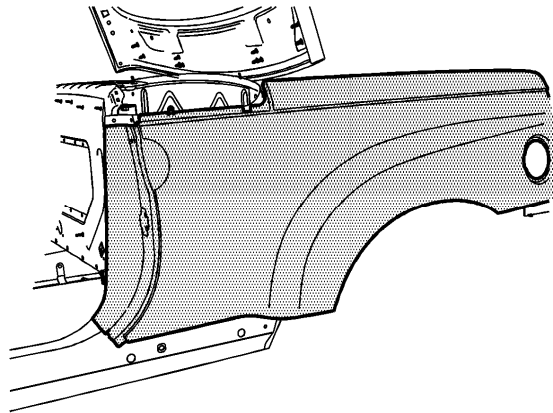


# Quarter Outer Panel Replacement (Weld-on)

## Removal Procedure

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

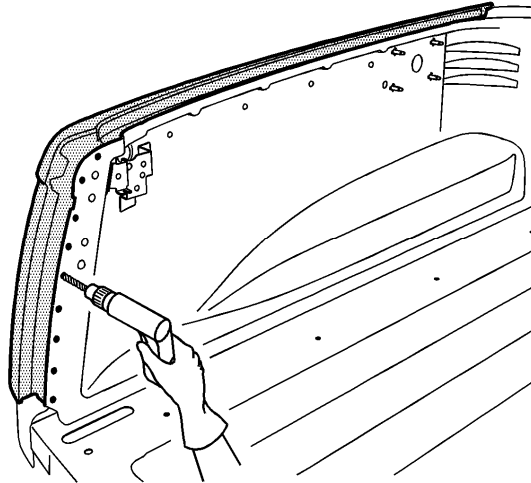
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.



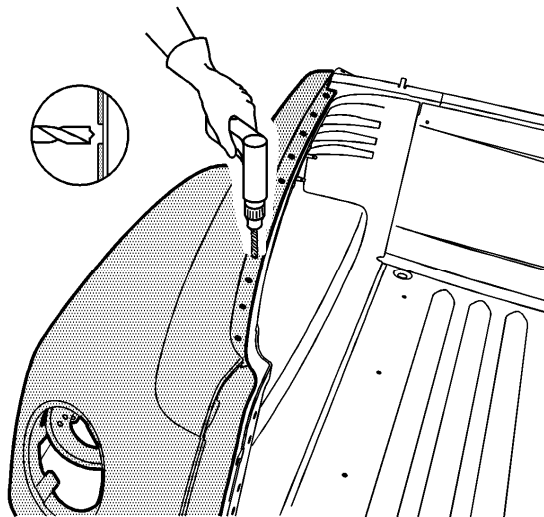
3. Remove all related panels and components including the rear compartment lid. Refer to [Rear Compartment Lid Replacement](#) and to [Endgate Replacement](#) in Body Rear End.
4. Repair as much of the damage as possible to factory specifications. Refer to Rear Compartment in [Dimensions - Body](#) .
5. Open the folding top stowage compartment lid. Refer to [Folding Top Stowage Compartment Lid Release Mech](#) .

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

6. 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.

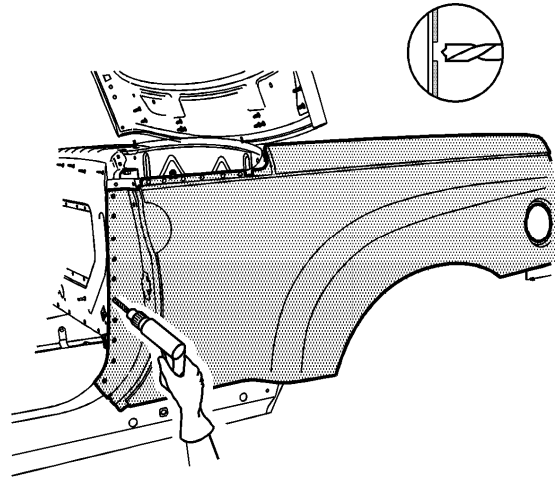


7. Locate and drill completely through all layers of metal at the factory welds along the rear compartment end gate opening.

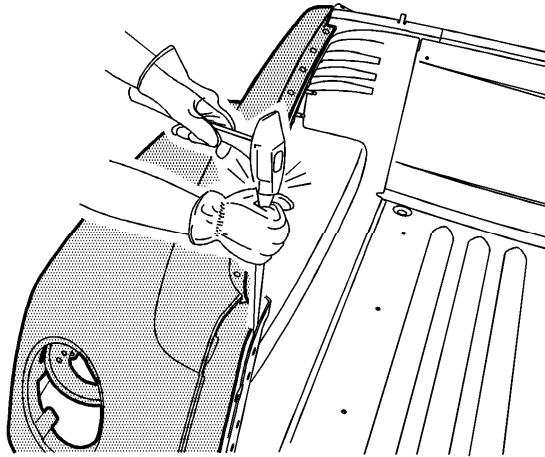


**Important:** Do NOT damage the inner panels or the reinforcements.

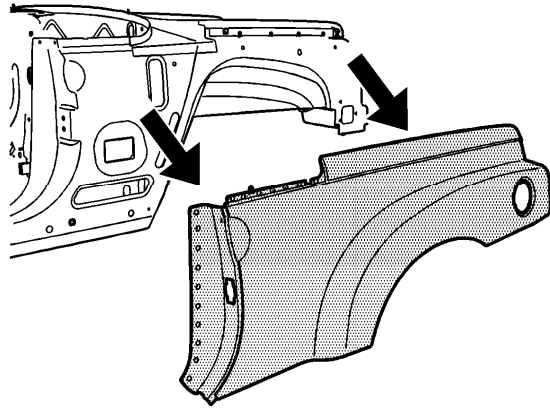
8. Locate and drill out all factory welds along the rear compartment opening. Note the number and location of the welds for installation of the service quarter panel.



9. Locate and drill out all factory welds along the lock pillar. Note the number and location of the welds for installation of the service quarter panel.

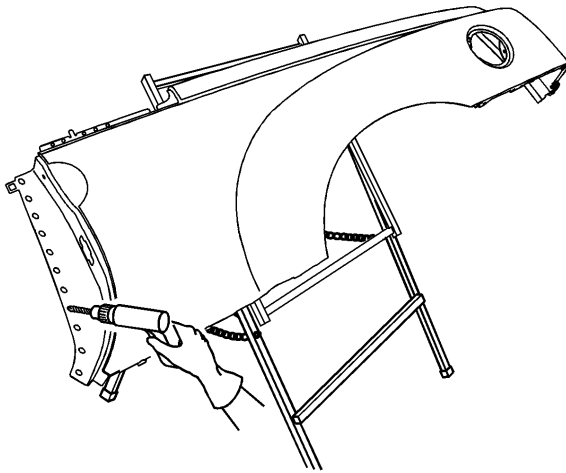


10. Verify the existence of structural weld-thru adhesive. Refer to [Structure Adhesive - Identification](#) . If necessary use a chisel to separate the outer quarter panel from the adjacent panels.



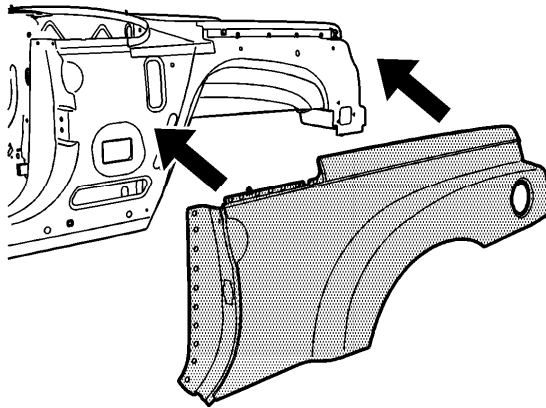
11. Remove the damaged quarter panel.

### Installation Procedure

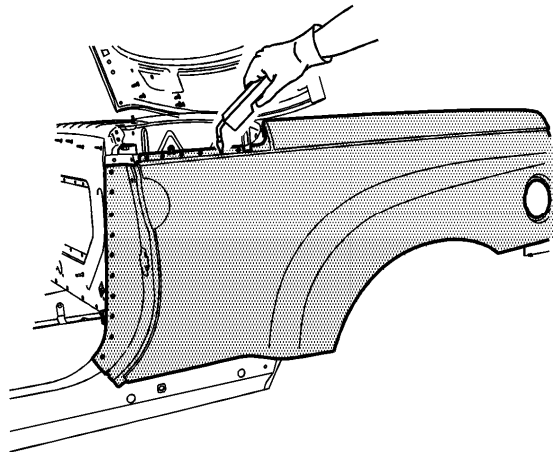


**Important:** Do NOT drill plug weld holes along the edge of the service quarter panel by the rear compartment end gate opening.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted on the original panel.
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. Position the quarter panel. Refer to Rear Compartment in [Dimensions - Body](#) .



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

8. Apply the sealers and the 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, including the rear compartment lid. Refer to [Rear Compartment Lid Replacement](#) and to [Endgate Replacement](#) in Body Rear End.
11. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
12. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.