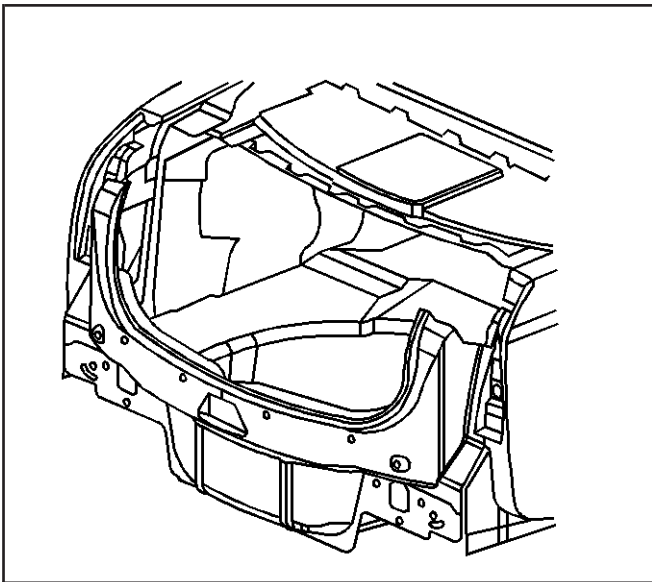


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5. Plug weld accordingly.
6. Clean and prepare all of the welded surfaces.
7. Install all of the related panels and components.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
9. Paint the repaired area.
10. Connect the negative battery cable.
11. Enable the SIR system.



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## Body Rear End Panel Replacement

This repair procedure gives you the option of using an installation procedure for either metal-inert gas (MIG) welding or adhesive bonding.

### Removal Procedure

**Caution:** To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

**Caution:** When performing service on or near the SIR components or the SIR wiring, the SIR system must be disabled. Refer to SIR Disabling and Enabling Zones. Failure to observe the correct procedure could cause deployment of the SIR components, personal injury, or unnecessary SIR system repairs.

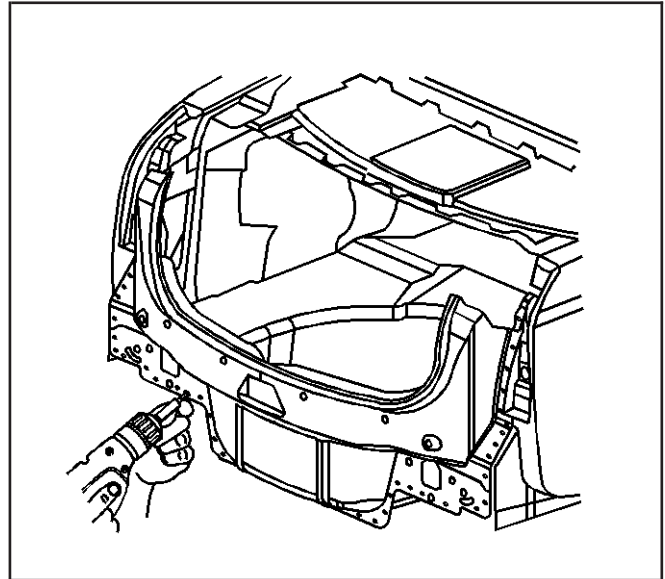
1. Disable the SIR system.

**Caution:** Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect the negative battery cable. Failure to follow these precautions may cause personal injury and/or damage to the vehicle or its components.

2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible. Refer to *Dimensions - Body* on page 3-7.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.

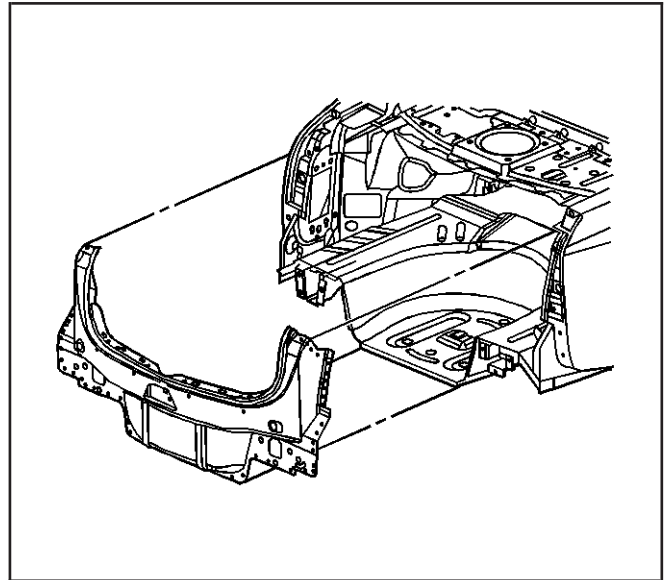
**Important:** Note the number and location of the factory welds for installation of the rear end panel.

6. Locate and drill out all the necessary factory welds.



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7. Remove the rear end panel.

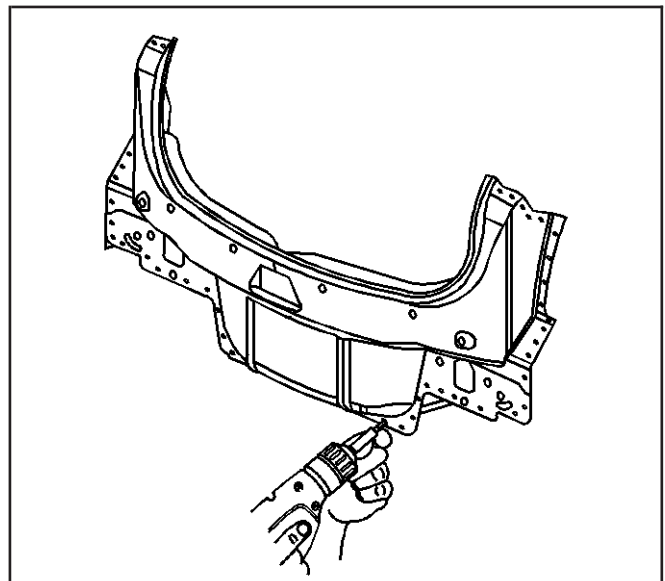


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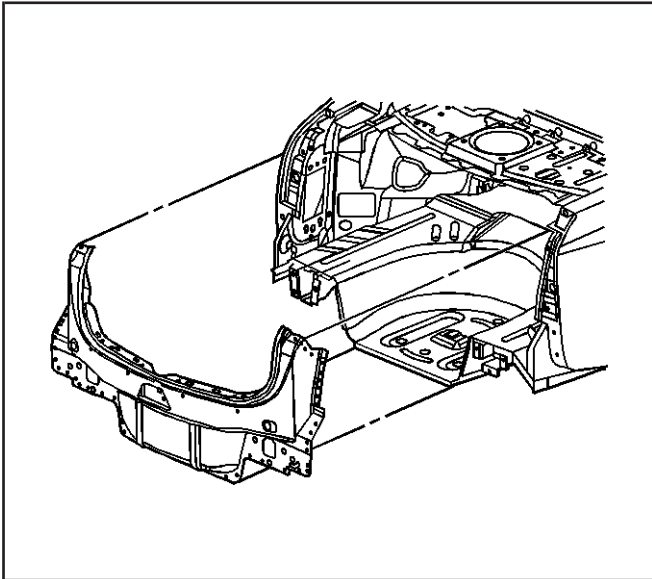
### Installation Procedure (Metal-Inert Gas (MIG) Welding)

**Important:** If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Prepare all mating surfaces as necessary.
3. Apply 3M® Weld-Thru coating P/N 05916 or equivalent to all mating surfaces.

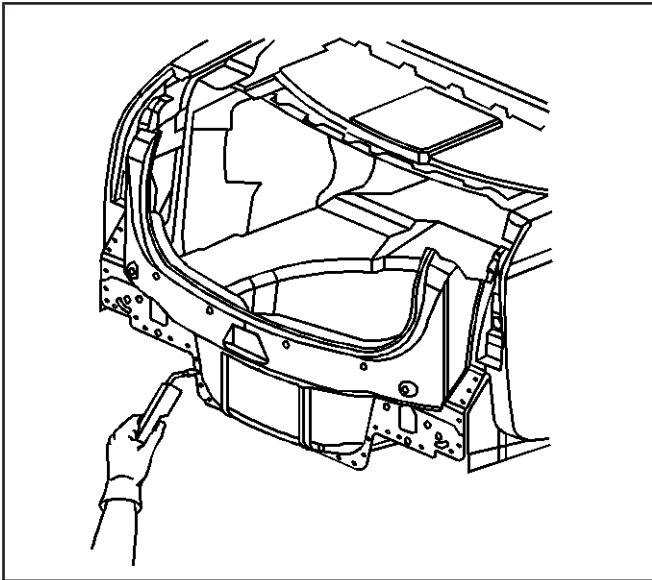


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4. Position the rear end panel on the vehicle. Use 3-dimensional measuring equipment to inspect the panel.
5. Clamp the panel in place.

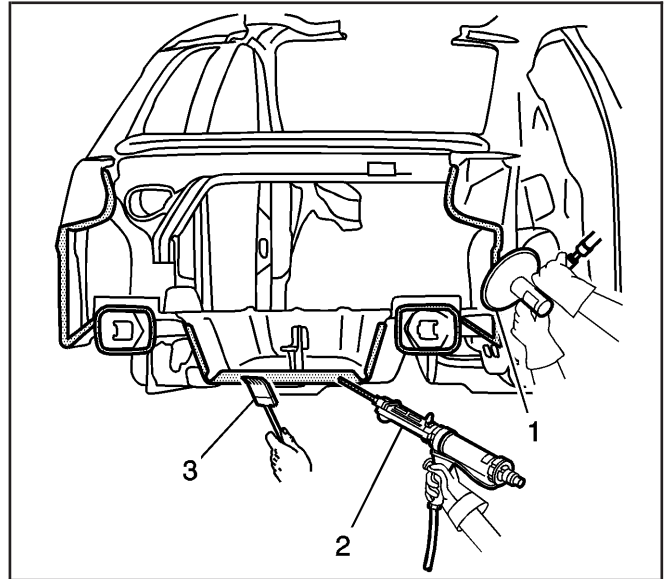


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6. Plug weld accordingly.
7. Clean and prepare all of the welded surfaces.
8. Install all of the related panels and components.
9. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
10. Paint the repaired area.
11. Connect the negative battery cable.
12. Enable the SIR system.

## Installation Procedure (Adhesive Bonding)

1. Grind the surface of the body mating flanges (1) to bare steel.



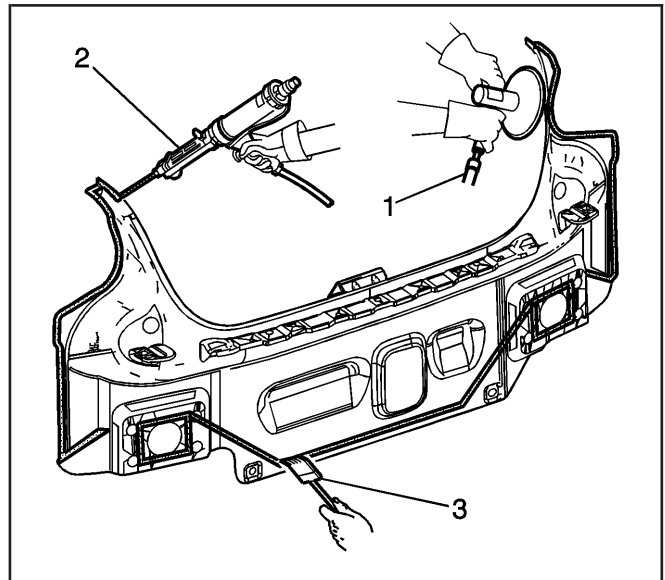
2. Grind the body rear end panel mating flanges (1) to remove the E-coating. Take care not to damage the corners or thin the metal during the grinding operation.
3. Clean the mating surfaces.

**Important:** The adhesive has a working time of 40–50 minutes. Do not allow the adhesive to totally cure off the vehicle, as proper alignment of the panel to the body will be difficult.

4. Apply a bead of metal panel bonding adhesive (2) GM P/N 12378566/7 (Canadian P/N 88901674/5) or equivalent to a thickness of 3–6 mm (1/8 to 1/4 in), to both of the mating surfaces.
5. Using a small acid brush (3), spread a coat of adhesive to cover all the bare metal surfaces to ensure corrosion protection.

**Important:** Do NOT pull the panels apart after joined together. Slide the panels against each other to realign the panels.

6. Install the body rear end panel to the vehicle.
7. Clamp the body rear end panel into position as required.
8. Using lacquer thinner remove the excess adhesive from the panel area.
9. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
10. Paint the repair area.
11. Install all related panels and components.
12. Connect the negative battery cable.
13. Enable the SIR system.



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