

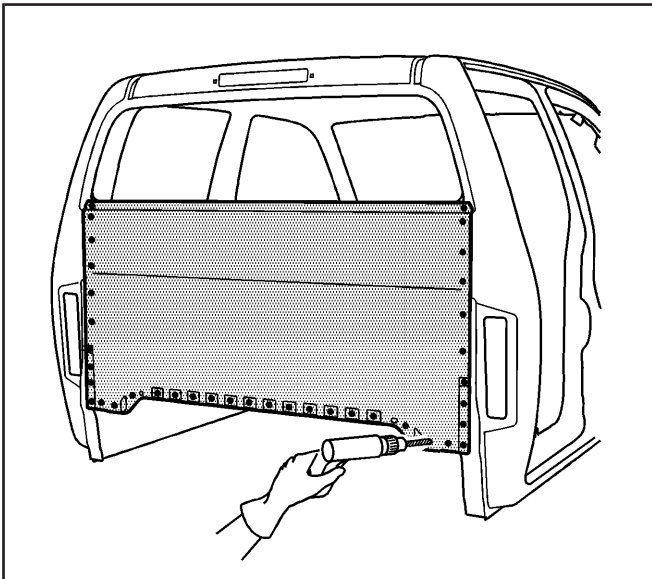
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Panel Replacement - Rear End

Removal Procedure

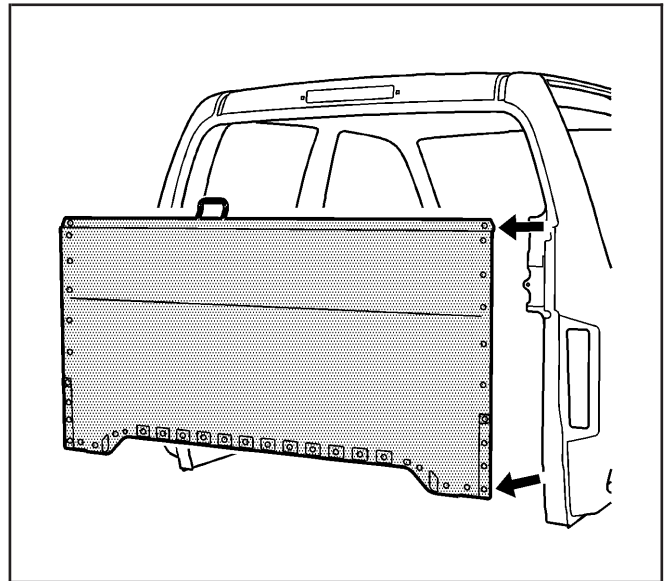
Caution: To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves,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

1. Disable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-81.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to *Dimensions - Body* on page 2-2.
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* on page 1-5 in General Information.
6. Locate and drill out all factory welds. Note the number and location of welds for installation of the service part.



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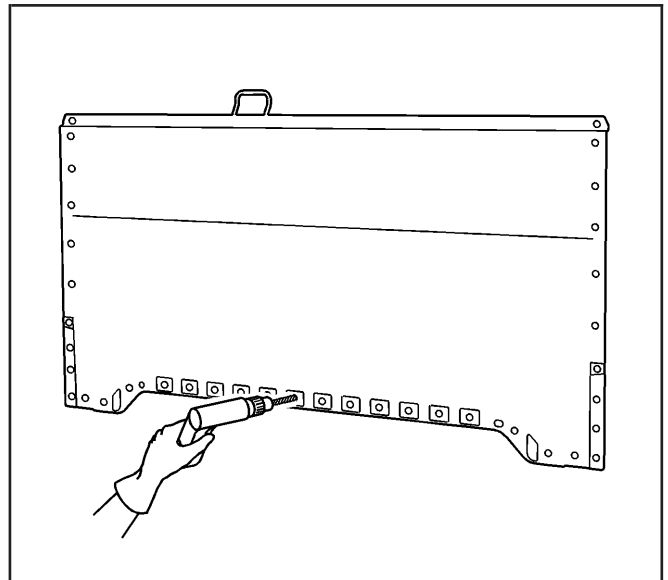
7. Remove the damaged rear end panel.



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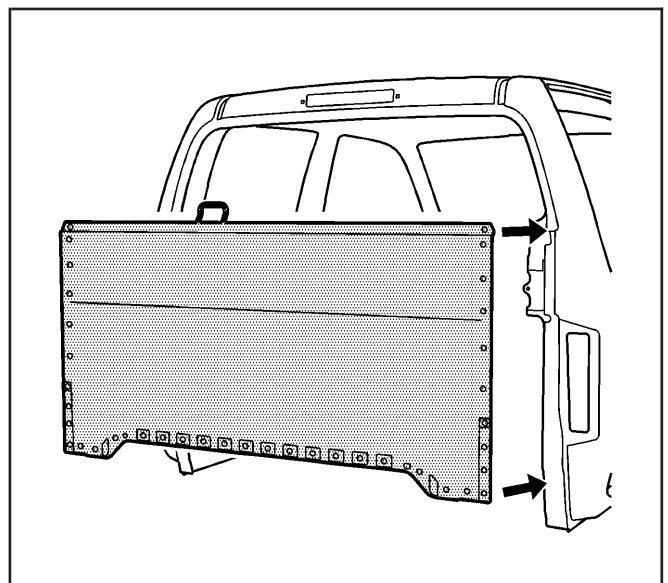
Installation Procedure

1. Prepare the mating surfaces as necessary. Inspect for proper fit of the service panel.
2. On the new panel, drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the original panel.
3. Apply 3M[®] Weld-Thru coating P/N 05916 or equivalent to all mating surfaces.

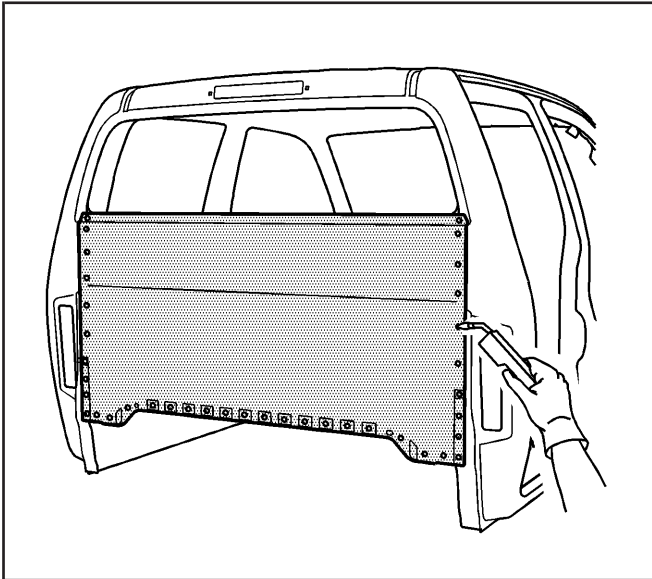


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4. Position the service panel. Inspect with 3-dimensional measuring equipment.

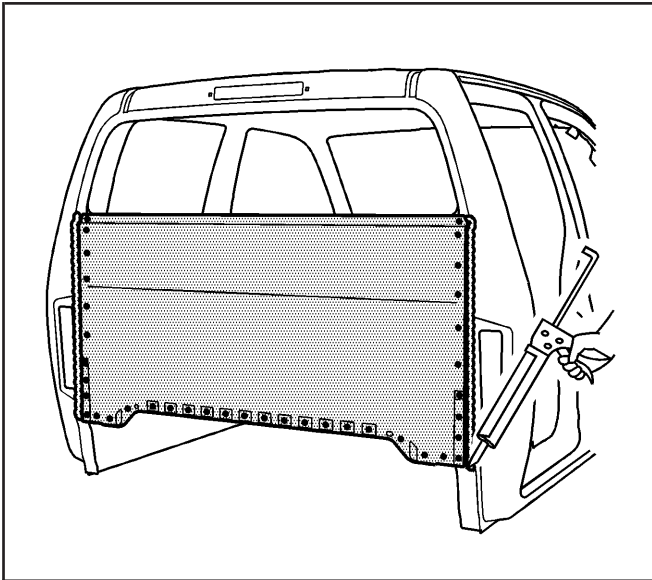


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5. Plug weld accordingly.
6. Clean and prepare all welded surfaces.



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7. Apply the sealers and the anti-corrosion materials to the repair area, as necessary. Refer to *Anti-Corrosion Treatment and Repair* on page 1-5 in General Information.
8. Paint the repair area. Refer to *Basecoat/Clearcoat Paint Systems* on page 1-7 in General Information.
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 2-81.