

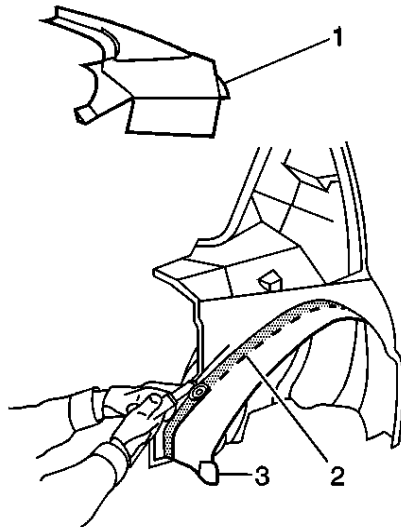
Rear Outer Wheelhouse Replacement

Removal Procedure

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

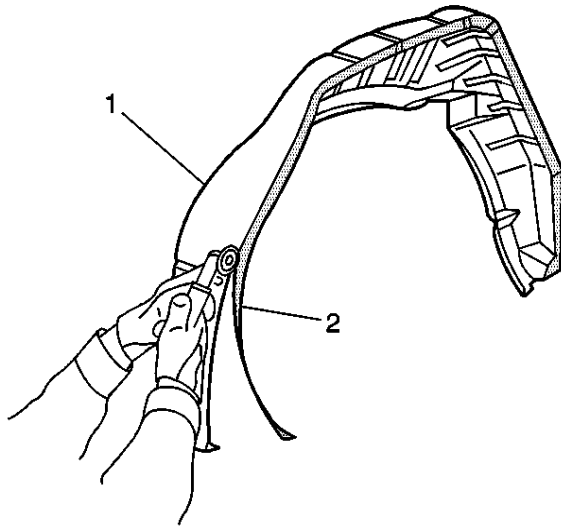
Important: Although full replacement of the rear outer wheelhouse can be performed, sectioning procedures have been developed for use when damage permits.

1. Remove all of the related panels and components including the quarter panel.
2. Visually inspect and restore as much of the damage as possible.
3. Remove the following materials as necessary:
 - The sealers
 - The sound deadeners
 - The anti-corrosion materials
6. After removing the quarter panel, locate, mark and drill out the welds attaching the reinforcement panel (1) to the outer wheelhouse and the quarter panel.

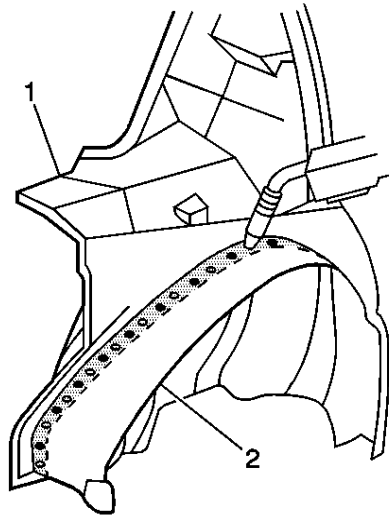


7. Apply a strip of 25 mm (1 in) masking tape along the horizontal surface of the bend in the wheelhouse (2).
8. Cut along the outboard side of the masking tape to create a 25 mm (1 in) flange (2).
9. Remove the damaged section of the wheelhouse (3).

Installation Procedure



1. Cut the wheelhouse service part (1) along the corner of the bend (2).
2. Remove and discard the unused section of the wheelhouse.
3. On the service part, drill 8 mm (5/16 in) plug weld holes every 40 mm (1½ in) along the cut.



4. Prepare the mating surfaces as necessary. Inspect for proper fit of the service part.
5. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
6. Check for proper fit and plug weld accordingly (2). Take care not to warp or distort the metal.
7. Repair or replace the outer wheelhouse reinforcement as necessary.
8. Position the reinforcement panel as noted from the original panel location.
9. Plug weld accordingly.
10. 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.

11. Prime with 2-part catalyzed primer.
12. Apply the sealers and the anti-corrosion materials as necessary.
13. Install all of the related panels and components.