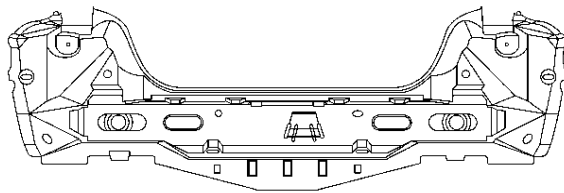


Rear End Panel Replacement

Removal Procedure

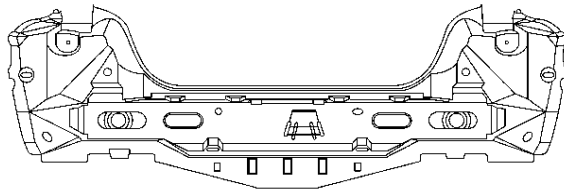
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

Important: The rear end panels is supplied as a complete assembly. Quarter panels extensions attach to the outside corners of the rear end panel. Service for this panel is performed at factory seams.



1. Remove all related panels and components
2. Visually inspect and restore as much of the damage as possible to factory specifications.
3. Remove sealers and anti-corrosion materials as necessary.
4. Locate, mark, and drill out all factory welds. Note the number and location of welds for installation of the service panel.
5. Remove the damaged rear panel.

Installation Procedure



1. Prepare the mating surfaces as necessary. Inspect or proper fit of the service panel.
2. On the new panel, drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the original panel.
3. Position the service panel, check with 3-dimensional measuring equipment.
4. Plug weld accordingly.
5. Clean and prepare welded surfaces.

Important: Prior to refinishing, refer to GM 4901MD-99 Refinish Manual for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

6. Prime with 2-part catalyzed primer.
 7. Apply the following as necessary:
 8. Apply sealers and anti-corrosion materials as necessary.
 9. Install all related panels and components.
-