

# 9. Quarter Panel

The quarter panel is attached to the vehicle structure with spot-welds, except at the rear roof pillar, where it is silicon-bronze welded to the door frame opening outer panel. Due to the manner in which the quarter panel attaches to the door frame opening, a special sectioning procedure has been developed for improved serviceability.

— Notice —

When replacing panels that involve servicing stationary glass, refer to GM Service Bulletin no. 43-10-48 before performing any priming or refinishing work.

## Quarter Panel Service Procedure

### Remove or Disconnect

1. Remove all related panels and components, including the side and back glass as necessary.
2. Visually inspect and restore as much of the damage as possible to factory specifications.
3. Remove sealers and anti-corrosion materials as necessary.
4. Locate the factory joint at the rear roof pillar where it attaches to the door frame opening outer panel, measure down the pillar 50mm (2 inches), mark and cut the quarter panel (figure 9-1).
5. Locate, mark, and drill out all factory welds. Note the number and location of welds for installation of the service assembly.
6. Remove the damaged quarter panel.

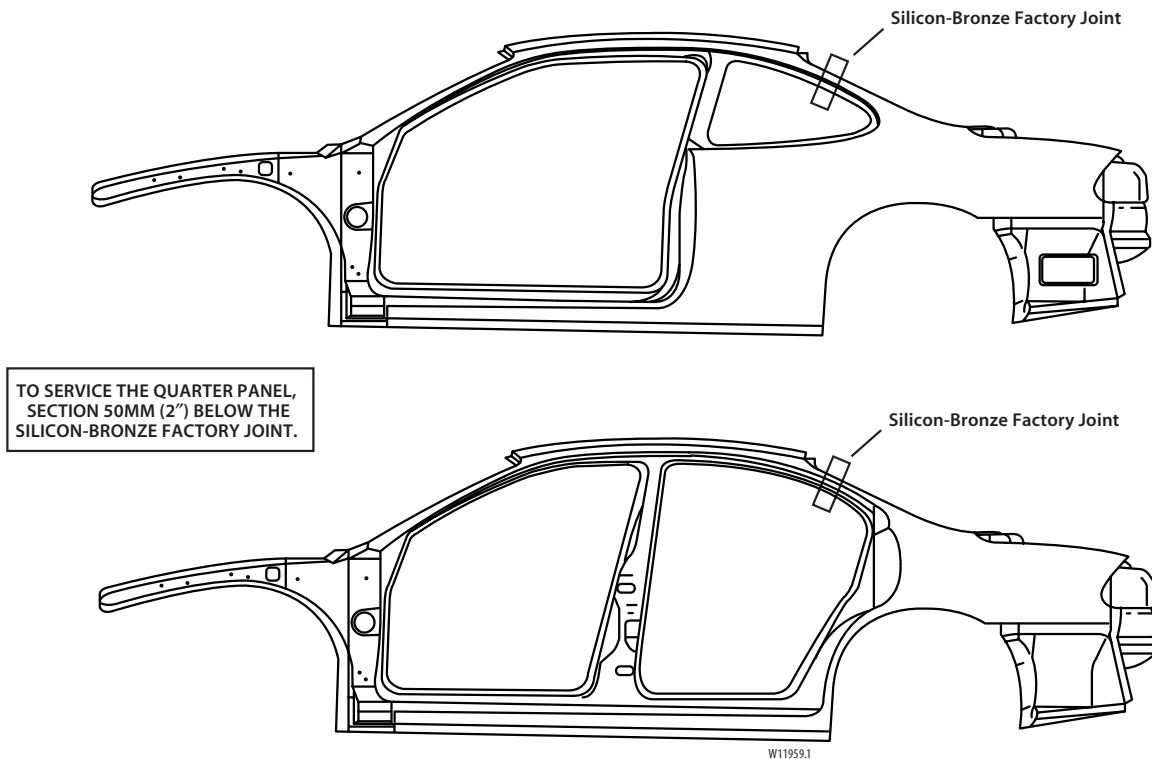


Figure 9-1:  
Roof Panel to Quarter Panel Connection

## Quarter Panel Service Procedure (cont'd)

### Install or Connect

1. Prepare the mating surfaces as necessary.
2. Temporarily position the service panel on vehicle. On the service part mark a horizontal line to leave a gap of one and one-half times the thickness of the metal at the sectioning joint. Cut the service panel along this line (figure 9-2).
3. Cut a 50mm (2 inch) piece from the unused portion of the service part, for a backing plate. Remove the flange on each side of the backing plate so that it will fit behind the sectioning joint.
4. Drill 8mm ( $\frac{5}{16}$  inch) plug weld holes as necessary in the locations noted from the original panel. Also drill plug weld holes along the sectioning cut of the service part. These should be located approximately 13mm ( $\frac{1}{2}$  inch) from the edge of the cut (figure 9-2).
5. Prepare the mating surfaces and position the backing plates with 25mm (1 inch) of the backing plate exposed, and plug weld. Position the service part to overlap the exposed 25mm (1 inch) of the backing plate, check for proper fit and alignment, and plug weld accordingly (figure 9-2).
6. Stitch weld along the entire joint. Make 25mm (1 inch) welds along the seam with 25mm (1 inch) gaps between them. Then go back and complete the stitch weld. This will create a solid joint with minimal heat distortion (figure 9-2).
7. Clean and prepare all welded surfaces. Prime with two-part catalyzed primer. Apply sealers and anti-corrosion protection materials as necessary. Do not combine paint systems. Refer to paint manufacturer's recommendations.
8. Install all related panels and components.

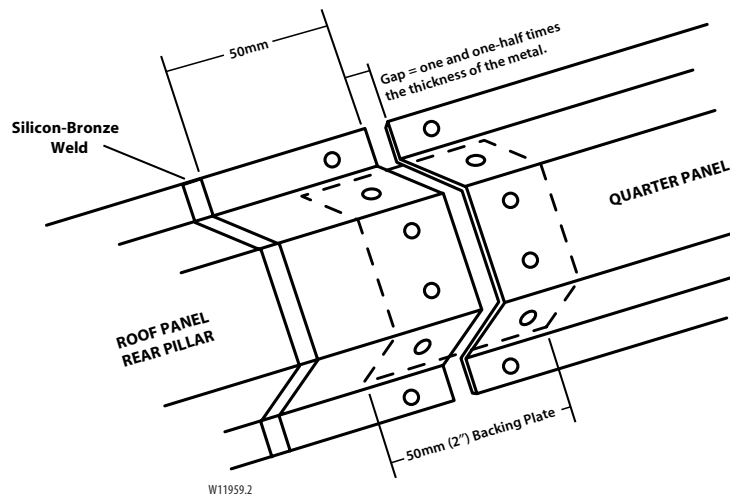


Figure 9-2:  
Roof Panel to Quarter Panel Connection