

Rear Compartment Floor Panel Sectioning (MIG-Brazing)

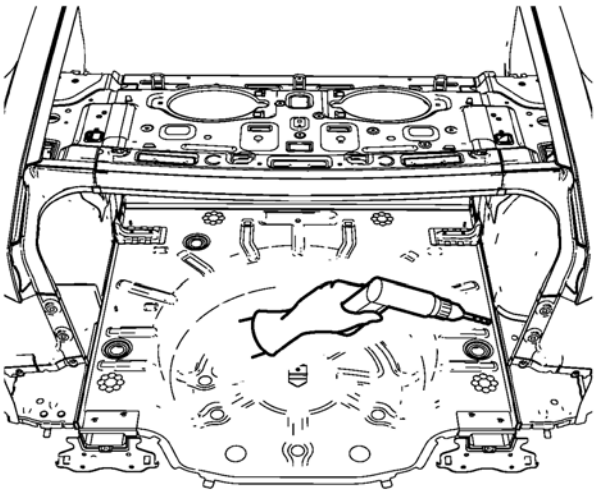
Note: According to different corrosion warranties, only the regional mandatory joining methods are allowed.

Removal Procedure

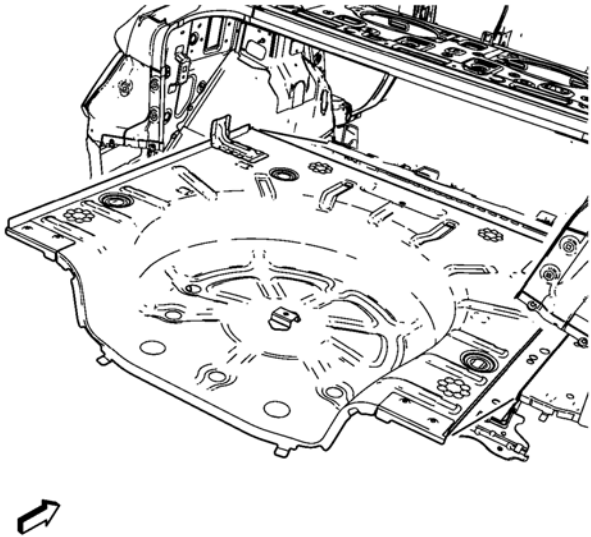
Warning: Refer to [Approved Equipment for Collision Repair Warning](#) in the Preface section.

Warning: Refer to [Glass and Sheet Metal Handling Warning](#) in the Preface section.

1. Disable the SIR System. Refer to [SIR Disabling and Enabling](#).
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
3. Remove all related panels and components.
4. Visually inspect the damage. Repair as much of the damage as possible.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).



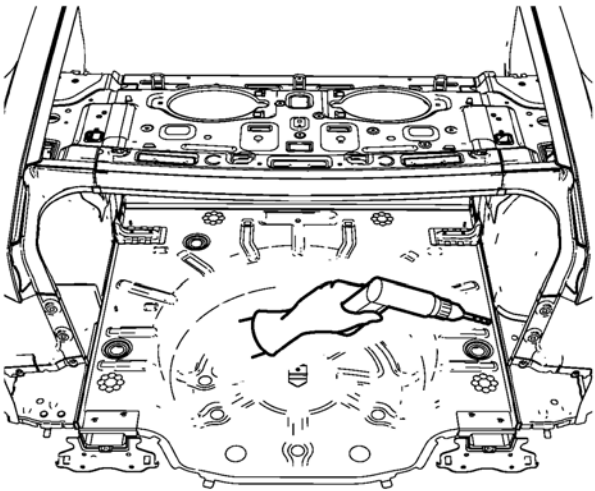
6. Locate and mark all the necessary factory welds of the rear compartment floor panel.
7. Note the number and location of weld studs for installation of the service assembly.
8. Drill all factory welds.



9. Remove the damaged rear compartment floor panel.

Installation Procedure

1. Align the rear compartment floor panel.



2. Drill 4 mm (3/16 in) for rivets along the edges of the rear compartment floor were you cant apply a resistance spot welder.