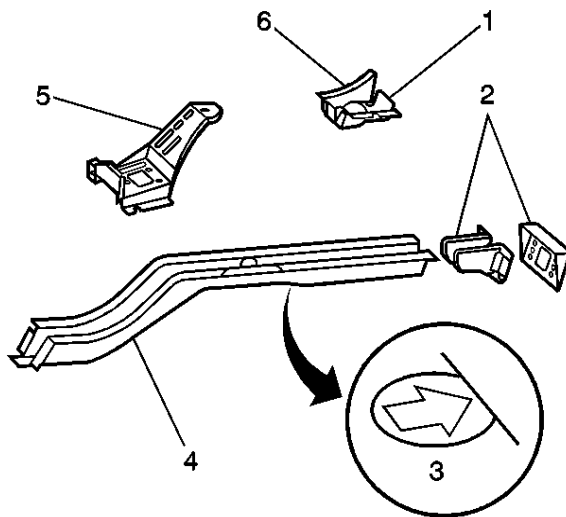


Rear Rail Replacement

Removal Procedure

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
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications.
5. 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.
6. Remove the rear end panel. Refer to [Rear End Panel Replacement](#) .
7. Remove the rear floor panel. Refer to [Floor Panel Replacement](#) .



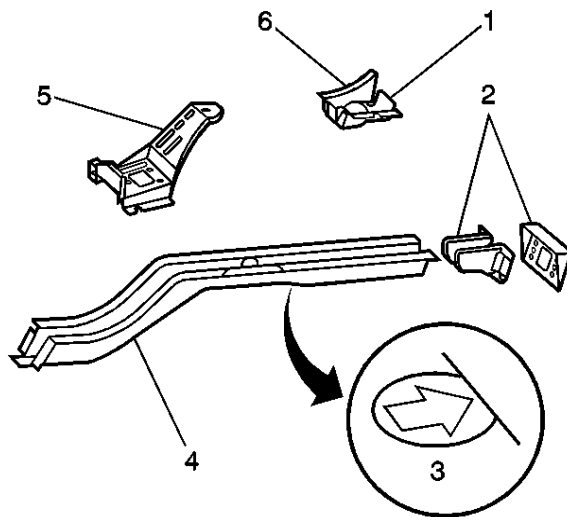
Important: Full rail replacement will require the removal of either the crossbar or an inner wheelhouse assembly. If sectioning is permitted, locate the diemark (3) on the lower surface of rail.

8. Locate, mark, and drill out all factory welds attaching the control arm mounting bracket (1) and the rear rail (4) to the vehicle.
9. The factory welds attaching the control arm mounting bracket weld flange (6) to the inner rocker panel must be drilled out from inside the vehicle.

Important: The corner of the floor panel above this area will need to be positioned out of the way (6) .

10. Locate, mark and drill out all factory welds. Note the number and location of welds for installation of the service assembly.
11. Remove the damaged rear rail assembly.

Installation Procedure



1. Clean and prepare the mating surfaces.
2. Verify for proper fit of the rear rail service 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 three-dimensional measuring equipment. Refer to [Dimensions - Body](#) .
7. Plug weld accordingly with frequent measurements to ensure proper fit.
8. Plug weld the control arm mounting bracket weld flange (6) to the inner rocker.

Important: Properly locate and drill the holes on the bumper mounting bracket (2). Use 3-dimensional measuring equipment.

9. Install the rear floor panel. Refer to [Floor Panel Replacement](#) .
10. Install the rear end panel. Refer to [Rear End Panel Replacement](#) .
11. Clean and prepare all welded surfaces.
12. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
13. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
14. Install all related panels and components.
15. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
16. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.