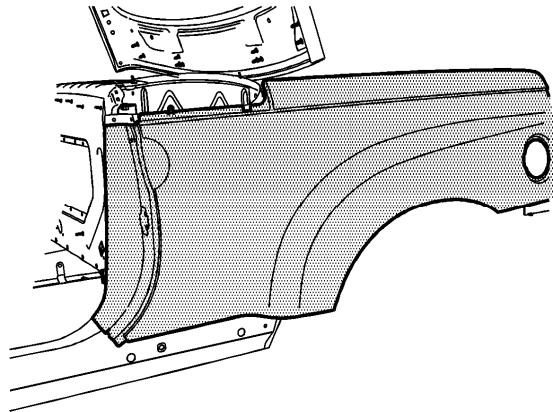


Quarter Outer Panel Replacement (Bond-on)

Removal Procedure

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



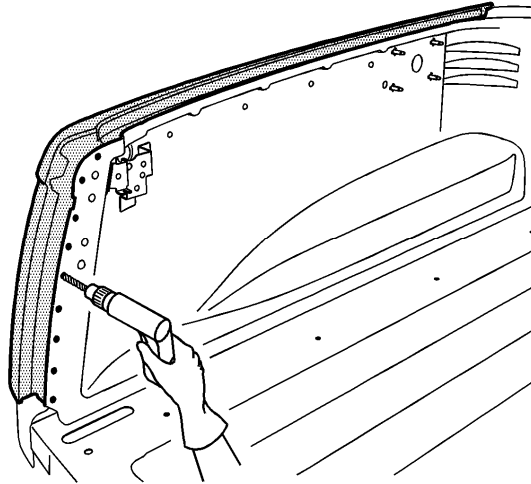
Important: Before you begin the repair, refer to [Metal Panel Bonding](#) for proper adhesive preparations and general information.

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 including the rear compartment lid. Refer to [Rear Compartment Lid Replacement](#) and to [Endgate Replacement](#) in Body Rear End.
4. Repair as much of the damage as possible to factory specifications. Refer to Rear Compartment in [Dimensions - Body](#) .

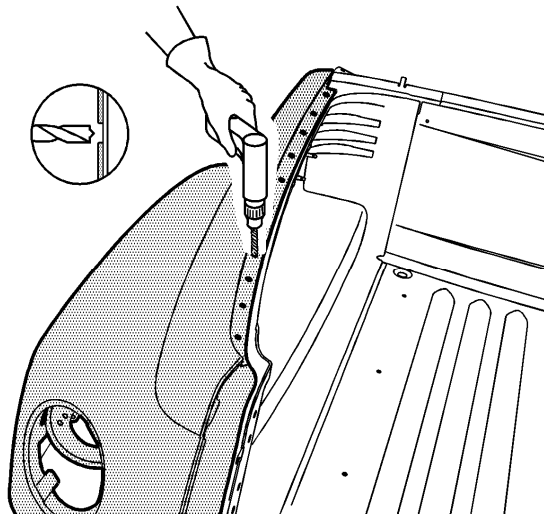
5. Open the folding top stowage compartment lid. Refer to [Folding Top Stowage Compartment Lid Release Mech](#) .

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

6. 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 and Coatings.

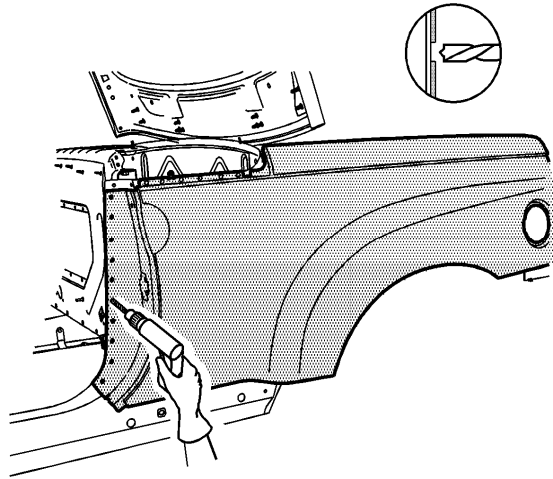


7. Locate and drill completely through all layers of metal at the factory welds along the rear compartment end gate opening.

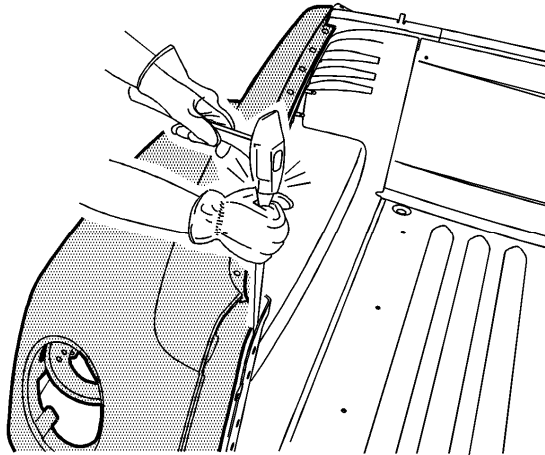


Important: Do NOT damage the inner panels or the reinforcements.

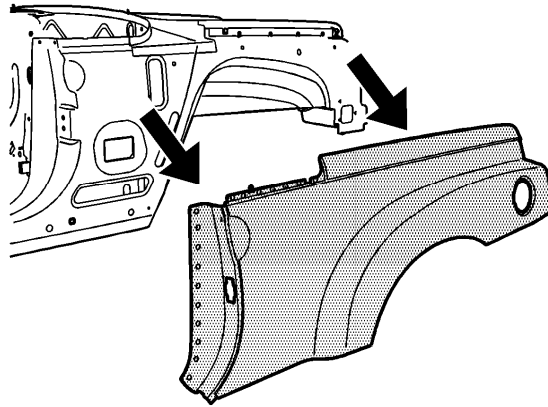
8. Locate and drill out all factory welds along the rear compartment opening



9. Locate and drill out all factory welds along the lock pillar.

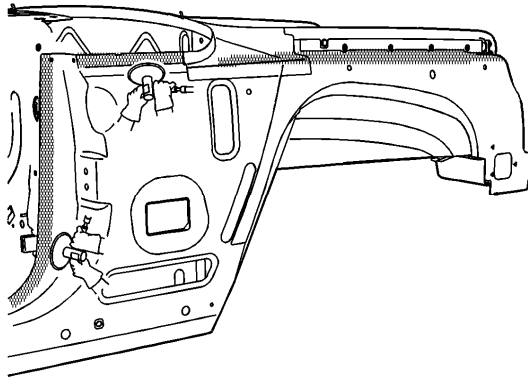


10. Verify the existence of structural weld-thru adhesive. Refer to [Structure Adhesive - Identification](#) . If necessary use a chisel to separate the outer quarter panel from the adjacent panels.

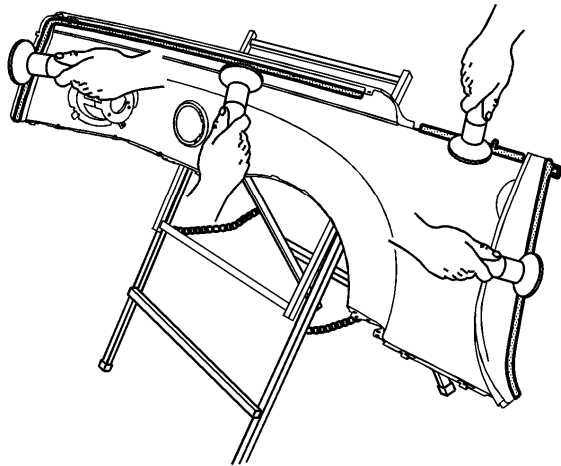


11. Remove the damaged quarter panel.

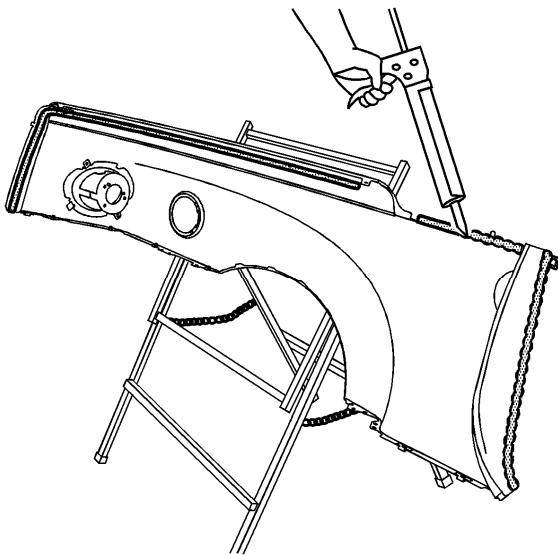
Installation Procedure



1. Grind the surface of the body mating flanges to bare steel. Do not damage the corners or thin the metal during the grinding process.

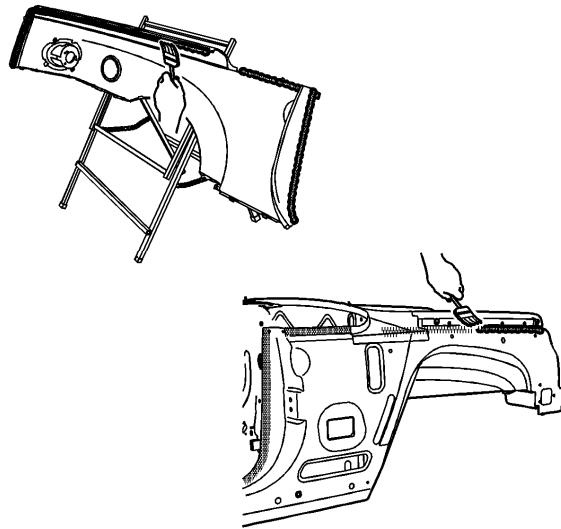


2. Grind the quarter panel mating flanges to remove the E-coating. Take care not to damage the corners or thin the metal during the grinding operation.
3. Clean the mating surfaces.

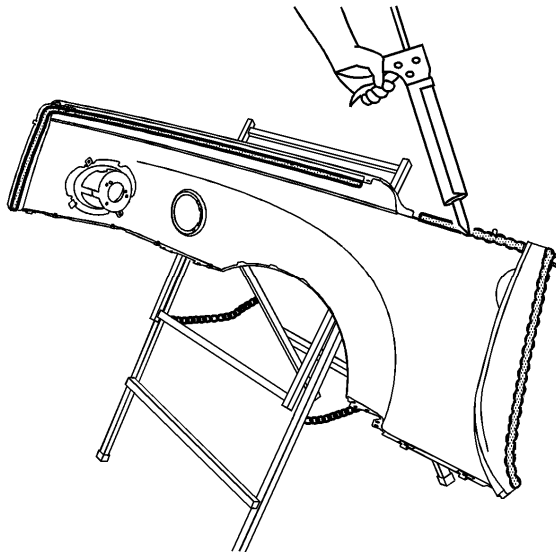


Important: The adhesive has a 40-50 minute working time. Do not allow the adhesive to cure prior to installing the quarter panel.

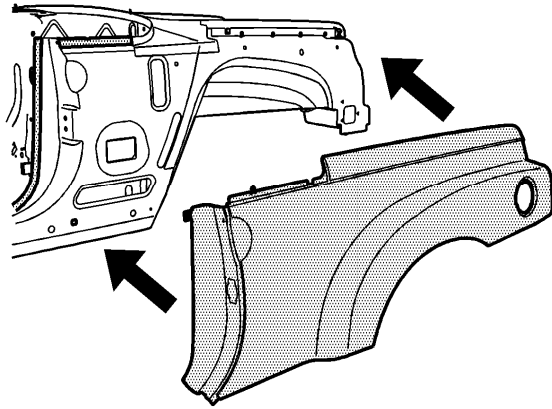
4. Apply a 3-6 mm (1/8 to 1/4 in) bead of metal panel bonding adhesive GM P/N 12378567 (Canadian P/N 88901675) or equivalent, to both of the mating surfaces.



5. Using a small acid brush, spread a coat of adhesive to both of the mating surfaces. Cover all of the bare metal to ensure corrosion protection.

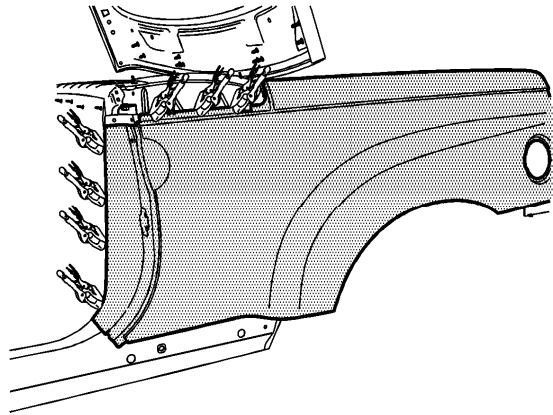


6. Apply a 9-13 mm (3/8 to 1/2 in) bead of metal panel bonding adhesive GM P/N 12378567 (Canadian P/N 88901675) or equivalent, to the mating surface of the service quarter panel.

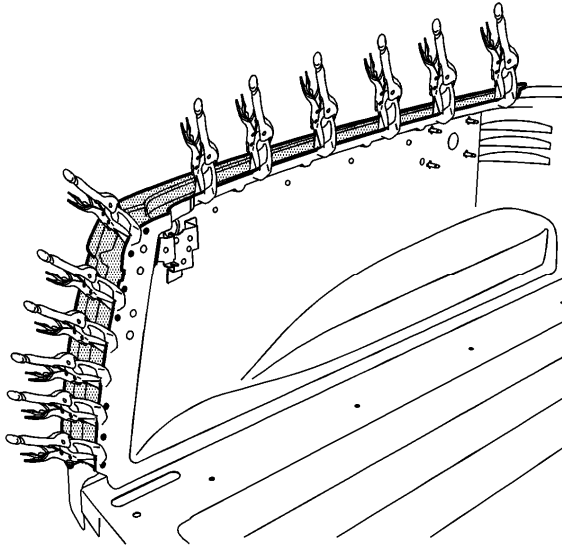


Important: DO NOT pull the panels apart after joined together. Slide the panels against each other to realign the panels.

7. Position the quarter panel to the body. Refer to [Dimensions - Body](#)



8. Clamp the quarter panel into position at the lock pillar area.



9. Clamp the quarter panel into position at the rear compartment opening.
10. Using lacquer thinner remove the excess adhesive from the quarter panel area.
11. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
12. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
13. Install all related panels and components, including the rear compartment lid.
Refer to [Rear Compartment Lid Replacement](#) and to [Endgate Replacement](#) in Body Rear End.
14. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
15. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.