

860975

Rail End Replacement - Rear

Tools Required

J 42058 Frame Adapter Clamp

Removal Procedure

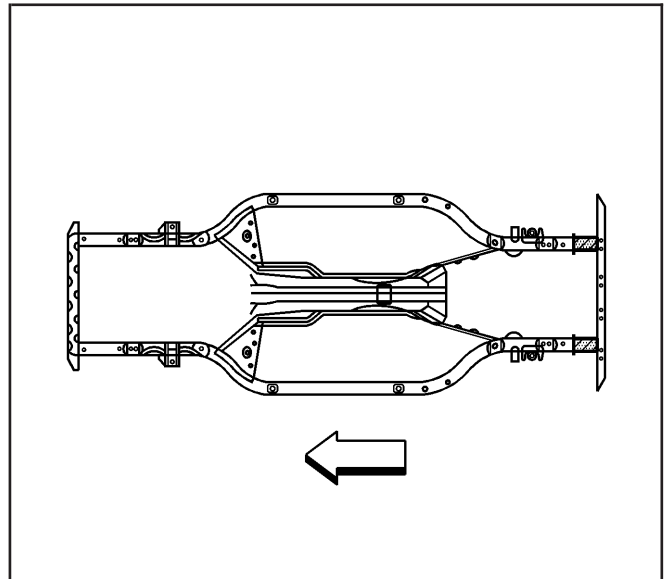
Caution: To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

1. Disable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-66.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Remove the rear impact bar. Refer to *Impact Bar Replacement - Rear Bumper* on page 2-13.
5. Note the location and remove the sealers and anti-corrosion materials from the repair area. Refer to *Anti-Corrosion Treatment and Repair* on page 1-5 in General Information.
6. Restore as much of the damage as possible to the factory specifications. Refer to *Dimensions - Body* on page 2-2 and *Measurements - Underbody* on page 2-4.
7. Use J 42058 to secure the vehicle if pulling and straightening is required.
8. Remove the damaged section of frame rail within the shaded area.

Installation Procedure

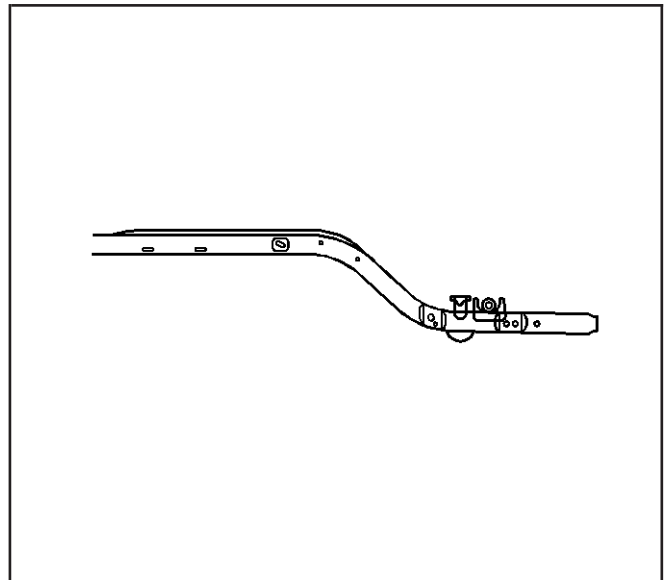
Caution: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

1. Determine the sectioning joint location within the recommended area.



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2. Cut the new frame rail end from the new frame rail assembly.
3. Perform the sleeved butt-joint sectioning. Refer to *Sleeved Butt Joint Repair* on page 2-28.
4. Install the rear impact bar. Refer to *Impact Bar Replacement - Rear Bumper* on page 2-13.
5. Apply the sealers and anti-corrosion materials to the repair area. Refer to *Anti-Corrosion Treatment and Repair* on page 1-5 in General Information.
6. Paint the repair area. Refer to *Basecoat/Clearcoat Paint Systems* on page 1-7 in General Information.
7. Install all related panels and components.
8. Connect the negative battery cable.
9. Enable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-66.



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