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Rail Replacement - Rear Section

Tools Required

J 42058 Frame Adapter Clamp

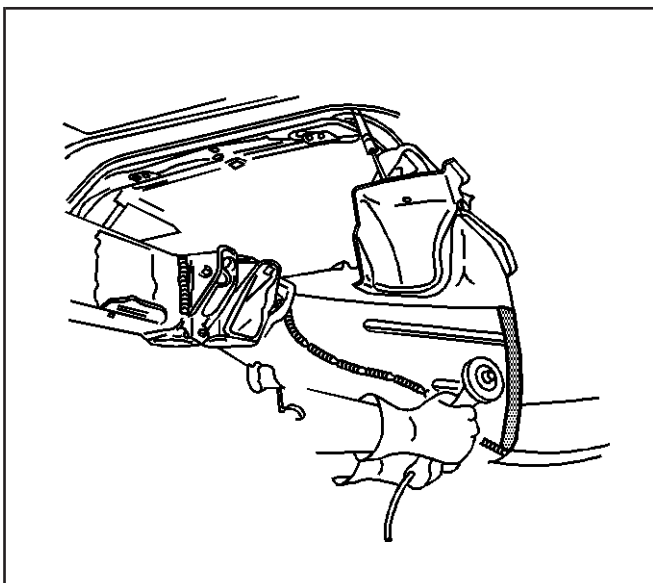
Removal Procedure

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. Remove the rear compartment panel. Refer to *Compartment Panel Replacement - Rear* on page 2-48.
6. Remove the fuel tank from the damaged side of the vehicle.
7. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to *Anti-Corrosion Treatment and Repair* on page 1-5 in General Information.
8. Restore as much of the damage as possible to the factory specifications. Refer to *Dimensions - Body* on page 2-2 or *Measurements - Underbody* on page 2-4.
9. Use J 42058 to secure the vehicle if pulling and straightening is required.
10. Inspect the front of dash panel, the floor panels, and all other sheet molded compounds for cracks or for areas that may need to be repaired or resealed.
11. Remove any welds as necessary and pry up the extension panel to expose the frame rail.

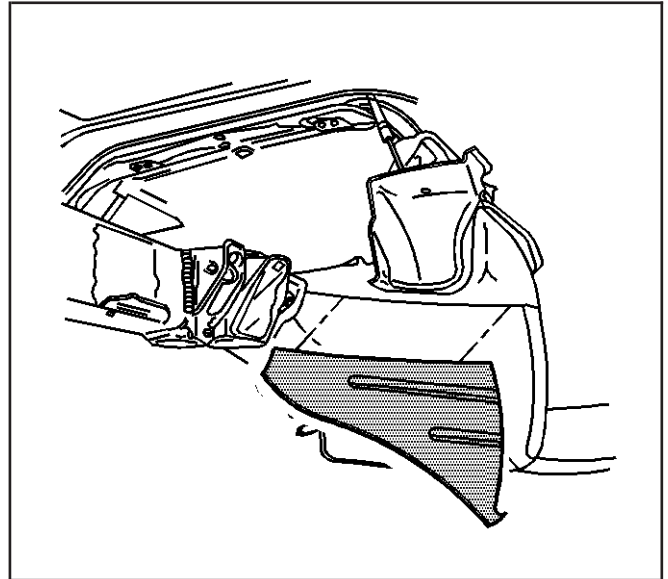
Caution: Sound deadener foam in the lock striker pillars can be a fire hazard. Create a weld flange to avoid welding directly to the lock striker pillars as damage to the vehicle and serious bodily injury may result.

12. Apply 25 mm (1 in) tape to the extension panel of the outer lock pillar.



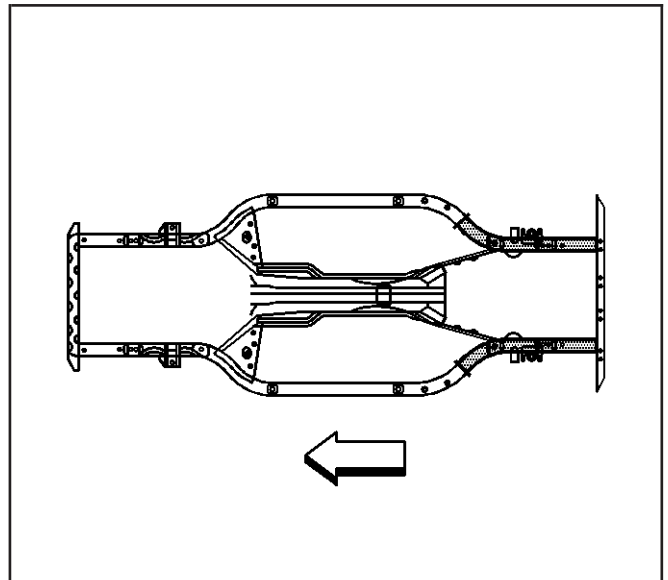
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13. Using a die grinder, cut along the edge of the tape line to create a weld flange, which will be used for installing the new extension panel for the outer lock pillar.
14. Locate and drill out all factory welds. Note the number and the location of the welds for installation of the new lower extension panel for the outer lock pillar.
15. Remove the outer lock extension panel.
16. Using a die grinder cut through the stitch welds that attach the tunnel brace to the frame rail. Make the cuts favoring the frame rail side of the welds.

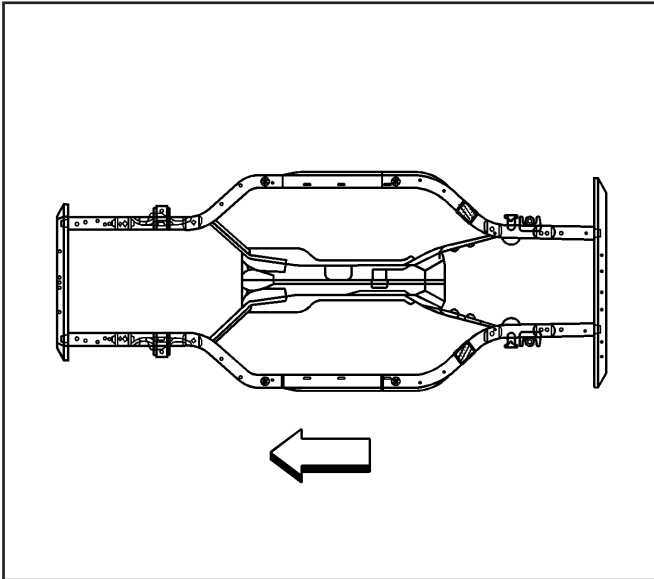


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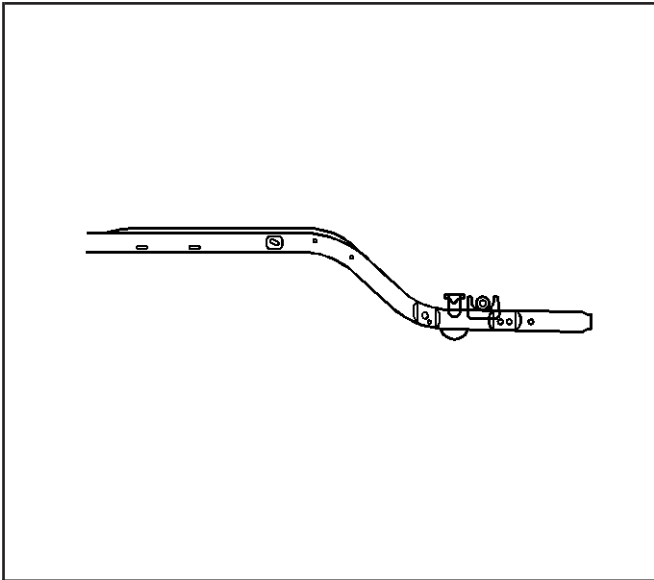
17. Remove the damaged section of the frame rail within the shaded area.



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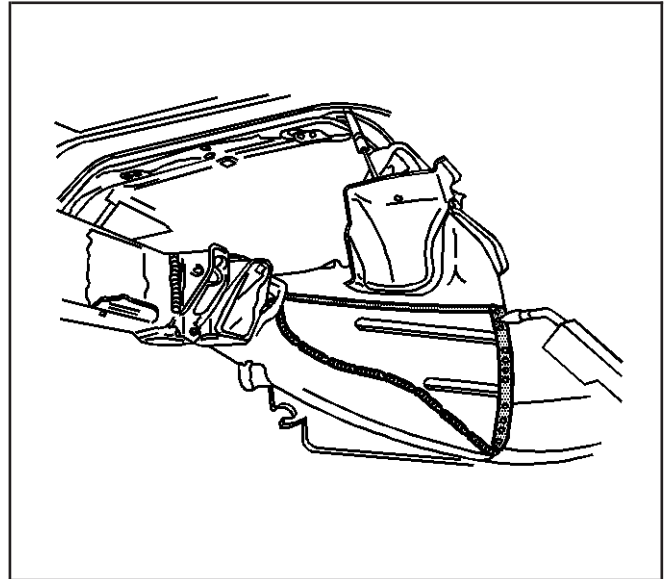
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Installation Procedure

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.
2. Cut the new frame section from the new frame rail assembly.

3. Perform the offset lap joint sectioning. Refer to *Offset Lap Joint Repair on page 2-30*.
4. Clean and prepare all of the welded surfaces.
5. Apply 3M[®] weld-thru coating P/N 05916 or equivalent as necessary.
6. Using a Metal Inert Gas (MIG) welder, stitch weld the tunnel brace to the frame rail duplicating the factory welds.
7. Position the extension panel.
8. Using a MIG welder, weld the extension panel duplicating the factory welds.
9. Replace the outer lock pillar extension panel. Trim to fit the outer lock extension panel overlapping the 25 mm (1 in) flange created from the original extension.
10. Drill 8 mm (5/16 in) holes in the new outer lock pillar extension for plug welding.
11. Using a MIG welder, tack weld the outer lock pillar extension panel into place.
12. Using a MIG welder, plug weld the outer lock pillar extension panel to the flange created from the original extension.
13. Using a MIG welder, plug weld the outer lock pillar extension panel to the extension panel.
14. Using a MIG welder, stitch weld the outer lock pillar extension to the frame rail duplicating the factory welds.
15. Install the rear impact bar. Refer to *Impact Bar Replacement - Rear Bumper on page 2-13*.
16. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to *Anti-Corrosion Treatment and Repair on page 1-5* in General Information.
17. Install the rear compartment panel. Refer to *Compartment Panel Replacement - Rear on page 2-48*.
18. Paint the repair area. Refer to *Basecoat/Clearcoat Paint Systems on page 1-7* in General Information.
19. Install the fuel tank.
20. Install all related panels and components.
21. Connect the negative battery cable.
22. Enable the SIR system. Refer to *SIR Disabling and Enabling Zones on page 2-66*.



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