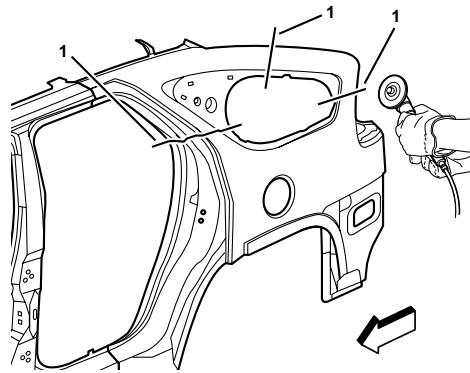
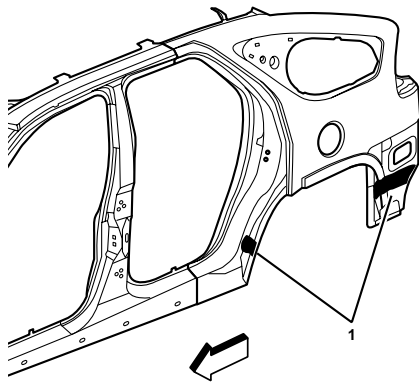


# Quarter Panel Replacement

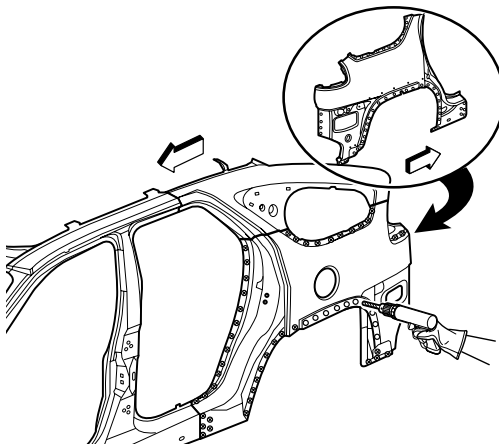
## Removal Procedure

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 quarter panel where sectioning is to be performed (1).

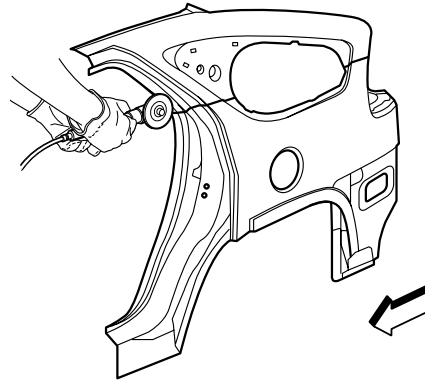


5. Locate and drill out all factory welds. Note the number and location of welds for installation of the service part.
6. Remove the damaged quarter.

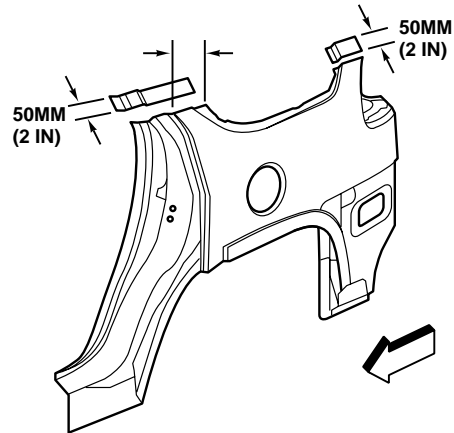
# Quarter Panel Replacement

## Installation Procedure

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



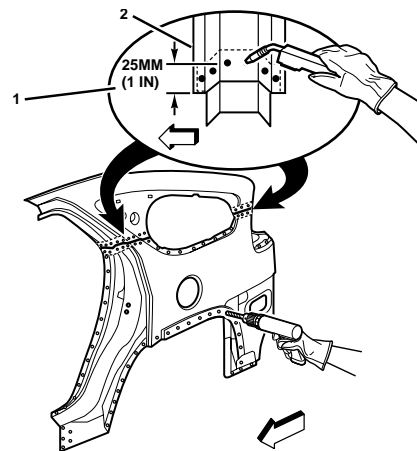
2. Create a 50 mm (2 in.) backing plate from the unused portion of the service part. Trim the backing plate as necessary to fit behind the sectioning joint.



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 (1-1/2 in.) apart.*

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



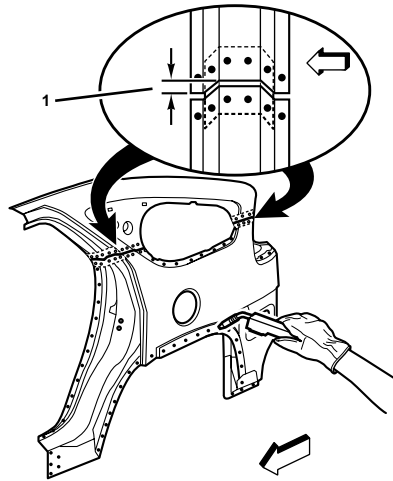
5. Prepare all attachment surfaces as necessary.

*IMPORTANT: Prior to refinishing, refer to publication GM4901M-D-01 GM Approved Refinish Materials for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.*

6. Apply weld-thru primer to all bare-metal surfaces.

—continued

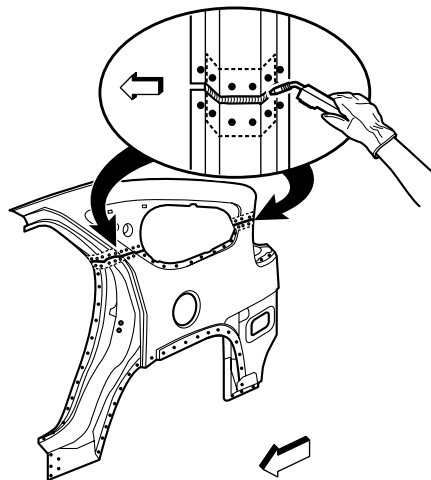
## Quarter Panel Replacement Installation Procedure con't



7. Fit the backing plate halfway into the sectioning joint, clamp and plug weld to the vehicle.

**CAUTION: THE FUEL FILLER OPENING MUST BE PROPERLY SEALED PRIOR TO POSITIONING THE QUARTER PANEL. FAILURE TO PROPERLY SEAL THE QUARTER PANEL COULD RESULT IN EXHAUST GAS LEAKAGE INTO THE INTERIOR OF THE VEHICLE, CAUSING PERSONAL INJURY.**

8. Install GM P/N 12399117 Sealing Strip between outer wheelhouse and quarter panel gas door pocket.
9. Install service quarter panel leaving a gap of one and one half times the thickness of the metal (1) at the sectioning joint.
10. Plug weld accordingly.



11. 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.
12. Clean and prepare all welded surfaces.
13. Apply the following as necessary:
  - Anti-corrosion materials
  - Sound deadeners
  - Sealers
14. Refinish as necessary.
15. Install all related panels and components.