

Panel Replacement – Rear End

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](#).

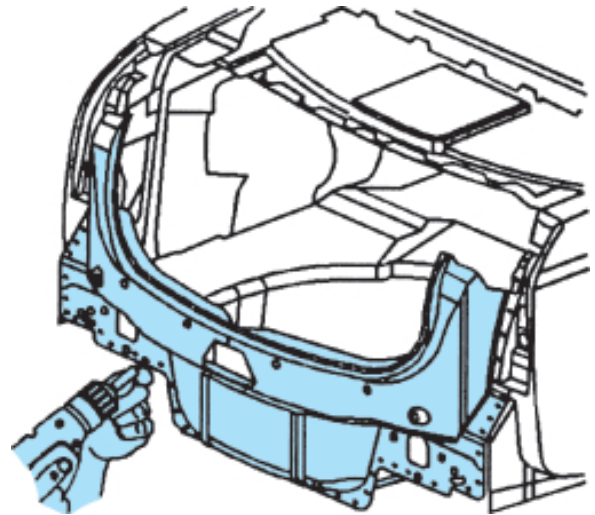
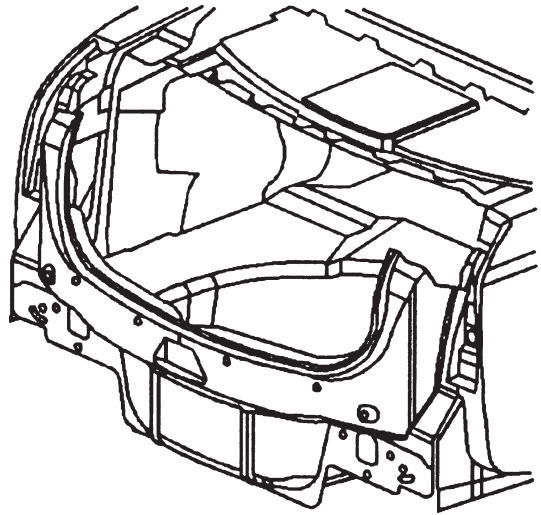
CAUTION: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

IMPORTANT: This panel is replaced at factory seams.

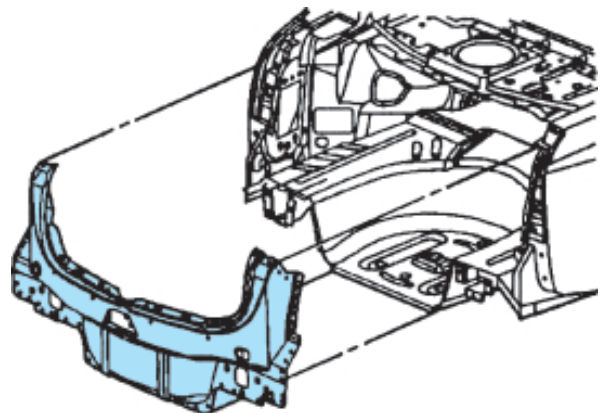
3. Remove all related panels and components.
4. Restore as much of the damage as possible.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair in Cautions and Notices](#).

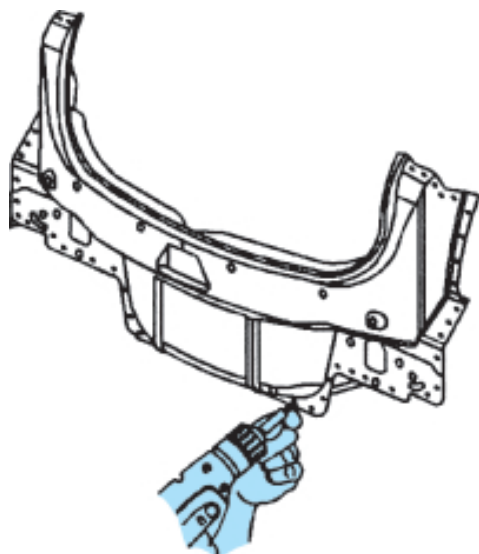
IMPORTANT: Note the number and location of the factory welds for installation of the rear end panel.

6. Locate, mark, and drill out all the necessary factory welds.



7. Remove the rear end panel.

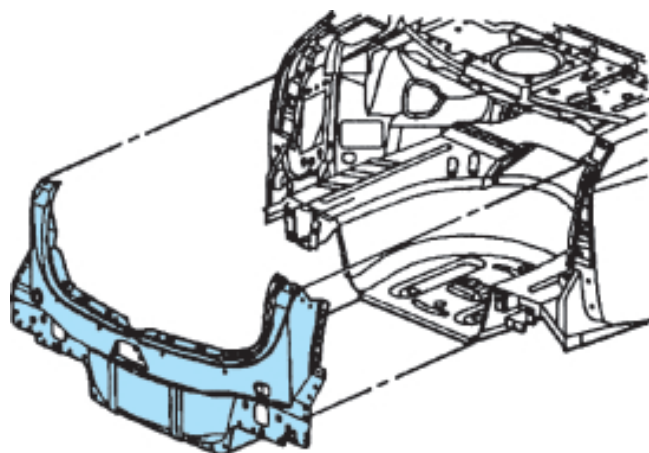




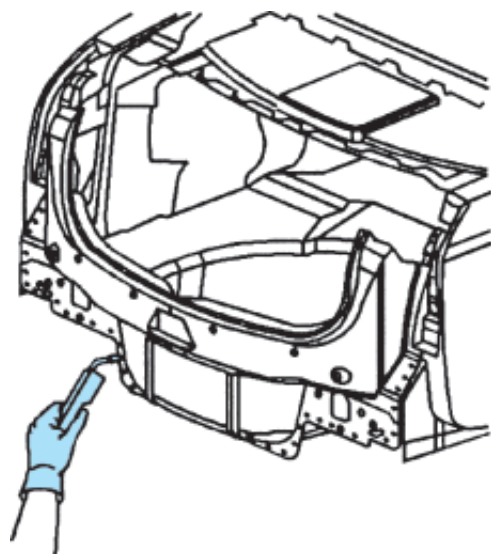
Installation Procedure

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

1. Drill 8 mm (5/16 in.) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Prepare all attachment surfaces as necessary.
3. Apply weld-thru primer to all bare metal surfaces.



4. Position the rear end panel.



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