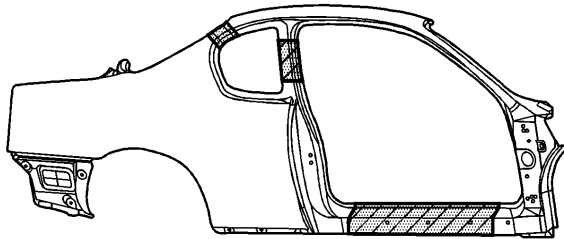


Quarter Panel Replacement

Removal Procedure

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

Important: The quarter panel is serviced as a body side service assembly which includes the outer door frame opening, and the lower rear quarter close-out panel. Replacement of the quarter panel requires removal of the quarter glass and the back glass. A special sectioning procedure has been developed for improved serviceability.

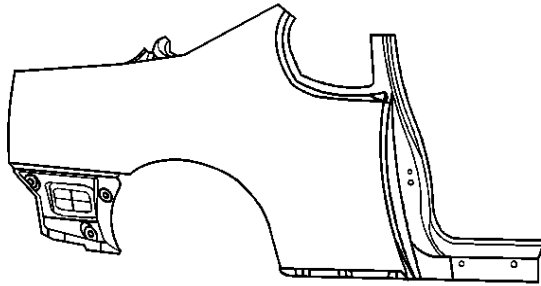


1. Visually inspect and restore as much of the damage as possible to factory specifications.
2. Remove all related panels and components.
3. Remove sealers and anti-corrosion materials, as necessary.
4. Scribe a cut line in upper quarter area.
5. Scribe a cut line in the rocker panel area.
6. Cut damaged section at marked locations.
7. Locate and mark all factory welds. Note the number and location of welds for installation of the service assembly.
8. Drill out all factory welds.

Important: Note the location of the sound deadening foam for installation.

9. Remove the damaged quarter panel.

Installation Procedure



1. Prepare the mating surfaces, as necessary.
2. On the service part, locate where to cut the upper quarter and rocker areas. Leave extra length in these areas for trimming.
3. Refer to general sectioning for appropriate usage of backing plates.
4. Trim the quarter panel to leave a gap of one and on-half times the thickness of the metal at the sectioning joints.
5. Check for proper fit and alignment.
6. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
7. Plug weld accordingly.

Important: The glass bonding area should be a primer surface ONLY, and NOT an after-market top-coated (paint, or color coated) surface. Materials such as BASF DE17, Dupont 2610, or PPG DP40, or equivalent, are appropriate for this application. Refer to [Urethane Adhesive Installation of Stationary Windows in Stationary Windows](#) for more detailed information.

8. Clean and prepare all 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 recommendation.

9. Prime with 2-part catalyzed primer.

Important: It is important to apply the sound deadening foam in the locations noted from removal.

10. Apply sealers and anti-corrosion materials as necessary.
11. Install all related panels and components.