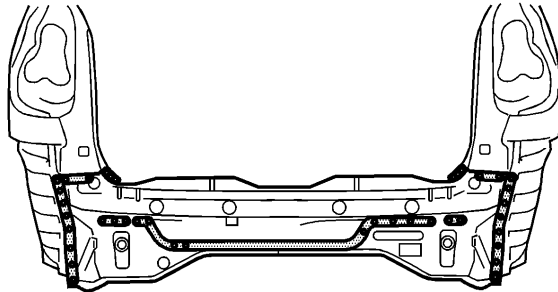


Rear End Panel Replacement

Removal Procedure

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

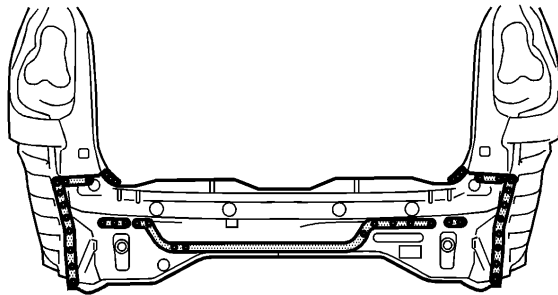


1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .
5. Locate, mark and drill out the factory welds.
6. Remove the outer rear end panel from the vehicle.

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

7. 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/Coatings.

Installation Procedure



1. Prepare the mating surfaces as necessary. Inspect for proper fit of the service panel.
2. On the new panel, drill 8-mm (5/16-in) plug weld holes, as necessary, in the locations noted from the original panel.
3. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
4. Position the service panel, check with 3-dimensional measuring equipment. Refer to [Dimensions - Body](#).
5. Plug weld accordingly.
6. Clean and prepare all welded surfaces.
7. Apply the sealers and the anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
8. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint/Coatings.
9. Install all related panels and components.
10. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
11. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.