

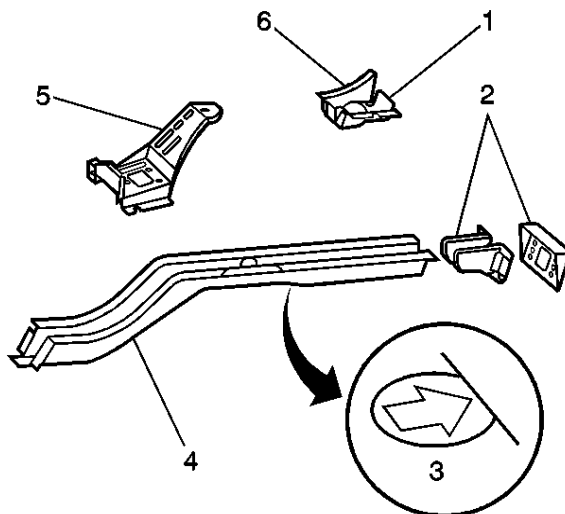
Rear Rail Replacement

Removal Procedure

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

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.

1. Remove all related panels and components including the rear suspension and seat.
2. Visually inspect and restore as much of the damage as possible to factory specifications.
3. Remove the following as necessary:
 - Sealers
 - Sound deadeners
 - Anti-corrosion materials

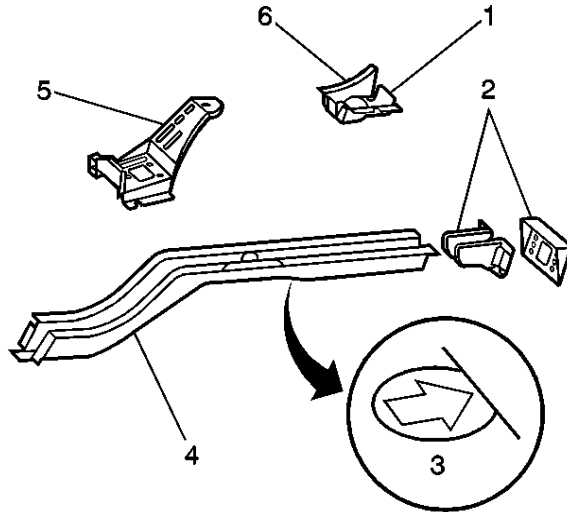


6. Locate, mark, and drill out all factory welds attaching the control arm mounting bracket (1) and the rear rail (4) to the vehicle.
7. The factory welds attaching the control arm mounting bracket weld flange (6) to the inner rocker panel must be drilled out from inside the vehicle.

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

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

Installation Procedure



1. Clean and prepare the mating surfaces.
2. Check 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. Position the service assembly.
5. Check fit with 3-dimensional measuring equipment.
6. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
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.
9. Reposition the floor panel into its original location.
10. Weld as necessary.

Important: The bumper mounting bracket (2) holes must be properly located and drilled. Use 3-dimensional measuring equipment.

11. Clean and prepare all welded surfaces.

Important: Prior to refinishing, refer to GM 4901MD-99 Refinish Manual for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

12. Prime with 2-part catalyzed primer.
13. Apply sealers and anti-corrosion materials as necessary.
14. Apply sound deadening materials to restore sound deadening quality as manufactured.
15. Install all related panels and components.

