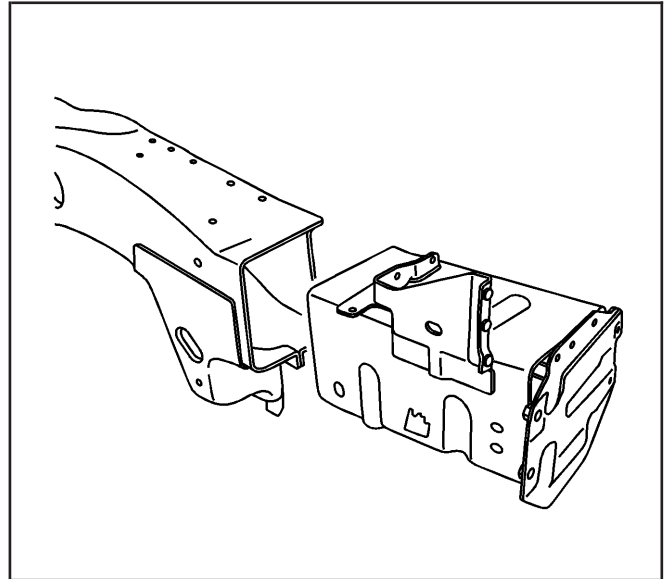
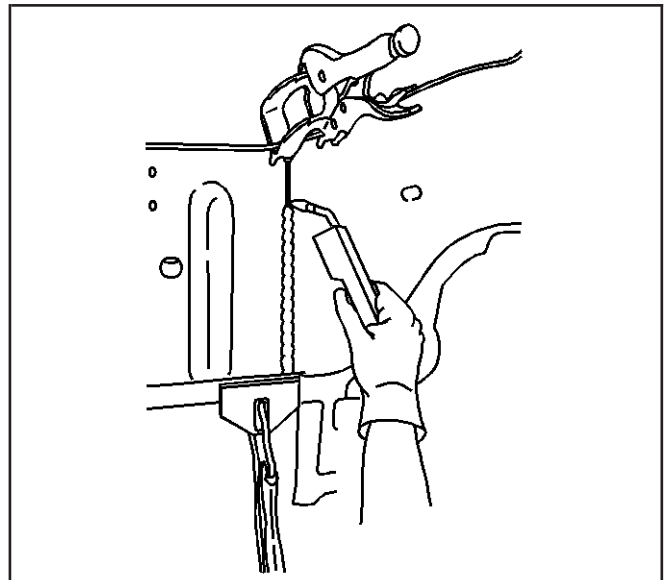


- Position the front rail section using 3-dimensional measuring equipment. Clamp the service part in place.



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- Tack weld the part into position.
- Inspect the service rail for proper dimensions using 3-dimensional measuring equipment.
- Stitch weld along the entire sectioning joint. Make 25 mm (1 in) welds along the seam with 25 mm (1 in) gaps between.
- Complete the stitch weld.
- Clean and prepare the welded surfaces.
- Install all of the related panels and components.
- Apply the sealers and anti-corrosion materials to the repair area, as necessary.
- Paint the repaired area.
- Enable the SIR system.
- Connect the negative battery cable.



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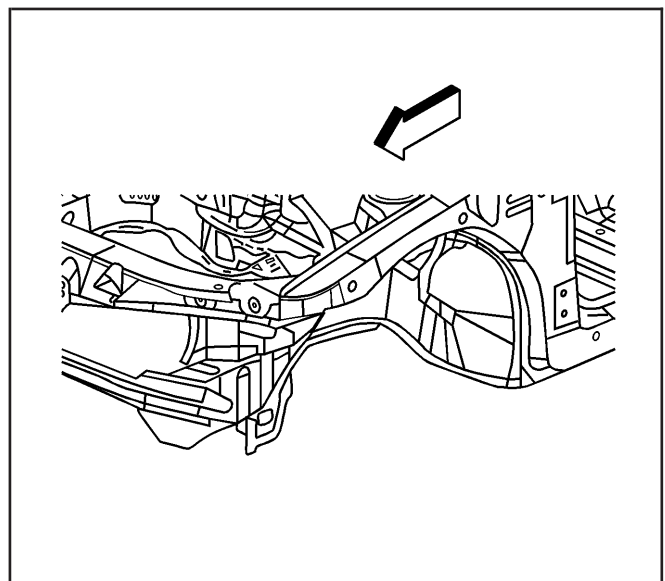
Rail Replacement Front Side Underbody - Outer

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.

- Disable the SIR system.



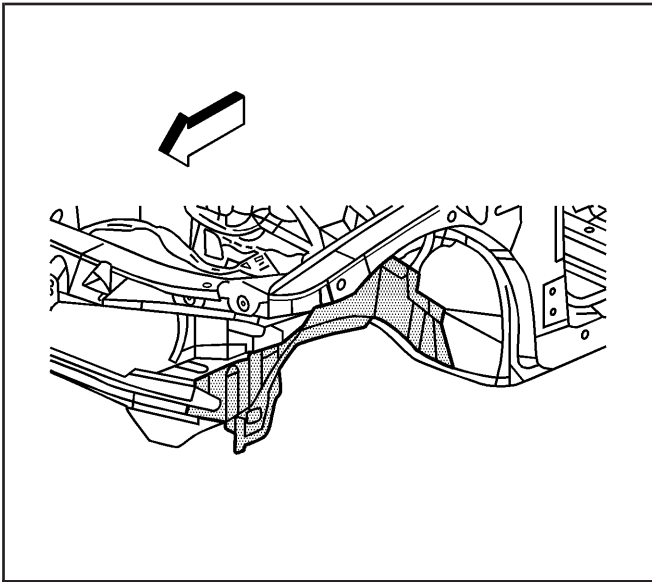
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Caution: Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with 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.

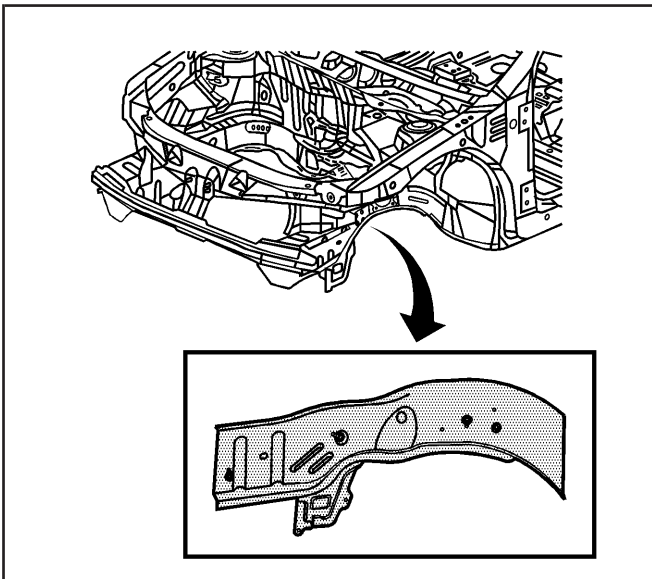
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible. Refer to *Dimensions - Body* on page 3-7.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.

Important: Note the number and location of the factory welds for installation of the outer rail.

6. Locate and drill out all the necessary factory welds.



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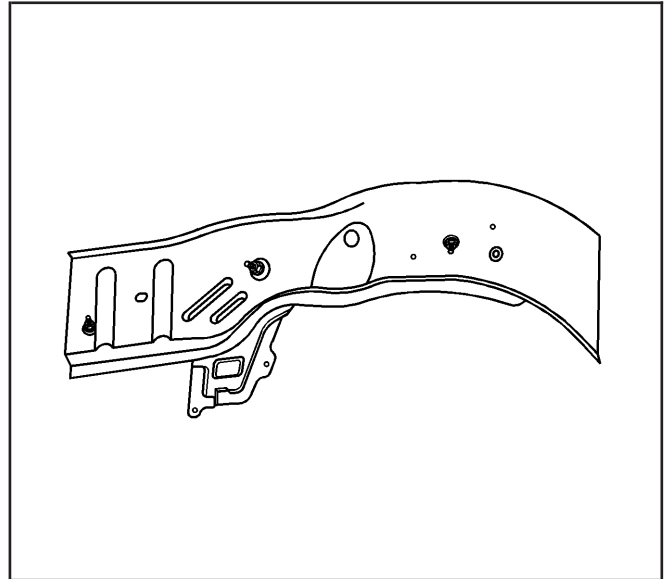
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7. Remove the outer rail from the vehicle.

Installation Procedure

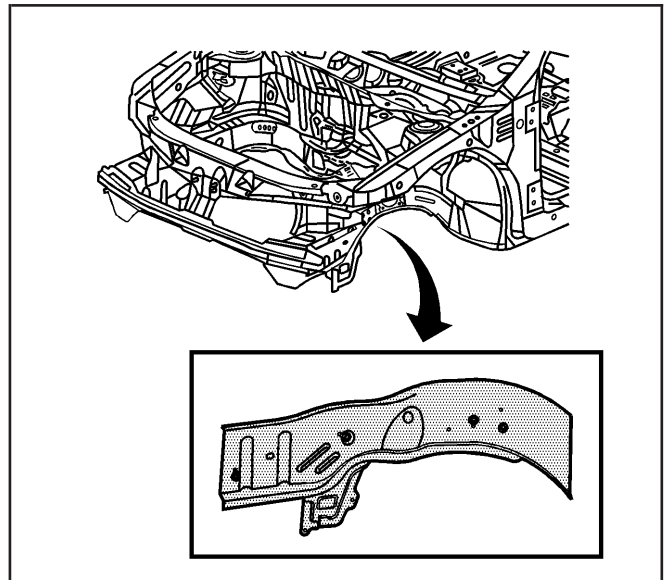
Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

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.



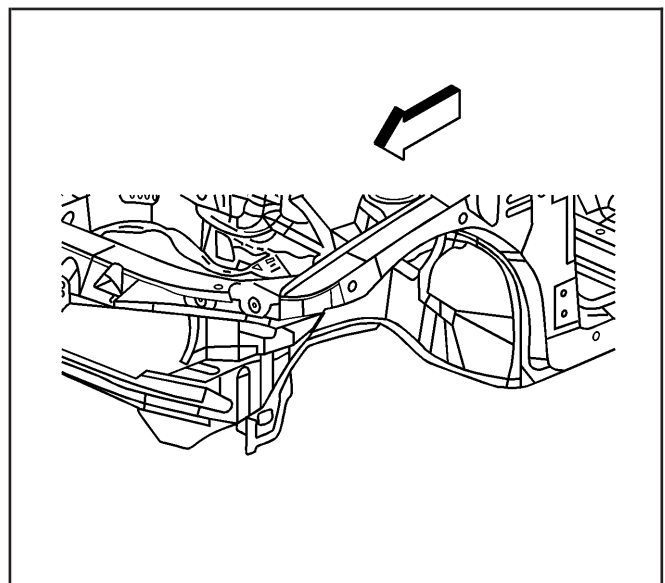
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4. Position the outer rail to the vehicle using 3-dimensional measuring equipment. Clamp the outer rail in place.



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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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