

13. Rear End Panel Assembly

The rear end panel is supplied as a complete assembly. Quarter panel extensions attach to the outside corners of the rear end panel. Service for all of these panels is performed at factory seams (figure 13-1).

Rear End Panel Service Procedure

Remove or Disconnect

1. Remove all related panels and components.
2. Visually inspect and restore as much of the damage as possible to factory specifications.
3. Remove sealers and anti-corrosion materials as necessary.
4. Locate, mark and drill out all factory welds. Note the number and location of welds for installation of the service panel.
5. Remove the damaged rear panel.

Install or Connect

1. Prepare mating surfaces and check for proper fit of the service panel.
2. On the new panel, drill 8mm ($\frac{5}{16}$ inch) plug weld holes as necessary in the locations noted from the original panel.
3. Position the service panel, check fit using three-dimensional measuring equipment, and plug weld accordingly with frequent measurements to ensure proper fit.
4. Clean and prepare welded surfaces. Prime with two-part catalyzed primer. Apply sealers and anti-corrosion protection materials, as necessary. Do not combine paint systems. Refer to paint manufacturer's recommendations.
5. Install all related panels and components.

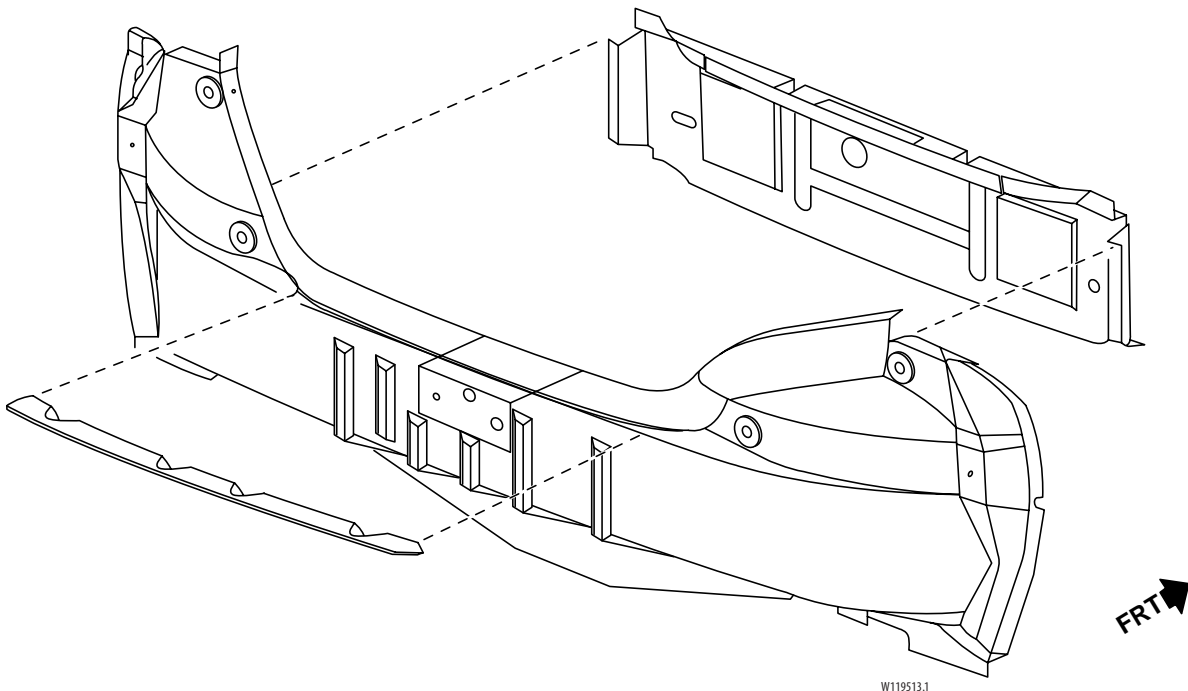


Figure 13-1:
Rear End Panel Assembly