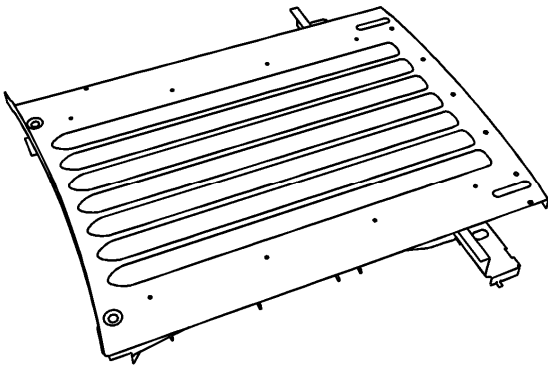


Rear Floor Replacement (Complete)

Removal Procedure



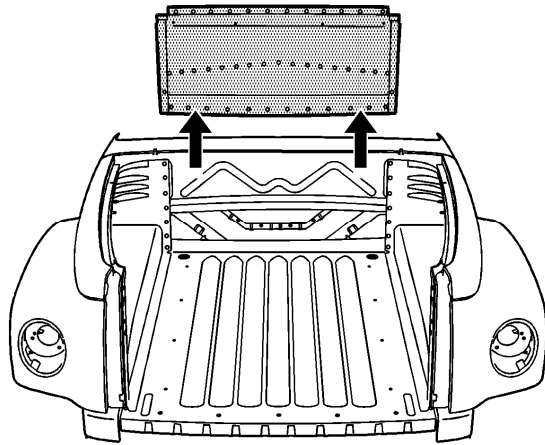
The replacement rear floor is serviced as a complete assembly. Parts in the rear floor pan assembly include the cross frame reinforcement, the right and left #5 cross bar brackets, and the rear floor panel.

When replacing the rear floor assembly, the #5 cross bar assembly is not included and must be ordered separately.

If the damage is less severe, a sectioning procedure has been developed for the rear floor assembly as a cost-effective alternative to complete replacement. This sectioning procedure eliminates the need to replace the rear outer body panel.

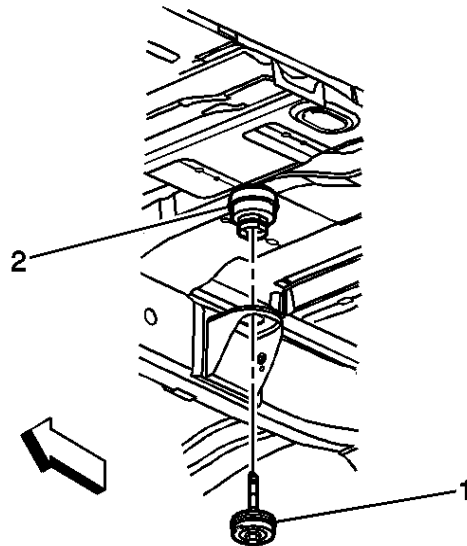
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

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

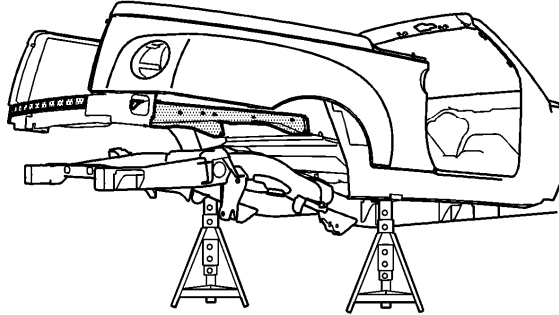


Important: When replacing the complete floor pan assembly, it is necessary to remove the rear outer body panel. Depending on the extent of the damage, you may section the floor assembly instead of replacing the rear outer body panel.

3. Remove all related panels and components including the rear outer body panel. Refer to [Panel Replacement - Body Rear Outer](#) .
4. Repair as much of the damage as possible to factory specifications. Refer to Rear Compartment in [Dimensions - Body](#) .



5. Loosen the mounting bolts that secure the body to the frame. Remove all of the bolts except the 2 bolts in the front tie bar and the 2 bolts under the front hinge pillar. Refer to [Frame Cushion or Insulator Replacement](#) in Frame and Underbody.

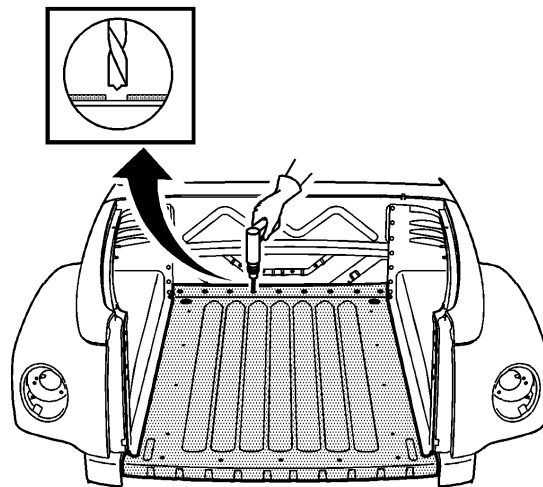


Important: Note the location and remove or disconnect any component that could be damaged while raising the rear portion of the body off of the frame.

6. Lift the rear of the body approximately 15 cm (6 in) off of the frame and support the body with vehicle stands forward of the rear wheel opening as shown.

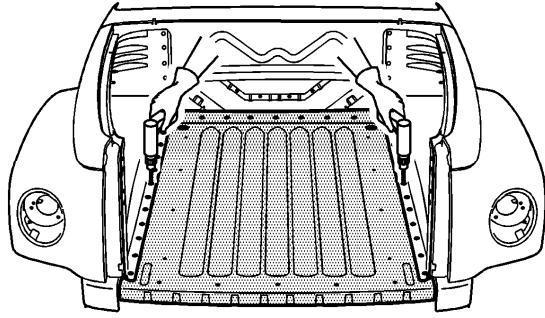
Caution: Refer to [Foam Sound Deadeners Caution](#) in Cautions and Notices.

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](#) in Paint and Coatings.

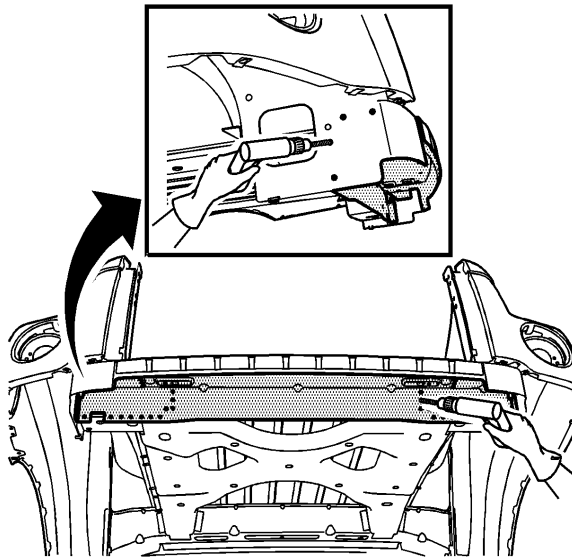


Important: Do NOT damage the inner panels or the reinforcements.

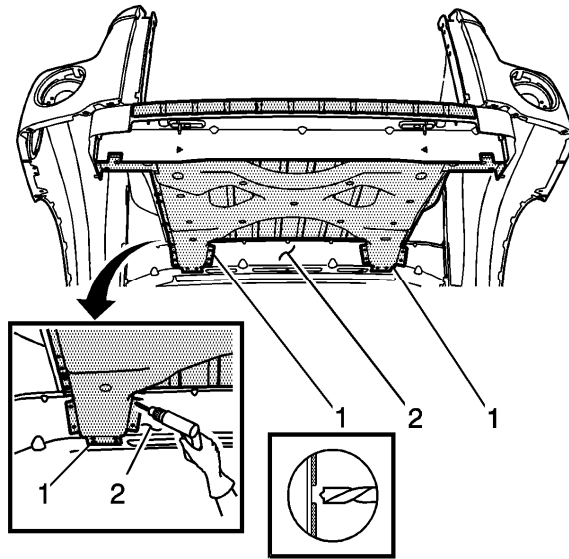
8. Locate and drill out all factory welds along the front box panel. Note the number and location of the welds for installation of the service floor assembly.



9. Locate and drill out all factory welds along the weld flange of the floor and the cargo box side panels. Note the number and location of the welds for installation of the service floor assembly.

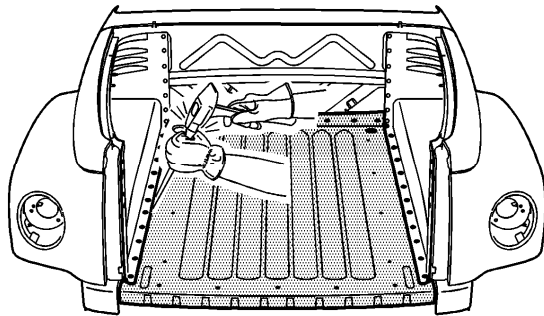


10. Locate and drill out all factory welds on each end of the #5 bar as shown.

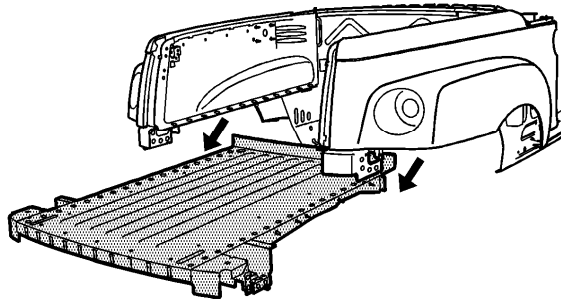


Important: Do NOT damage the inner panels or the reinforcements.

11. Locate and drill out all factory welds attaching the cross frame reinforcement (1) to the #3 cross sill (2).

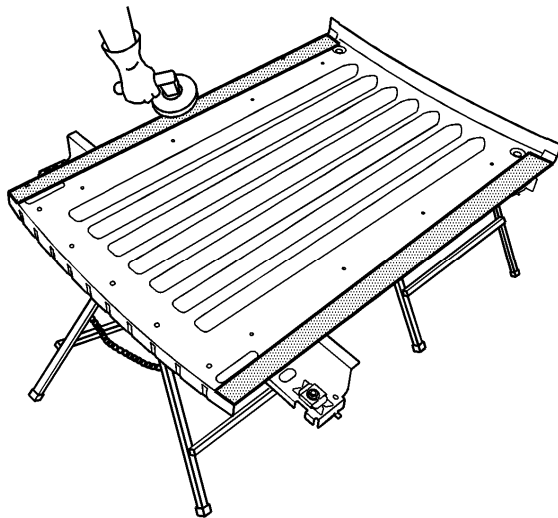


12. Verify the existence of structural weld-through adhesive. Refer to [Structure Adhesive - Identification](#) . If necessary use a chisel to separate the rear floor assembly from the adjacent panels.



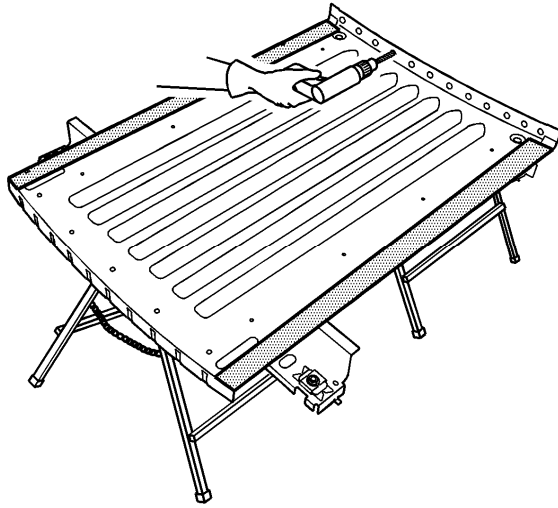
13. Remove the damaged floor assembly.

Installation Procedure

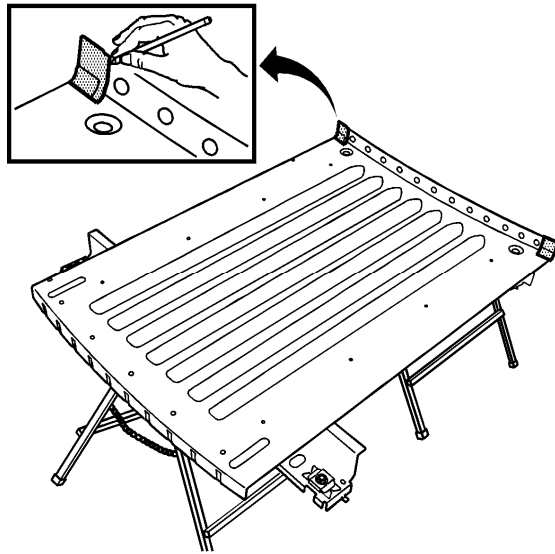


Important: Do NOT drill MIG plug weld holes along either side of the service floor panel.

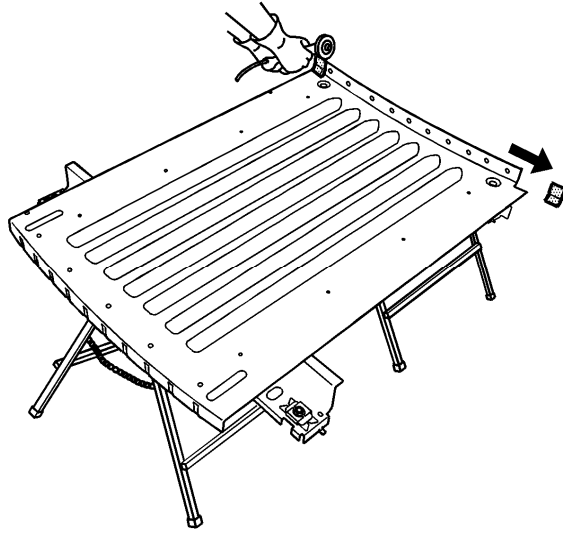
1. Remove the primer from along both sides of the floor panel, as shown.



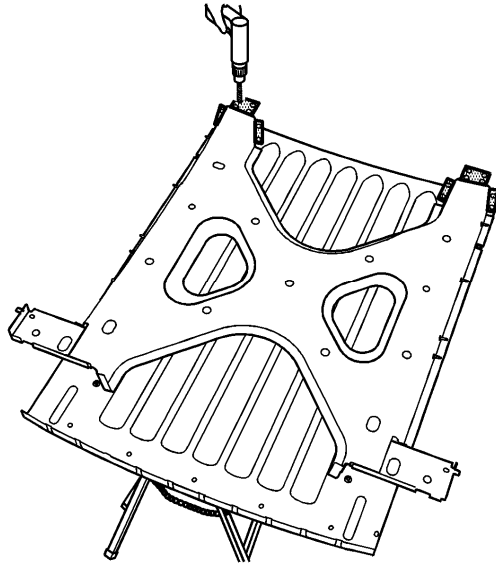
2. Drill 8 mm (5/16 in) plug weld holes in the service floor assembly along the front weld flange as noted from the original panel.



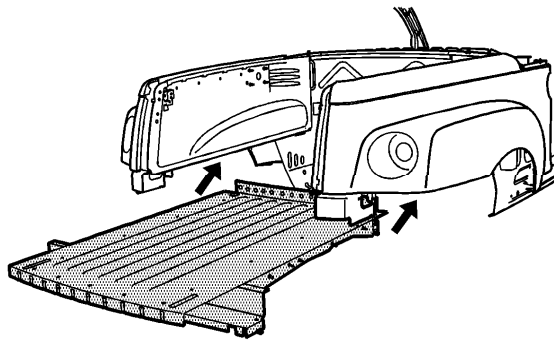
3. Mark a 50 mm (2 in) square in each corner of the front weld flange as shown.



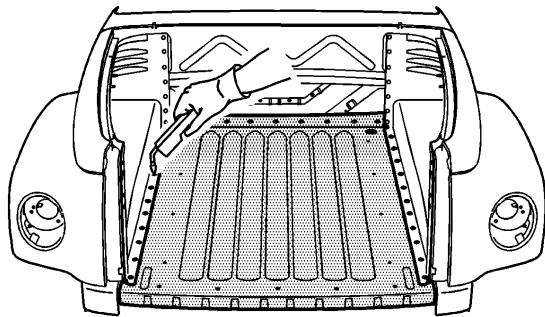
4. Using a cut-off wheel or equivalent, remove each marked corner from the front weld flange.



5. Drill 8 mm (5/16 in) plug weld holes along the weld flanges of the cross frame reinforcement as noted from the original panel.
6. Replace the structural adhesive with an additional plug weld between existing plug welds where necessary.
7. Prepare all mating surfaces as necessary.
8. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



9. Position the rear floor assembly. Align and inspect for proper positioning. Refer to Rear Compartment in [Dimensions - Body](#) .



10. Plug weld accordingly.
11. Install all related panels including the rear outer body panel and the #5 crossbar. Refer to [Panel Replacement - Body Rear Outer](#) and to [Cross Bar No.5 Replacement - Floor Panel](#) .
12. Clean and prepare all welded surfaces.
13. Apply the sealers and the anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.

Notice: Refer to [Fastener Notice](#) in Cautions and Notices.

14. Lower the body to the frame. Attach the mounting bolts that secures the body to the frame.

Tighten

Tighten the bolts to 140 N·m (103 lb ft).

15. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.

16. Install all related panels and components.

17. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.

18. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.