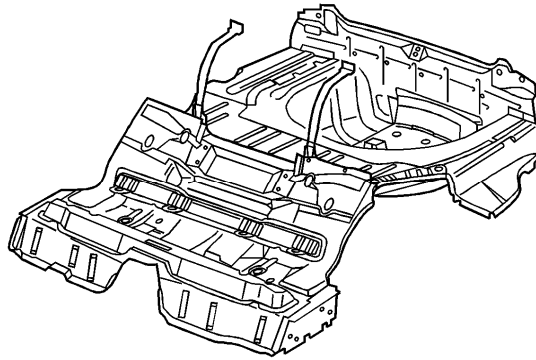


Rear Rail Replacement

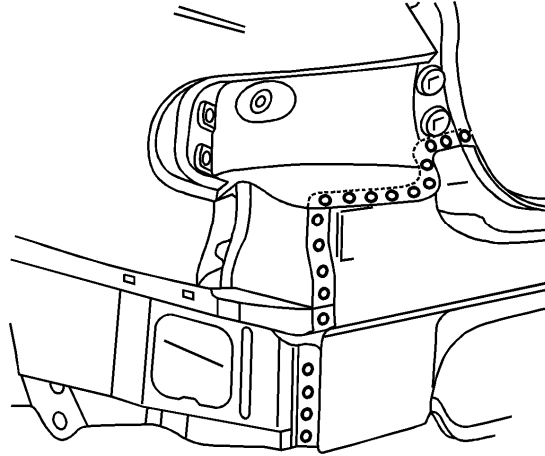
Removal Procedure

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

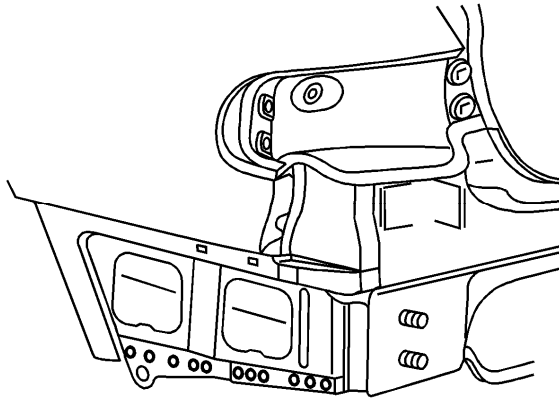


Important: The rear lower rails are supplied as a complete rear underbody assembly. This must be replaced as an assembly. Sectioning or single rail replacement is not allowed.

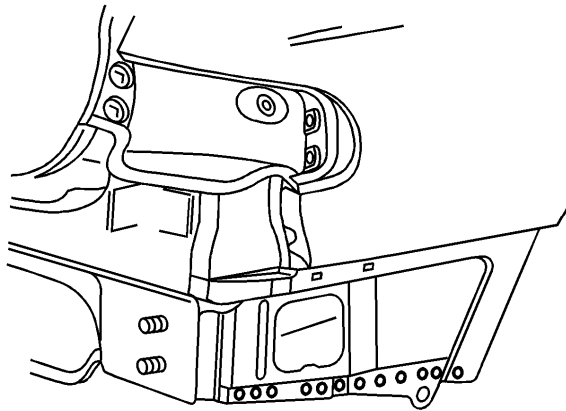
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
3. Remove the fuel tank. Refer to [Fuel Tank Replacement](#) in Engine Controls.
4. Remove all related panels and components.
5. Repair as much of the damage as possible to factory specifications.
6. 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.



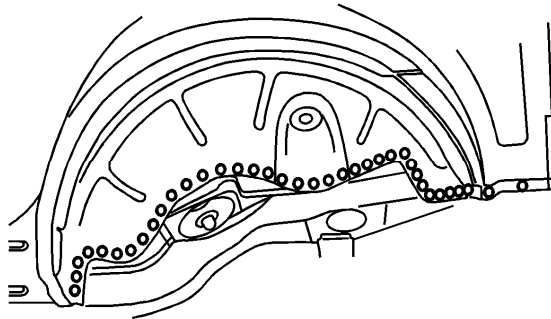
7. Locate, mark, and drill out all factory welds attaching the rear end panel assembly to the tail lamp housing, rear quarter panel and quarter panel lower extension.



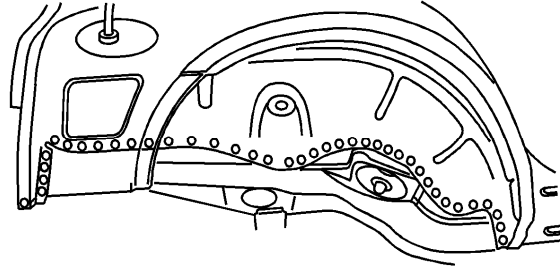
8. Locate, mark, and drill out all factory welds attaching the left rear quarter panel to the left quarter panel inner assembly and the left rear compartment floor panel outer extension.



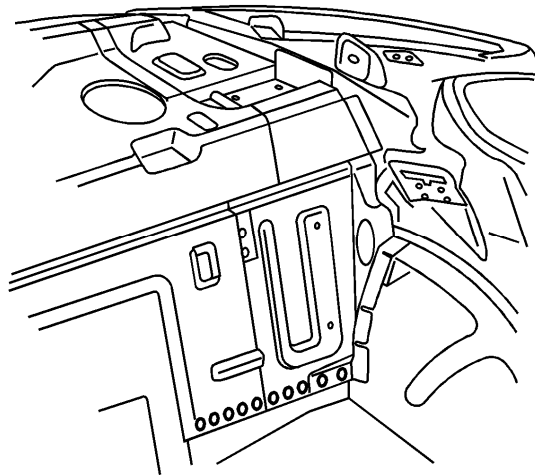
9. Locate, mark, and drill out all factory welds attaching the right rear quarter panel to the right quarter panel inner assembly and the right rear compartment floor panel outer extension.



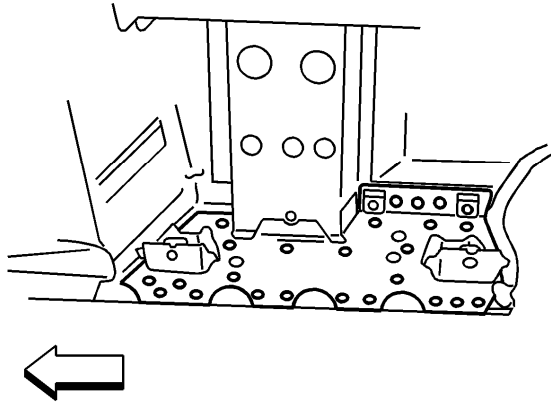
10. Locate, mark, and drill out all factory welds attaching the left rear inner wheelhouse panel assembly to the rear floor panel assembly and rear compartment floor panel assembly.



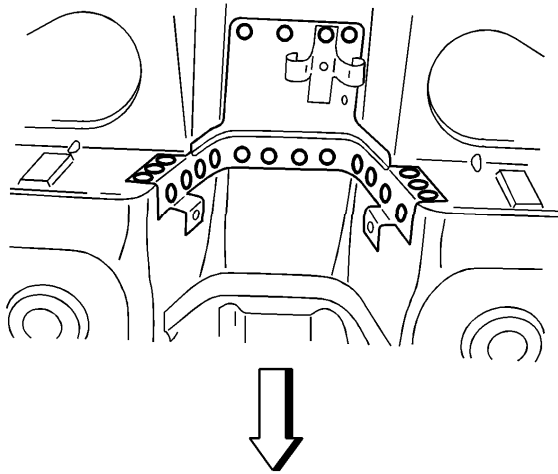
11. Locate, mark, and drill out all factory welds attaching the right rear inner wheelhouse panel assembly to the rear floor panel assembly and rear compartment floor panel assembly.



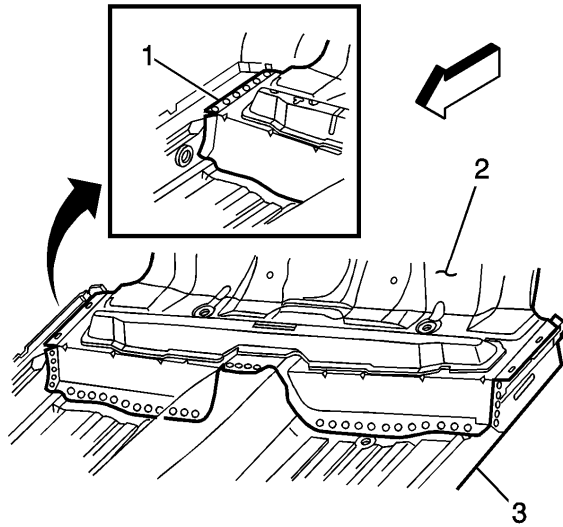
12. Locate, mark, and drill out all factory welds attaching the rear floor panel assembly to the rear window panel assembly and the rear seat back panel extension assembly.



13. Locate, mark, and drill out all factory welds attaching the rear floor panel outer extension to the inner rocker panel.

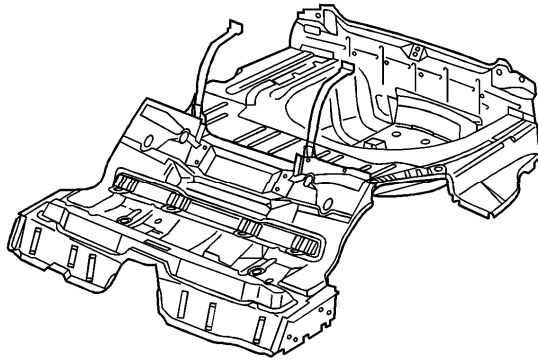


14. Locate, mark, and drill out all factory welds attaching the park brake cable bracket to the rear floor panel assembly.



15. Locate, mark, and drill out all factory welds attaching the front floor panel assembly (3) and the rear floor panel assembly (2).
16. Locate, mark, and drill out all factory welds attaching the rear floor panel assembly to the inner rocker panel (1) on each side.
17. Locate, mark and drill out all factory welds. Note the number and location of welds for installation of the service assembly.
18. Remove the damaged rear rail underbody assembly.

Installation Procedure



1. Clean and prepare the mating surfaces.
2. Verify for proper fit of the rear rail underbody assembly.
3. Drill 8-mm (5/16-in) plug weld holes on the service assembly, as necessary, in the locations noted from the original assembly.
4. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
5. Position the service assembly.
6. Verify the fit with 3 dimensional measuring equipment. Refer to [Dimensions - Body](#).
7. Plug weld accordingly with frequent measurements to ensure proper fit.
8. Clean and prepare all welded surfaces.
9. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
10. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint/Coatings.
11. Install all related panels and components.
12. Install the fuel tank. Refer to [Fuel Tank Replacement](#) in Engine Controls.
13. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
14. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.