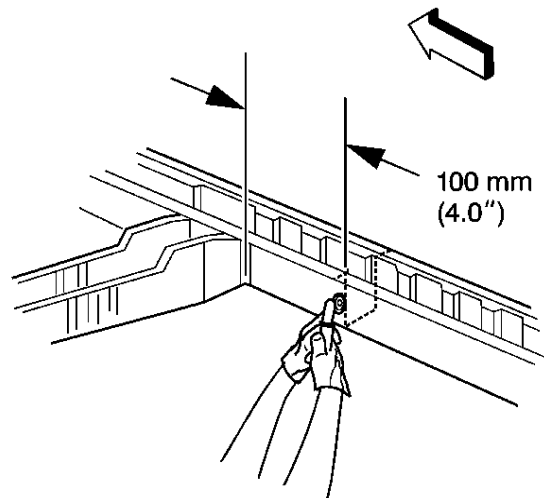


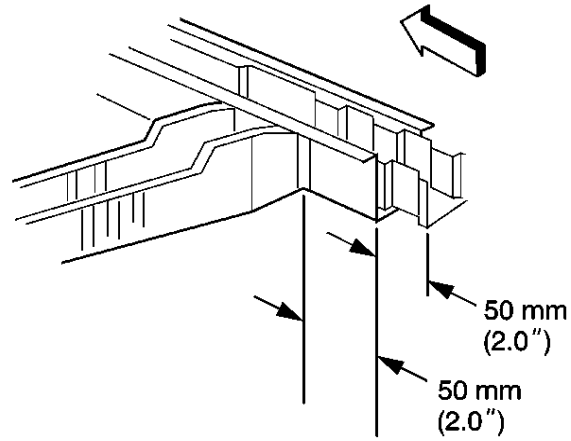
Rear Rail Replacement

Removal Procedure



1. Remove all related panels and components.
2. Visually inspect the damaged area.
3. Restore as much of the damage as possible to factory specifications.
4. Remove the sealers, sound deadeners and anti-corrosion materials as necessary.
5. Measure the right rear rail 100 mm (4 in) rearward of the number 5 crossbar.
6. Completely cut around the rear rail through the reinforcement.
7. Remove the damaged portion of the rail.

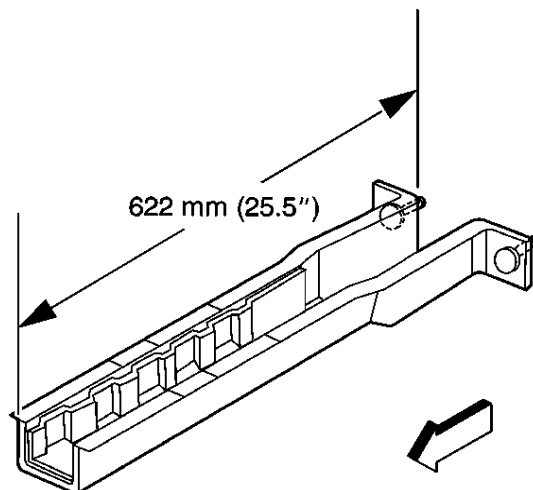
8. Measure 50 mm (2 in) forward of the cut.



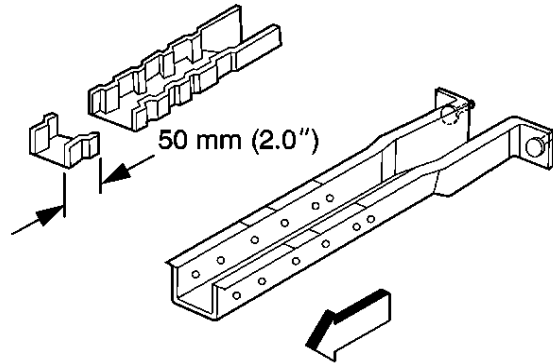
Important: Do not cut the inner reinforcement.

9. Cut the outer rail only, this should leave the rail 50 mm (2 in) shorter than the reinforcement.

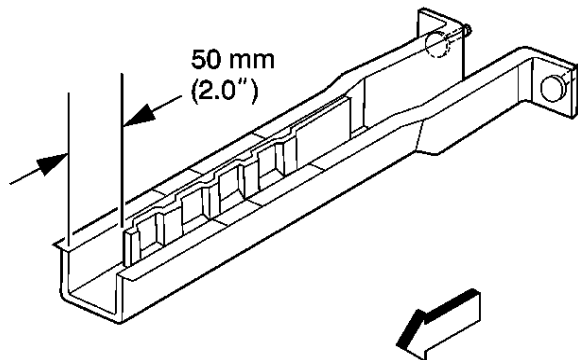
Installation Procedure



1. Measure approximately 622 mm (25.5 in) from the rear edge of the service rail.
2. Mark the service rail.
3. Cut the service rail.



4. Drill the welds attaching the reinforcement to the outer rail.
5. Remove the reinforcement from the outer rail.
6. Measure rearward 50 mm (2 in) from the cut end of the reinforcement.
7. Cut the reinforcement.



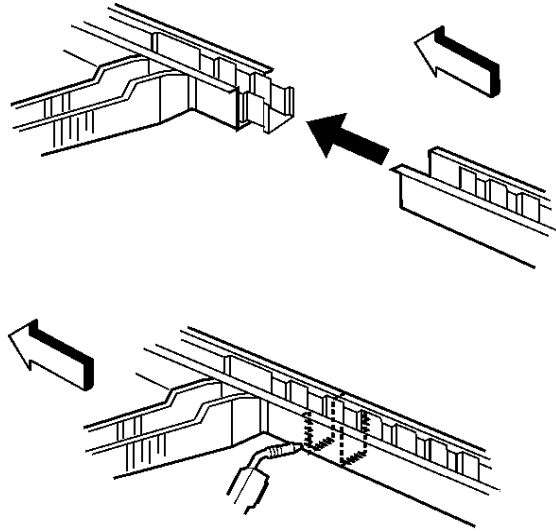
8. Install the reinforcement in the original location.

Important: The following step should create a staggered joint for welding. The staggered joint for welding maintains the structural performance of the rail.

9. Plug weld the reinforcement as necessary.
10. Prepare the mating surfaces.
11. Position the service rail, allowing it to slide over the inner reinforcement extending from the original rail section.
12. Check the position of the service rear rail section using three-dimensional measuring equipment.

Important: Be sure to plug weld the inner reinforcement to the new rail section. This may require drawing the reinforcement flat against the rail with a screw to temporarily secure the joint for welding. Sectioning joints should have a gap approximately 1½ times the thickness of the metal to ensure a secure weld, trim the part as necessary to achieve the gap.

13. Plug weld the service rear rail section accordingly with frequent measurements to ensure proper fit.
14. Stitch weld along the entire joint of the outer rail and to the inner reinforcement.
15. Make 25 mm (1 in) welds along the seam, with 25 mm (1 in) gaps between.



16. Complete the stitch weld. This should create a solid joint with minimal heat distortion
17. Clean and prepare welded surfaces.
18. Prime with two-part catalyzed primer.

Important: Do not combine paint systems. Refer to paint manufacturer's recommendations.

19. Apply sealers and anti-corrosion materials as necessary.
20. Install all related panels and components.