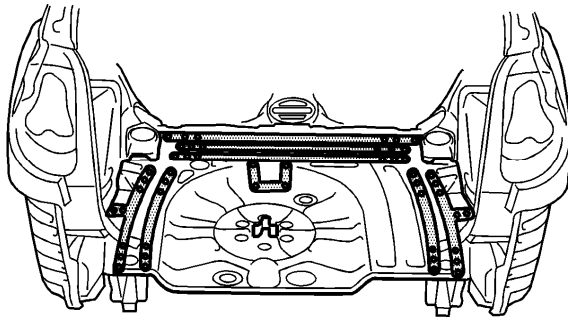


Rear Floor Replacement

Removal Procedure

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



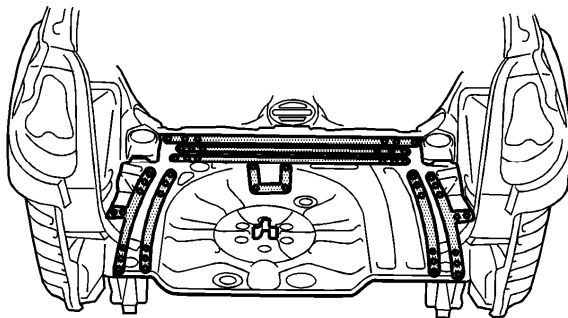
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory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

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

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/Coatings.

6. Note the number and location of welds for installation of the floor service assembly.
 7. Drill out all factory welds.
 8. Cut the damaged floor along the rear edge of the crossbar.
 9. Do not damage the following components:
 - The rear rails
 - The crossbar
 - The wheelhouse
12. Remove the damaged floor section.

Installation Procedure



1. Prepare the mating surfaces as necessary.
2. Check for proper fit.
3. Mark the location of the rear rail and crossbar flanges on the bottom of the floor service assembly.
4. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the original floor assembly.
5. Drill holes approximately 40 mm (1 in) apart where the new floor section attaches to the rear rail and crossbar flanges.
6. Position the service assembly and check for proper fit.

7. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces.
Refer to [Anti-Corrosion Treatment and Repair](#).
8. Plug weld accordingly.
9. Clean and prepare all welded surfaces.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
11. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint/Coatings.
12. Install all related panels and components.
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.