

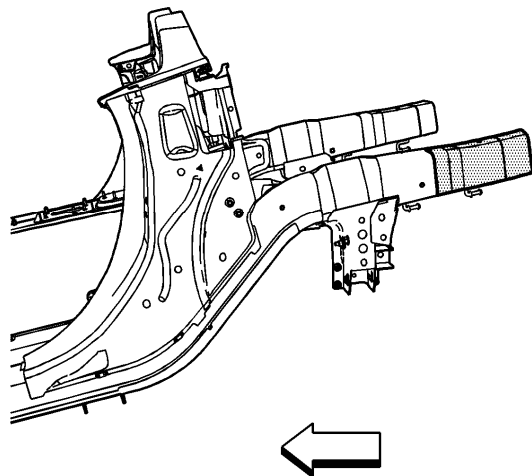
Rear Rail End Replacement

Removal Procedure

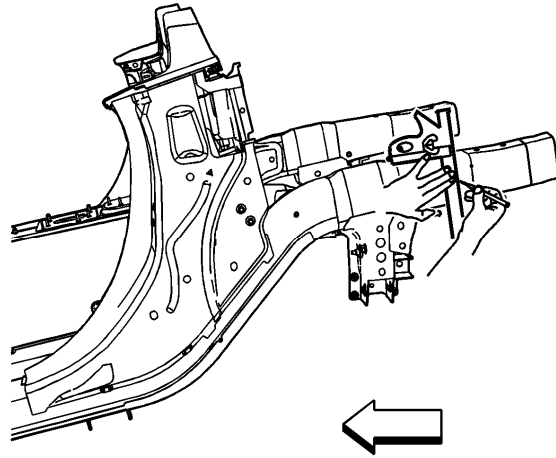
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) .
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
3. Remove all related panels and components.
4. Remove the rear impact bar. Refer to [Rear Bumper Impact Bar Replacement](#) .
5. Remove the rear compartment. Refer to [Rear Compartment Panel Replacement](#) .
6. Note the location and remove the sealers and anti-corrosion materials from the repair area. Refer to [Anti-Corrosion Treatment and Repair](#) .
7. Repair as much of the damage as possible to the factory specifications.

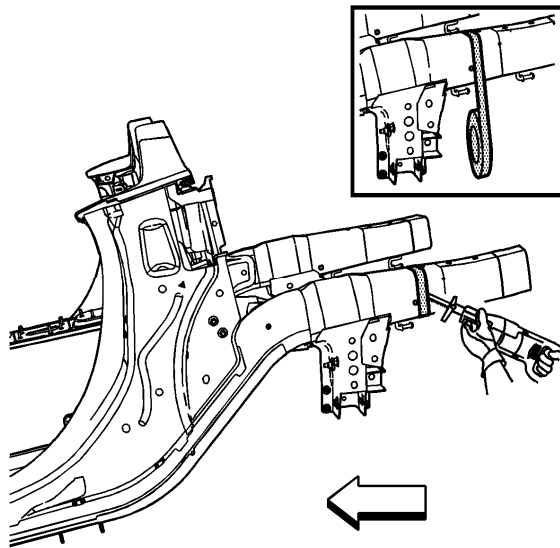
Caution: Refer to [Collision Sectioning Caution](#) in Cautions and Notices.



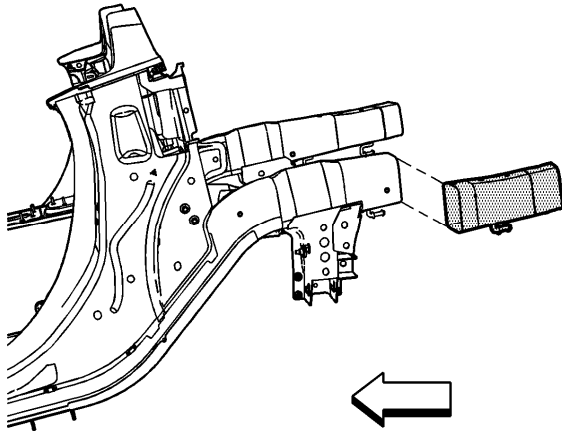
- Determine the sectioning joint location within the recommended area.



- Determine the sectioning joint location.
- Mark the top of the frame rail at the sectioning location.
- At the mark, align a sliding square or similar tool square to the surface to the vertical walls of the frame rail.
- Scribe a line to both sides of the frame rail.

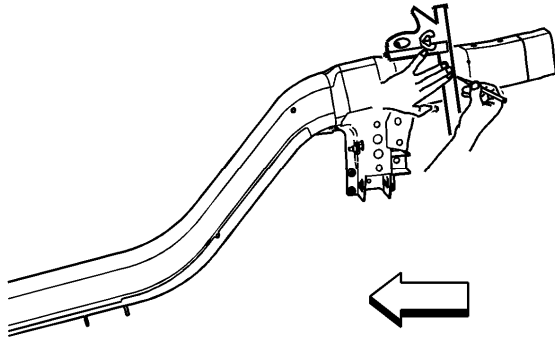


- Apply masking tape to the scribe line. Apply the tape completely around the frame rail.
- Use a reciprocating saw or equivalent tool to cut the frame rail at the rear edge of the tape line.

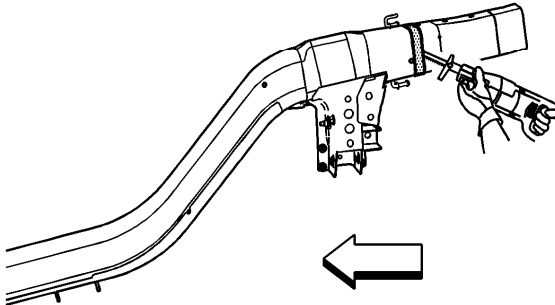
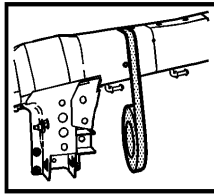


15. Remove the damaged frame rail end section.

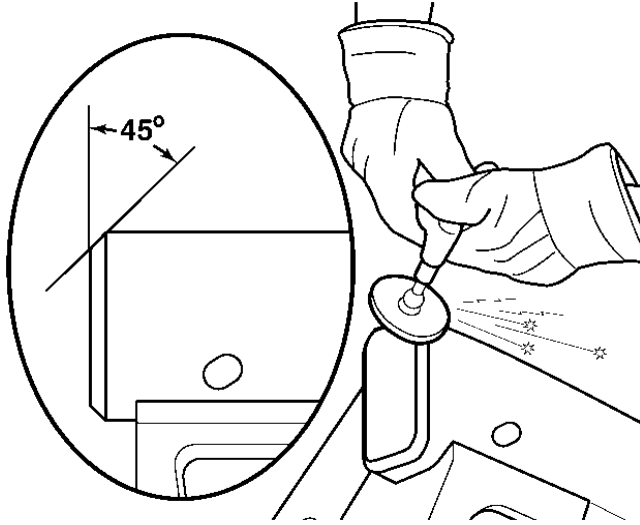
Installation Procedure



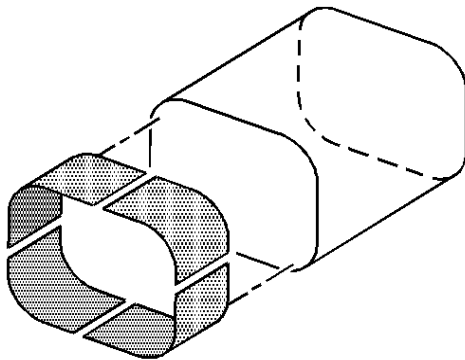
1. Determine the sectioning joint location from the new frame rail assembly



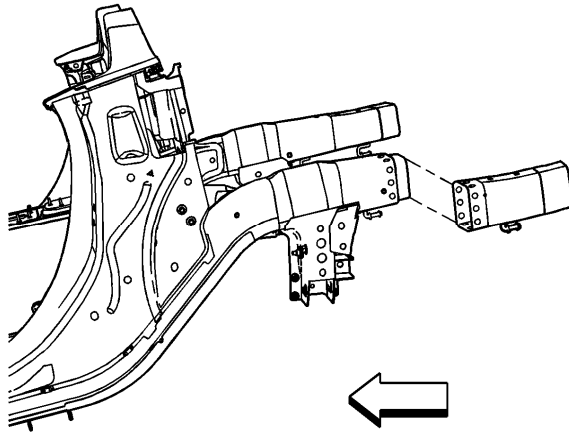
2. Cut the new frame rail end.



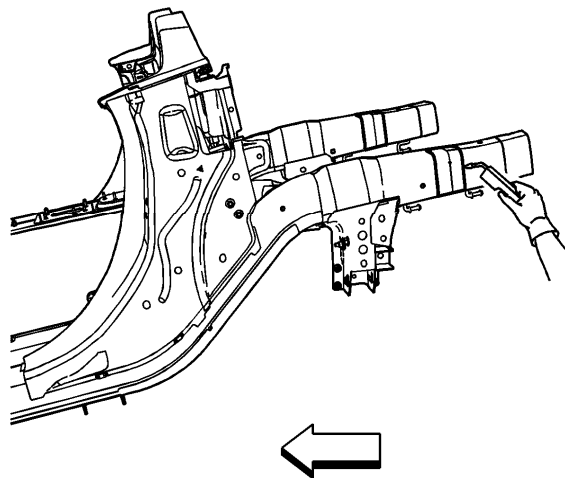
3. Grind the existing frame rail sectioning location to a 45 degree angle.
4. Clean and prepare all of the welded mating surfaces.
5. Apply GM-approved weld-thru coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



6. Make a 50-mm (2-in) weld backer sleeve. Refer to [Sleeved Butt Joint Repair](#) .



7. Position the service frame section to the existing frame.
8. Maintain a gap of 1 1/2 times the frame rail metal thickness at the sectioning joint. Clamp in place.
9. Inspect the frame measurements 3-dimensional to ensure proper position in the service frame.



Important: Use a 25 mm (1 in) stitch weld for minimal heat distortion.

10. Using a metal-inert gas (MIG) welder, weld completely around the sleeve joint.
11. Install the rear impact bar. Refer to [Rear Bumper Impact Bar Replacement](#) .
12. Install the rear compartment. Refer to [Rear Compartment Panel Replacement](#) .

13. Apply the sealers and anti-corrosion materials to the repair area. Refer to [Anti-Corrosion Treatment and Repair](#) .

Important: Do NOT top coat any bonding surface. Use primer only on bonding surfaces. Refer to the adhesive manufacturer's recommendations.

14. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
15. Install all related panels and components.
16. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
17. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .