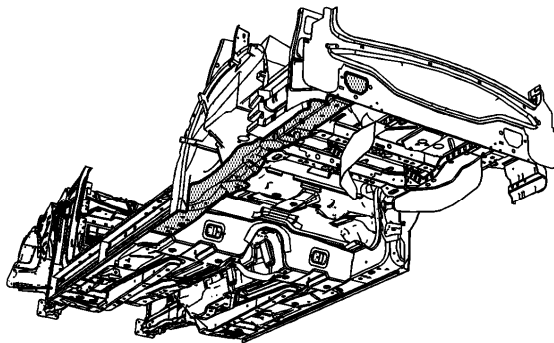


# Underbody Rear Side Rail Replacement

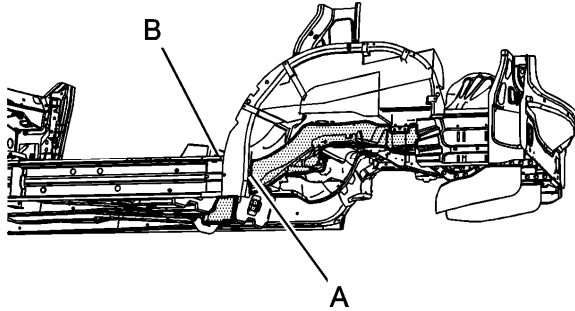
## Removal Procedure

**Caution:** Refer to [Approved Equipment for Collision Repair Caution](#) in the Preface section.

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

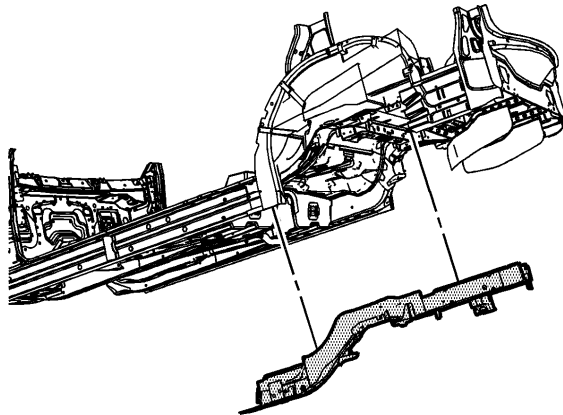


6. Locate and drill out all the necessary factory welds.



**Important:** Two hidden welds (A, B) are in the wheel house and rocker panel arms.

7. Locate and note the areas with structural adhesive.
8. Bend down the weld flange on the #5 bar.

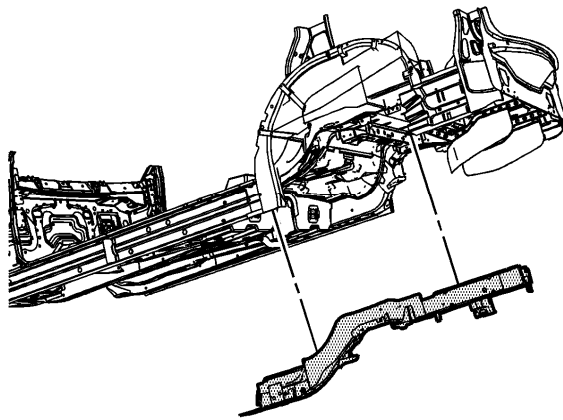


9. Remove the rear rail.

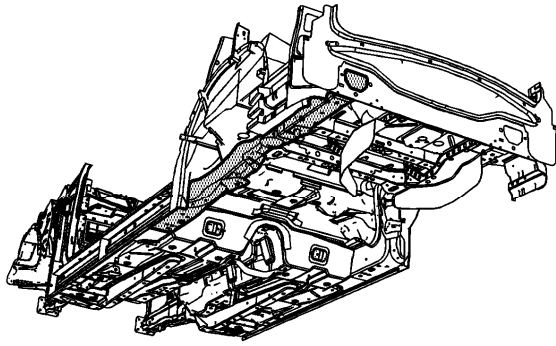
## Installation Procedure

**Important:** If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ 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 mating surfaces for welding as necessary.
3. Apply Weld-Thru Coating to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



4. Position the rear rail to the vehicle using 3-dimensional measuring equipment. Clamp the rail in place.
5. Install structural adhesive as noted during the Removal Procedure. Refer to [Metal Panel Bonding](#) .



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

