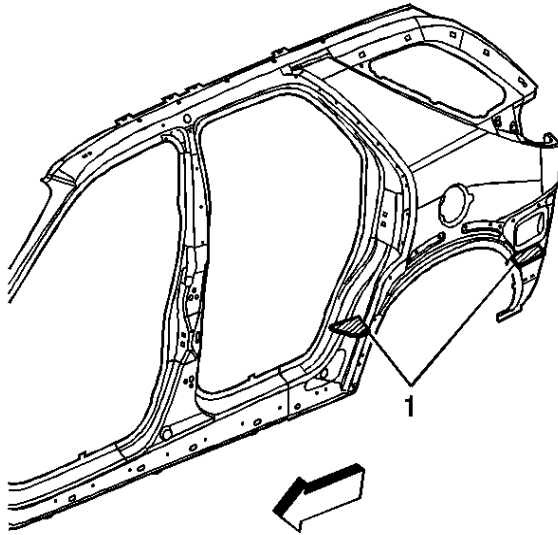


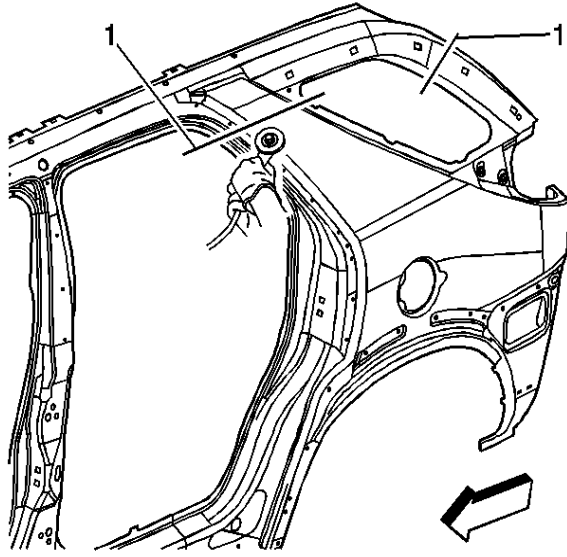
Quarter Panel Replacement (Rendezvous)

Removal Procedure

Important: For full quarter panel replacement the roof panel must be removed.

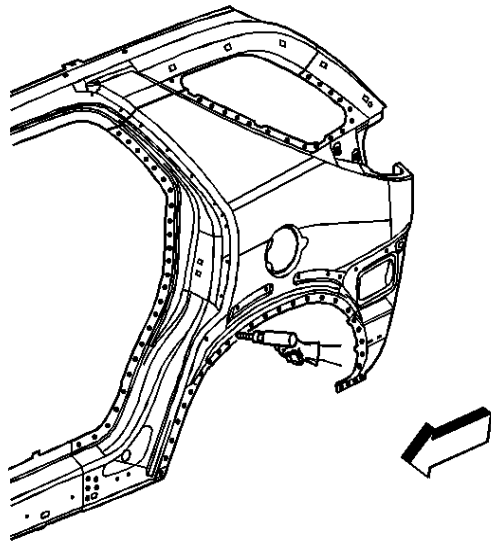


1. Remove all related panels and components.
2. Restore as much of the damage as possible to factory specifications.
3. Note the location and remove the following as necessary:
 - Sealers
 - Sound deadeners (1)
 - Anti-corrosion materials



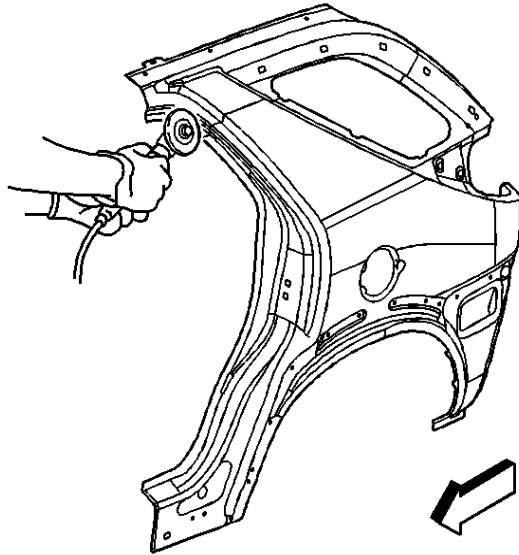
Important: Do not damage any inner panels or reinforcements.

4. Cut the panel where sectioning is to be performed (1).

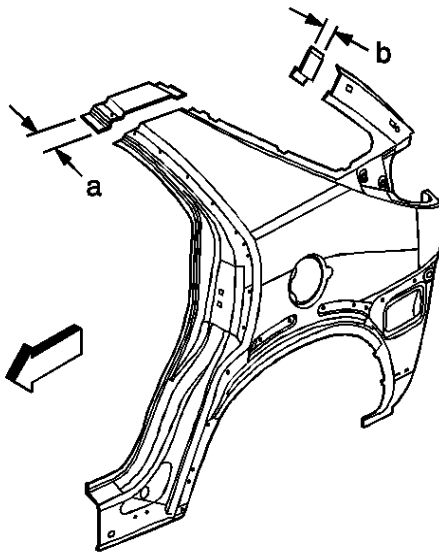


5. Locate and drill out all factory welds. Note the number and location of welds for installation of the service part.
6. Remove the damaged section.

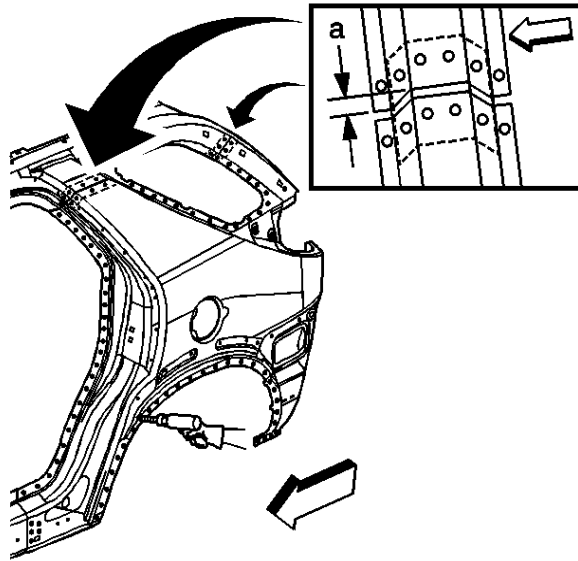
Installation Procedure



1. Cut the replacement quarter panel in corresponding locations to fit the remaining original panel (1). The sectioning joint should be trimmed to allow a gap of one-and-one-half times the metal thickness at the sectioning joint.



2. Create a 50 mm (2 in) backing plate from the unused portion of the service part. Trim the backing plate as necessary to fit behind the sectioning joint.



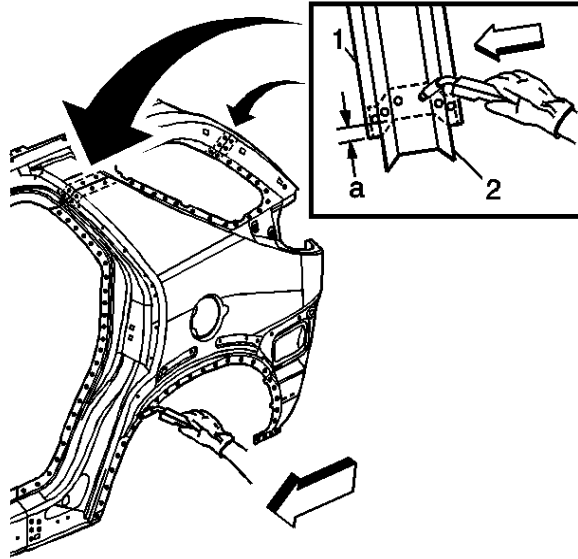
3. Drill 8 mm (5/16 in) plug weld holes (1) along the sectioning cut on the remaining original part (2).

Important: In any area damaged beyond recognition, space plug weld holes every 40 mm (1 ½ in) apart.

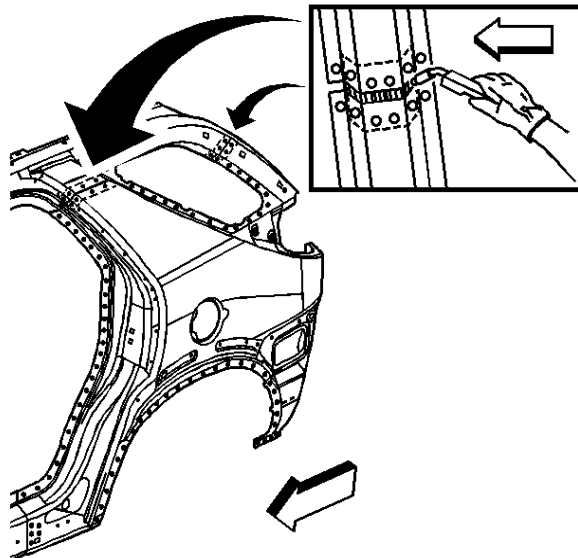
4. Drill 8 mm (5/16 in) (1) plug weld holes in the service part as necessary in the locations noted from the original panel and along the sectioning cut.
5. Prepare all attachment surfaces as necessary.

Important: Prior to refinishing, refer to the publication GM4901M-D-2000 GM Approved Refinish Materials for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

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



7. Fit the backing plate halfway into the sectioning joint clamp and plug weld to the vehicle.
8. Install service quarter panel leaving a gap of one and one half times the thickness of the metal.
9. Plug weld accordingly.



10. To create a solid weld with minimum heat distortion, make 25 mm (1 in) stitch welds along the seam with 25 mm (1 in) gaps between them. Then go back and complete the stitch weld.
11. Clean and prepare all welded surfaces.
12. Apply the following as necessary:

- Anti-corrosion materials
- Sound deadening materials
- Sealers

13. Refinish as necessary.

14. Install all related panels and components.