

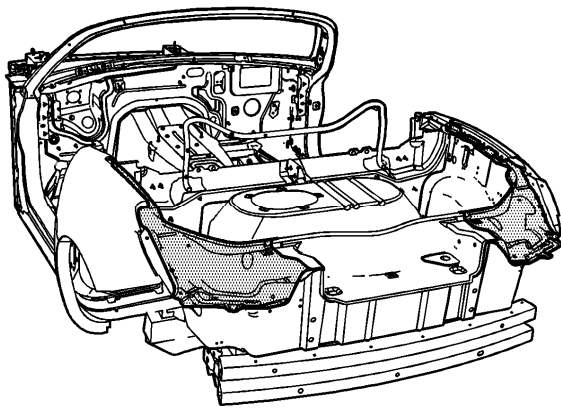
Quarter Panel Filler Replacement - Lower

Tools Required

[J 42058](#) Frame Adapter Clamp

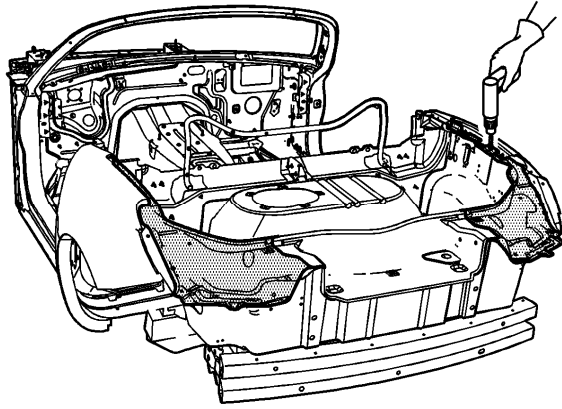
Removal Procedure

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



1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) .
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
3. Remove all related panels and components.

Caution: Refer to [Actions to Take When Working with Fuel Caution](#) in Cautions and Notices.



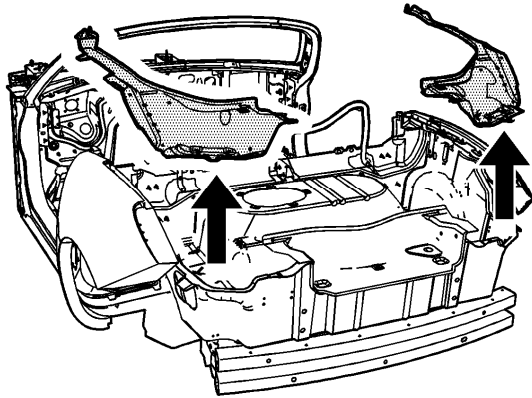
Important: Note the location of the original welds.

4. Drill out all welds that attach the quarter panel filler to the quarter outer panel.

Important: Do not damage any inner panels or reinforcements.

Important: The temperature will need to reach 300-500 degrees for the rear end panel to be released from the adhesive.

5. Apply heat and pry to detach the quarter panel filler from the adhesive along the bonding surface.



6. Remove the quarter panel filler.

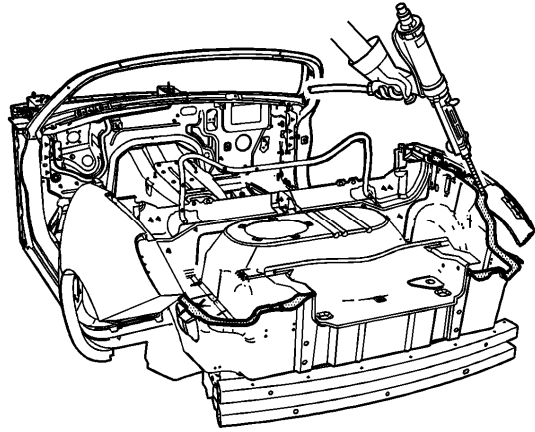
Important: Note the location of the urethane adhesive

7. Remove the entire urethane adhesive using a pneumatic knife or equivalent.
8. Inspect the rear structure and frame rails for damage.
9. Repair as much of the damage as possible to the factory specifications.
10. Use [J 42058](#) to secure the vehicle if pulling and straightening is required.

Installation Procedure

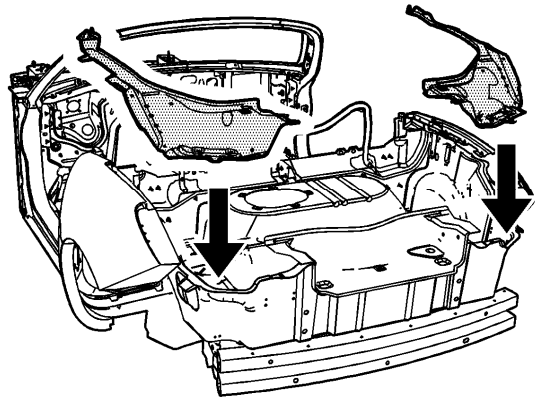
Important: Shims may be necessary to achieve proper panel alignment.

1. Before applying the adhesive, dry fit the quarter panel for proper fit and alignment.
2. Prepare all mating surfaces as necessary for welding.
3. Apply GM-approved weld-thru coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .
4. Clean and prepare all bonding mating surfaces according to the adhesive manufacturer's recommendations.

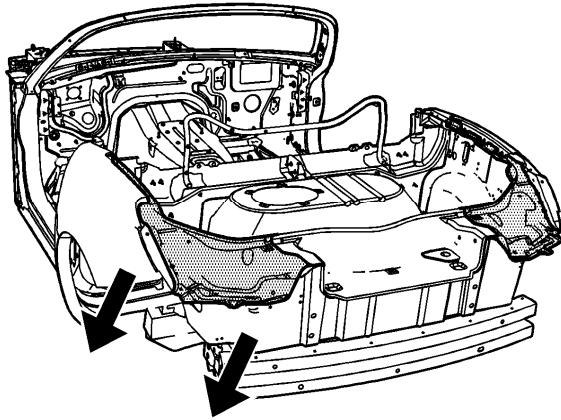


Important: Do not top coat any bonding surface. Use windshield urethane primer only on bonding surfaces. Refer to the adhesive manufacturer's recommendations.

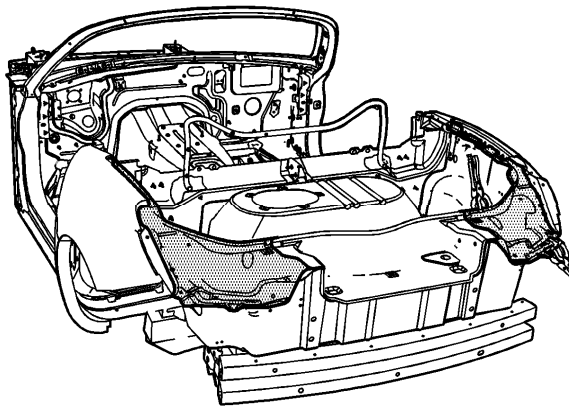
5. Use a urethane adhesive kit GM P/N 12346392 or equivalent to apply a consistent bead of windshield urethane adhesive 10 mm (3/8 in) in diameter to the mating surfaces of the quarter panel filler, and to all areas originally bonded.



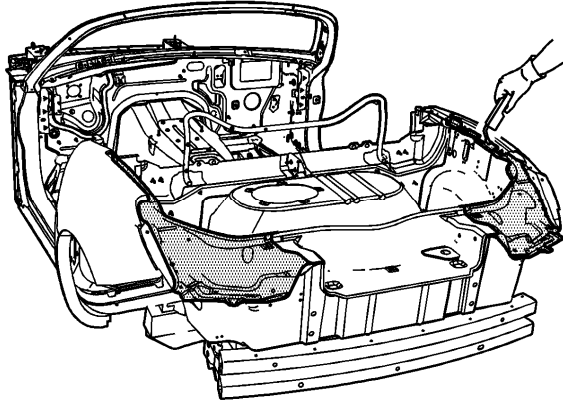
6. Position the quarter panel filler to the vehicle.



7. Apply pressure to the quarter panel filler to set the adhesive.
8. Remove any excess adhesive.



9. Clamp or mechanically fasten the rear end panel into place.



10. Using a MIG-welder, weld the quarter panel filler to the quarter panel in the same location as the original welds.
11. Apply the sealers and anti-corrosion materials to the area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
12. Paint the repair area. Refer to [Paint Identification](#) .
13. Install all related panels and components.
14. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
15. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .