

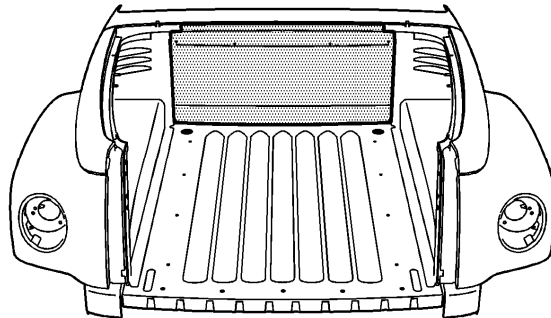
Panel Replacement - Body Rear Outer

Removal Procedure

Caution

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

1. Disable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.

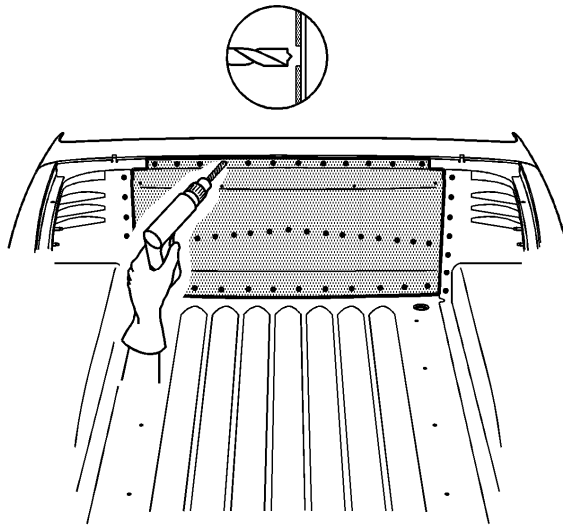


3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to Rear Compartment, and Roof Storage Compartment in [Dimensions - Body](#) .

Caution

Refer to [Foam Sound Deadeners Caution](#) in Cautions and Notices.

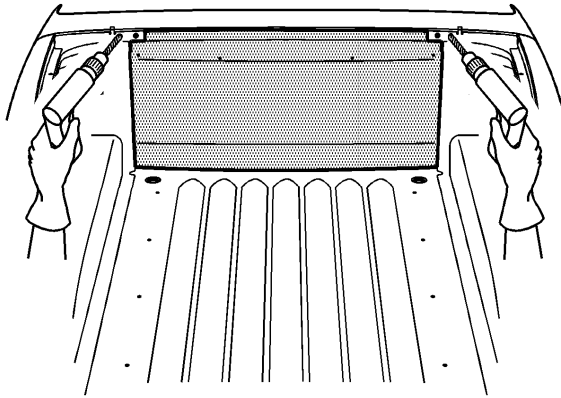
5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.



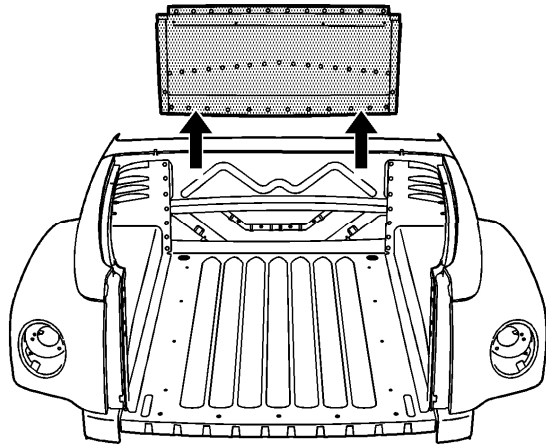
Important

Do not damage any inner panels or reinforcements.

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

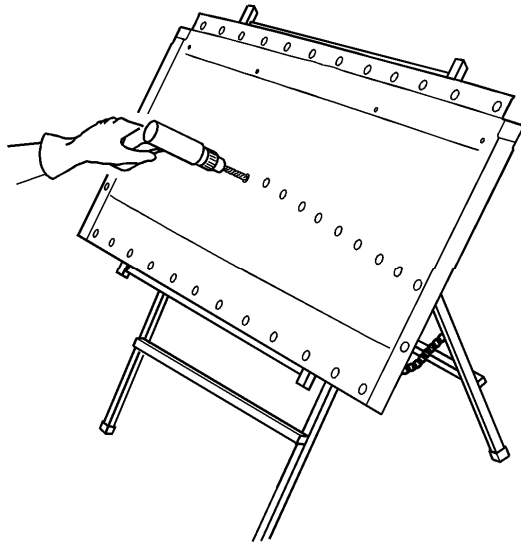


7. Locate and drill out two welds on each side of the outer body panel as shown.
8. Verify the existence of structural weld-through adhesive. Refer to [Structure Adhesive - Identification](#) . If necessary use a chisel to separate the outer body panel from the adjacent panels.



9. Remove the damaged outer body panel by raising the panel up and away from the vehicle.

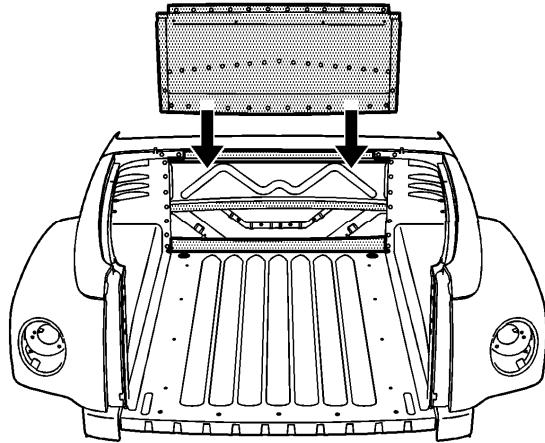
Installation Procedure



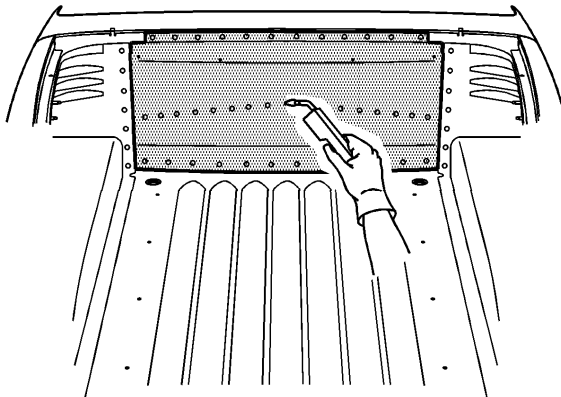
Important

Do NOT drill MIG plug weld holes along either side of the weld flanges on the service outer body panel.

1. Drill 8 mm (5/16 in) plug weld holes in the service part only in the areas shown.
2. Replace the structural adhesive with an additional plug weld between the existing plug welds, where necessary.
3. Prepare all mating surfaces as necessary.
4. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces.
Refer to [Anti-Corrosion Treatment and Repair](#) .



5. Lower the rear body panel into position. Refer to Rear Compartment, and Roof Stowage Compartment in [Dimensions - Body](#) .



6. Plug weld accordingly.
7. Clean and prepare all welded surfaces.

8. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
9. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
10. Install all related panels and components.
11. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.
12. Enable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.