

## Compartment Panel Frame Replacement - Rear

### Tools Required

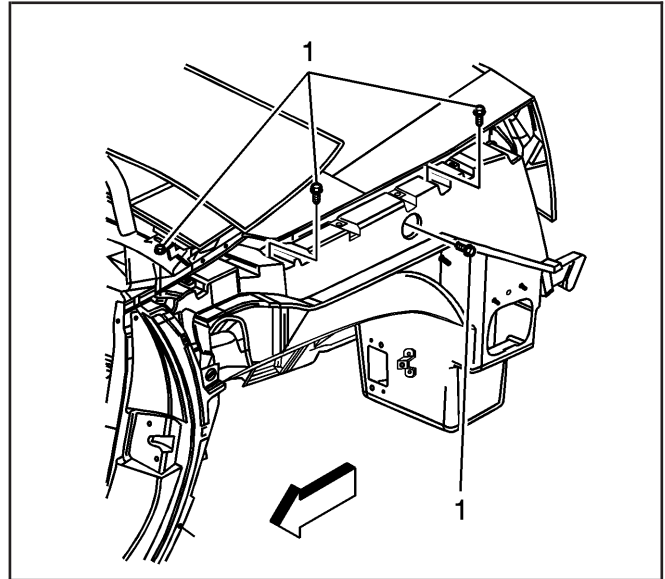
J 42058 Frame Adapter Clamp

### Removal Procedure

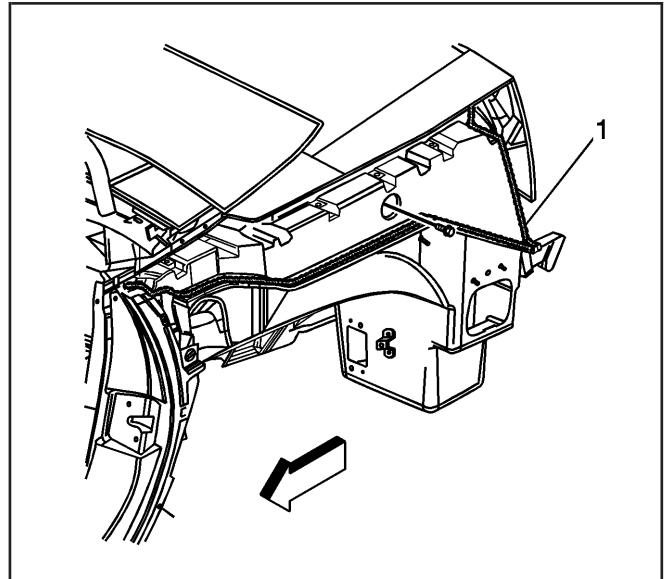
The rear compartment frame is made of Sheet Molding Compound (SMC), and is bonded to the rear structure with structural adhesive.

**Caution:** To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

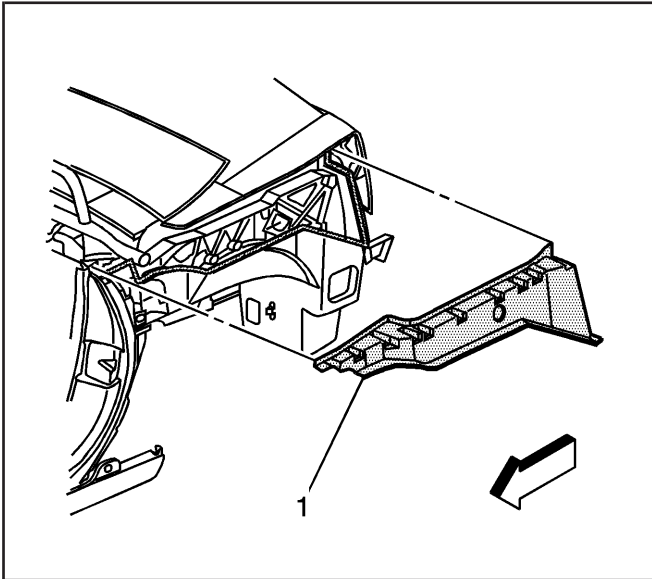
1. Disable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-66.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Remove the bolts (1) attaching the rear compartment frame to the rear compartment panel.
5. Remove the rear compartment frame by applying heat and pry to detach the adhesive along the bonding surface (1).



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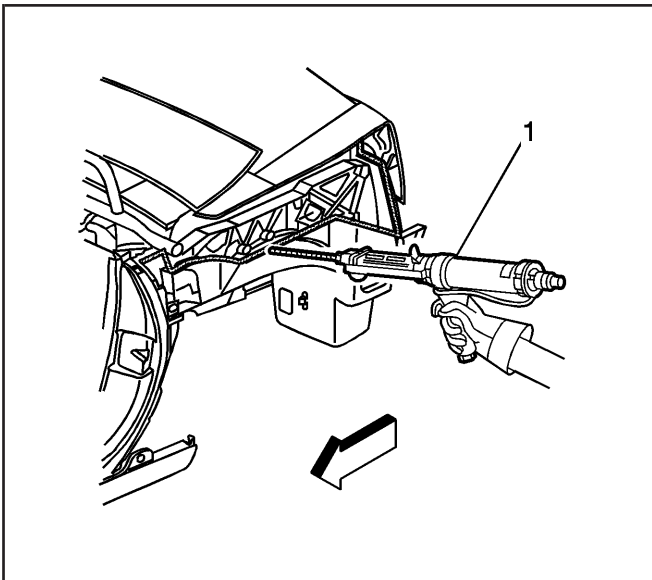


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6. Remove the rear compartment frame (1).
7. Note the location of the adhesive and remove all remaining loose adhesive.
8. Inspect the rear structure and frame rails for damage.
9. Repair as much of the damage as possible to the factory specifications. Refer to *Dimensions - Body* on page 2-2 and *Measurements - Underbody* on page 2-4.
10. Use J 42058 to secure the vehicle if pulling and straightening is required.



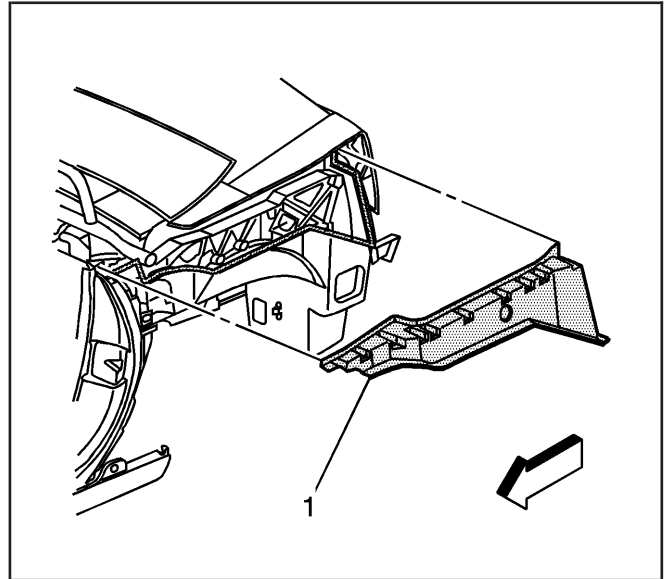
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### Installation Procedure

**Important:** Shims may be necessary to achieve proper panel alignment.

1. Before applying the adhesive, dry fit the rear end panel for proper fit and alignment.
2. Clean and prepare all bonding mating surfaces according to adhesive manufacturer's recommendations.
3. Apply a consistent bead of structural adhesive (1) 10 mm (3/8 in) in diameter to the rear structure to mate with the rear compartment frame. Refer to *Sheet Molded Compound (SMC) Panel Bonding* on page 2-56.

4. Install the rear compartment frame (1).
5. Apply pressure to the rear compartment frame to set the adhesive.



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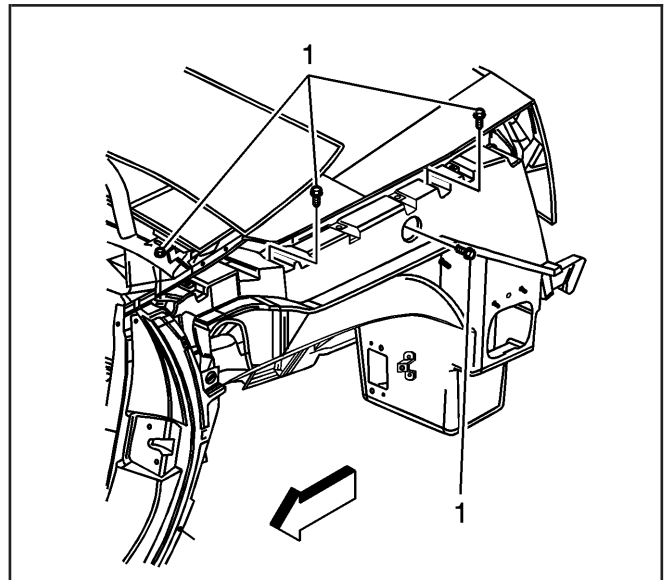
**Notice:** Use the correct fastener in the correct location. Replacement fasteners must be the correct part number for that application. Fasteners requiring replacement or fasteners requiring the use of thread locking compound or sealant are identified in the service procedure. Do not use paints, lubricants, or corrosion inhibitors on fasteners or fastener joint surfaces unless specified. These coatings affect fastener torque and joint clamping force and may damage the fastener. Use the correct tightening sequence and specifications when installing fasteners in order to avoid damage to parts and systems.

6. Hand tighten the bolts (1) that attach the rear compartment frame to the rear compartment panel.

**Tighten**

Tighten the bolts to 25 N·m (18 lb ft).

7. Clamp or mechanically fasten the rear compartment frame into place.
8. Remove any excess adhesive.
9. Install all related panels and components.
10. Connect the negative battery cable.
11. Enable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-66.



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