Rear Compartment Floor Panel Sectioning
Removal Procedure

**Warning:** Refer to Approved Equipment for Collision Repair Warning.

**Warning:** Refer to Foam Sound Deadeners Warning.

**Warning:** Refer to Battery Disconnect Warning.

**Note:** The upper flanges of the rear compartment floor panel are trapped between the rear lower frame rail and rear frame rail upper reinforcement, on both sides of the panel. This procedure describes how to perform a partial replacement of the rear compartment floor panel, by creating a 25 mm (1 in) flange on both sides of the original panel and should be used when the rear frame rail and frame rail reinforcement do not require replacement. Complete panel replacement can be done when the rear frame rails, or frame rail reinforcements have been removed.

1. Disable the SIR system and then disconnect the negative battery cable. Refer to SIR Disabling and Enabling.
2. Remove all related panels and components.
3. Repair as much of the damage as possible. Refer to Dimensions - Body.
4. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
5. Remove the body rear end panel (1). Refer to Body Rear End Panel Replacement.

6. Apply a 25 mm (1 in) wide piece of masking tape to the rear compartment panel along the top side of the panel, below the rear frame rail upper extension, on both sides (1).

7. Create a 25 mm (1 in) weld flange on both sides of the floor panel, to attach the replacement panel. Cut along the bottom of the tape, below the rear frame rail upper reinforcement (1).

**Note:** Do not damage any inner panels or reinforcements.

8. Cut the rear compartment panel, vertically at the forward corners, leaving two 25 mm (1 in) flanges to attach the replacement floor.
Note: Record the number and location of welds for installation of the service assembly.

9. Locate, mark, and remove the factory weld along the forward edge of the rear floor panel.
10. Remove the damaged rear compartment panel from the vehicle.

Installation Procedure

Note: To create the service part to fit properly, the upper edge of the replacement floor panel will need to be removed on both sides.
1. Cut the top flange off of the rear compartment panel replacement part, along the sides only (1). This will create a 25 mm (1 in) overlap joint to fit over the flange that was left from the original panel.

2. Clean and prepare all welding surfaces (1). Place 8 mm (5/16 in) holes 40 mm (1 1/2 in) apart along the sides of the panel that will overlap the flanges left from the original panel, to MIG plug weld the replacement part.

3. Install and align the service part as necessary.

4. Weld the service part along the front edge, at the original weld locations (1).
5. MIG plug weld on the sides of the replacement part, along the 25 mm (1 in) overlap joint (1).
6. Replace the body rear end panel. Refer to Body Rear End Panel Replacement.
7. Clean and prepare all welded surfaces.

**Note:** Apply sealer along the top edge of the 25 mm (1 in) overlap joint, where the rear compartment panel was sectioned.

8. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
10. Install all related panels and components.
11. Enable the SIR system and then connect the battery negative cable. Refer to SIR Disabling and Enabling.

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