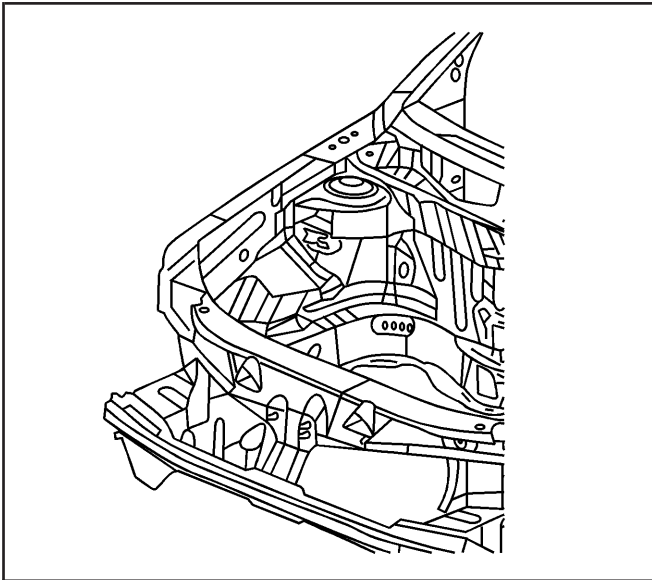


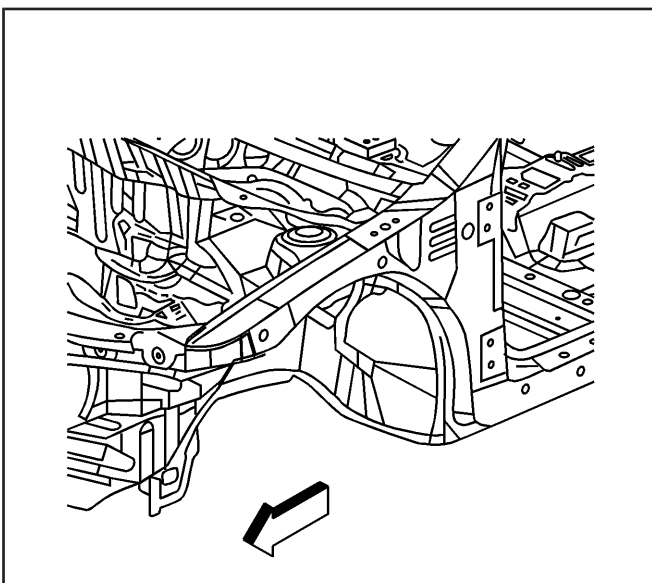
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4. Position the front wheelhouse extension to the vehicle using 3-dimensional measuring equipment. Clamp the extension in place.



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5. Plug weld accordingly.
6. Clean and prepare all of the welded surfaces.
7. Install all of the related panels and components.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
9. Paint the repaired area.
10. Connect the negative battery cable.
11. Enable the SIR system.



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## Rail Replacement Front Compartment - Side Upper

### Removal Procedure

**Caution:** To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

**Caution:** Refer to SIR Caution on page 1-1 in General Information.

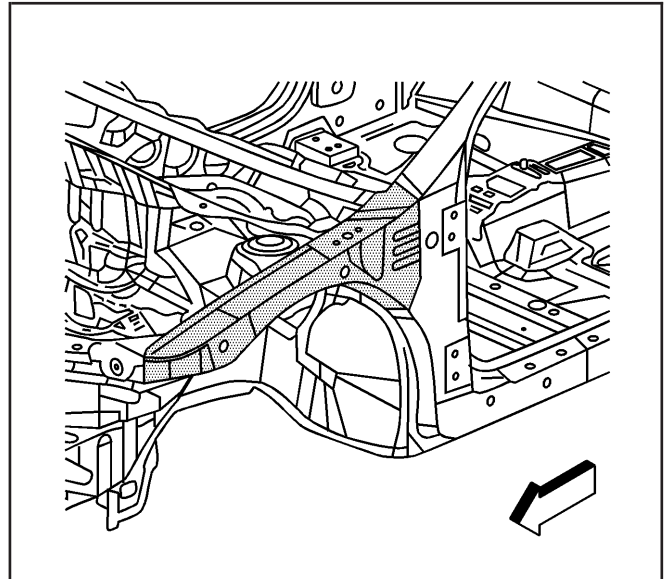
1. Disable the SIR system.

**Caution:** Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect the negative battery cable. Failure to follow these precautions may cause personal injury and/or damage to the vehicle or its components.

2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to *Dimensions - Body* on page 3-7.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.

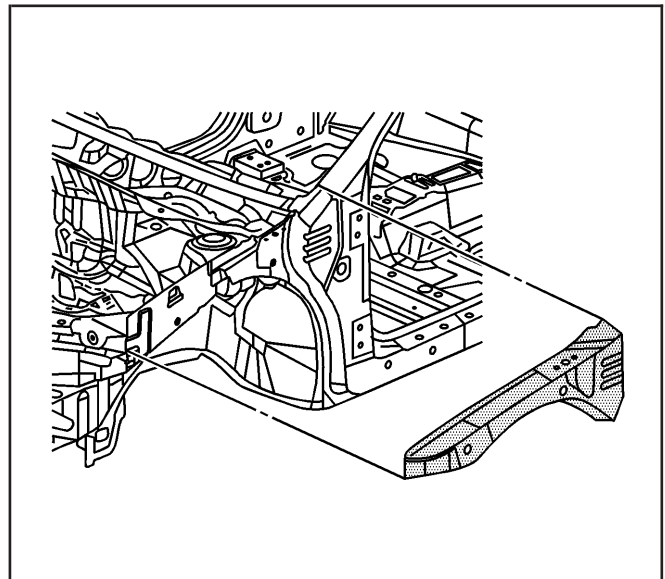
**Important:** Do not damage any inner panels or reinforcements.

6. Locate and drill out all factory welds. Note the number and location of the welds for installation of the front upper rail.

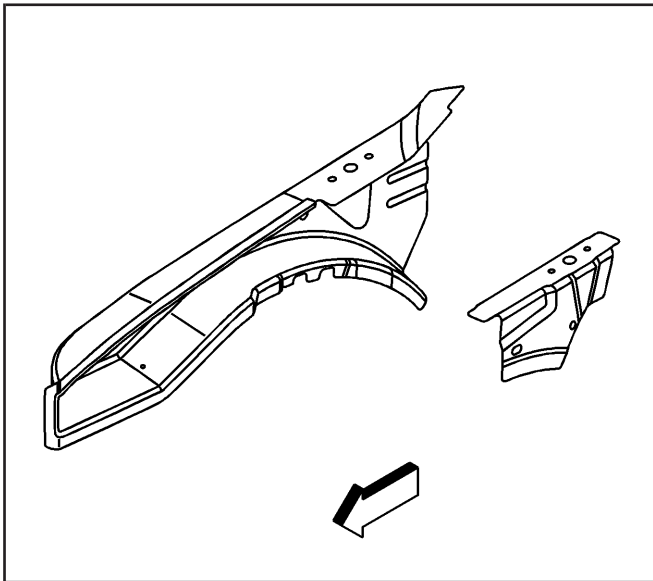


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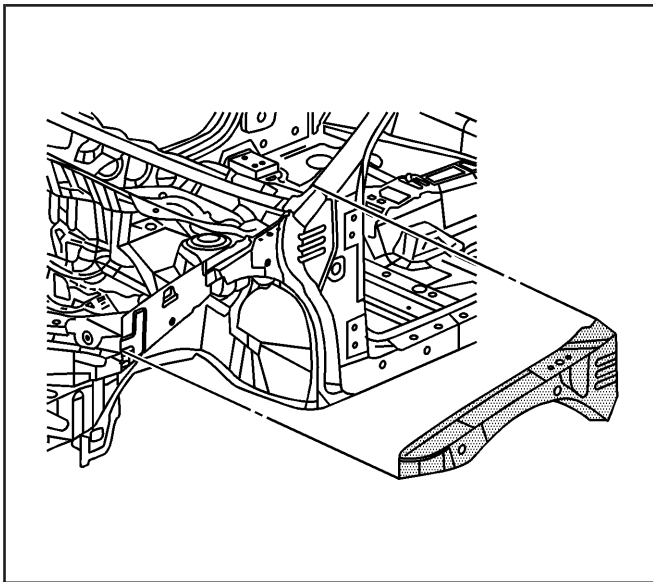
7. Remove the damaged front upper rail.



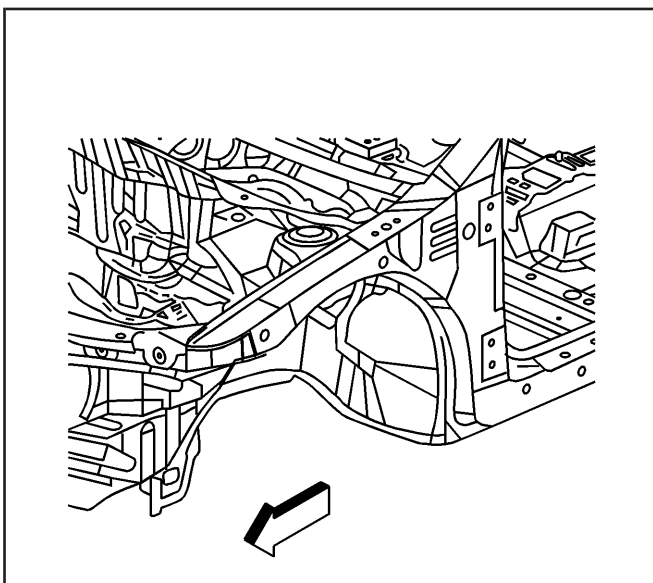
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## Installation Procedure

**Important:** If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Prepare all mating surfaces as necessary.
3. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.
4. Position the front upper rail on the vehicle using 3-dimensional measuring equipment. Clamp the rail in place.

5. Plug weld accordingly.
6. Clean and prepare all welded surfaces.
7. Install all related panels and components.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
9. Paint the repair area.
10. Connect the negative battery cable.
11. Enable the SIR system.