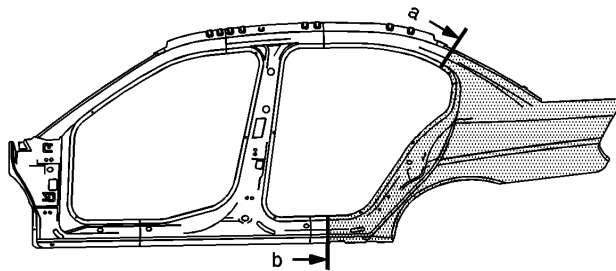


# Quarter Outer Panel Sectioning (Sedan Weld-On)

## Removal Procedure

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

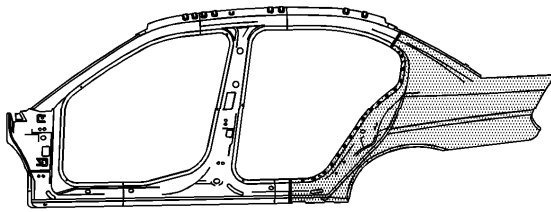
1. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
2. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) .
3. Restore as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .
4. Remove all related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



6. Section the sail panel (a) and the rocker panel (b).
  - At the sail panel, measure from the back glass opening down 120 mm

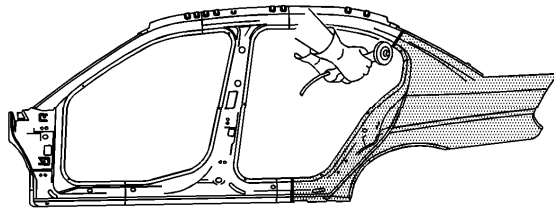
(4 3/4 in). Scribe a line.

- At the rocker panel, measure 70 mm (2 3/4 in) rearward from the rocker panel locating hole. Scribe a line.

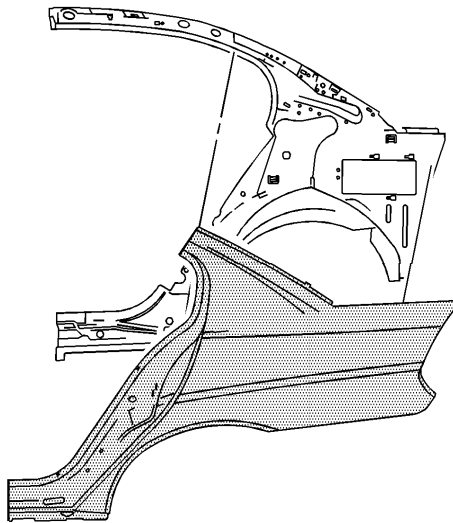


8. Locate and drill out all factory welds. Note the number and location of welds for installation of the quarter panel.

**Important:** Do not damage any other panel or reinforcements when cutting at the marked locations.



9. Cut the panel at the marked locations.

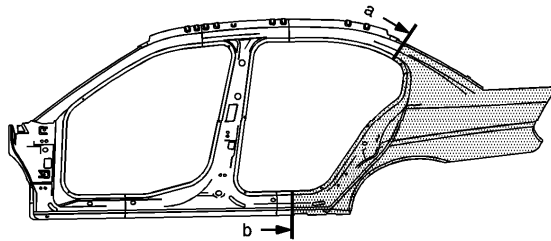


10. Remove the lower quarter panel.

## Installation Procedure

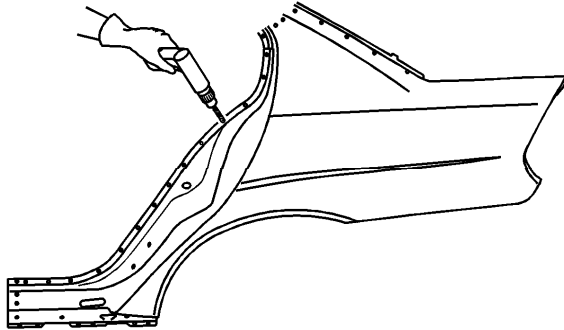
**Important:** To allow proper layout and cutting of the service part, review the sectioning information in the removal procedure.

1. Locate the area on the service part where the sectioning will be performed.



2. Measure and mark the cut line location on the service area.
3. Cut the service panel at the marked locations (a, b). Trim the sectioning butt joints to allow a gap equal to the metal thickness at the sectioning joint.
4. Create backing plates 50 mm (2 in) for the sail panel and 100 mm (4 in) for the rocker panel. Create the backing plates from the unused portion of the service part.

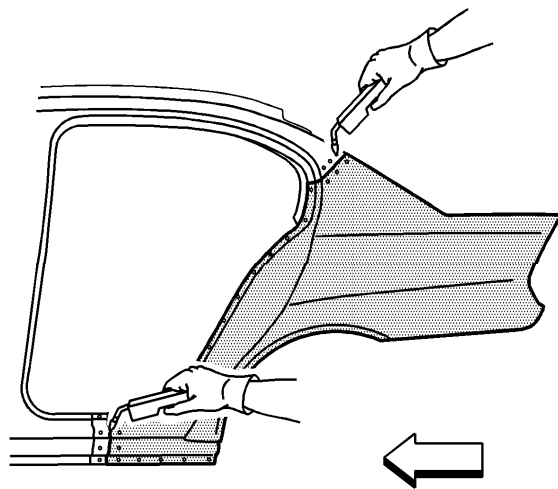
- Trim the backing plates as necessary to fit behind the panel at the sectioning joints.



- Drill 8 mm (5/16 in) plug weld holes as necessary in locations noted from the original quarter panel.

**Important:** If the location of the original plug weld holes can not be determined, or if structural weld-thru adhesive is present, space the plug weld holes every 40 mm (1 ½ in) apart.

- Prepare all mating surfaces as necessary.
- Apply GM Weld-Thru coating to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
- Perform the sectioning procedure. Refer to [Overlap/Backing Plate Sectioning](#).



10. Plug weld accordingly.
11. Stitch weld the sail panel and rocker panel accordingly.
12. Clean and prepare all welded surfaces.
13. Apply the sealers and anti-corrosion materials to the repair area, as necessary.  
Refer to [Anti-Corrosion Treatment and Repair](#) .
14. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
15. Install all related panels and components.
16. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .
17. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .