

Rear Panel Replacement

1. Remove the related parts.

- Rear bumper
- Rear bumper upper beam
- Trunk lid lock and its attachments
- Other related parts
- Rear and side trim panels
- Taillights

2. Pull out and straighten the damaged area.

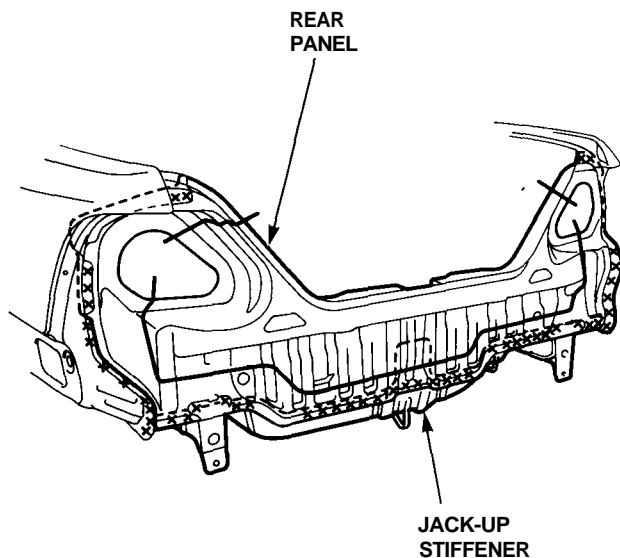
- Pull out the related rear side inner panel, rear floor, rear side frame and other damaged parts with the frame straightener.
- Attach the car to the frame straightener by tightening the underbody clamps located at the jack-up points on the bottom of the side sill and the side sill side flanges.

3. Cut and pry off the rear panel.

- Cut along the bold line shown with a gas cutter or an air chisel and remove the rear panel.
- Center punch around the spot weld imprints with the rear side outer panel and rear floor.
- Drill holes using the spot cutter.

NOTE: Be careful not to let holes penetrate through to the rear floor.

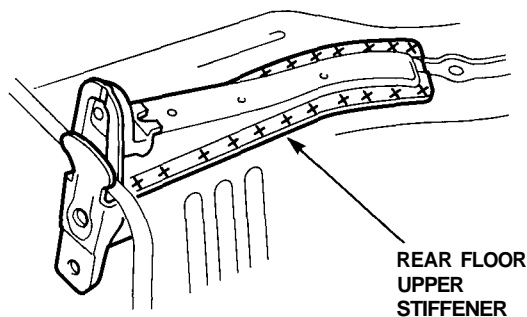
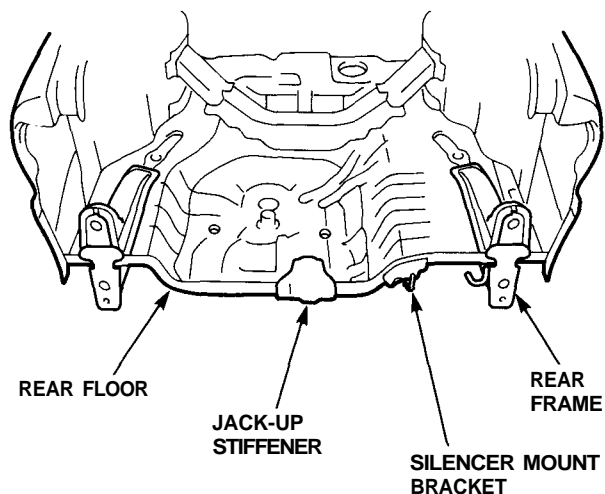
- Remove weld flange with a chisel.



4. Mold the related parts.

- Repair the rear floor upper stiffener if necessary.
- Repair all cracks, holes or other defects by MIG or gas welding.

⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.



5. Set the new rear panel.

- Paint the inside of the panel with the body color.
- See Paint Repair section.

⚠ WARNING

- Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.
 - Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
 - Paint is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.
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- Remove the undercoat from the welding section of the panel and expose the steel plate using a disc sander.

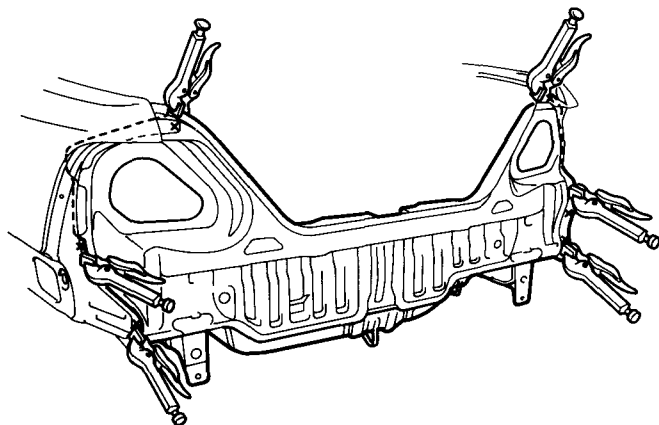
⚠ WARNING

To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

- Install the new rear panel and clamp it with vise-grips.

NOTE: Apply the spot sealer to the welding surface when spot welding.

- Check the rear panel position using the body dimensional drawings (see [section 6](#)).



6. Tack weld the rear panel.

- Weld the clamped sections for temporary installation.

⚠ WARNING

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7. Open and close the trunk lid to check for proper installation.

NOTE: Make sure the trunk lid or tailgate locks securely.

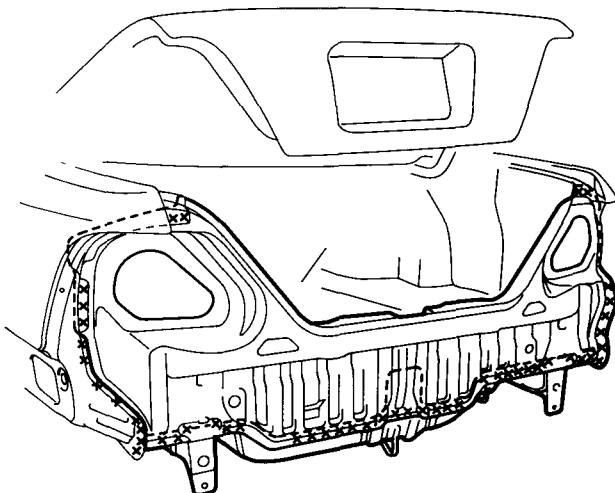
Position the rear panel in its correct position with the rear bumper and taillight installed.

8. Perform the main welding.

⚠ WARNING

To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Make 20% to 30% more spot welds than there were holes drilled.



(cont'd)

Rear Panel

Replacement (cont'd)

9. Finish the welding areas.

- Level the welded areas with a disc sander, then even out high areas with a hammer. Be careful not to deform them.

⚠ WARNING

To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

- Even out the spot welded flange area with a hammer and dolly.

10. Apply the sealer (see [section 5](#)).

- Apply sealer to the rear side outer joint and around the taillight areas of the rear panel.
- Apply sealer to the rear panel and rear floor joint.

11. Apply the paint.

See Paint Repair section.

⚠ WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.**

12. Apply anti-rust agent (see [section 7](#)).

- Apply agent to the outer panel, rear panel and rear floor joint.
- Apply agent to the inside of the jack-up stiffener.

13. Install the related parts.

Install in the reverse order in which they were removed.

14. Inspect, check, and clean.

- Adjust the clearance with the trunk lid, then adjust the level difference and fit. Check operation.
- Test for leaks in the trunk compartment.
- Clean the trunk floor.