at the roof line.



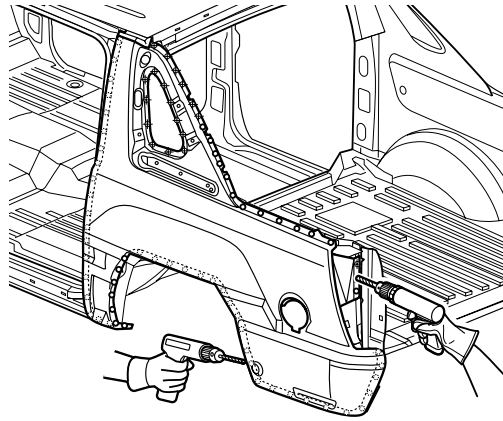
**IMPORTANT:** Do not damage any inner panels or reinforcements.

5. Cut the Quarter Panel at the bottom edge of the tape.

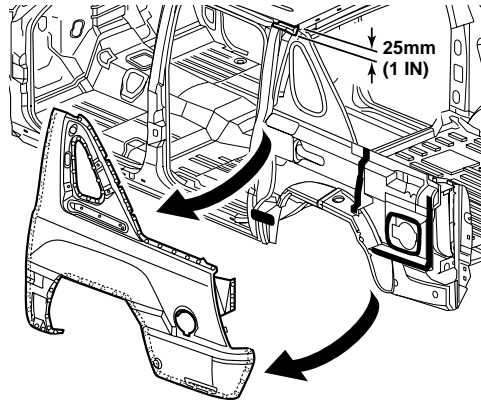
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## Quarter Panel Removal Procedure cont'd

6. Locate and drill out all factory welds. Note the number and location of welds for installation of the service part.



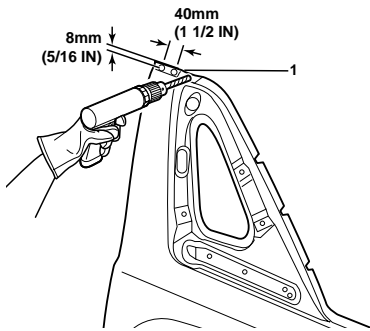
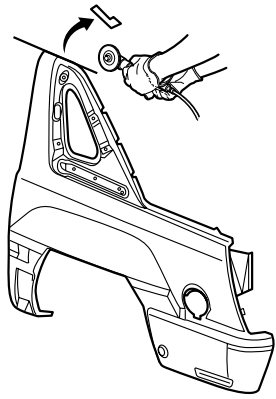
7. Remove the damaged Quarter Panel, leaving a 25 mm (1 in.) flange attached to the roof.



# Quarter Panel

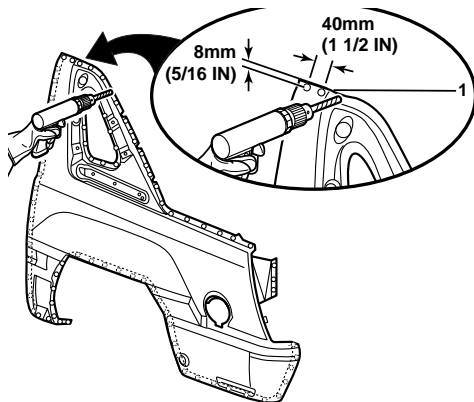
## Installation Procedure

1. Trim and discard the upper mounting flange on the service Quarter Panel so that it will fit over the 25 mm (1 in.) flange left from the original panel.



2. Drill 8 mm (5/16 in.) plug weld holes along the sectioning cut on the service part. Locate these holes 13 mm (1/2 in.) from the edge and spaced 40 mm (1-1/2 in.) apart (1).

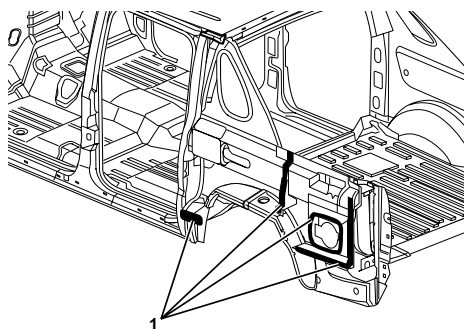
**IMPORTANT:** In any area damaged beyond recognition, space plug weld holes every 40 mm (1-1/2 in.) apart.



4. Drill 8 mm (5/16 in.) plug weld holes in the service part as necessary in the locations noted from the original panel and along the sectioning cut.
5. Prepare all attachment surfaces as necessary.
6. Apply weld-through primer to all bare metal surfaces.

**CAUTION:** THE FUEL FILLER OPENING MUST BE PROPERLY SEALED PRIOR TO POSITIONING THE QUARTER PANEL. FAILURE TO PROPERLY SEAL THE QUARTER PANEL COULD RESULT IN EXHAUST GAS LEAKAGE INTO THE INTERIOR OF THE VEHICLE CAUSING PERSONAL INJURY.

7. Install GM P/N 12399117 Sealing Strip between outer wheelhouse and quarter panel gas door pocket.

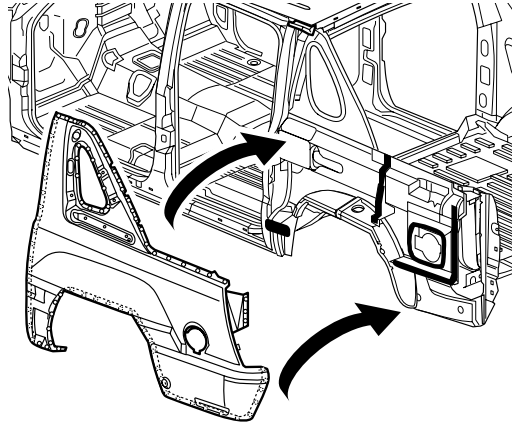


8. Apply internal sealers (1) in the locations noted from the removal procedure.

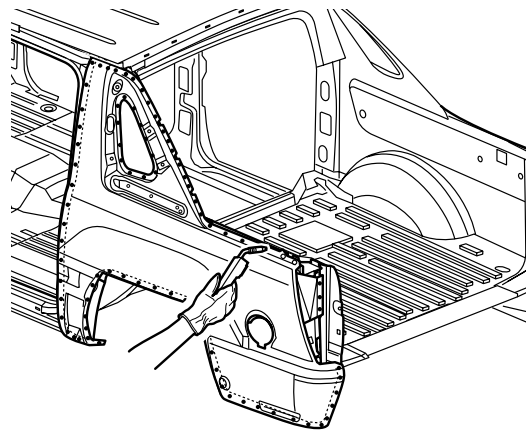
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## Quarter Panel Installation Procedure cont'd

9. Position the Quarter Panel to the vehicle.



10. Plug weld accordingly.
11. To create a solid weld with minimum heat distortion, make 25 mm (1 in.) stitch welds along the seam with 25 mm (1 in.) gaps between them. Then go back and complete the stitch weld.
12. Clean and prepare all welded surfaces.



**IMPORTANT:** Prior to refinishing, refer to publication GM4901M-D-01 GM Approved Refinish Materials for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

13. Apply the following as necessary:
  - Anti-corrosion primer
  - Sound deadeners
  - Sealers
14. Refinish as necessary.
15. Install all related panels and components.

