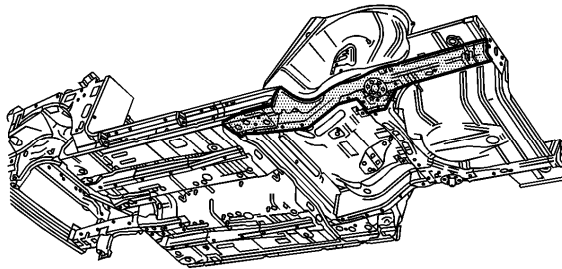


Rail Replacement Rear Side Underbody (Sedan)

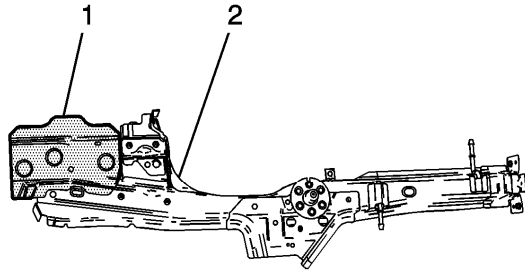
Removal Procedure

Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

1. Disable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.



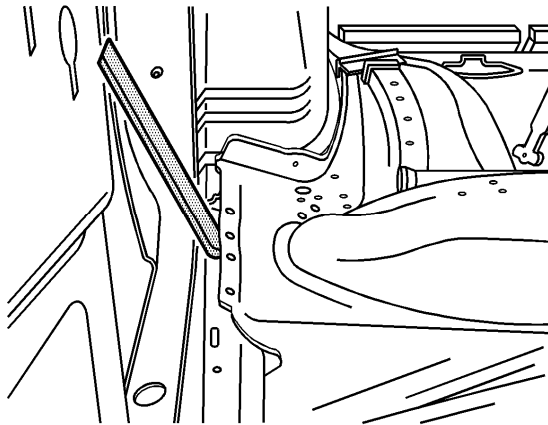
3. Remove all related panels and components.
4. Repair as much of the damaged area as possible. Refer to [Dimensions - Body](#) .
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.



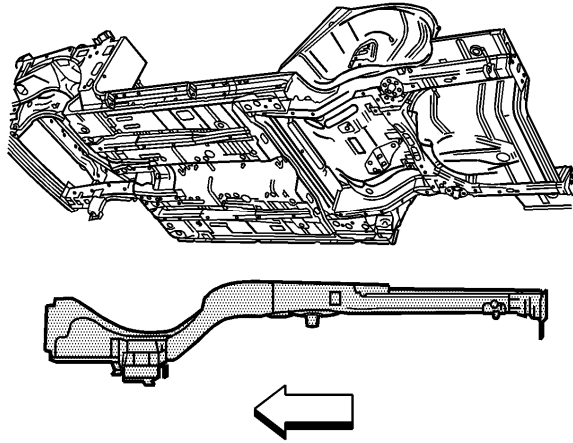
6. Remove the filler rocker inner panel (1).
7. Remove the door wheel house extension (2).

Important: There is a hidden weld under the wheelhouse and the brace opening.

8. Locate and drill out all the necessary factory welds.

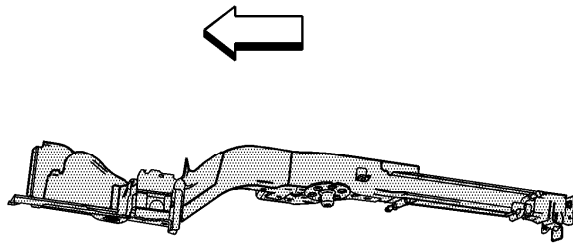


9. Pry back the rear of the floor pan to access the spot welds at the front of the rail assembly.



10. Remove the rear rail.

Installation Procedure



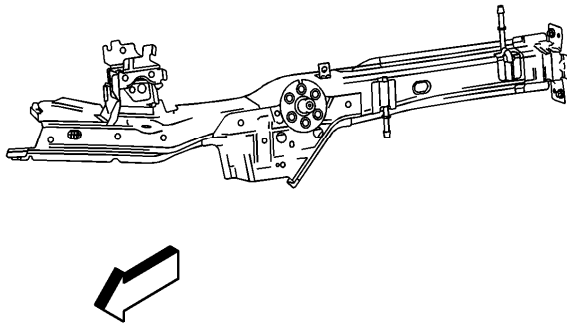
Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel.

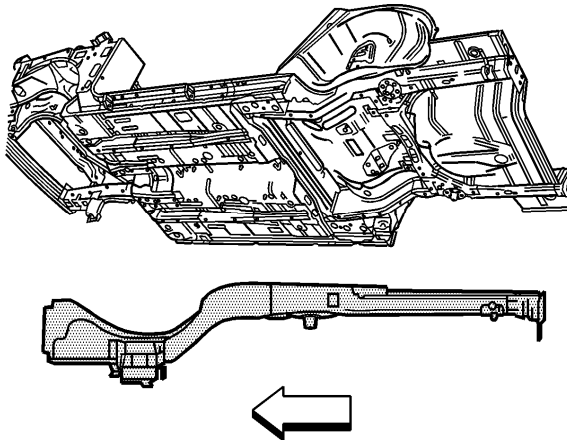
2. Prepare all mating surfaces for welding as necessary.
3. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).

Important: The service part includes a rear wheelhouse extension and a filler rocker inner panel. The rear rail can not be installed with the rear wheelhouse and filler rocker inner panel.

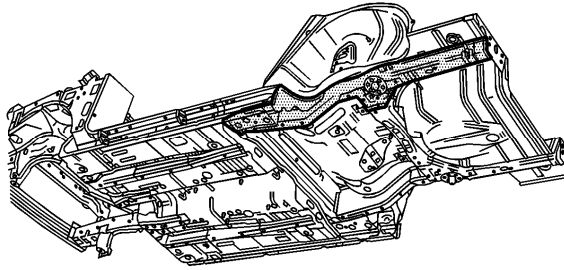
4. Drill out the spot welds.



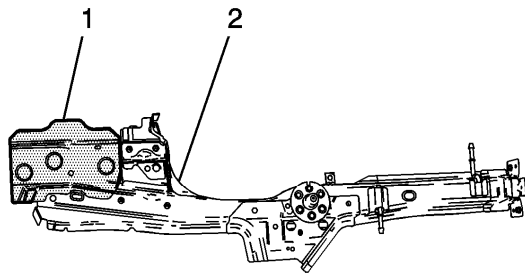
5. Remove the rear wheel house extension and filler rocker inner panel.



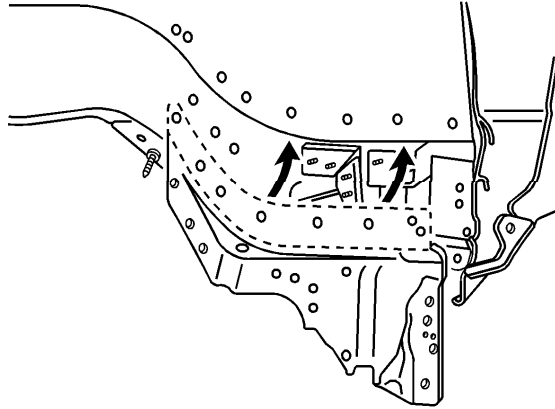
6. Position the rear rail to the vehicle using 3-dimensional measuring equipment. Clamp the rail in place.



7. Plug weld accordingly.



8. Install the rear wheelhouse extension (1) to the rear rail (2).



9. Install the rear rocker inner panel (1).
10. Clean and prepare all of the welded surfaces.
11. Install all of the related panels and components.
12. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
13. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
14. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.
15. Enable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.