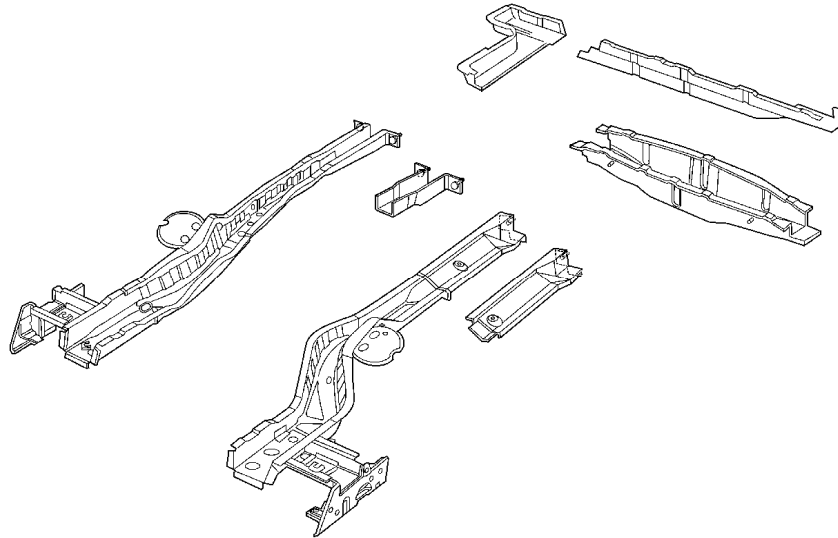


Underbody Side Rail Description



The left and right rear rails are available as complete service assemblies. The left extension is available separately to simplify service. Additionally, there are two crossbars that connect the rear rails for added strength and support. The left rear rail extension can be replaced at factory seams, however if the damage exceeds the rear extension, replace the complete rails assembly at factory seams. Sectioning of the rails is not recommended forward of the crossbar.

Complete replacement of the right and left rear rail assemblies can be performed at the factory seams by locating and drilling out all the factory welds necessary to remove the damaged rail. The service rail should be prepared by drilling 8 mm (0.31 in) holes for plug welding in the locations noted from the original rail assembly. Check for proper fit using three-dimensional measuring equipment, and plug weld as necessary.

Rear rail sectioning procedures can be used to repair the right rear rail if just the portion rearward of the crossbar is damaged. The service part is supplied with the inner reinforcement attached. Sectioning is performed by staggering the cut on the reinforcement, and creating a 50 mm (2 in) staggered joint.
