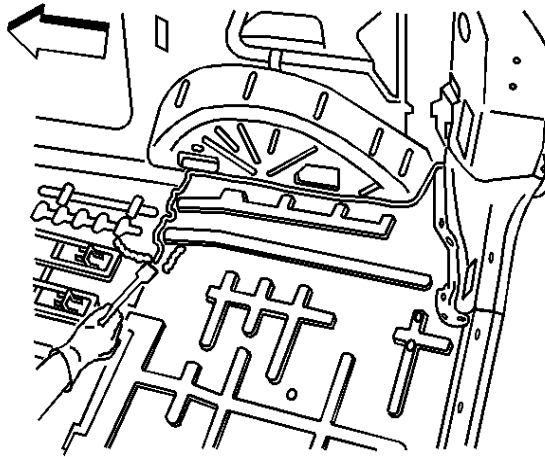
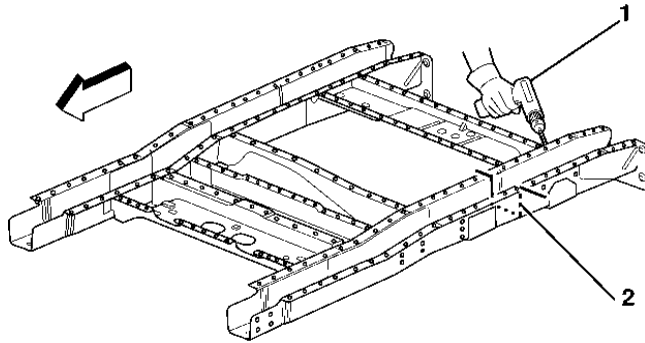


Rear Rail Sectioning

Removal Procedure

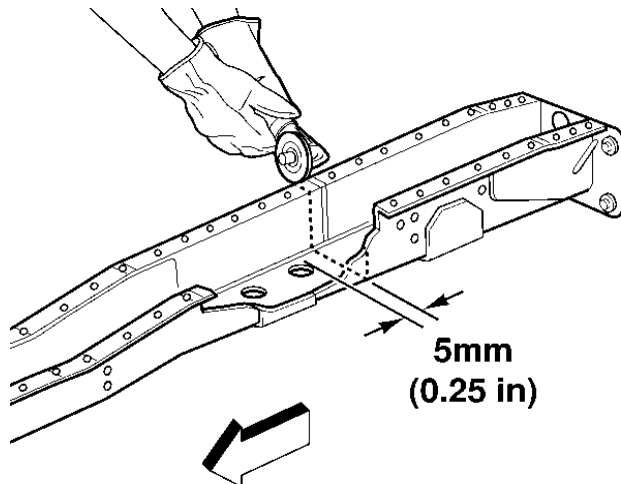


1. Remove all related panels and components.
2. Restore as much of the damage as possible to factory specifications.
3. Note the location and remove the following as necessary:
 - Anti-corrosion materials
 - Sound deadeners
 - Sealers

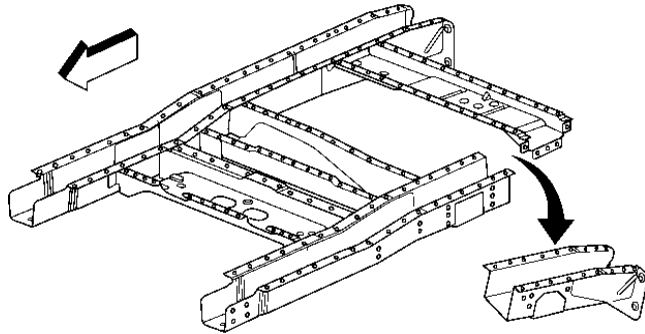


Important: Do not damage any inner panels or reinforcements.

4. Perform the necessary procedures to gain access to the rear rail.
5. Locate (2) and drill out all factory welds (1). Note the number and location of welds for installation of the Rear Rail.
6. Mark the cut location by measuring 5 mm (1/4 in) from the rear edge of the hole rearward.

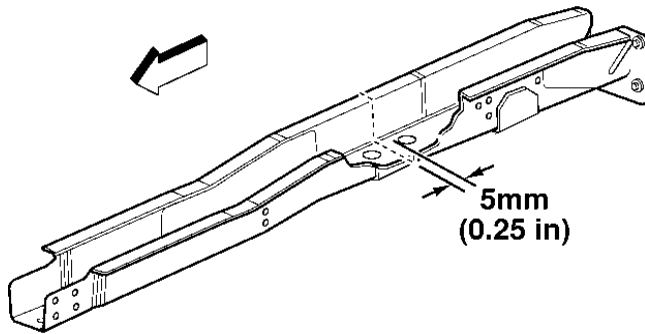


7. Cut the rear rail section.

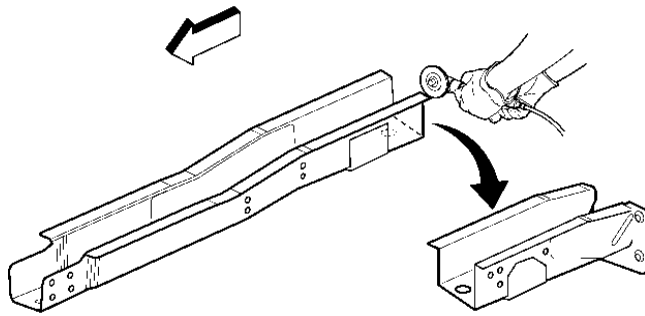


8. Remove the damaged rear rail section.

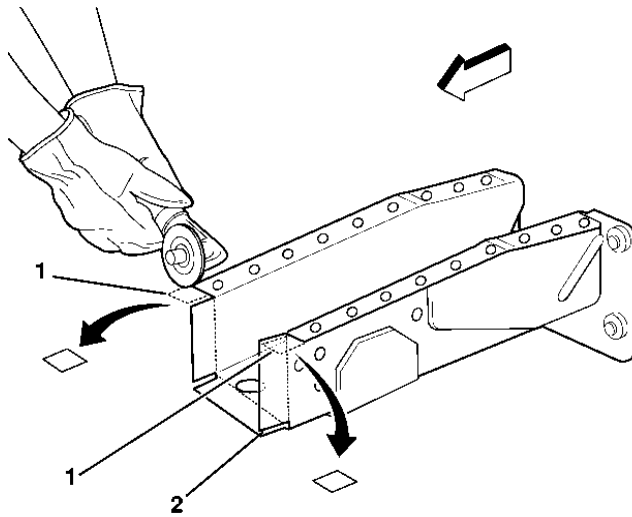
Installation Procedure



1. Mark the cut location on the service rail by measuring 5 mm (1/4 in) from the front edge of the hole forward.

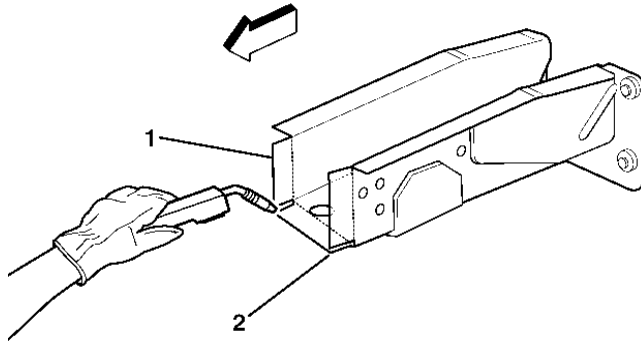


2. Cut the rear rail service part.



3. Cut and remove 30 mm (1 3/16 in) from the flanges on either side of the service section rail to create 30 mm (1 3/16 in) tabs (1).

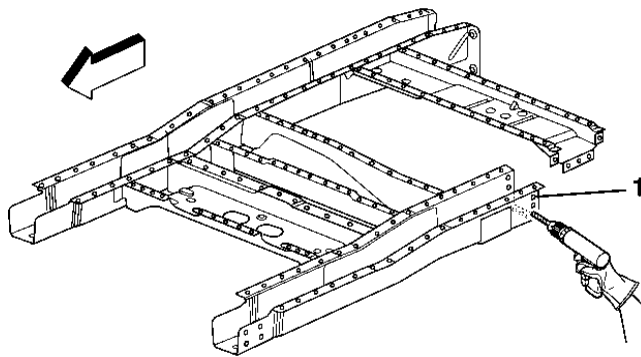
- Cut 5 mm (1/4 in) wide gaps in the bottom corners(2).



- Step the tabs inward (1) to allow the service rail section to fit inside of the original rear rail.

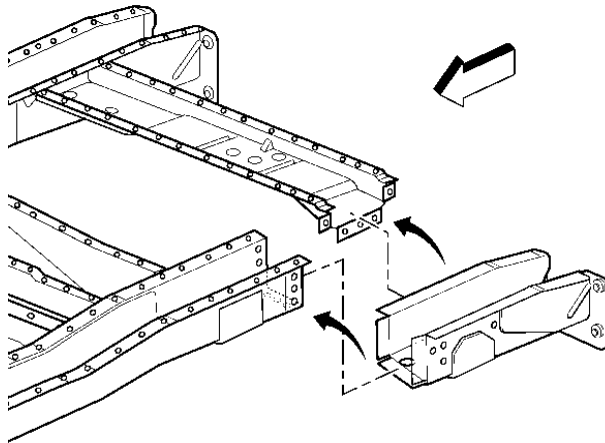
Important: The metal of the rear rail is of a heavy gage. However, the tabs can be created using the appropriate tools.

- Weld the tabs together along the lower edges (2).

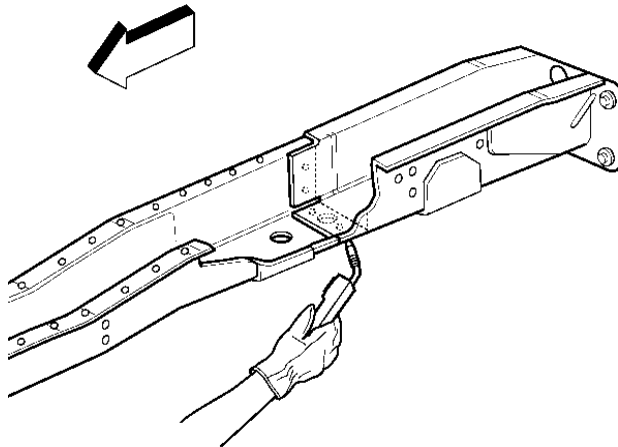


Important: In any area damaged beyond recognition, space plug weld holes every 40 mm (1 1/2 in) apart.

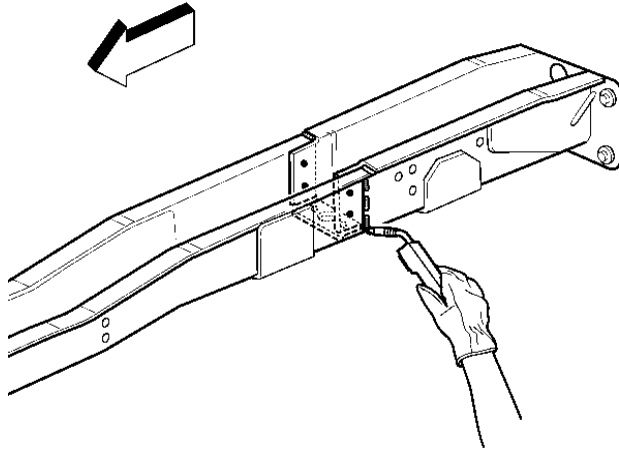
7. Drill 8 mm (5/16 in) plug weld holes along the sectioning cut on the original rail. Locate these holes 13 mm (1/2 in) from the edge and spaced 40 mm (1 1/2 in) apart.
8. Prepare all attachment surfaces as necessary.
9. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



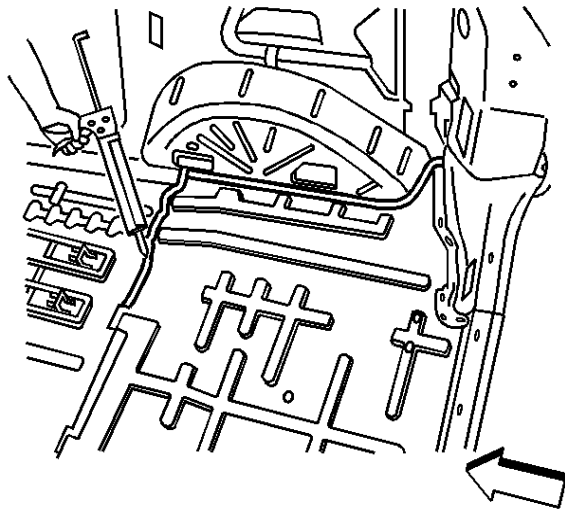
10. Align the service part over the stepped tab using three-dimensional measuring equipment.



11. Plug weld accordingly.



12. 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.



Important: Prior to refinishing, refer to publication GM 4901M-D-2000 GM Approved Refinish Materials for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

13. Clean and prepare all welded surfaces.

14. Apply the following as necessary:

- Anti-corrosion materials
- Sound deadeners
- Sealers

17. Install all related panels and components.