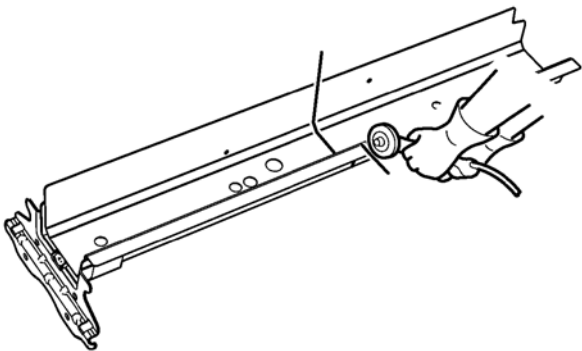
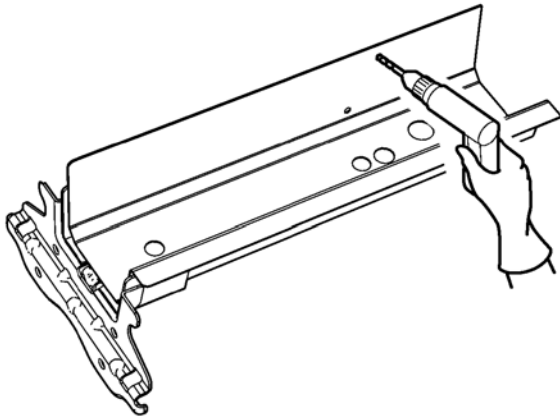


10. Remove the damaged rear side rail.

Installation Procedure



1. Cut the rear side rail in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
2. Create a 50 mm (2 in) backing plate from the unused portion of the service part.
3. Drill 8 mm (5/16 in) along the sectioning cut on the remaining original part. Locate these holes 13 mm (1/2 in) from the edge of part and spaced 40 mm (1½ in) apart.
4. Prepare all mating surfaces as necessary.
5. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.
6. Align the rear side rail.



7. Drill 8 mm (5/1 in) for plug welding along the edges of the rear side rail as noted from the original panel.
8. Clean and prepare the attaching surfaces for welding.