

# Rail Replacement – Rear

## Removal Procedure

**CAUTION:** Refer to Glass and Sheet Metal Handling in Cautions and Notices,

1. Disable the SIR system. Refer to Disabling the SIR System in Cautions and Notices.
2. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnect/Connect Procedure in Cautions and Notices.

**IMPORTANT:** The rear rails are available as complete assemblies. The rear rail section is also available separately.

**IMPORTANT:** This procedure should be used if the damage is rearward of the factory joint between the front and rear rail components.

3. Remove all related panels and components.

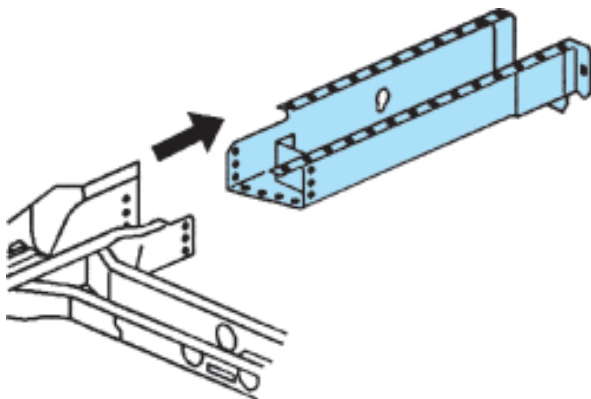
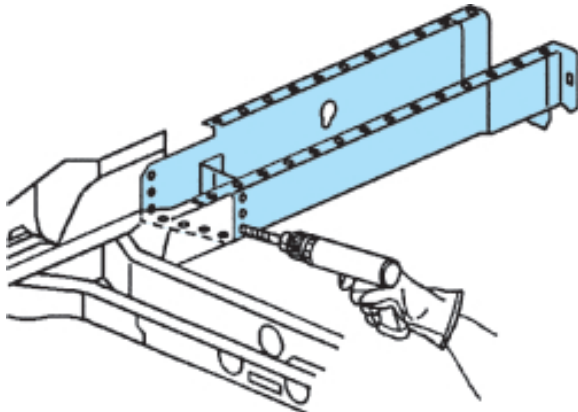
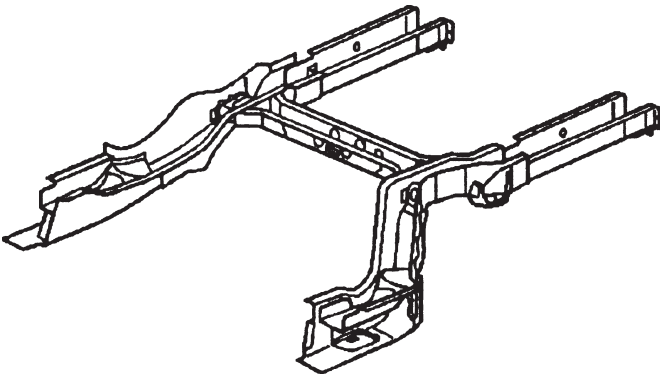
**CAUTION:** Foam sound deadeners must be removed from areas within 152.4 mm (6 in.) of where flame is to be used for body repairs. When reinstalling foam sound deadeners, avoid inhaling fumes as bodily injury may result.

4. Remove and note the location of any sound deadening materials.
5. Remove and note the location of the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Cautions and Notices.
6. Restore as much of the damage as possible.

**IMPORTANT:** Do not damage any inner panels or reinforcements.

7. Locate, mark, and drill out all factory welds. Note the number and location of welds for installation of the service assembly.

8. Remove the damaged rail section.

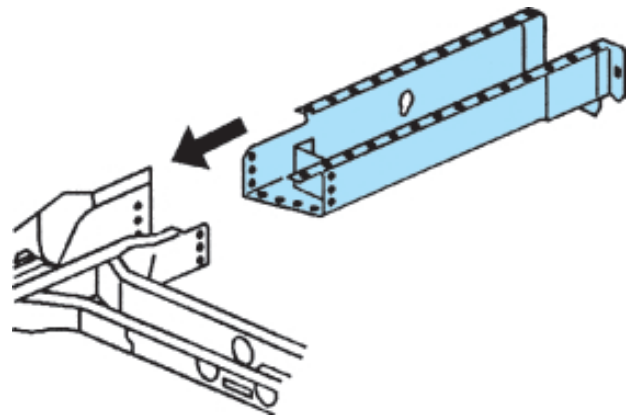
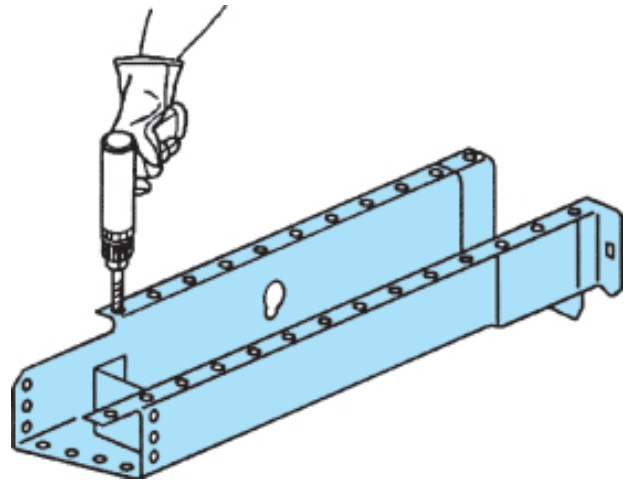


## Installation Procedure

**IMPORTANT:** This part has structural weld-thru adhesive in the joint areas. It is necessary to replace this with additional spot welds at the attachment points. This can be accomplished by adding an additional weld between each factory weld in all areas.

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

1. Drill 8mm (5/16 in.) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Prepare the mating surfaces as necessary.
3. Apply weld-thru primer.
4. Position the rear rail service part and check with 3-dimensional measuring equipment.



5. Plug weld accordingly.
6. Clean and prepare all welded surfaces.
7. Prime with 2-part catalyzed primer.
8. Apply sound deadening materials as necessary.
9. Apply the sealers, and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Cautions and Notices.
10. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems in Cautions and Notices.
11. Install all related panels and components.
12. Connect the negative battery cable. Refer to Battery Negative Cable Disconnect/Connect Procedure in Cautions and Notices.
13. Enable the SIR system. Refer to Enabling the SIR System in Cautions and Notices.

