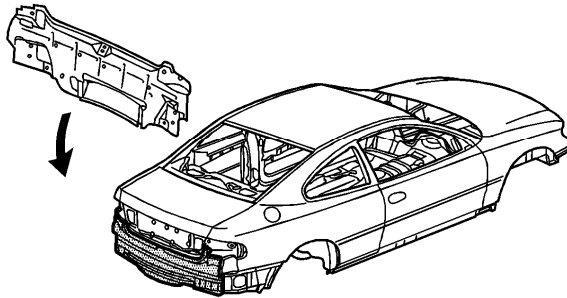


# Rear End Panel Replacement (Inner)

## Removal Procedure

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



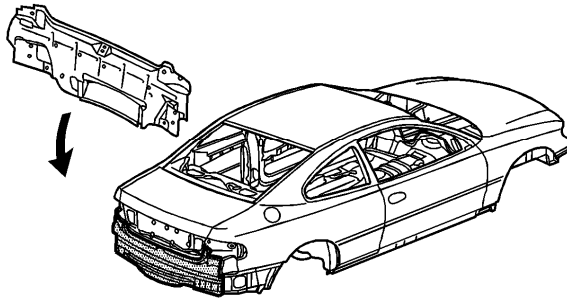
**Important:** This procedure describes the removal of the rear end panel outer and rear end panel inner together. As the panels are supplied individually, this procedure contains the replacement of the rear end panel inner only. Refer to [Rear End Panel Replacement](#) .

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.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .
5. Locate, mark and drill out the factory welds.
6. Remove the inner rear end panel from the vehicle.

**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/Coatings.

## Installation Procedure



1. Prepare the mating surfaces, as necessary. Inspect for proper fit of the service panel.
2. On the new panel, drill 8-mm (5/16-in) plug weld holes, as necessary, in the locations noted from the original panel.
- 3.
4. Position the service panel, check with 3-dimensional measuring equipment. Refer to [Dimensions - Body](#) .
5. Plug weld accordingly.
6. Install the rear end panel outer. Refer to [Rear End Panel Replacement](#) .
7. Clean and prepare all welded surfaces.
8. Apply the sealers and the anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
9. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint /Coatings.
10. Install all related panels and components.
11. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.

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