
Quarter Outer Panel Replacement

Removal Procedure

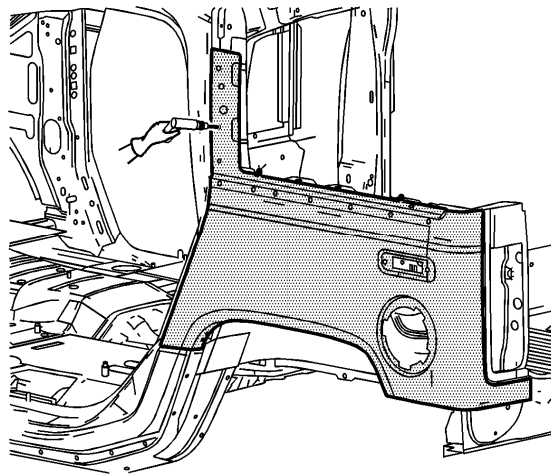
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

Important: Before beginning the repair, refer to [Metal Panel Bonding](#) for proper adhesive preparations and general information.

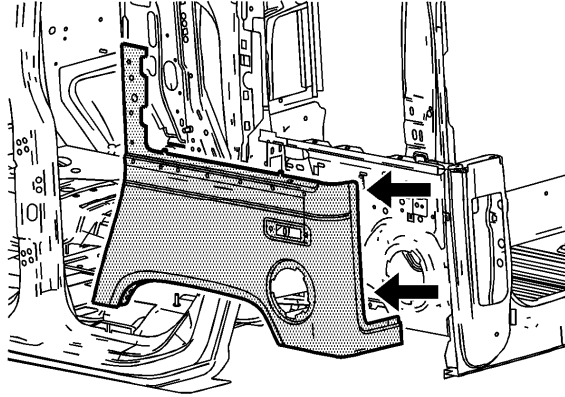
1. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
2. Disable the SIR system. Refer to [SIR Disabling and Enabling](#).
3. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#).
4. Remove all related panels and components.

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](#).

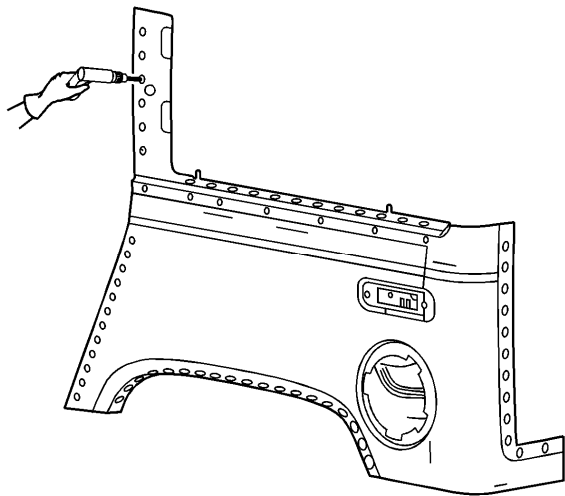


6. Locate and drill out all factory welds. Note the number and location of welds for installation of the quarter panel.



7. Remove the quarter panel.

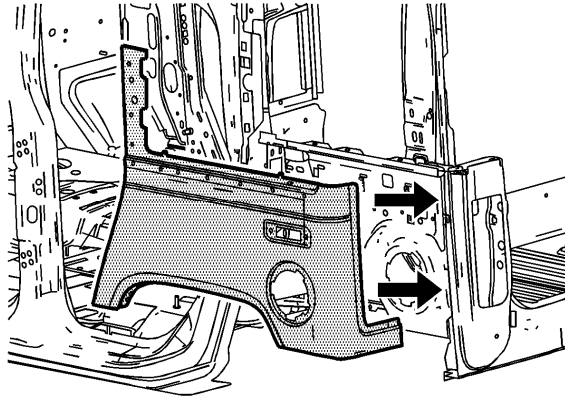
Installation Procedure



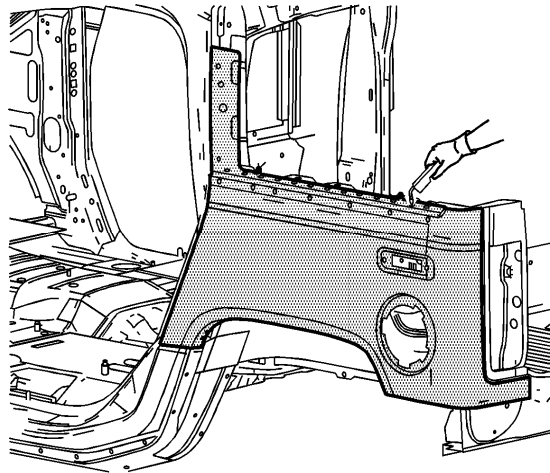
1. Drill 8 mm (5/16 in) plug weld holes, as necessary, in locations noted from the original quarter panel.

Important: If the location of the original plug weld holes cannot be determined, or if structural weld-thru adhesive is present, space the plug weld holes every 40 mm (1½ in) apart.

2. Prepare all mating surfaces, as necessary.
3. Apply GM-approved weld thru coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).



4. Position the quarter panel to the body.



5. Plug weld accordingly.
6. Clean and prepare all welded surfaces.
7. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).

8. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#).
 9. Install all related panels and components.
 10. Enable the SIR system. Refer to [SIR Disabling and Enabling](#).
 11. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
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