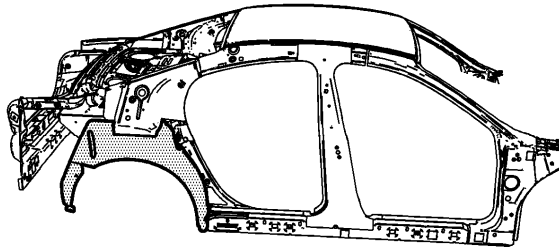


# Rear Outer Wheelhouse Replacement

## Removal Procedure

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

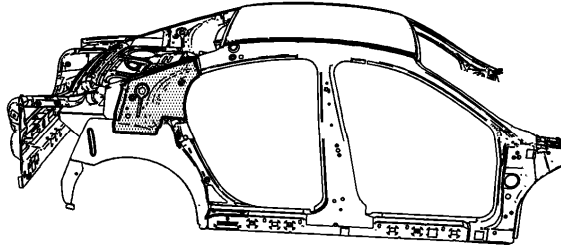
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.



3. Remove all related panels and components.
4. Restore as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .

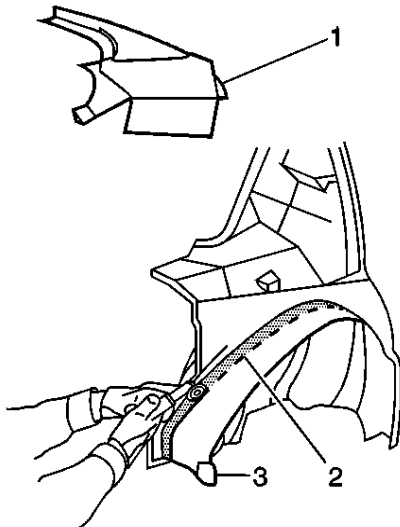
**Caution:** Refer to [Foam Sound Deadeners Caution](#) in Cautions and Notices.

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.
6. Perform the necessary procedures to gain access to repair. Refer to [Quarter Panel Replacement](#) .



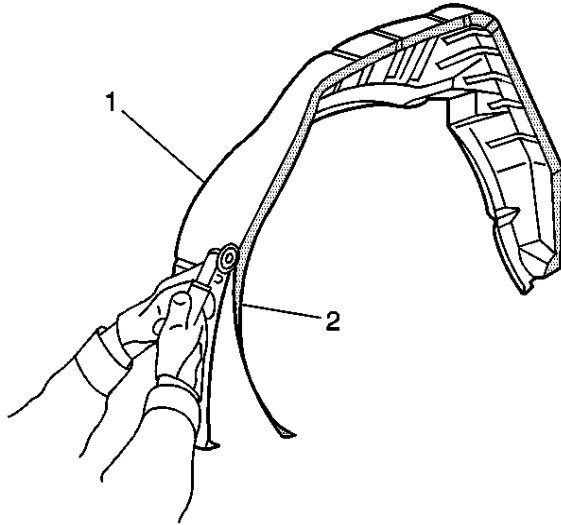
**Important:** Do not damage any inner panels or reinforcements.

7. After removing the quarter panel, locate, mark, and drill out the welds attaching the reinforcement panel (1) to the outer wheelhouse and the inner quarter.

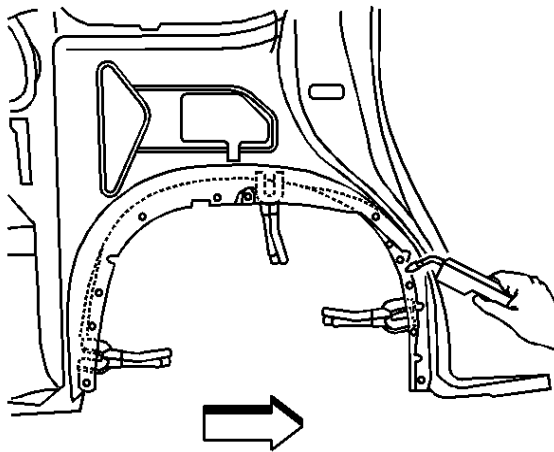


8. Apply a strip of 25 mm (1 in) masking tape (2) along the horizontal surface of the bend in the wheelhouse (3).
9. Cut along the outboard side of the masking tape to create a flange of length 25 mm (1 in).
10. Remove the damaged section of the wheelhouse (3).

## Installation Procedure

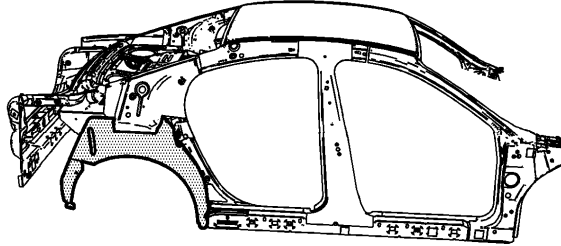


1. Cut the wheelhouse service part (1) along the corner of the bend (2).
2. Remove and discard the unused section of the wheelhouse.
3. On the service part, drill 8 mm (5/16 in) plug weld holes every 40 mm (1½ in) along the cut.



4. Prepare the mating surfaces.
5. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .

6. Position the service part.
7. Inspect for proper fit and plug weld accordingly (2). Take care not to warp or distort the metal.



8. Repair or replace the outer wheelhouse reinforcement as necessary.
9. Position the reinforcement panel as noted from the original panel location.
10. Plug weld accordingly.
11. Complete the necessary procedures. Refer to [Quarter Panel Replacement](#) .
12. 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.
13. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
14. Install all related panels and components.
15. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
16. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .