

Rear Rail Assembly

Rear Rail Replacement

Important: Complete rear rail replacement can be performed by drilling out all the factory welds. The outboard flange at the forward end of the rail must be cut in one location and bent upward, and the bottom flange of the crossbar must be bent downward. The rear rail can then be lowered from the vehicle (Fig. 4.33). When installing the service rail, the outboard flange must be cut and bent up, installed, then straightened, and aligned. Weld as necessary.

Rear Rail Sectioning

Notice: The rear rail outer panel is available separately for sectioning purposes only.

— REMOVE OR DISCONNECT —

- 1 Remove all panels and components as necessary for access.
- 2 Restore as much of the damage as possible to factory specifications.
- 3 Cut the rear rail along the rearward flange of the crossbar (Fig. 4.34). Continue this cut around the rear rail.

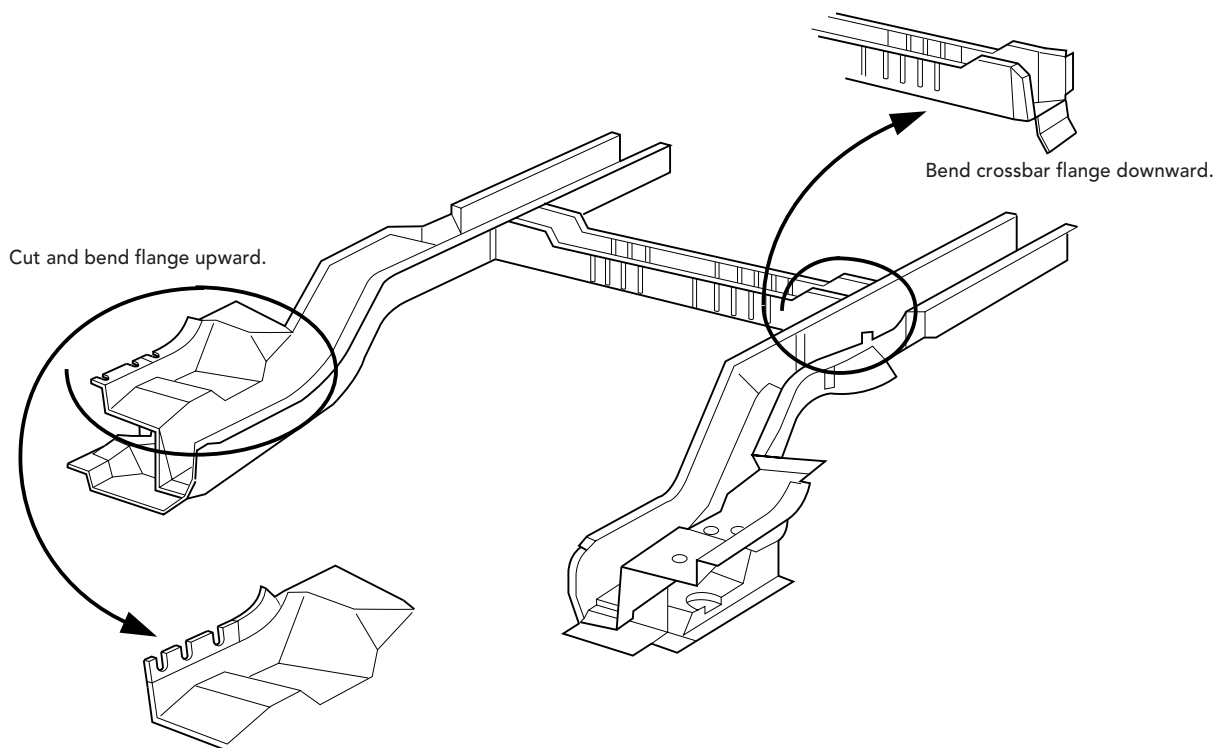


Fig. 4.33 — Full Rail Replacement

— INSTALL OR CONNECT —

- 1 Using the original part as a guide, mark a line on the service rail 35mm (1-5/16 inches) forward of the cut made to the original part. *This will provide an overlap for welding the service section.*
 - 2 Cut the service rail along the marked lines and discard the unused section.
 - 3 Cut and remove approximately 35mm (1-5/16 inches) of the flanges on the service rail. Cut a 5mm (1/4 inch) gap approximately 35mm (1-5/16 inches) along the corners of the service rail to create tabs (Fig. 4.35).
 - 4 Step the tabs inward to allow the service rail to fit inside the original rail (Fig. 4.36).
 - 5 Position the modified service rail inside the original rail, allowing 35mm (1-5/16 inches) of overlap.
 - 6 Check the position of the service rear rail section using three-dimensional measuring equipment and tack weld in three locations along all three sides of the rail. Stitch weld along the entire seam and replace factory welds, as necessary (Fig. 4.37).
 - 7 Drill two 8mm (5/16 inch) holes for plug welding in each of the three sides of the rail approximately 30mm (1-3/16 inches) from the sectioning joint, plug weld through the drilled holes into the service rail.
 - 8 Clean and prepare all bare metal surfaces. Apply as necessary:
 - sealers and anti-corrosion materials
 - sound deadeners
 - two-part catalyzed primer
 - top-coat
- Important: Do not combine paint systems. Refer to paint manufacturer's recommendations.**
- 9 Install the panels and components previously removed for access.

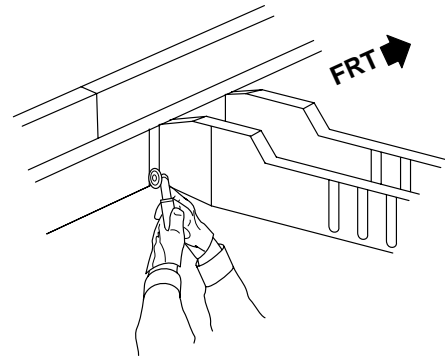


Fig. 4.34 — Cut the Rail for Sectioning

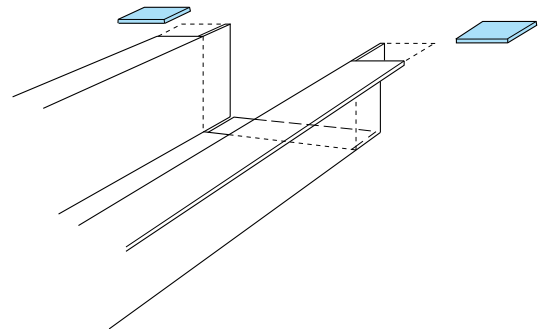


Fig. 4.35 — Create Tabs on the New Rail Section

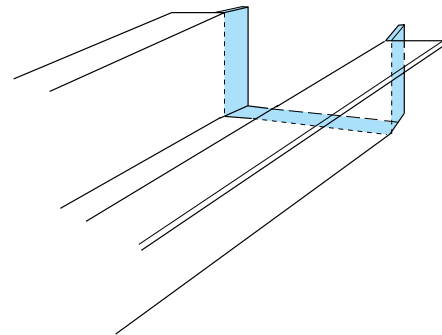


Fig. 4.36 — Step Tabs Inward on the New Rail Section

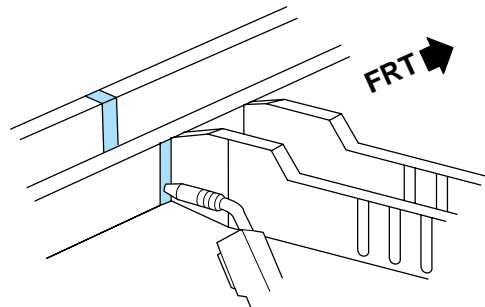


Fig. 4.37 — Install the New Rail Section