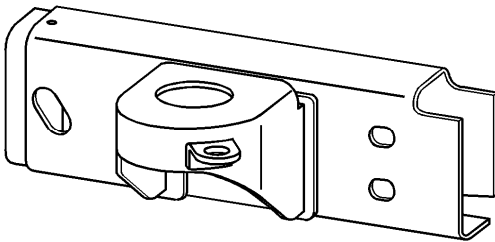
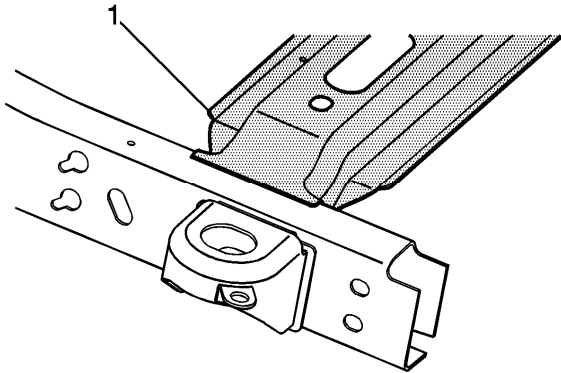


Rear Rail End Replacement

[Removal Procedure](#)



The service assembly for the left and the right rear frame rails is pre-sleeved, mild steel, hydro-formed parts. The assembly includes the body support mounting bracket, a trailer hitch and rear bumper mounting holes.

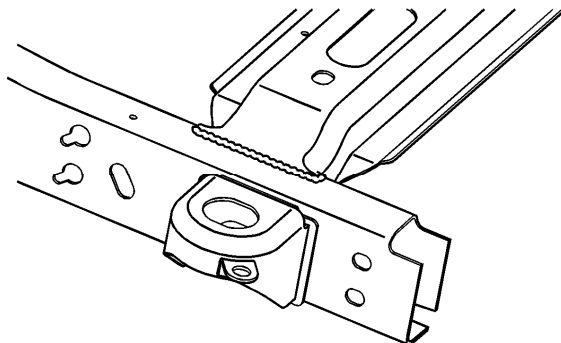


Important: The position of the rear cross-member (1) varies upon the wheel-base of the vehicle. This procedure applies to all vehicles.

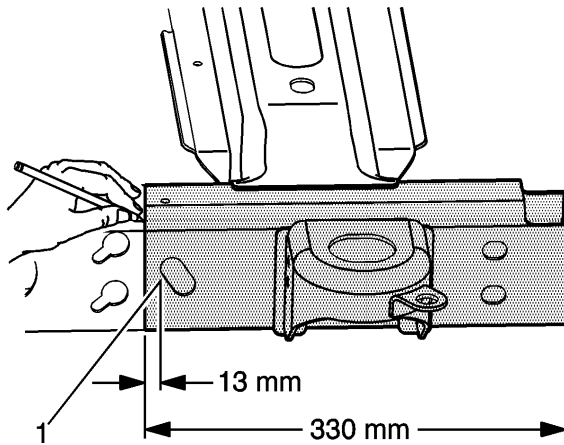
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

Caution: Refer to [Collision Sectioning Caution](#) in Cautions and Notices.

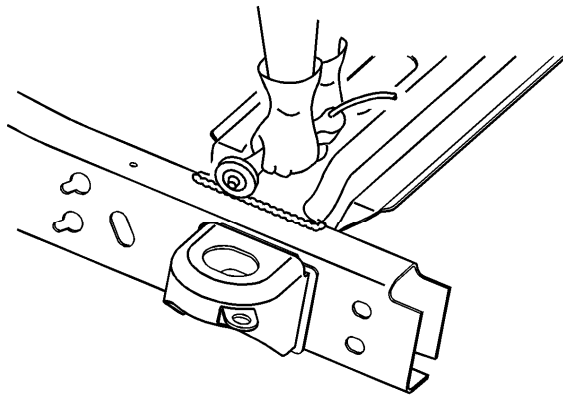
1. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.



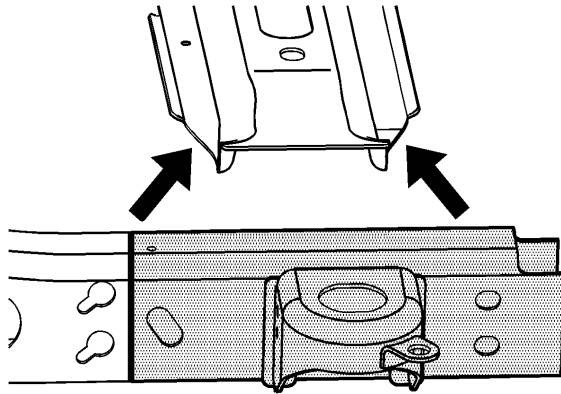
2. Remove all of the related panels and components.
3. Repair as much of the damage as possible to factory specifications.



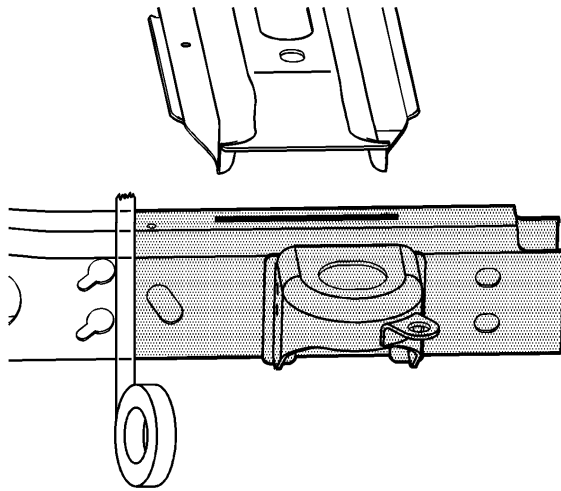
4. Locate the sectioning location by measuring 13 mm forward from the shipping slot (1) or 330 mm forward of the frame rail end. Scribe a line around the rail.



5. Using a cut-off wheel or equivalent, remove the weld which attaches the rear cross-member to the damaged frame rail.

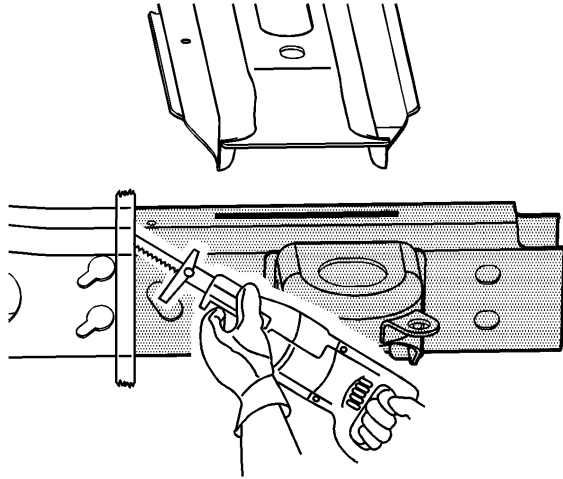


6. Move the cross-member clear of the damaged frame rail.

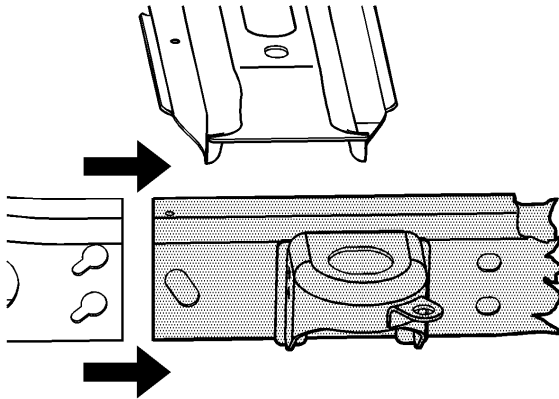


Important: Align the edge of the masking tape with the sectioning location.

7. Apply masking tape next to the sectioning location and around the frame as shown.

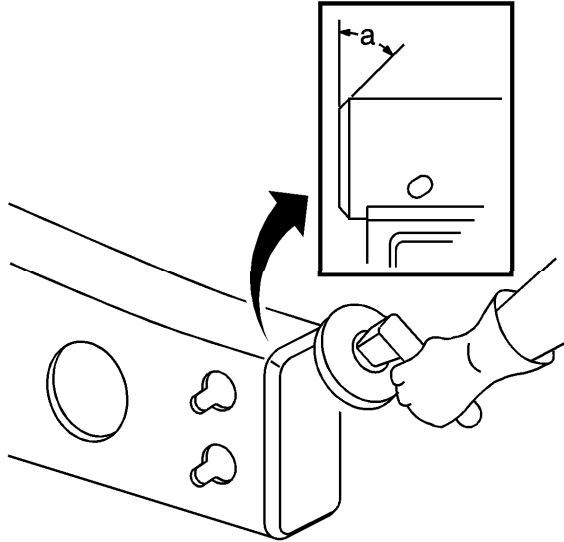


8. Cut the damaged frame rail along the sectioning location using a reciprocating saw or equivalent, as shown.

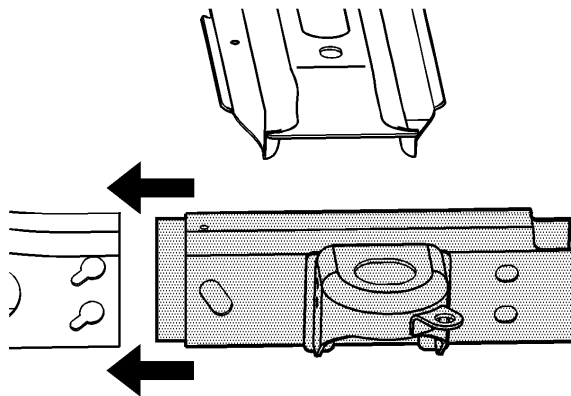


9. Remove the damaged frame section.

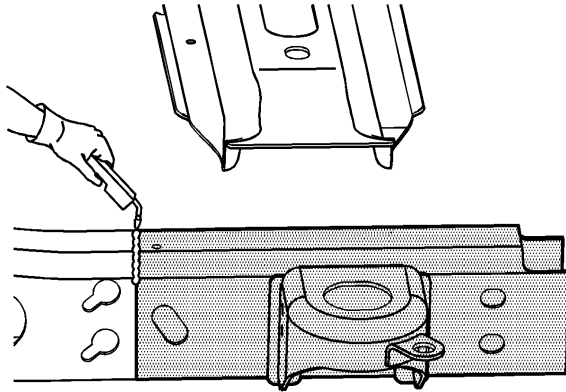
Installation Procedure



1. Grind the existing frame rail sectioning location to a 45 degree angle, as shown in the figure.
2. Prepare all of the attaching surfaces as necessary.

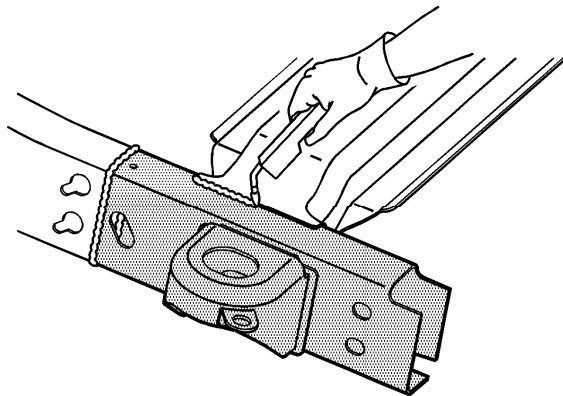


3. Position the service frame section to the existing frame and clamp in place.



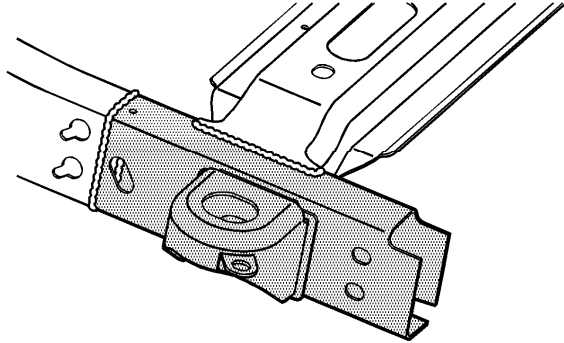
Important: Inspect the frame measurements three-dimensionally to ensure proper position of the service frame prior to welding.

4. Continuous-weld the sectioning location completely around the rail.
5. Lower and clamp the rear cross-member in place.



Important: Inspect the frame measurements three-dimensionally to ensure the proper position of the rear cross-member.

6. Continuous-weld the cross-member to the frame rail.



7. Clean and prepare all of the welded surfaces.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
9. Install all of the related panels and components.
10. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.