

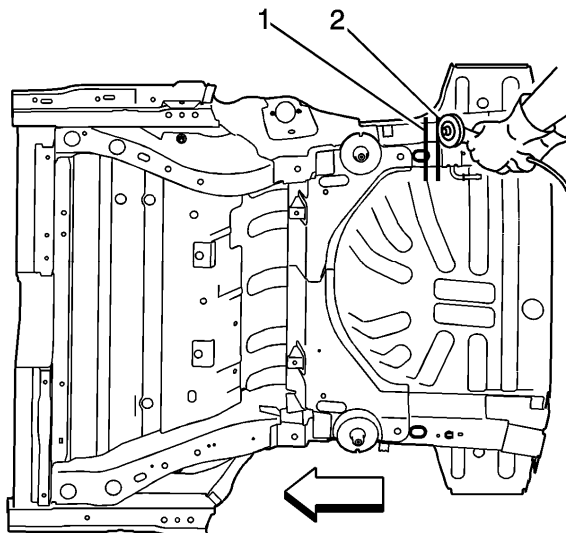
Rail Sectioning Rear Side Underbody (Extended Sedan)

Removal Procedure

Sectioning procedures can be used to repair the rear rail if just the portion rearward of the crossbar is damaged. The assembly consists of the outer rail panel with the bumper mounting brackets attached and the shock mount with internal reinforcements.

Important: If damage exceeds the recommended area for sectioning and the rail cannot be straightened, the complete rail must be replaced.

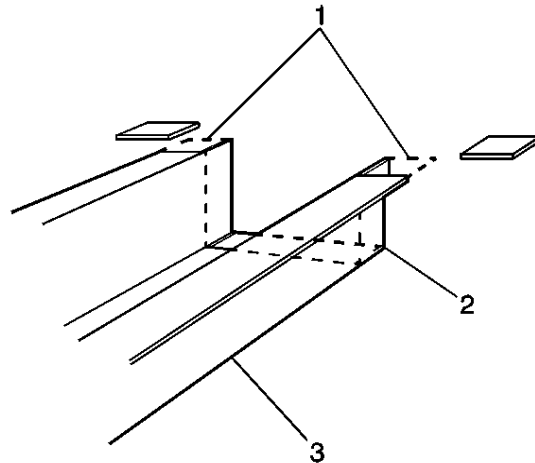
1. Remove all related panels and components.
2. Visually inspect and restore as much of the damage as possible to factory specifications.
3. Remove sealers and anti-corrosion materials as necessary.
4. Locate, mark, and drill out all factory welds. Note the number and location of welds for installation of the service assembly.



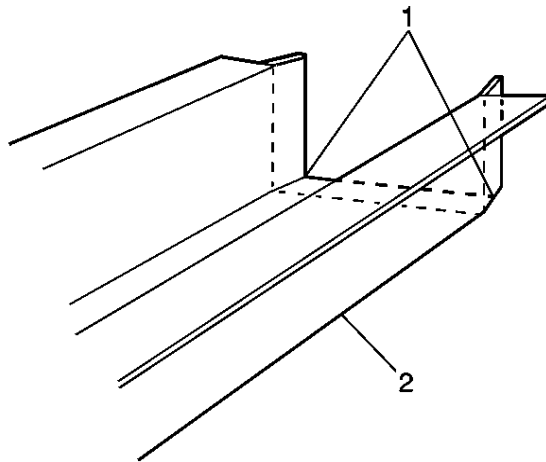
5. Locate the rear edge shipping slot (1) 25 x 40 mm (1 x 1.6 in) in the rear rail.
6. Use a straight edge to scribe a line around the rail.
7. Mark and cut the damaged rail (2) 30 mm (1.8 in) rearward of the shipping slot.
8. Remove the damaged section of the rail.

Installation Procedure

1. Locate the rearward shipping slot on the service part.
2. At the rear edge of the shipping slot, mark and cut the rail. This is the service part.
3. Cut the service part and discard the unused portion.

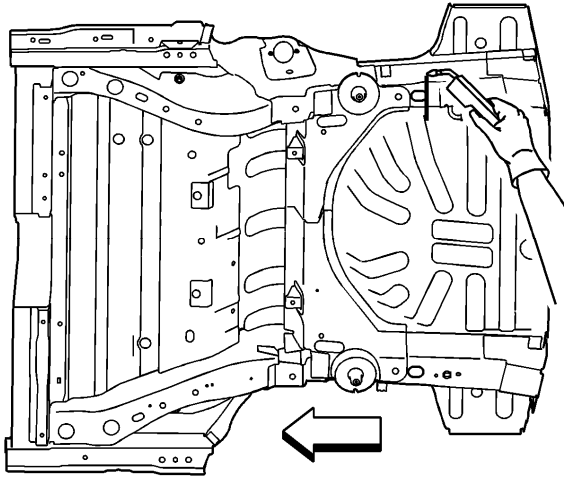


4. Cut and remove 30 mm (1 3/16 in) from the flanges on either side (1) of the service rail (3) to create 30 mm (1 3/16 in) tabs.
5. Cut 5 mm (3/16 in) wide gaps in the bottom corners (2).



6. Step the tabs inward to allow the service section (2) to fit inside of the original rail.
7. Weld the tabs together along the edges (1).
8. Clean and prepare the mating surfaces.
9. Position the service part.

10. Check fit with 3-dimensional measuring equipment.
11. Plug weld accordingly.



12. Stitch weld along the entire joint (2).
13. Make 25 mm (1 in) welds along the seam with 25 mm (1 in) gaps between.
14. Go back and complete the stitch weld. This will create a solid joint with minimal heat distortion.

Important: The bumper mounting holes must be properly located and drilled. Use three-dimensional measuring equipment.

15. Clean and prepare welded surfaces.
16. Prime with two-part catalyzed primer.

Important: Prior to refinishing, refer to publication GM 4901MD-01 GM Approved Refinish Materials for recommended products. Do not combine the paint systems. Refer to the paint manufacturer's recommendations.

17. Apply the following and refinish as necessary:

- Sealers
- Sound deadening materials
- An approved anti-corrosion primer.

20. Install all related panels and components.