



RC01S Deck Lid

**Uniform
Procedures For
Collision Repair
UPCR**

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v.4.0



1. Description

This procedure describes the repair and replacement of a steel deck lid. Inspection and evaluation requirements are also included.



2. Purpose

The purpose of this procedure is to provide industry-accepted requirements for performing high-quality repair of steel deck lids. This procedure is intended for use by professionals who are qualified through training and experience.



3. Referenced Documents

The following documents are considered part of this procedure by reference.

3.1 Procedures

- CP01S Corrosion Protection
- DO01 Hinges
- PS01 Personnel Safety
- RF01S Surface Preparation
- RF41 Finish Application
- ST21S Metal Repair
- ST31 Body Fillers
- WE01S GMA (MIG) Plug Weld
- WE11S GMA (MIG) Fillet Weld

3.2 Other Information

- Equipment-specific information
- Recycled parts information
- Vehicle-specific repair information



4. Equipment And Material Requirements

4.1 Equipment

The use of a hinge-pin removal tool is included in this procedure.

4.2 Welding Equipment

Use welding equipment as described in **WE01S** or **WE11S**.



5. Damage Analysis

5.1 General Damage

Inspect a deck lid assembly for these conditions:

- visible damage
- improper previous repairs
- misalignment with adjacent panels
- reinforcements that have separated from the deck lid
- cracks at spot welds, or damaged fasteners
- damaged or missing trim, labels, seals, etc.
- missing or damaged anti-flutter materials
- damaged latch or lock cylinder
- damaged hinges or torsion rods
- damaged lamp or reflector assembly

Determine if the deck lid is to be repaired or replaced. Verify the availability of replacement parts. If there is severe damage to the hinge or striker mounting areas, the deck lid should be replaced. For hinge replacement procedures, see **DO01**.



6. Personnel Safety

6.1 General Safety

General safety information is in **PS01**.

6.2 Welding Safety

Welding safety information is in **WE01S** or **WE11S**.

6.3 Deck Lid Repair Safety

Make sure the deck lid is properly supported, and use proper lifting techniques during removal and installation.

Torsion rods and spring-loaded hinges are under tension. Use special caution when working on deck lids equipped with torsion rods or spring-loaded hinges.



7. Environmental Safety

Does not apply.



8. Vehicle Protection

8.1 Deck Lid And Adjacent Areas

When working with a steel deck lid:

- Protect the deck lid to prevent further damage during the repair.
- Protect adjacent panels and glass from damage.



9. Repair Procedure

9.1 Deck Lid Repair

To repair a steel deck lid:

- 1. Remove the inner trim panel, if required for access.
- 2. Perform repairs using metal repair and heat shrinking procedures, as appropriate.
- 3. Replace damaged welded-on trim-mounting studs, if required.
- 4. Apply corrosion-resistant primer to all interior and exterior surfaces damaged by the collision or repairs.
- 5. Check the deck lid alignment. Adjust if required.
- 6. Refinish the deck lid to restore the appearance, including edges damaged by the collision or repairs. Refinish cosmetic surfaces after all body repairs are complete.
- 7. Replace or restore sound deadeners, anti-flutter materials, etc., that were damaged by the collision or repairs.
- 8. Install the inner trim panel.
- 9. Replace all trim, labels, weatherstrips, etc.
- 10. Continue vehicle reassembly.

9.2 Deck Lid Removal

To remove a steel deck lid:

- 1. Open and support the deck lid.
- 2. Protect the backlite and adjacent panels.
- 3. Disconnect the electrical connectors, cables, hoses, and torsion rods, if required.

(cont'd)



9. Repair Procedure (cont'd)

- 4. Mark the hinge positions on the deck lid, and on the body panel if the hinges are being replaced. Use existing painted surfaces as a reference.
- 5. Unfasten the deck lid from the hinges. Note the location of any shims.
- 6. Carefully remove the deck lid from the vehicle.
- 7. Remove the striker assembly.

9.3 Deck Lid Installation

To install a steel deck lid:

- 1. If installing a replacement deck lid, refinish the underside and edges of the deck lid before installation.
- 2. Protect the backlite and adjacent panels.
- 3. Support the deck lid on the hinges and loosely install the fasteners. Reinstall any removed shims.
- 4. Lower the deck lid slowly. Make sure it does not contact the adjacent panels.
- 5. Check for proper alignment to the adjacent panels. Adjust the position at the hinges as needed.
- 6. Raise the deck lid and properly torque all fasteners to the vehicle maker's recommendations.
- 7. Close the deck lid and recheck the alignment.
- 8. Install the striker assembly.
- 9. Lower the deck lid slowly to see if the striker properly enters the latch assembly without forcing the deck lid out of alignment. Align the latch assembly, or the striker as needed.
- 10. Reconnect the torsion rods, electrical connectors, cables, and hoses.
- 11. Spot paint the hinges and fasteners, if required.
- 12. Refinish the deck lid, if required. Refinish cosmetic surfaces after all body repairs are complete.
- 13. Transfer or install replacement parts such as handles, lock cylinders, etc.
- 14. Install trim, labels, weatherstrips, seals, etc.
- 15. Lubricate the hinges and latch, if required. Follow the vehicle maker's recommendations.
- 16. Test all electrical accessories for proper operation.
- 17. Perform water leak tests to ensure proper sealing.
- 18. Continue vehicle reassembly.



10. Use Of Recycled (Salvage) Parts

10.1 Condition Of Salvage Parts

Do not install a salvage steel deck lid having any of these defects:

- unrepairable damage
- corrosion that has caused pitting
- improper previous repairs
- reinforcements that have separated from the deck lid

Replace any damaged or missing trim, labels, seals, latches, etc. Confirm that all labels or information decals match the original. Replace if required.



11. Inspection And Testing

11.1 Inspection Of A Repaired Or Replaced Steel Deck Lid

After installation or repair, inspect a steel deck lid for these conditions:

- proper alignment with adjacent panels
- fasteners torqued to the vehicle maker's recommendations
- proper application of anti-flutter material
- proper lubrication of the hinges, latch, and lock cylinder
- proper operation of the lock cylinder
- proper operation of the torsion rods
- proper latching and release
- proper finish appearance and film thickness
- proper installation of all trim, labels, and fasteners
- proper installation of hoses, cables, wiring, and electrical connectors
- proper operation of electrical accessories
- proper sealing against air and water leaks

Correct any defects.