

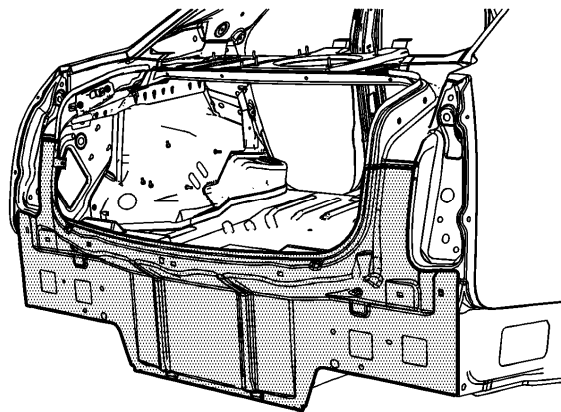
Rear End Panel Replacement

Removal Procedure

Caution: Refer to **Approved Equipment for Collision Repair Caution** in the Preface section.

Important: This panel is replaced at factory seams.

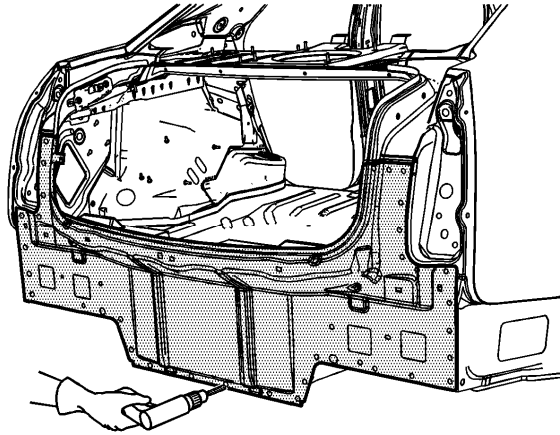
1. Disable the SIR system. Refer to **SIR Disabling and Enabling** .
2. Disconnect the negative battery cable. Refer to **Battery Negative Cable Disconnection and Connection** .



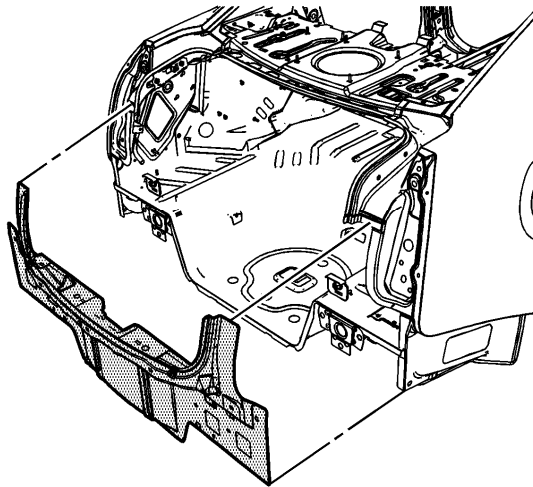
Caution: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

3. Remove all related panels and components.
4. Repair 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](#) .

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

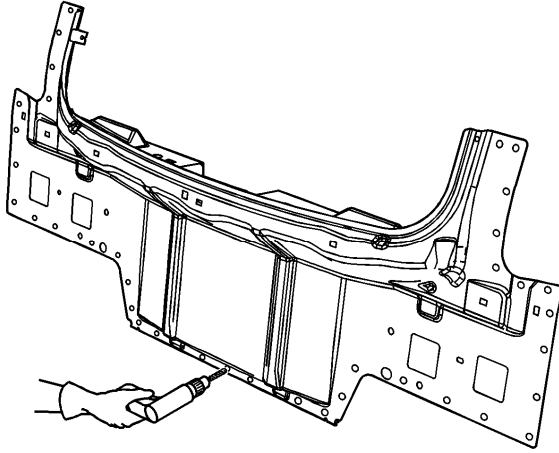


6. Locate, mark, and drill out all the necessary factory welds.



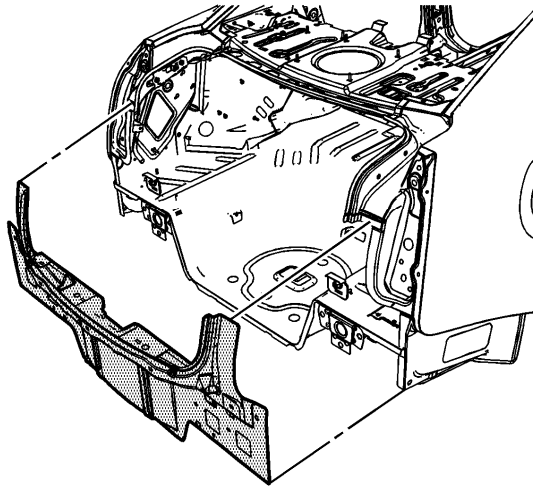
7. Remove the rear end panel.

Installation Procedure

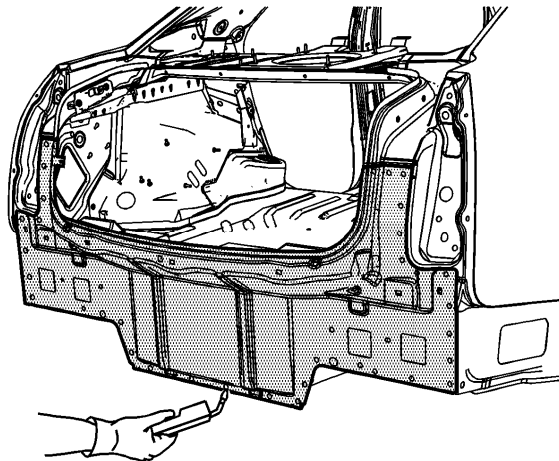


Important: If the location of the original plug weld holes can not be determined, or if structural weld-thru adhesive is present, space the plug weld holes every 40 mm (1½ in).

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 mating surfaces as necessary.
3. Apply Weld-Thru Coating to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



4. Position the rear end panel.



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