

Quarter Outer Panel Sectioning (SS Weld-On)

Removal Procedure

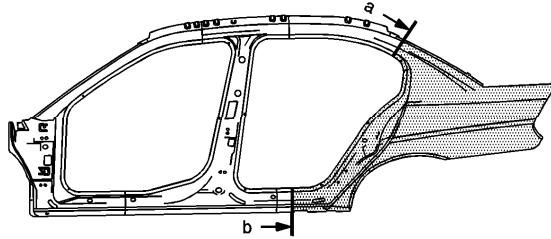
Tools Required

Fender Flanging Tool

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

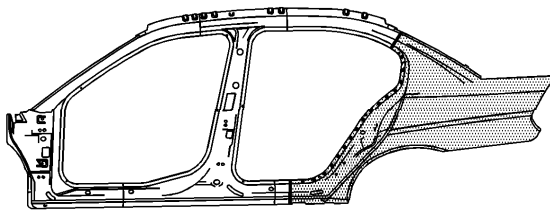
Important: Before beginning the repair, refer to [Metal Panel Bonding](#) for proper adhesive preparations and general information.

1. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
2. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) .
3. Restore as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .
4. Remove all related panels and components.
5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .



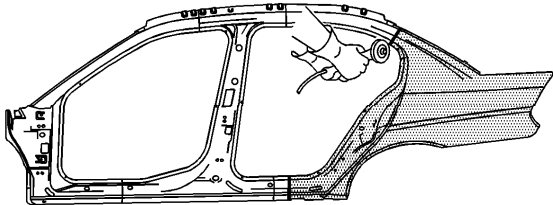
6. Section the sail panel (a) and the rocker panel (b).

- At the sail panel, measure from the back glass opening down 120 mm (4 3/4 in). Scribe a line.
- At the rocker panel, measure 70 mm (2 3/4 in) rearward from the rocker panel locating hole. Scribe a line.

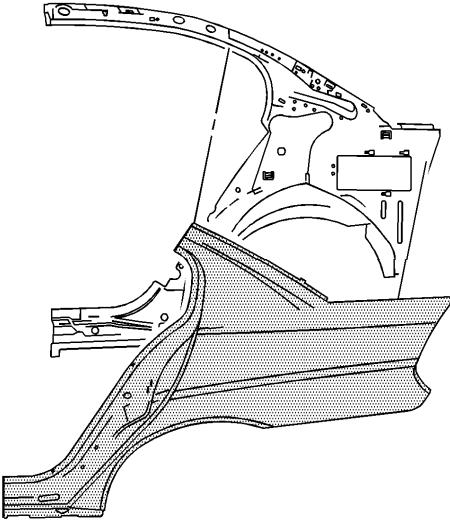


8. Locate and drill out all factory welds. Note the number and location of welds for installation of the quarter panel.

Important: Do not damage any other panel or reinforcements when cutting at the marked locations.



9. Cut the panel at the marked locations.

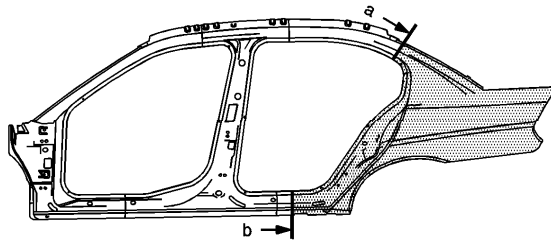


10. Remove the lower quarter panel.

Installation Procedure

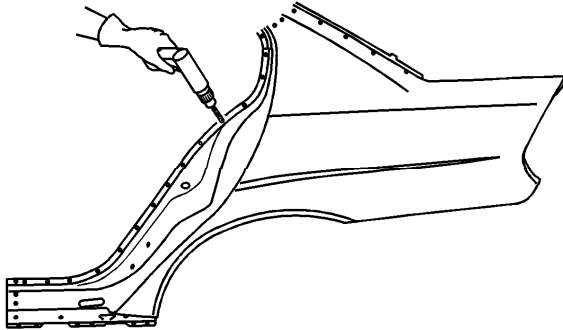
Important: To allow proper layout and cutting of the service part, review the sectioning information in the removal procedure.

1. Locate the area on the service part where the sectioning will be performed.



2. Measure and mark the cut line location on the service area.
3. Cut the service panel at the marked locations (a, b). Trim the sectioning butt joints to allow a gap equal to the metal thickness at the sectioning joint.
4. Create backing plates 50 mm (2 in) for the sail panel and 100 mm (4 in) for the rocker panel. Create the backing plates from the unused portion of the service part.

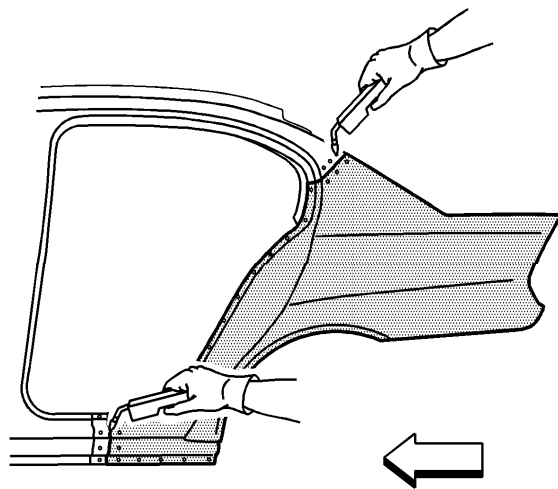
- Trim the backing plates as necessary to fit behind the panel at the sectioning joints.



- Drill 8 mm (5/16 in) plug weld holes as necessary in locations noted from the original quarter panel.

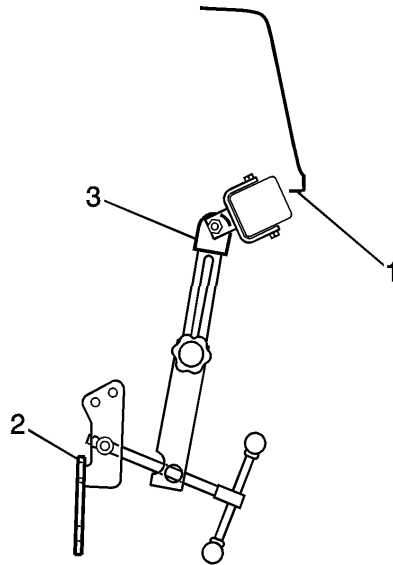
Important: If the location of the original plug weld holes can not be determined, or if structural weld-thru adhesive is present, space the plug weld holes every 40 mm (1 ½ in) apart.

- Prepare all mating surfaces as necessary.
- Apply GM Weld-Thru coating to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .
- Perform the sectioning procedure. Refer to [Overlap/Backing Plate Sectioning](#) .



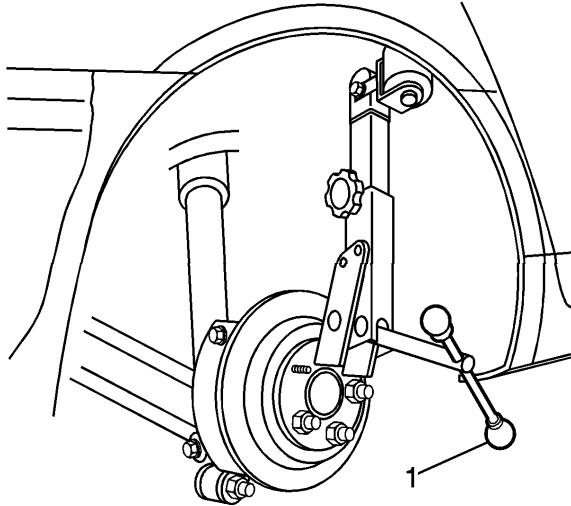
10. Plug weld accordingly.
11. Stitch weld the sail panel and rocker panel accordingly.
12. Clean and prepare all welded surfaces.
13. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
Refer to [Anti-Corrosion Treatment and Repair](#) .
14. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
15. Install all related panels and components.
16. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .
17. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .

Fender Flanging Procedure

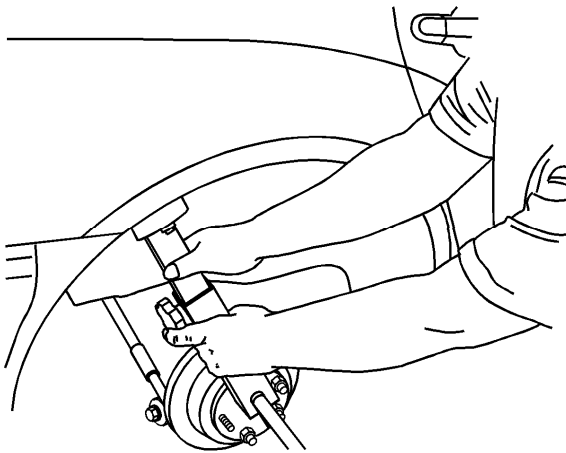


1. Raise the rear of the vehicle. Safely secure the vehicle on a jack stand.
2. Remove the rear wheel when the flange needs to be bent (1).
3. Place the tool hub dish flange onto the wheel hub. Tighten the lugs to snug (2).
4. Adjust the arm length so that the center of the roller is aligned with the inboard flange of the outer wheelhouse.

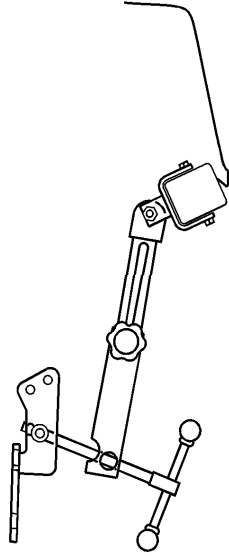
5. Adjust the roller to achieve the desired angle to wheelhouse lip (3).



6. Tighten the hand wheel located on the tool (1) to apply slight pressure.
7. Use a heat gun to gently warm the area to be rolled. This will make the adhesives and paints more pliable around the outer wheelhouse.



8. Hold the tool firmly. Swing the tool in an arcing motion to reform the inner fender lip.



9. Adjust the tool as necessary by adding pressure to the rollers to redirect the flange to the desired location.
10. Remove the flanging tool.