

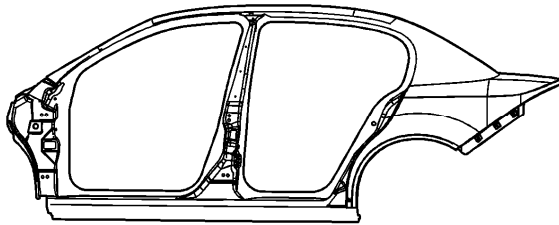
Body Side Outer Panel Replacement

Removal Procedure

The graphics in this procedure show the sedan. Procedures for the coupe are similar.

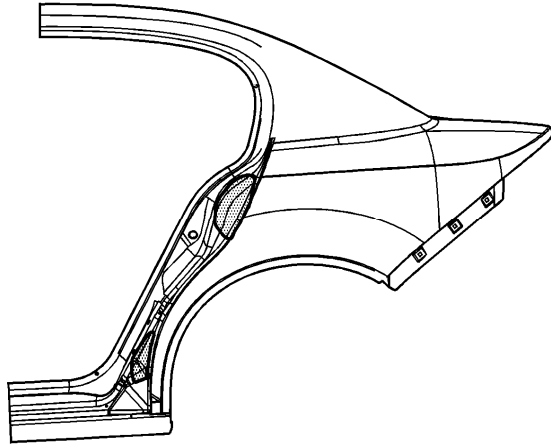
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
3. Remove all related panels and components.
4. Repair as much of the damaged area as possible. Refer to [Dimensions - Body](#) .
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.

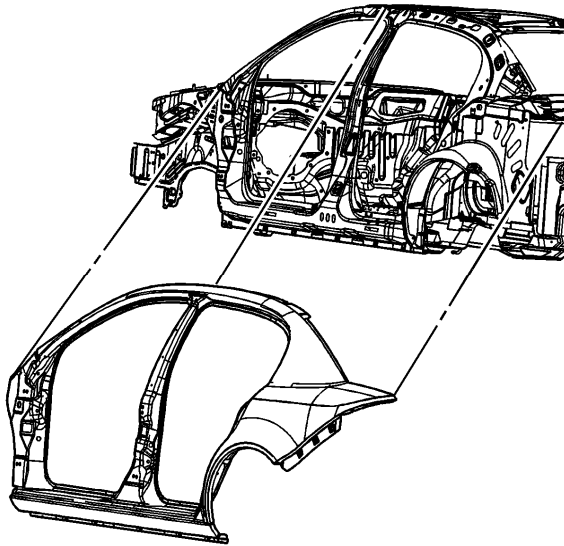


Important: Note the number and location of the factory welds for installation of the outer body side panel.

6. Locate and drill out all the necessary factory welds.

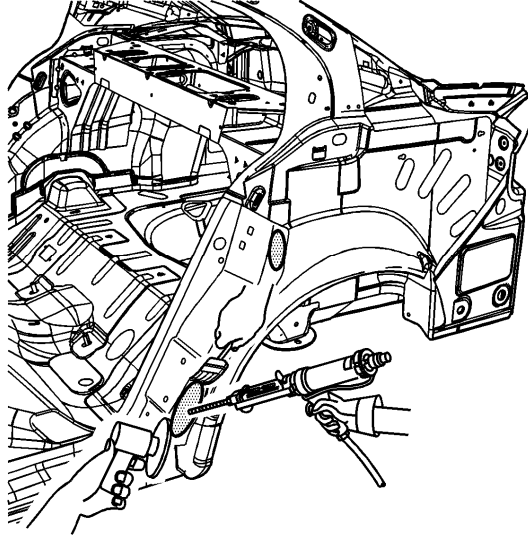


7. On the sedan, structural adhesive is present in the dog leg area of the quarter panel. Heat the quarter panel at the locations shown with a small flame from an oxy-acetylene torch to release the bond to the quarter panel.

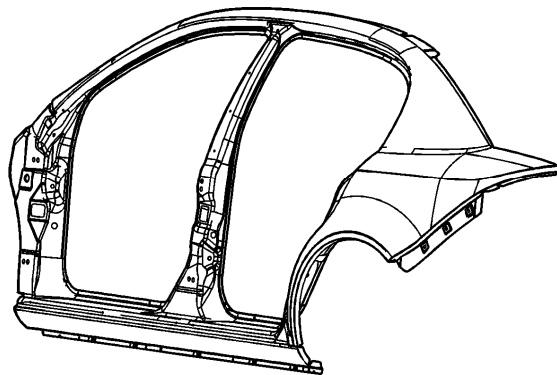


8. Remove the outer body side panel.

Installation Procedure

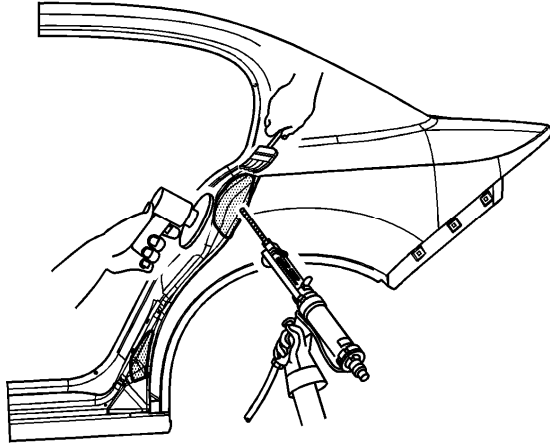


1. At the structural adhesive locations of the dog leg inner reinforcement, grind the surface to bare steel.



Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

2. Drill 8-mm (5/16-in) plug weld holes in the service part as necessary in the corresponding locations noted on the original panel.
3. Prepare all mating surfaces for welding as necessary.
4. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).



5. Grind the outer body side panel mating area to the dog leg reinforcement to remove the E-coating.

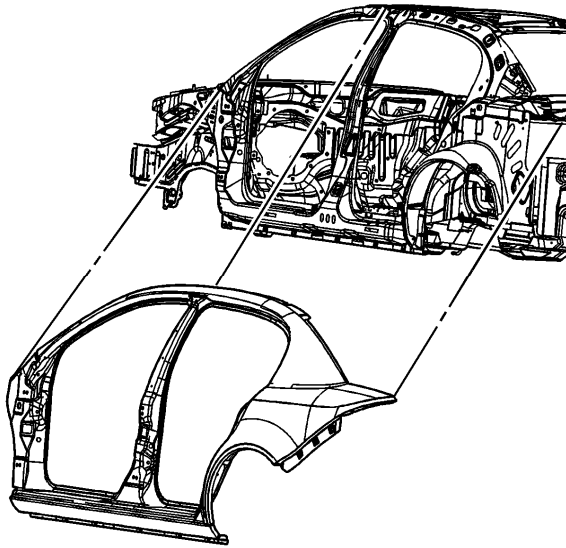
Important: Do not damage the corners or thin the metal during the grinding process.

6. Clean the mating surfaces.

Important: The adhesive has a working time of 40-50 minutes. DO not allow the adhesive to totally cure off the vehicle, as the proper alignment of the panel to the body will be difficult.

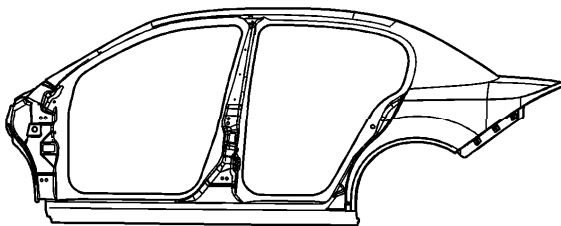
7. Apply a bead of metal panel bonding adhesive GM P/N 12378566/7 (Canadian P/N 88901674/5) or equivalent to a thickness of 3-6 mm (1/8 to 1/4 in) to both of the mating surfaces.
8. Using a small acid brush (3), spread a coat of adhesive to cover all of the bare metal surfaces to ensure corrosion protection.

Important: Spread the adhesive thick enough to ensure panel contact between the dog leg inner reinforcement and the body side outer panel in the quarter panel area.



Important: Do not pull the panels apart after the panels have been joined together. Slide the panels against each other to align the panels.

9. Position the outer body side panel to the vehicle, using 3-dimensional measuring equipment. Clamp the panel in place.
10. Use lacquer thinner to remove the excess adhesive from the panel area.



11. Plug weld accordingly.
12. Clean and prepare all of the welded surfaces.
13. Install all of the related panels and components.

14. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
15. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
16. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
17. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.