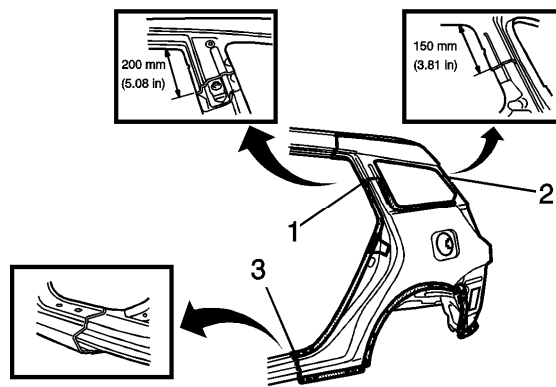


Quarter Panel Replacement

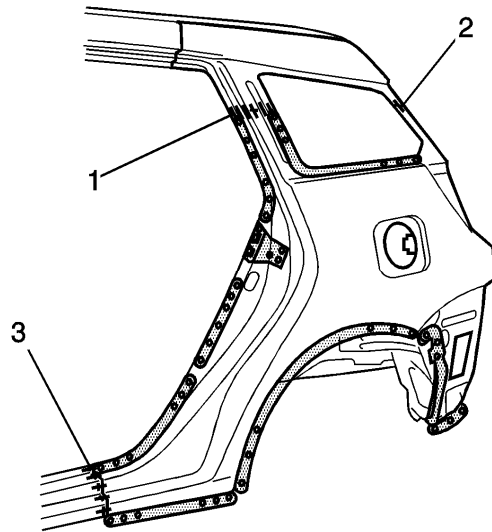
Removal Procedure



1. Remove all related panels and components.
2. Restore as much of the damage as possible to factory specifications.
3. Note the location and remove the following as necessary:
 - Sealers
 - Sound deadeners
 - Anti-corrosion materials
6. **Important:** Do not damage the inner panels or reinforcements.
7. Cut the quarter panel (1) 200 mm (5.08 in) from the bottom of the door opening frame.
8. Cut the quarter panel (2) 150 mm (3.81 in) from the bottom of the roof line.
9. Cut the quarter panel to rocker panel (3) using the service replacement panel for reference.
10. Locate and drill out all factory welds. Note the number and location of the welds for installation of the service part.

11. Remove the damaged quarter panel section.

Installation Procedure



Important: In any area damaged beyond recognition, space plug weld holes every 40 mm (1 in) apart.

1. Drill 8 mm (5/16 in) plug weld holes in the service panel as necessary in the locations noted from the original panel and along the sectioning cut.

Caution: Foam sound deadeners must be removed from areas within 152.4 mm (6 in) of where flame is to be used for body repairs. When reinstalling foam sound deadeners, avoid inhaling fumes as bodily injury may result.

2. Prepare all attachment surfaces as necessary.
3. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
4. Align the quarter panel to adjacent panels using 3-dimensional measuring equipment. Leave a gap of 1½ times the metal thickness at the sectioning joint.
5. Plug weld accordingly.
6. To create a solid joint with minimal heat distortion, make 25 mm (1 in) stitch welds along the seams (1), (2), (3) with 2 mm (1 in) gaps between them, then go back and complete the stitch weld.
7. Clean and prepare all welded surfaces.

Important: Prior to refinishing, refer to publication GM 4901M-D-2000 GM Approved Refinish Materials for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

8. Apply the following as necessary:
 - An approved anticorrosion primer
 - Sound deadening materials
 - Sealers
 - Refinish materials

12. Install all related panels and components.