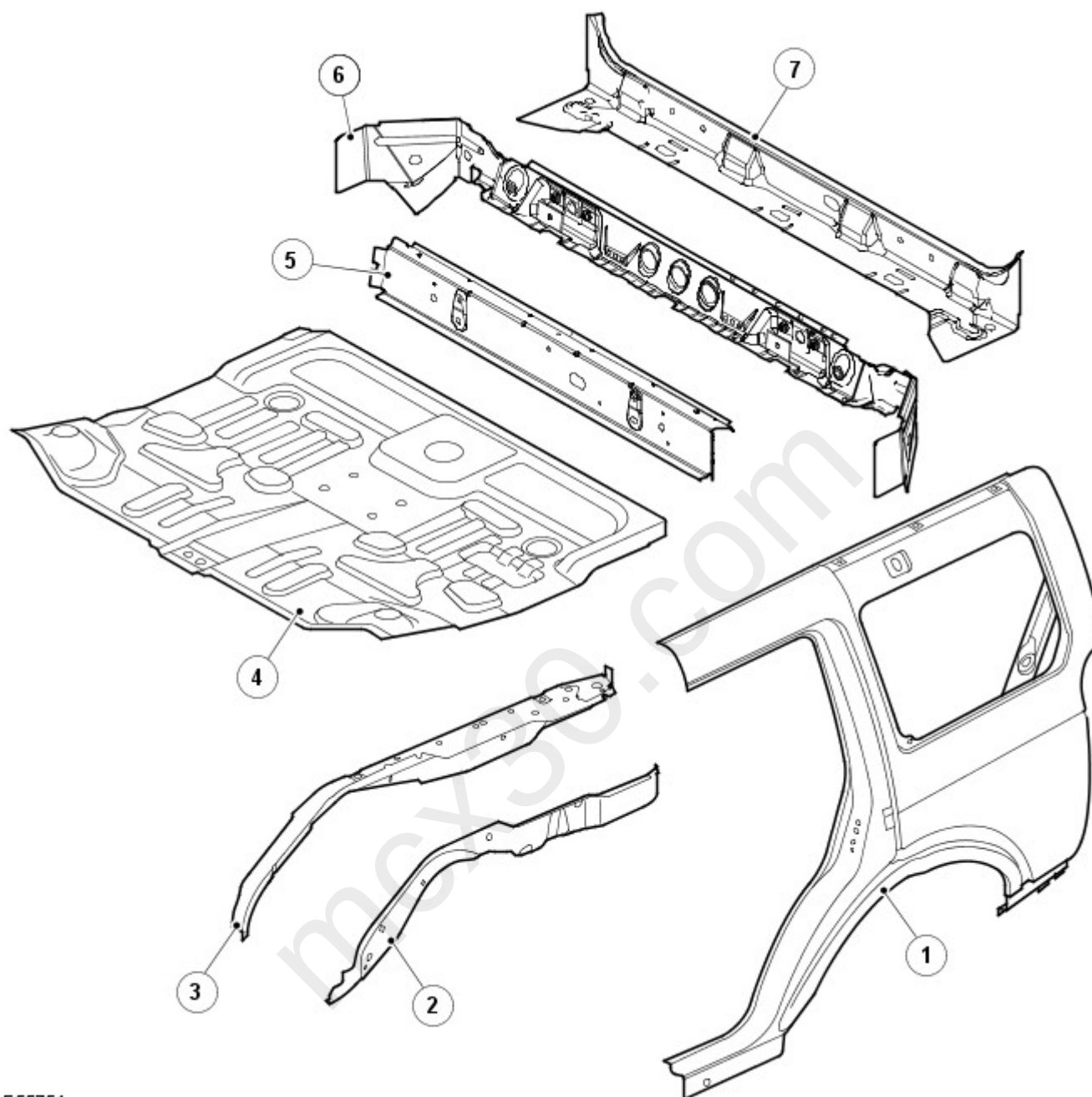


Rear End Sheet Metal Repairs - Rear End Sheet Metal

Description and Operation

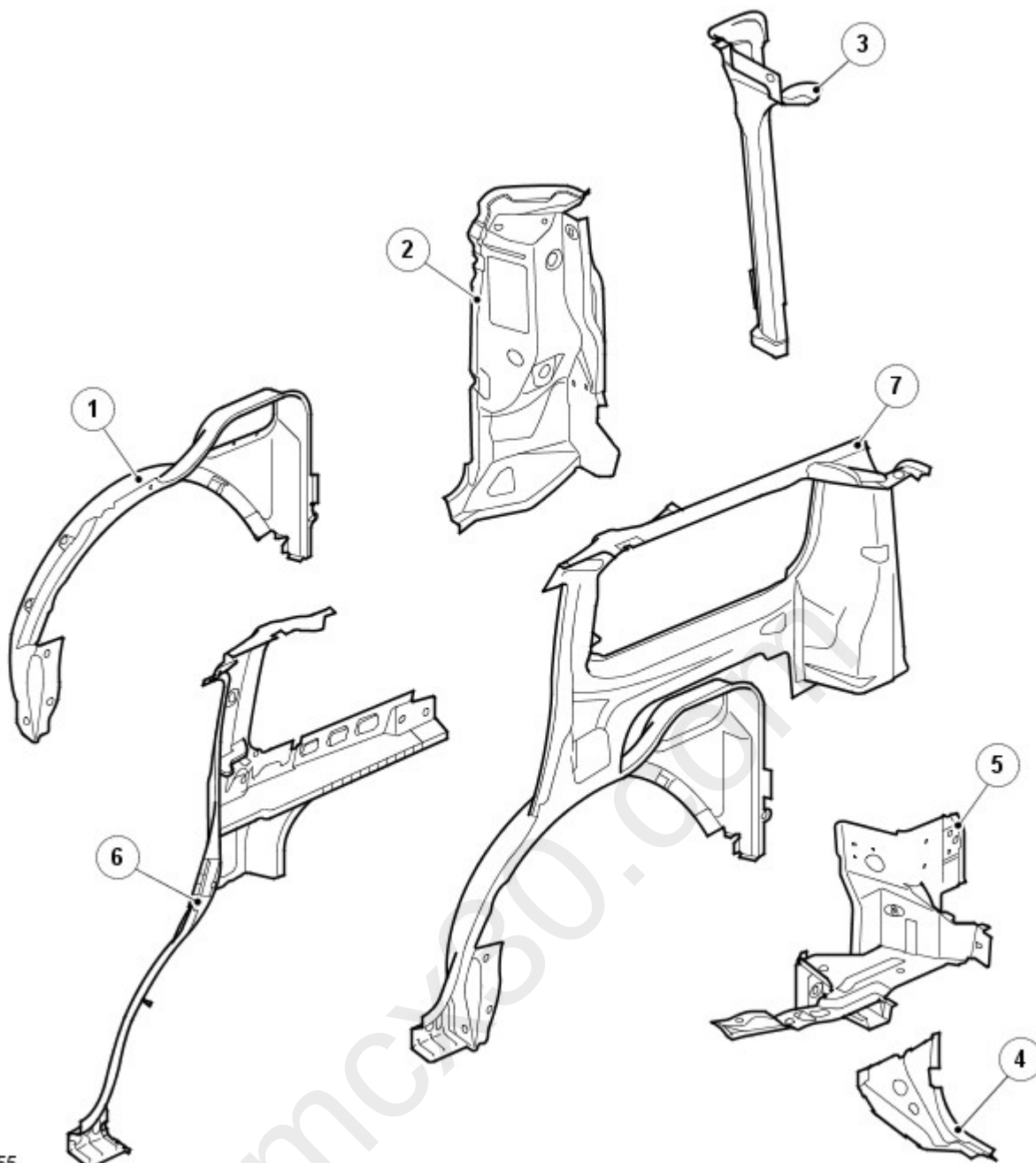
Rear end service panels



E55754

Item	Description	Service part No
1	Quarter panel outer	R/H ALA780100 L/H ALA780110
2	Rear side member	R/H AGA780021 L/H AGA780031
3	Rear side member	R/H AFD780080 L/H AFD780090
4	Rear floor panel	AFD780010
5	Rear crossmember	AQA780050
6	Rear panel reinforcement	AQR780080
7	Rear panel outer	AQA780030

Rear end service panels



E55755

Item	Description	Service part No
1	Rear wheelhouse outer	R/H ALK780100 L/H ALK780110
2	Rear lamp mounting panel	R/H AME780320 L/H AME780330
3	Water drain panel	R/H AME780300 L/H AME780310
4	D-pillar closing panel	R/H AFF780060 L/H AFF780070
5	D-pillar inner lower panel assembly	R/H AGY780060 L/H AGY780070
6	Inner quarter panel	R/H ALR780220 L/H ALR780230
7	Inner quarter panel/side panel rear section	R/H ALJ780120 L/H ALJ780130

Time sechedules, front end

The following information shows the total time taken to replace single panels and complete assemblies. This time includes removal of Mechanical, Electrical and Trim (MET) items, plus paint times based on Metallic Clear Over Base Paint.

The times shown were generated by Thatcham (the motor insurance repair and research centre) and are to be used as a guide only.

Single panel times

Panel Description	Petrol	Diesel
Liftgate	9.0	9.0

Panel Description	Petrol	Diesel
Tailgate	6.7	6.7
Quarter panel L/H	23.4	23.4
Quarter panel R/H	23.7	23.7

Combination panel replacement times

The following panel combination times show the total time to remove/refit body panels, MET items and any paint process.

Combination panel times

Panel Description	Petrol	Diesel
Rear bumper		
D-Pillar closing panel L/H and R/H		
Rear lamp panel		
Rear crossmember		
Rear panel		
Quarter panel		
Tailgate		
Total Time	L/H 35.6 R/H 35.9	L/H 35.6 R/H 35.9

Combination panel times

Panel Description	Petrol	Diesel
Rear bumper		
D-Pillar closing panel L/H and R/H		
Rear lamp panel L/H and R/H		
Rear panel		
Rear crossmember		
Tailgate		
Quarter panel L/H and R/H		
Total Time	62.1	62.1

Combination panel times

Panel Description	Petrol	Diesel
Body off integraed frame		
Rear floor panel section		
Rear bumper		
Rear side member section		
D-Pillar closing panel		
D-Pillar inner lower panel assembly		
Rear lamp panel		
Rear panel		
Rear crossmember		
Tailgate		
Quarter panel		
Total Time	L/H 64.1 R/H 64.3	L/H 64.3 R/H 64.5

Combination panel times

Panel Description	Petrol	Diesel
Body off integraed frame		
Rear floor panel section		
Rear bumper		
Rear side member section L/H and R/H		
D-Pillar closing panel L/H and R/H		
D-Pillar inner lower panel assembly L/H and R/H		
Rear lamp panel L/H and R/H		
Rear panel		
Rear crossmember		
Tailgate		
Quarter panel L/H and R/H		
Total Time	87.4	87.6

Combination panel times

Panel Description	Petrol	Diesel
Rear bumper		
D-Pillar closing panel		
D-Pillar inner lower panel assembly		
Rear lamp panel		
Rear panel		
Rear crossmember		
Tailgate		
Quarter panel		
Total Time	48.7	48.7

Combination panel times

Panel Description	Petrol	Diesel
Rear bumper		
Rear lamp panel		
Rear panel		
Rear crossmember		

Panel Description	Petrol	Diesel
D Pillar closing panel L/H and R/H		
Tailgate		
Total Time	27.1	27.1

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Rear End Sheet Metal Repairs - Quarter Panel

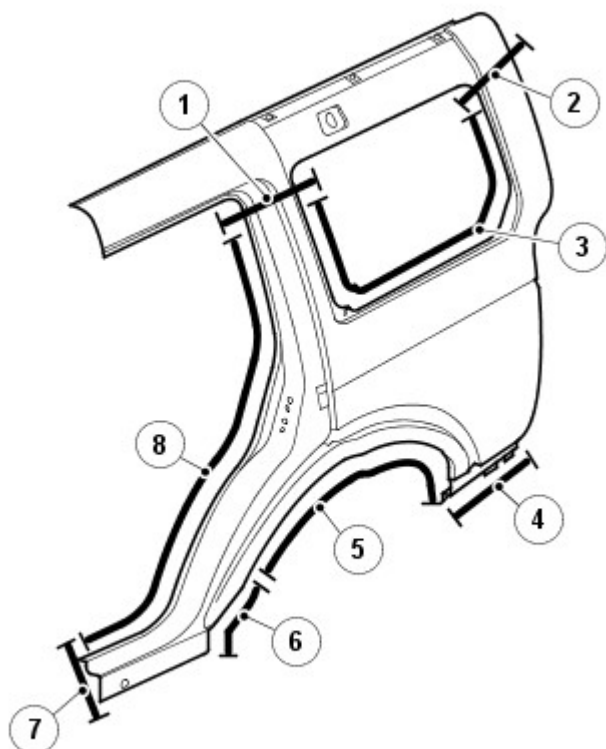
Removal and Installation

Removal

1. Load vehicle onto ramp.
2. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
3. Remove the rear wheel and tire.
4. Remove the rear bumper cover.
For additional information, refer to: [Rear Bumper Cover](#) (501-19 Bumpers, Removal and Installation).
5. Remove the forced air extraction grille.
6. R/H side: Remove fuel tank.
For additional information, refer to: [Fuel Tank](#) (310-01A Fuel Tank and Lines - TDV6 2.7L Diesel, Removal and Installation).
7. R/H side: Remove the fuel tank filler pipe.
For additional information, refer to: [Fuel Tank Filler Pipe](#) (310-01C Fuel Tank and Lines - 2.7L Diesel, Removal and Installation).
8. R/H side: Remove the fuel filler interlock catch.
For additional information, refer to: [Fuel Filler Interlock Catch](#) (501-03 Body Closures, Removal and Installation).
9. Remove the headliner.
For additional information, refer to: [Headliner](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
10. Remove the rear seat.
For additional information, refer to: [Rear Seat - Vehicles With: 60/40 Split Seat](#) (501-10 Seating, Removal and Installation).
11. Remove the C-pillar side impact sensor.
For additional information, refer to: [C-Pillar Side Impact Sensor](#) (501-20B Supplemental Restraint System, Removal and Installation).
12. Remove the side air curtain module.
For additional information, refer to: [Side Air Curtain Module](#) (501-20B Supplemental Restraint System, Removal and Installation).
13. Remove the rear quarter window glass.
For additional information, refer to: [Rear Quarter Window Glass](#) (501-11 Glass, Frames and Mechanisms, Removal and Installation).
14. Remove the rocker panel finisher.
15. Remove the exhaust heatshield.
16. Remove the tailgate latch.
For additional information, refer to: [Tailgate Latch](#) (501-14 Handles, Locks, Latches and Entry Systems, Removal and Installation).
17. Remove the tailgate weatherstrip.
18. With assistance remove the tailgate.
19. Remove the load space trims.
20. Remove the load space carpets.
21. Release the wiring harness.

22.

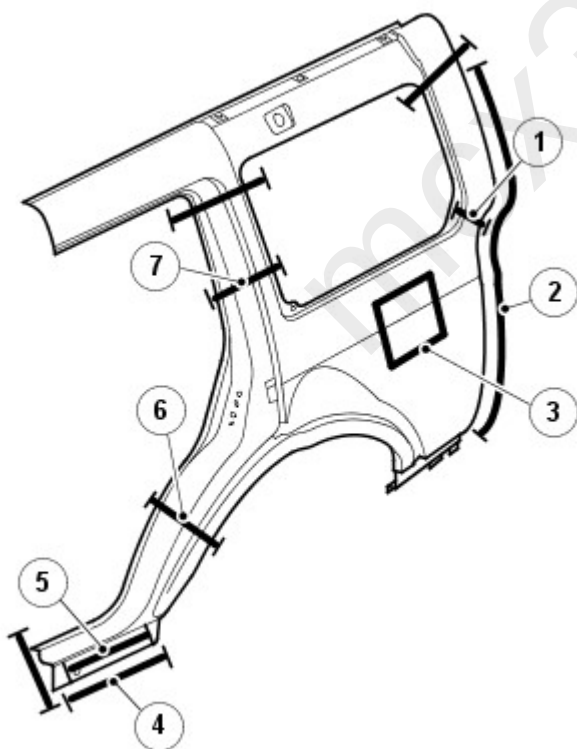
Item	Part Number	Description
1	-	Butt weld.
2	-	Butt weld.
3	-	50 spot welds.
4	-	5 spot welds.
5	-	40 spot welds.
6	-	9 spot welds.
7	-	Butt weld.
8	-	40 spot welds.



E56609

23.

Item	Part Number	Description
1	-	Acoustic seal.
2	-	16 plug welds.
3	-	Acoustic seal R/H.
4	-	7 plug welds.
5	-	3 plug welds.
6	-	Acoustic seal.
7	-	Acoustic seal.



E57109

24. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#)
(501-25A Body Repairs - General Information, Description and Operation).

- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.

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Rear End Sheet Metal Repairs - Inner Quarter Panel

Removal and Installation

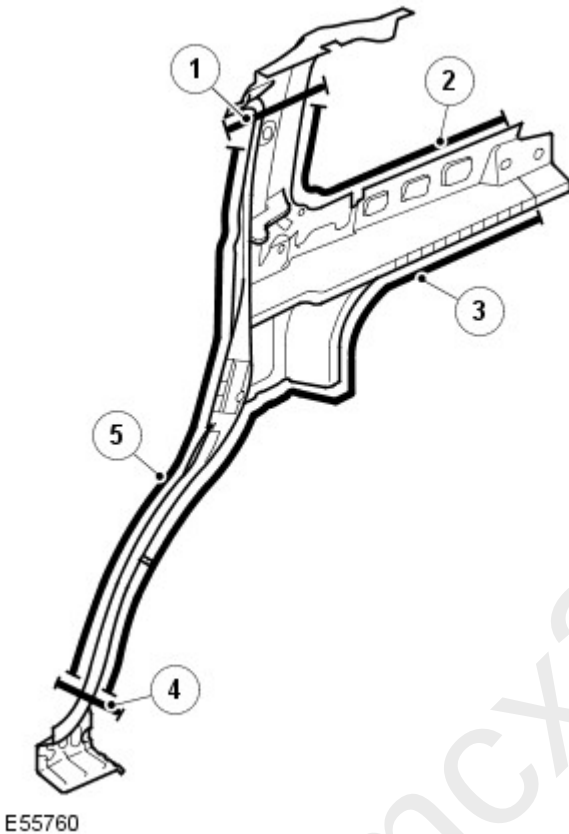
Removal

- NOTE: In this procedure, the inner quarter panel is replaced in conjunction with the quarter panel.

1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Remove the quarter panel.
For additional information, refer to: [Quarter Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

3.

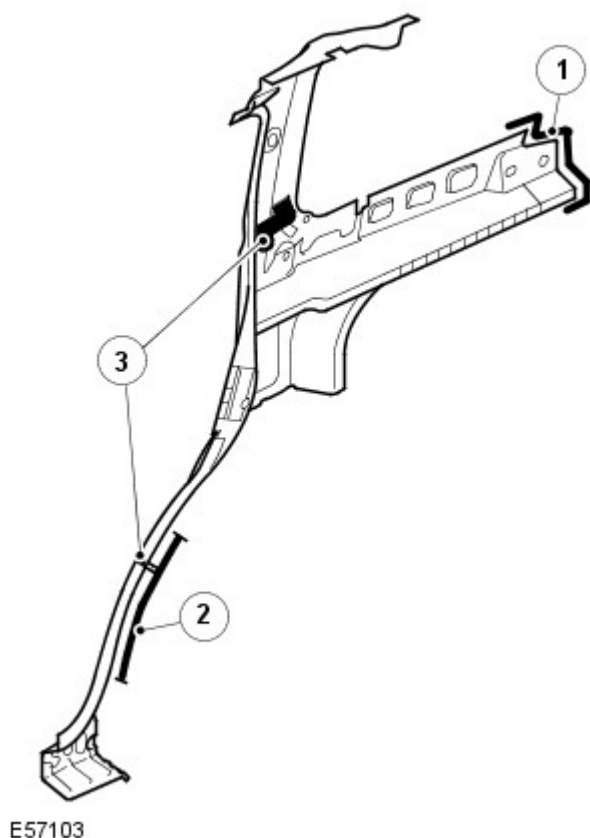
Item	Part Number	Description
1	-	Butt weld.
2	-	24 spot welds.
3	-	11 spot welds.
4	-	Butt weld.
5	-	40 spot welds.



E55760

4.

Item	Part Number	Description
1	-	5 plug welds.
2	-	8 plug welds.
3	-	Acoustic seals



5. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.

Rear End Sheet Metal Repairs - Water Drain Panel

Removal and Installation

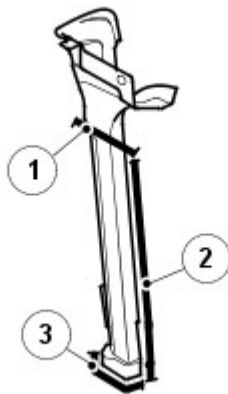
Removal

- NOTE: In this procedure, the water drain panel is replaced in conjunction with the quarter panel.

1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Remove the quarter panel.
For additional information, refer to: [Quarter Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

3.

Item	Part Number	Description
1	-	Butt weld.
2	-	12 spot-welds.
3	-	2 plug-welds.



E55934

4. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.

Rear End Sheet Metal Repairs - Rear Wheelhouse Outer

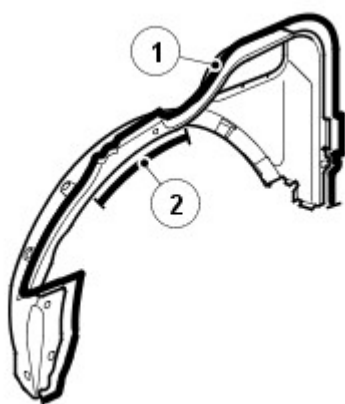
Removal and Installation

Removal

- NOTE: In this procedure, the rear wheelhouse outer is replaced in conjunction with the quarter panel.

1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Disconnect the parking brake cables.
For additional information, refer to: Parking Brake Cable (206-05 Parking Brake and Actuation, Removal and Installation).
3. Remove the brake line.
4. Remove the rear suspension.
For additional information, refer to: Rear Suspension (204-02 Rear Suspension, Description and Operation).
5. Remove the quarter panel.
For additional information, refer to: [Quarter Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
- 6.

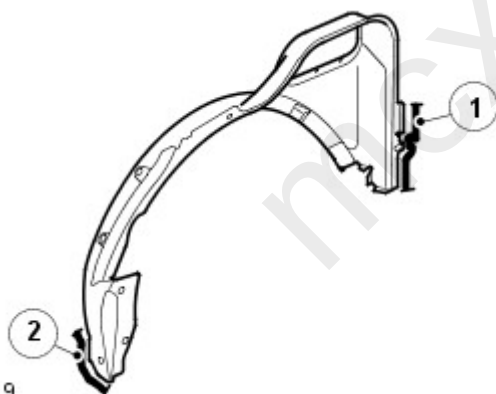
Item	Part Number	Description
1	-	60 spot welds.
2	-	10 spot welds.



E55930

7.

Item	Part Number	Description
1	-	160mm (6.29) adhesive.
2	-	2 plug welds and 5 spot welds.



E57119

8. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.

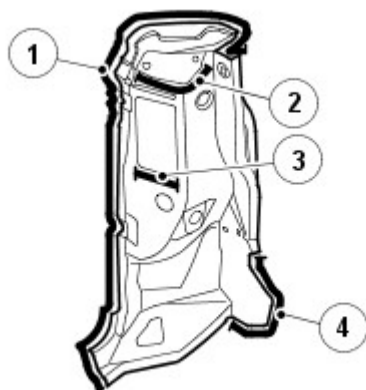
Rear End Sheet Metal Repairs - Rear Lamp Mounting Panel

Removal and Installation

Removal

- NOTE: In this procedure, the rear lamp mounting panel is replaced in conjunction with the quarter panel.

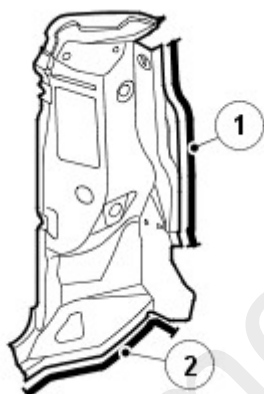
1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Remove the quarter panel.
For additional information, refer to: [Quarter Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
- 3.



E57102

Item	Part Number	Description
1	-	18 plug welds.
2	-	Adhesive.
3	-	3 plug welds.
4	-	2 plug welds.

- 4.



E55761

Item	Part Number	Description
1	-	16 spot welds.
2	-	11 spot welds.

5. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.

Rear End Sheet Metal Repairs - Back Panel

Removal and Installation

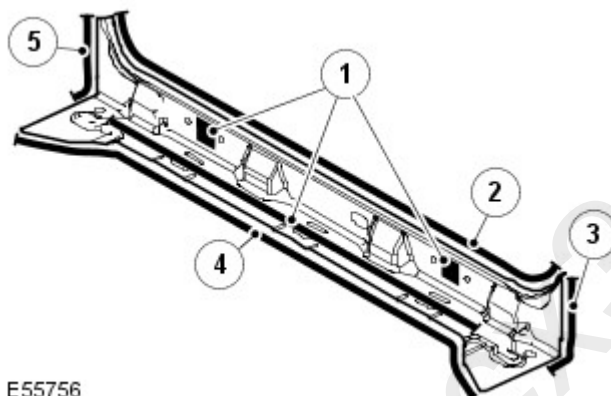
Removal

- NOTE: When replacing the back panel it is necessary to remove a section of the rear lamp panel.

1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Remove the rear bumper cover.
For additional information, refer to: [Rear Bumper Cover](#) (501-19 Bumpers, Removal and Installation).
3. Remove both D-pillar trim panels.
For additional information, refer to: [D-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
4. Remove the tailgate hinge trim cover.
5. Remove the tailgate weather seal.
6. Remove the load space trims.
7. Remove the load space carpets.
8. With assistance remove the tailgate.
9. Remove the L/H exhaust heatshield tailpipe.
10. Remove the R/H exhaust heatshield tailpipe.
11. Remove the spare wheel and tire.
12. Release the back panel wiring harness.

13.

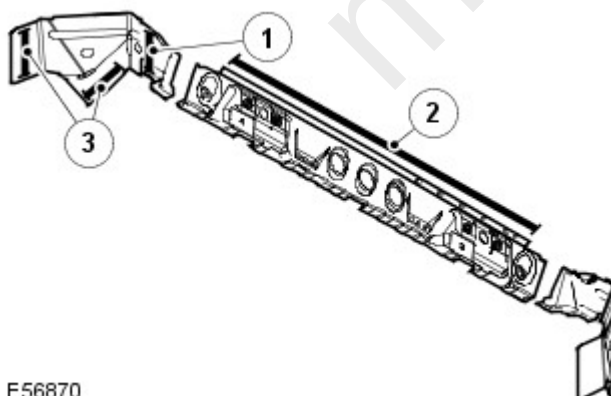
Item	Part Number	Description
1	-	20 plug welds.
2	-	42 spot welds.
3	-	4 plug welds.
4	-	21 plug welds.
5	-	4 plug welds.



E55756

14.

Item	Part Number	Description
1	-	2 plug welds. (R/H is symmetrically opposite to L/H)
2	-	30 spot welds.
3	-	7 spot welds. (R/H is symmetrically opposite to L/H)



E56870

15. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#)

Installation

1. Install is the reversal of removal.

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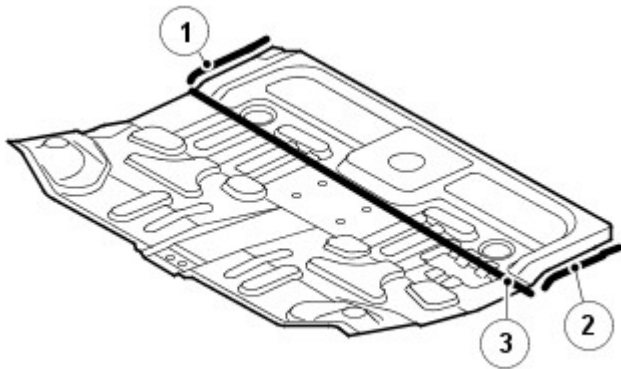
Rear End Sheet Metal Repairs - Rear Floor Panel Section

Removal and Installation

Removal

- NOTE: In this procedure, the rear floor panel section is replaced in conjunction with the back panel and rear crossmember.

1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Remove the back panel.
For additional information, refer to: [Back Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
3. Remove the rear crossmember.
For additional information, refer to: [Rear Crossmember](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
- 4.



E55762

Item	Part Number	Description
1	-	Mig-weld.
2	-	Mig-weld.
3	-	Mig-welds and 18 plug-welds.

5. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.

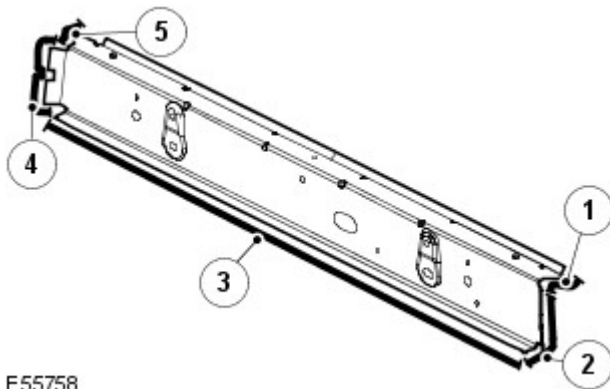
Rear End Sheet Metal Repairs - Rear Crossmember

Removal and Installation

Removal

- NOTE: In this procedure, the rear crossmember is replaced in conjunction with the back panel.

1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Remove the back panel.
For additional information, refer to: [Back Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
- 3.



E55758

Item	Part Number	Description
1	-	Mig weld.
2	-	3 spot welds.
3	-	12 plug welds.
4	-	3 spot welds.
5	-	Mig weld.

4. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.

Rear End Sheet Metal Repairs - Quarter / Side Panel Rear Section LH

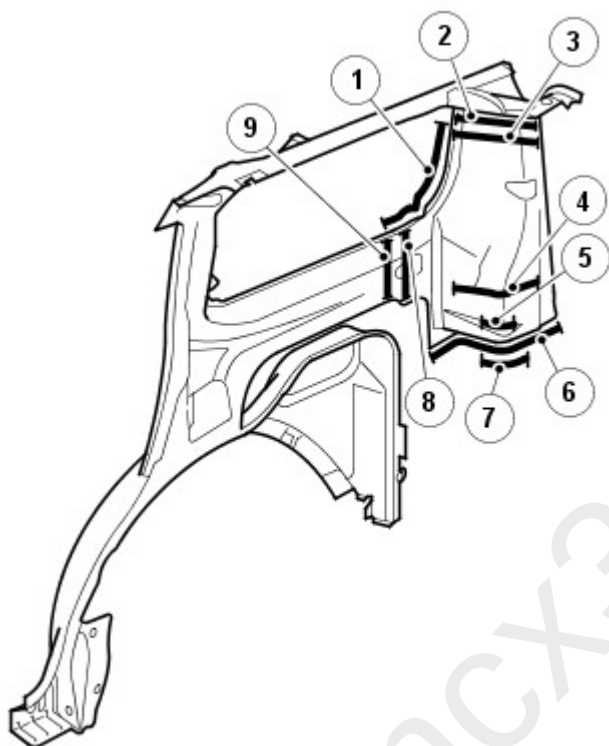
Removal and Installation

Removal

- NOTE: The quarter / side panel rear section R/H is symmetrically opposite to the L/H.
- NOTE: In this procedure, quarter / side panel rear section is replaced in conjunction with the quarter panel.

1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Remove the quarter panel.
For additional information, refer to: [Quarter Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
- 3.

Item	Part Number	Description
1	-	15 spot welds.
2	-	Butt weld.
3	-	Butt weld.
4	-	Acoustic seal.
5	-	3 plug welds.
6	-	8 plug welds.
7	-	Mig weld.
8	-	5 plug welds.
9	-	Butt weld.



E55933

4. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.

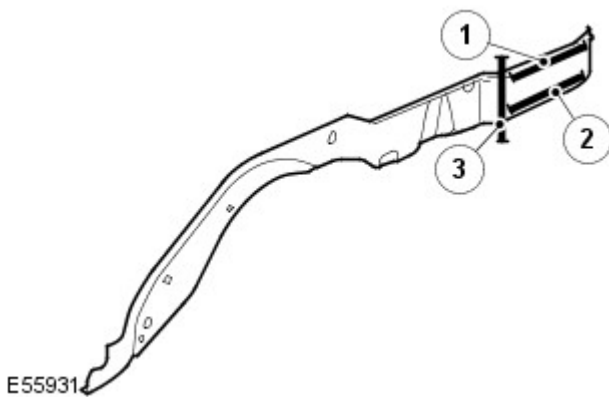
Rear End Sheet Metal Repairs - Rear Side Member Section

Removal and Installation

Removal

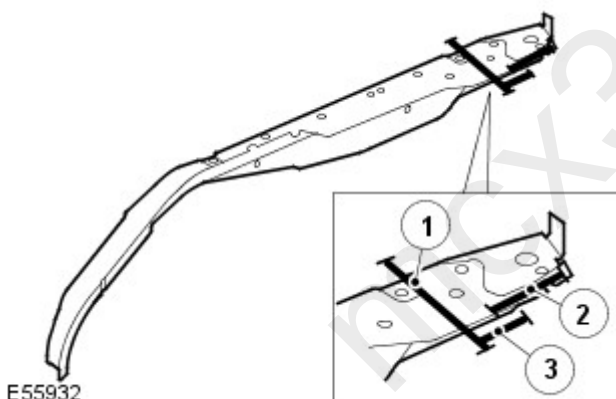
• **NOTE:** In this procedure, the rear side member section is replaced in conjunction with the back panel and rear crossmember.

1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Remove the back panel.
For additional information, refer to: [Back Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
3. Remove the rear crossmember.
For additional information, refer to: [Rear Crossmember](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
- 4.



Item	Part Number	Description
1	-	2 plug welds. (also see graphic E55932)
2	-	2 plug welds.
3	-	Butt weld.

5.



Item	Part Number	Description
1	-	Butt weld.
2	-	2 plug welds.
3	-	4 plug welds.

6. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.

Rear End Sheet Metal Repairs - D-Pillar Inner Lower Panel

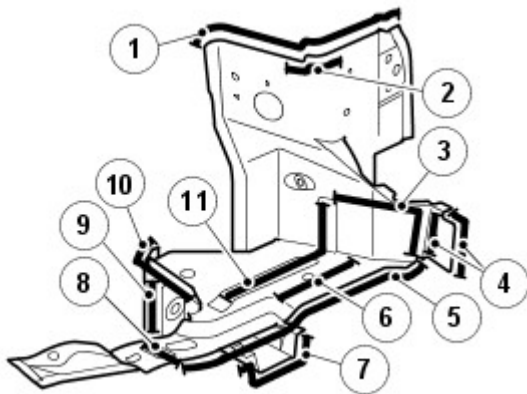
Removal and Installation

Removal

- NOTE: In this procedure the D-Pillar inner lower panel is replaced in conjunction with the quarter panel.

1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Remove the quarter panel.
For additional information, refer to: [Quarter Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

3.



E56610

Item	Part Number	Description
1	-	8 plug welds.
2	-	3 plug welds.
3	-	4 plug welds.
4	-	Mig weld.
5	-	7 plug welds.
6	-	6 plug welds.
7	-	4 plug welds.
8	-	Butt weld.
9	-	Adhesive
10	-	4 plug welds.
11	-	6 plug welds.

4. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.

Rear End Sheet Metal Repairs - D-Pillar Closing Panel

Removal and Installation

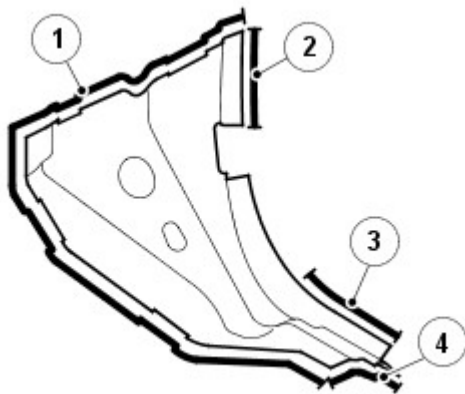
Removal

- NOTE: In this procedure the D-Pillar closing panel is replaced in conjunction with the quarter panel.

1. Disconnect both battery cables.
For additional information, refer to: Specifications (414-00 Charging System - General Information, Specifications).
2. Remove the quarter panel.
For additional information, refer to: [Quarter Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

3.

Item	Part Number	Description
1	-	Mig weld.
2	-	2 plug welds.
3	-	1 plug weld.
4	-	4 plug welds.



E56611

4. For additional information:

- Welding.
For additional information, refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).
- Corrosion protection.
For additional information, refer to: [Corrosion Protection](#) (501-25B Body Repairs - Corrosion Protection, Description and Operation).
- Tolerance checks.
For additional information, refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

Installation

1. Install is the reversal of removal.