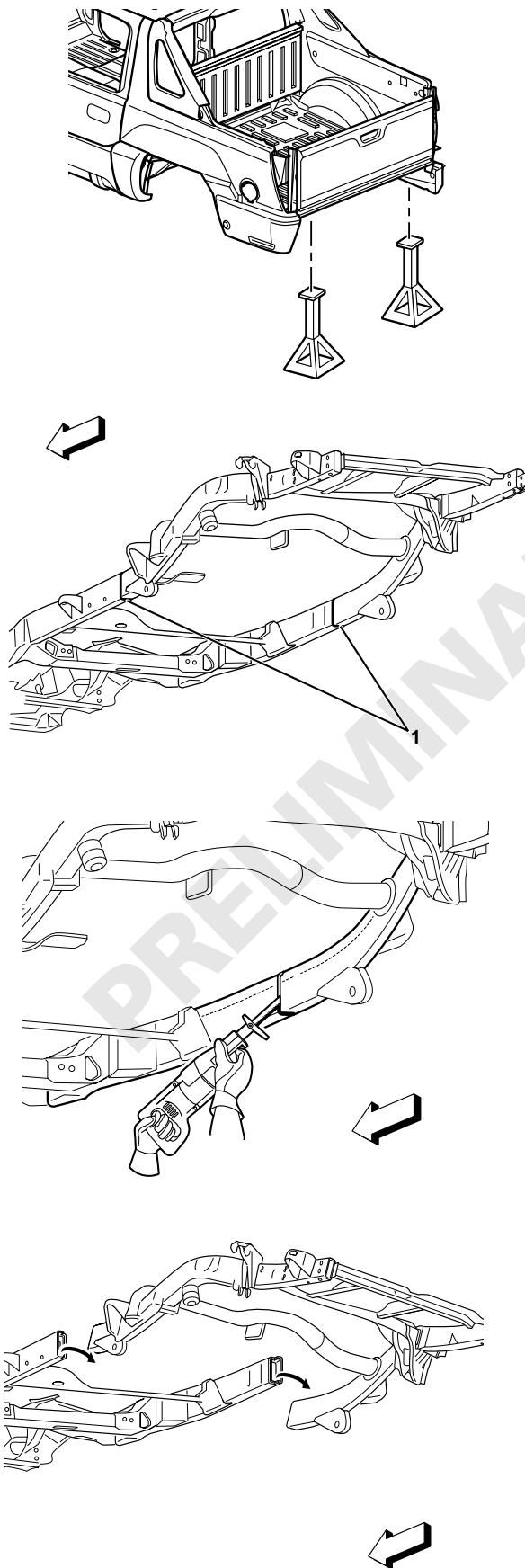


# Rear Module Replacement

## Removal Procedure

1. Remove all related panels and components.
2. Restore as much of the damage as possible to factory specifications.
3. Support the rear of the body at the outer edges of the rear cross sill to keep the vehicle stable while performing rear module replacement.
4. Locate the rear module factory seams (1) in front of rear axle trailing arm mounts.
5. Cut each frame rail at the rear edge of the factory weld.

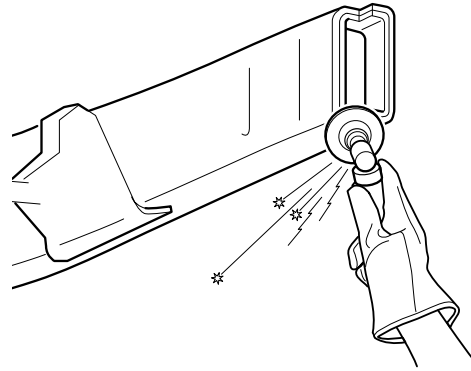


6. Remove the damaged rear frame module.

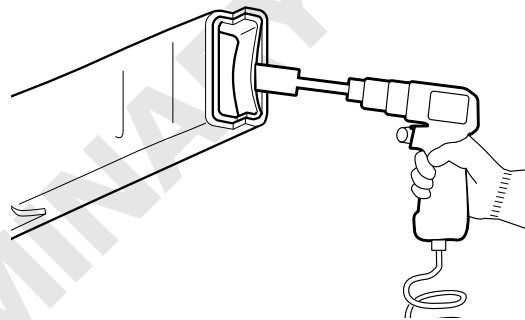
—continued

## Rear Module Replacement Removal Procedure con't

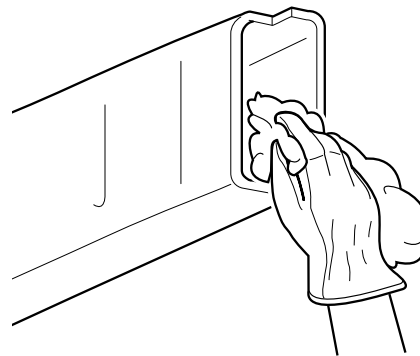
7. Grind remaining portion of rear rails back to middle section.



8. Remove the remaining section of the rear rails from the inside of middle section.



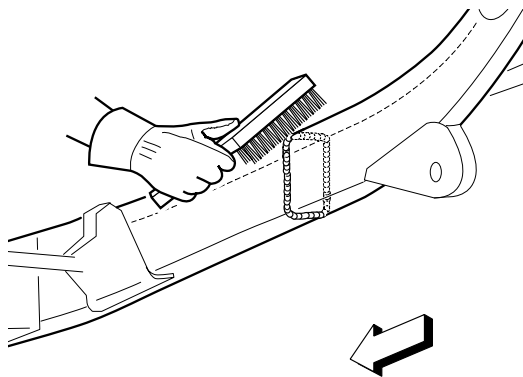
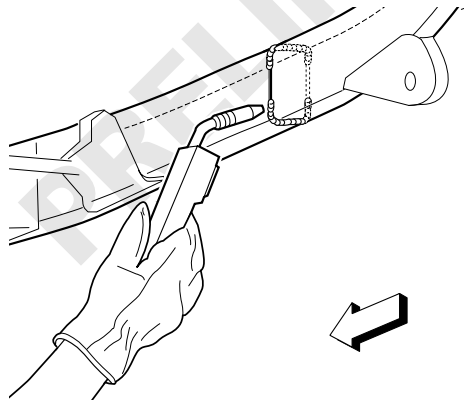
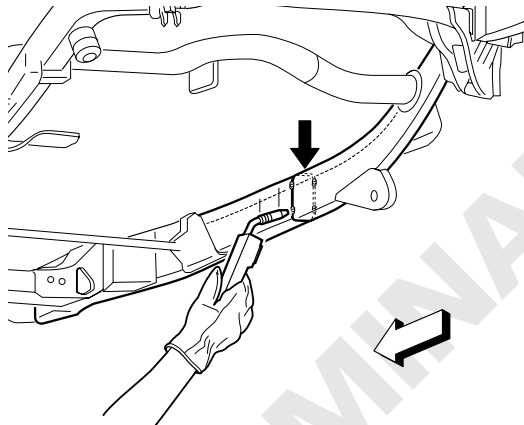
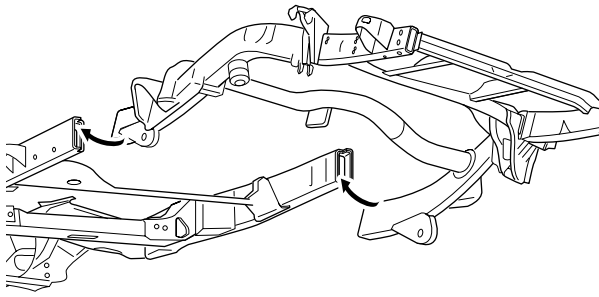
9. Remove the wax coating from inside and outside surfaces of the middle rails.



# Rear Module Replacement

## Installation Procedure

1. Prepare all bare metal surfaces as necessary.
2. Install and position the replacement module using three-dimensional measuring. *Refer to frame dimensions.*
3. Tack weld the rear module into position.



- IMPORTANT: Check all measurements three-dimensionally to ensure proper position of the rear module. Refer to frame dimensions.*
4. Continuous-weld upper and lower horizontal joints from corner to corner.
  5. Continuous-weld inner and outer vertical joints from corner to corner.
  6. Clean and prepare the welded surfaces.
  7. Apply suitable wax coating to the inside and the outside of the rails at the repair locations.
  8. Install all related panels and components.