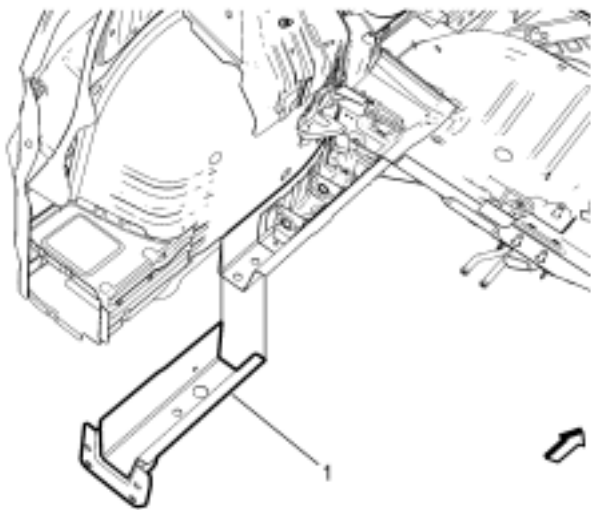
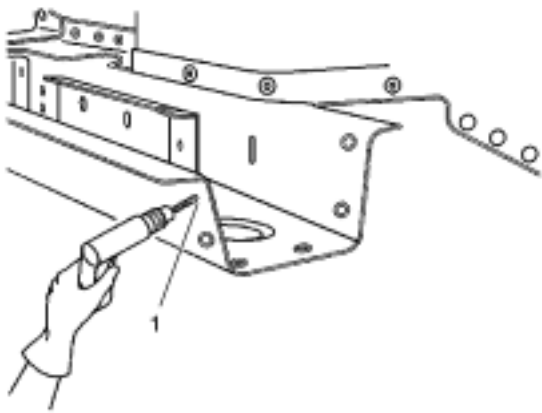


9. Drill all factory welds (1). Note the number and location of welds for installation of the service assembly.



10. Remove the damaged rear side rail (1).



11. Drill two **8mm (5/16 in)** plug weld holes on each of the 3 sides of the rear rail (1). Position the center of the holes **10mm (3/8 in)** from the cut edge.

Installation Procedure

1. Locate the original cutting line on the service part rear rail.
2. Align a sliding square or similar tool to the original cutting line and scribe a line across the rail.
3. Use the same tool to transfer this scribed line onto the sides and the weld flanges of the rail.
4. Place a mark forward, **25mm (1 in)** from the scribed line on all 3 sides of the service rail.
5. Use the tool to scribe a line on all 3 sides and weld flanges of the rail.