



NOTE: Use caution not cut into the mid rear side rail as it will be reused.

Grind the welds that attach the upper and lower reinforcements and remove the reinforcements on both sides.

Use the General Equipment: Grinder



6.

Grind the welds that retain the mid rear and rear frame sections.

Separate the ground area of the joints using an air chisel or similar tool and remove the complete rear frame section.

Use the General Equipment: Grinder



REMOVAL AND INSTALLATION > FRAME MEMBERS-REAR FRAME SECTION > INSTALLATION

1.

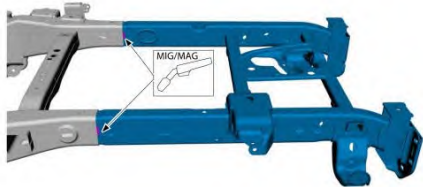
Refer to: Joining Techniques .

2.



NOTE: Verify dimensional accuracy **before** performing any welding operations.

Install the new rear frame section into the mid rear section of the frame and tack weld the frame rails. Refer to: Body and Frame .

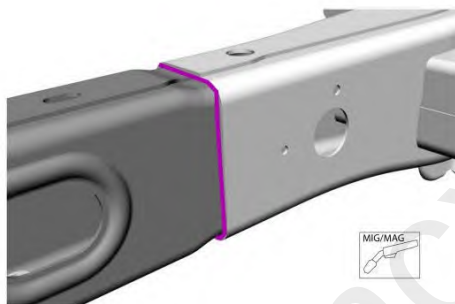


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3.

Perform a final measurement, then final weld the new rear section to the mid rear section on all overlap joints on both sides.

Use the General Equipment: MIG/MAG Welding Equipment



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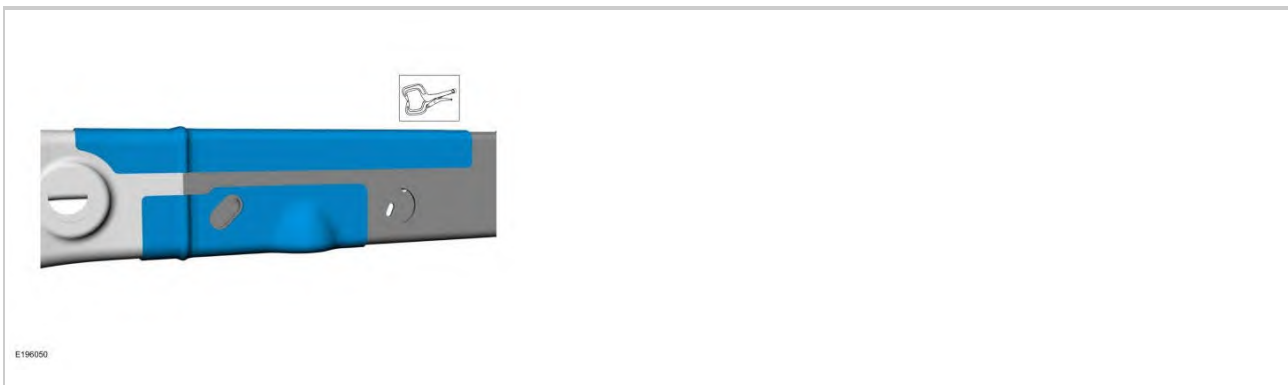
4.

Metal finish the joint area typical metal finishing techniques.

5.

Position the upper and lower reinforcements and clamp in place on both sides.

Use the General Equipment: Locking Pliers



6.



NOTE: Reinforcement welds skip over frame rail joint.

Weld the upper and lower reinforcements to the outer mid rear and rear frame section LH and RH sides.



7.



NOTE: Reinforcement welds skip over frame rail joint and do not go around the frame rail inboard corners.

Weld the upper and lower reinforcements to the inner mid rear and rear frame section LH and RH sides.

