

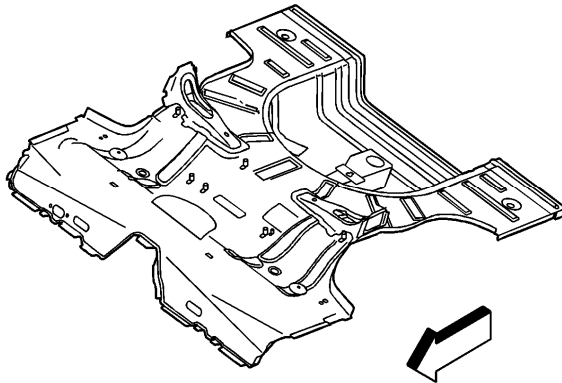
Rear Compartment Floor Panel Sectioning (Sedan)

Removal Procedure

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

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.

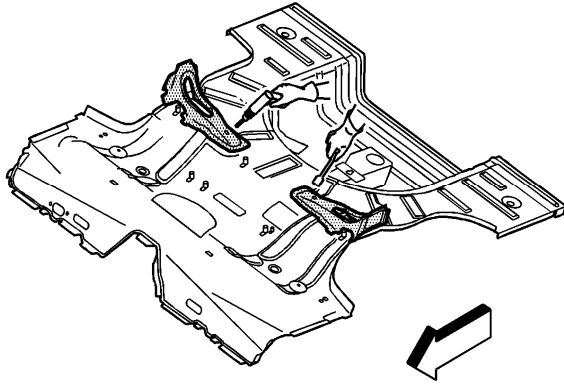
1. Disable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.



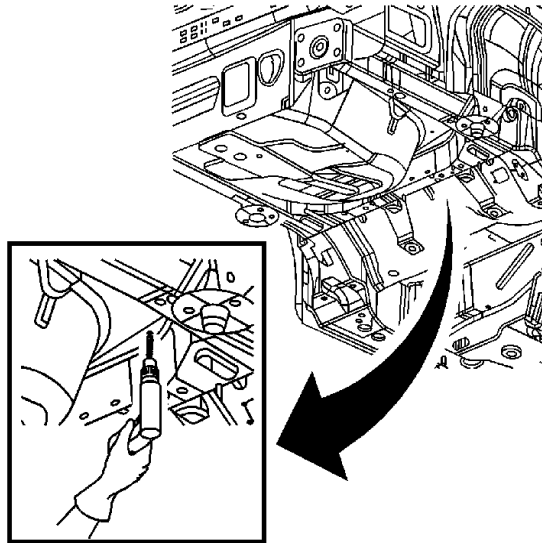
Important: The rear floor pan service part comes as a complete panel. You must make a cut to create the needed part for sectioning.

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

5. Repair as much of the damaged area as possible. Refer to [Dimensions - Body](#) .

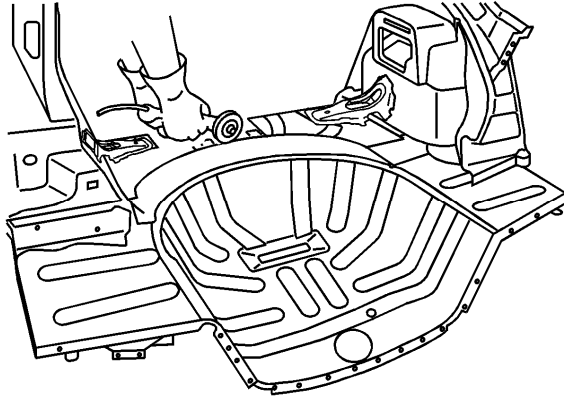


6. Drill out the spot weld along the rearward edge of the inner wheelhouse reinforcements. Pry upward to allow for service panel overlap of the floor panel.



Important: Do not damage any adjacent panels or components when cutting or drilling out spot welds.

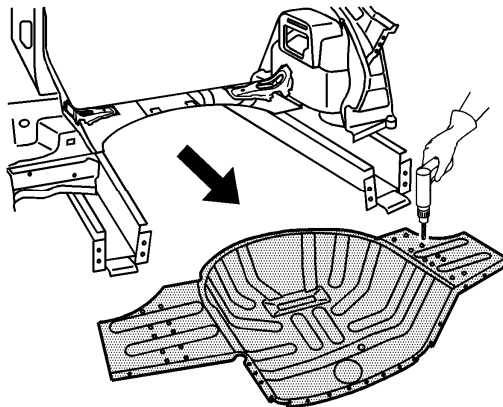
7. Locate the rear edge of cross bar #5 from under the vehicle.
8. Drill several 1/8 in holes, in the floor pan only, along the rear edge of the rear weld flange of cross bar #5. This will aid in identifying the location from the top side of the floor pan for the radius cut.



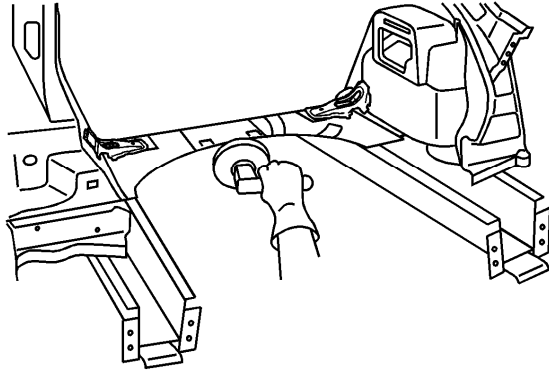
9. Cut the floor panel by following the holes that were previously drilled from the underside rear edge radius of the #5 bar.
10. Cut the floor panel from the point where the #5 bar ends at the rails. Cut the floor panel straight across the flat area at the top of the frame rails.

Important: Do not damage any inner panels or reinforcements.

11. Cut slightly rearward of the holes drilled along the floor pan. Later, the floor panel will be ground flush to the rear edge of the weld flange.

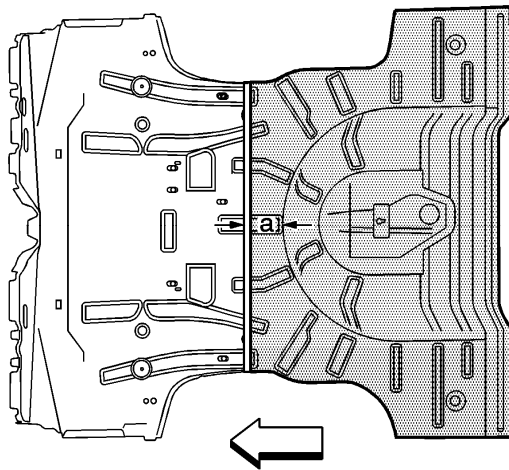


12. Drill out all of the spot welds along the rails. Drill out the spot welds where the rails attach to the wheelhouse, rearward of the cutline. Remove the rear floor compartment. Note the number and location of the welds for installation of the service part.

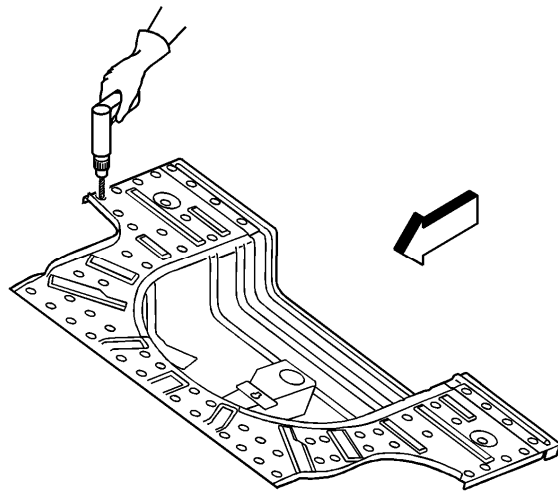


13. Grind flush the original panel of the rear compartment panel at the rear edge of the #5 crossbar.

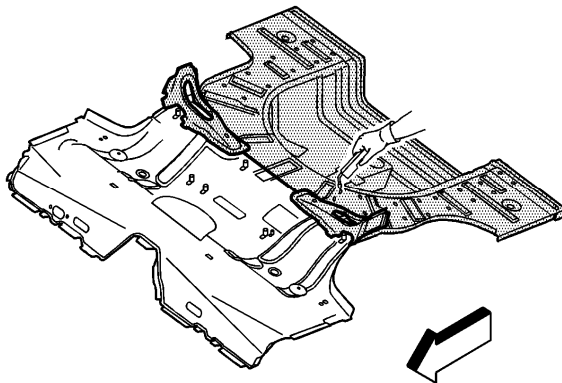
Installation Procedure



1. Remove the inner wheelhouse reinforcements on the service part.
2. On the rear compartment floor panel service part, measure from the front edge of the tire tub 200 mm (8 in) (a) forward. Scribe a line across the rear compartment pan.

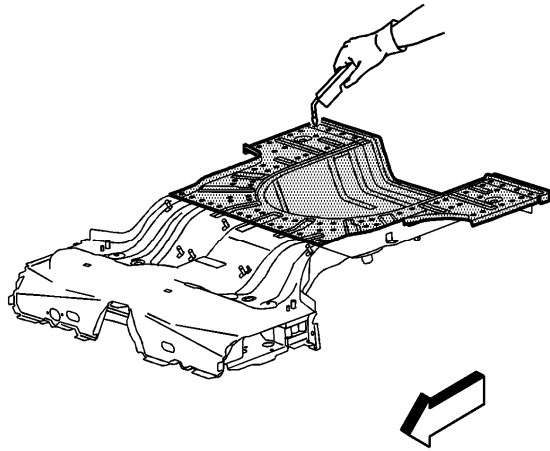


3. Cut along the forward edge of the tape, the edge that would be closest to the front of the #5 bar seat, and remove the rear portion of the panel.
4. Drill 8 mm (5/16 in) plug weld holes in the service part, as necessary, in the corresponding locations noted on the original panel.
5. Lay out and drill 2 additional rows of 8 mm (5/16 in) plug weld holes on top of the #5 bar weld flanges.
6. Prepare all mating surfaces for welding as necessary.
7. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).

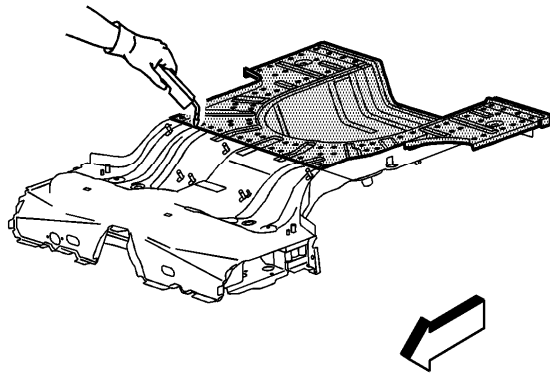


8. Slide the floor pan under the inner wheelhouse reinforcements. Overlap the existing floor.

9. Position the rear floor pan to the vehicle using 3-dimensional measuring equipment. Clamp the part in place.



10. Plug weld accordingly.



11. Weld the seam along the front cut edge of the floor panel service part. To create a solid weld along the front of the service part with a minimum of heat distortion , make a stitch weld along the seam with 25 mm (1 in) gaps between each weld.
12. Hammer the rear inner wheelhouse reinforcement rear edge down. Reweld the plug-weld holes.
13. Clean and prepare all welded surfaces.
14. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.

15. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
16. Install all related panels and components.
17. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.
18. Enable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.