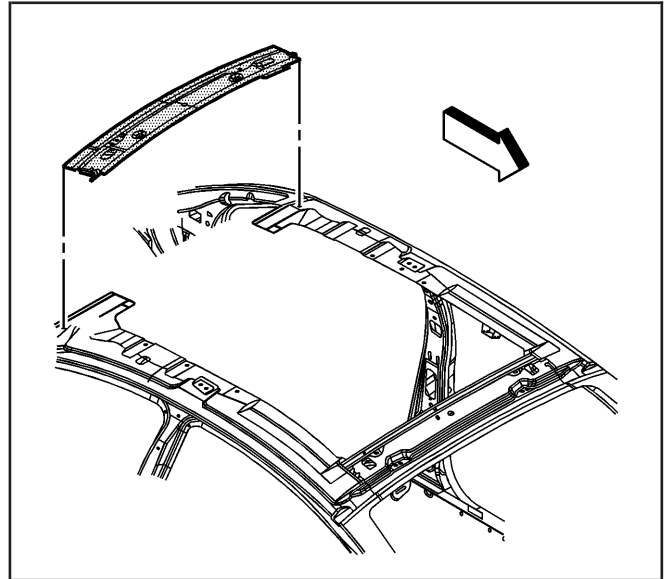
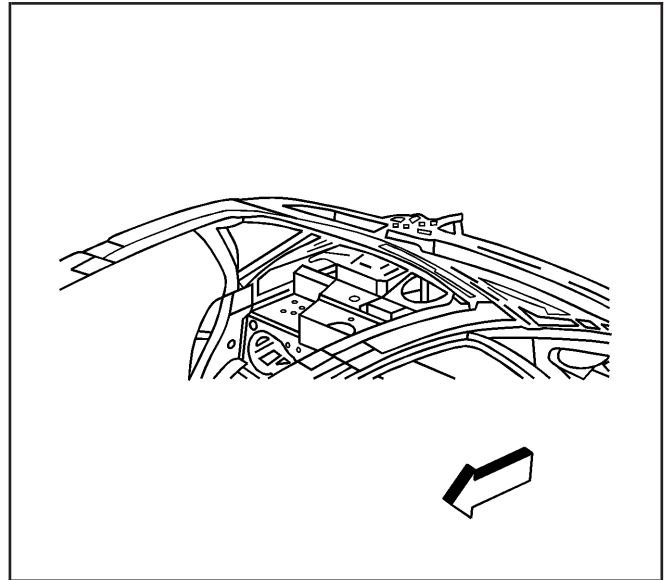


4. Position the rear window frame header panel to the vehicle using 3-dimensional measuring equipment. Clamp the rear header panel in place.



870872

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.



870868

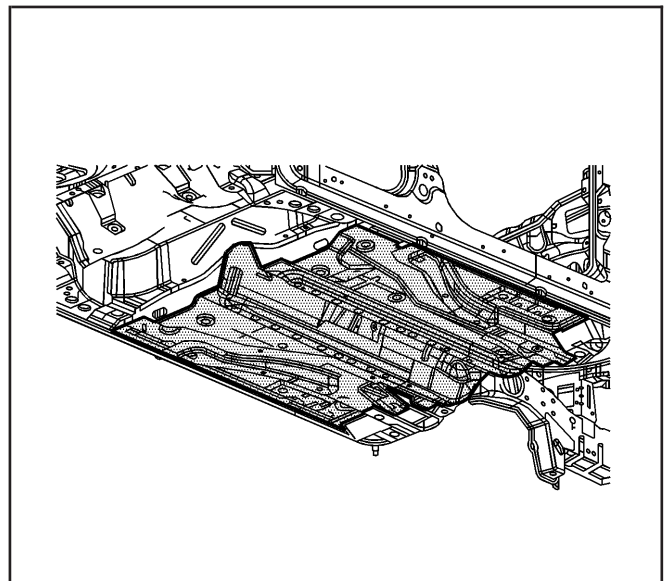
Floor Panel Replacement - Center

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.



870895

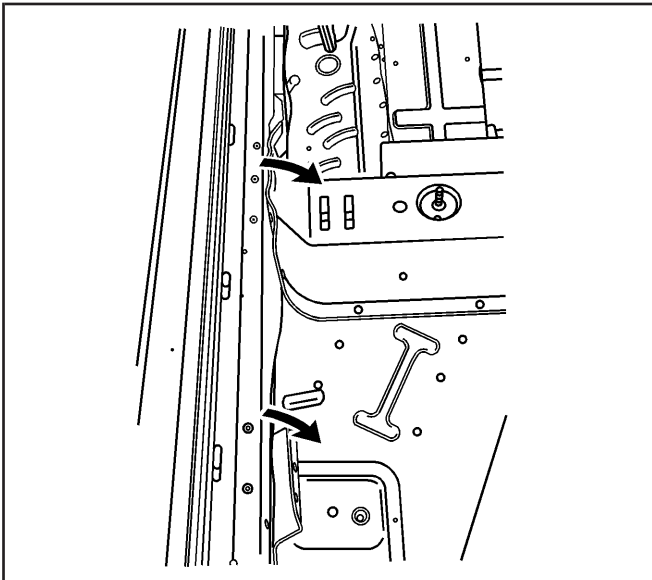
Caution: Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect 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 damaged area as possible. Refer to *Dimensions - Body* on page 3-7.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.

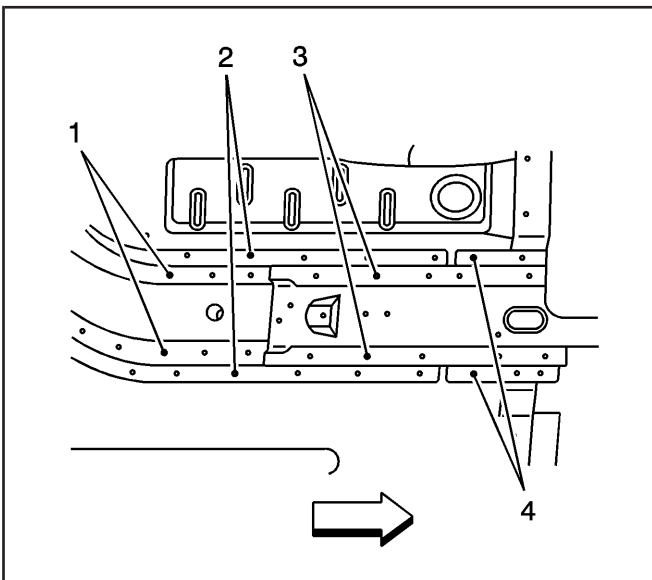
Important: Note the number and location of the factory welds for installation of the center floor panel.

Important: Do NOT damage or drill through adjacent panels.

6. Locate and drill out the #2 and #3 bar attachments to the inner rocker panel.
7. Bend the upper weld flange up and away from the inner rocker panel.



870890

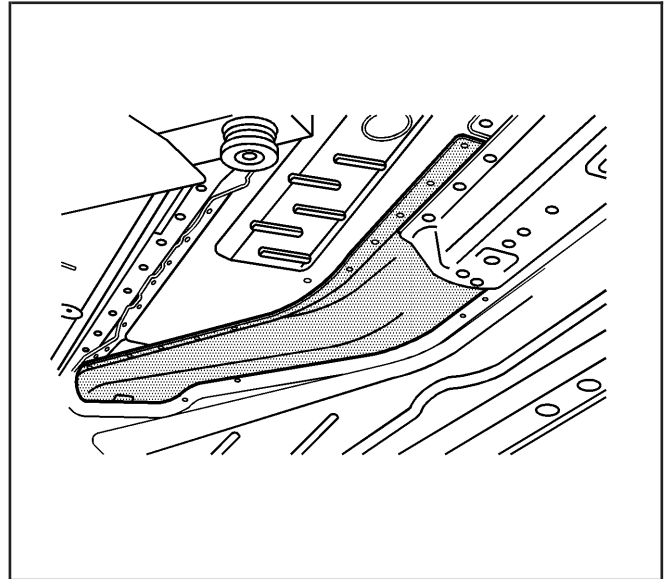


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Important: The rear portion of the front compartment lower rail is a multi-layered assembly.

8. Note the layering (1,2,3,4) of the weld flanges.
 - The rear portion of the front rail to rail assembly
 - The rear upper reinforcement of the front rail to floor pan
 - The intermediate portion of the front rail to rear upper reinforcement of the front rail
 - The intermediate reinforcement to the floor pan

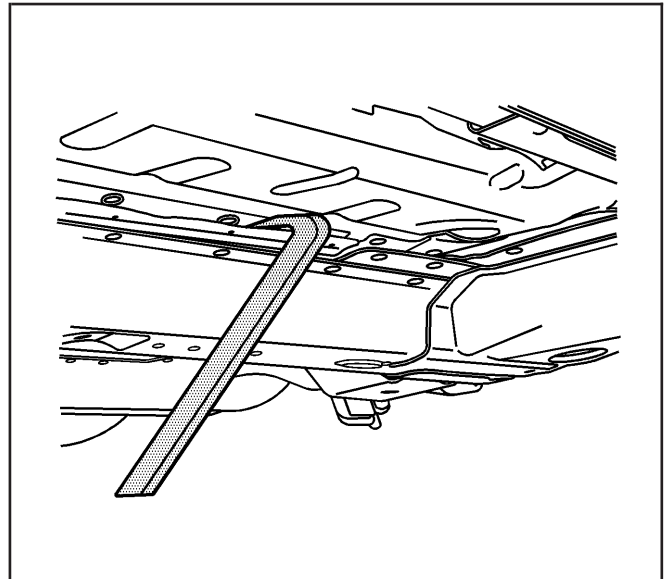
9. Drill out all plug welds in the rear portion of the front rail connected to the center floor panel. If the rail portion is undamaged, keep the portion for reinstallation.
10. Drill out all plug welds that attach the rear portion of the front rail to the intermediate portion of the front rail.



870893

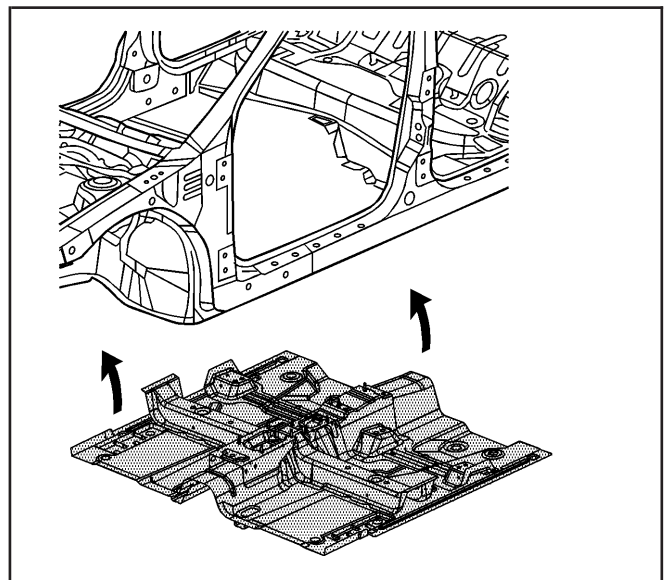
Important: Remove the rear section of the rail before you remove the center floor panel.

11. Using a 90 degree bent pry tool, pry the intermediate portion of the front rail apart from the rear portion of the rail far enough to allow the rear portion to slide free of the intermediate portion. Remove the rear portion of the front compartment rail.

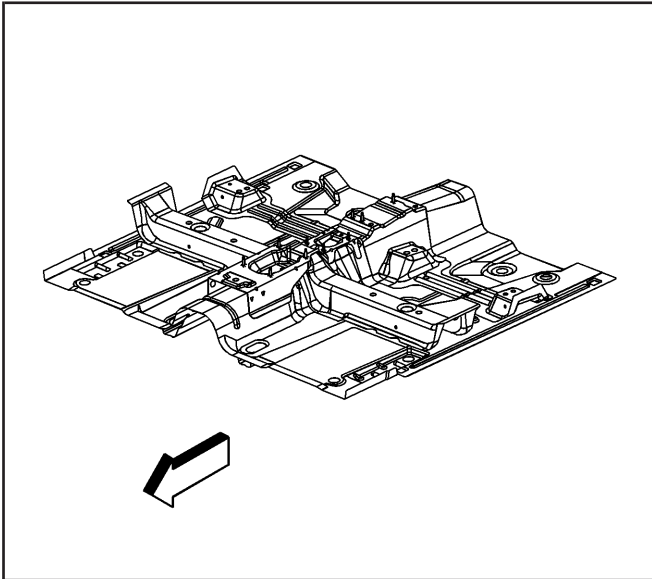


870891

12. Locate and drill out all of the spot welds that attach the center floor pan to the following components:
 - The dash and panel
 - The #1 bar area
 - The lower inner rockers
 - The rear floor pan
13. Remove the center floor panel by lowering the rear edge first and pulling down and rearwards until the floor pan is free from the vehicle.



870894

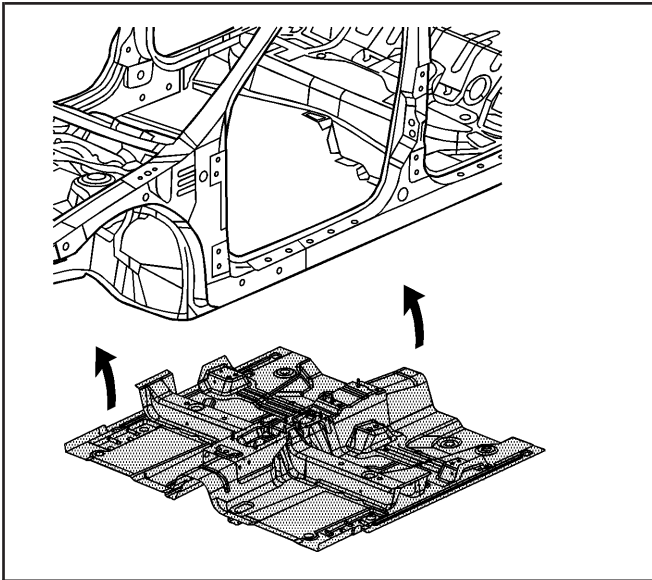


870888

Installation Procedure

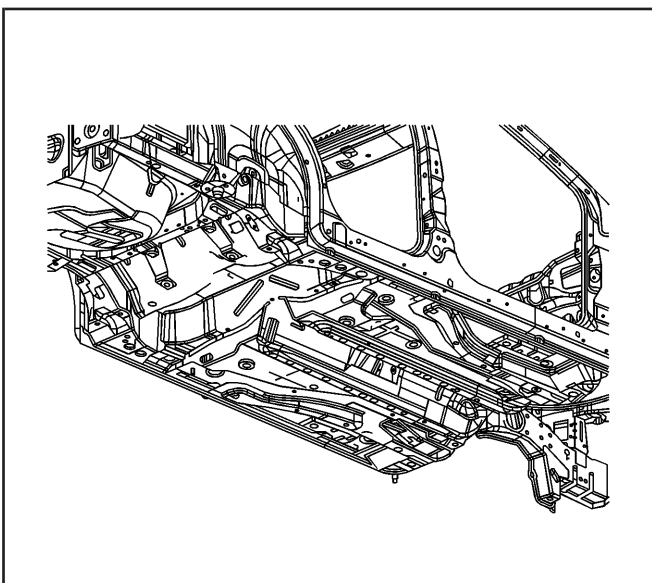
Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the corresponding locations noted on 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.



870894

4. Position the center floor panel to the vehicle using 3-dimensional measuring equipment. Clamp the panel in place.



870886

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.