

## Underbody Rear Side Rail Reinforcement Replacement (MIG-Brazing)

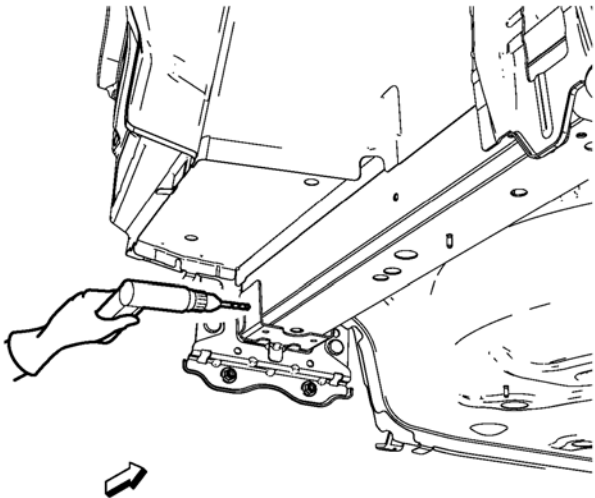
**Note:** According to different corrosion warranties, only the regional mandatory joining methods are allowed.

### 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.

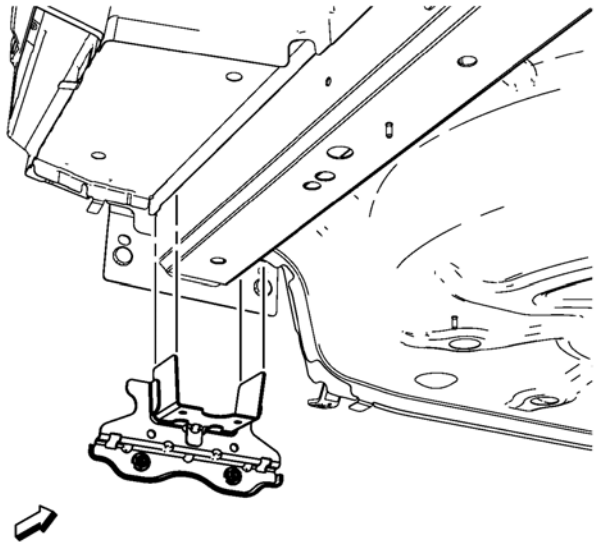
1. Disable the SIR System. Refer to [SIR Disabling and Enabling](#).
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
3. Remove all related panels and components.
4. Visually inspect the damage. Repair as much of the damage as possible.
5. Remove 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 end panel plate.

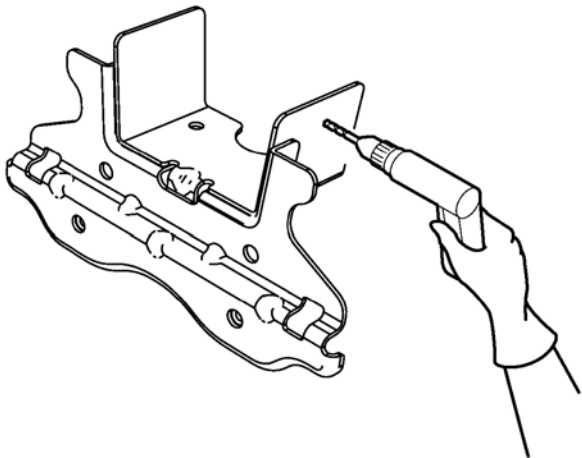
**Note:** Note the number and location of welds for installation of the service assembly.

7. Drill all factory welds.



8. Remove the underbody rear side rail reinforcement.

### Installation Procedure



1. Create 8 24 mm (5/16 x 15/16 in) slots for MIG-brazing along the edges of the underbody rear side rail reinforcement as noted from