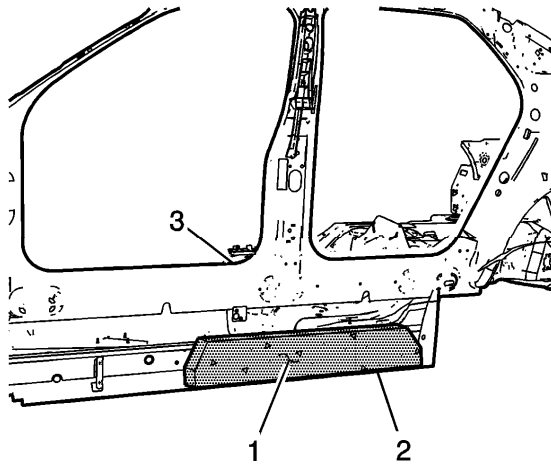


Structure Foam Replacement

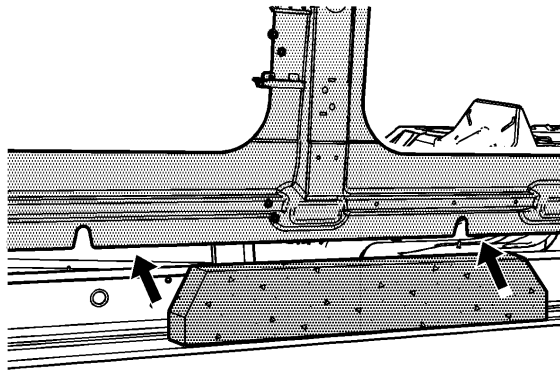
Removal Procedure



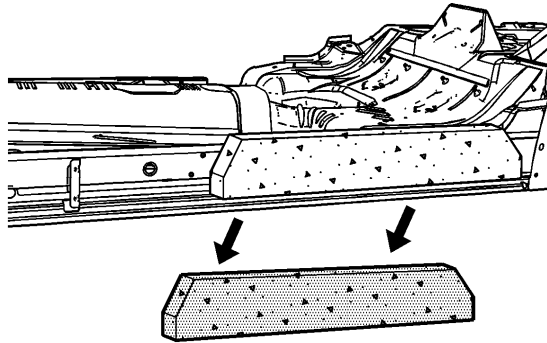
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

Important: Structural foam (1) is located between the inner rocker (2) and the inner body side panel (3) on both the right and the left side of the vehicle. Precast structural foam replacement blocks are available if necessary, and can be ordered separately.

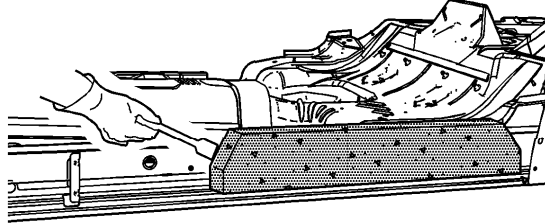
Failure to replace any damaged structure foam reinforcement as described could compromise the structural integrity of the vehicle.



1. Remove the inner front door lock pillar. Refer to [Pillar Lock Front Door Sectioning Replacement - Inner](#) .



2. Remove the damaged structural foam reinforcement.



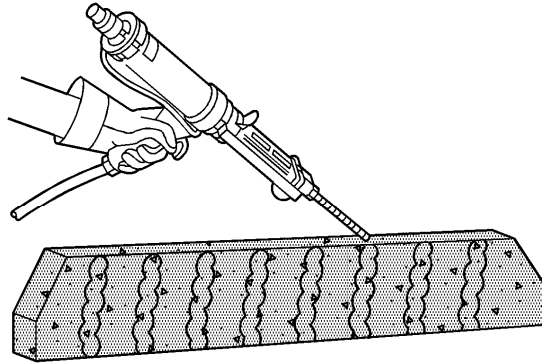
Important: Do NOT remove existing primer from the inner panels when removing the structural foam.

3. If the inner rocker panel is not being replaced, use a chisel or equivalent to remove the excess and loose structural foam from the inner rocker panel.

Installation Procedure

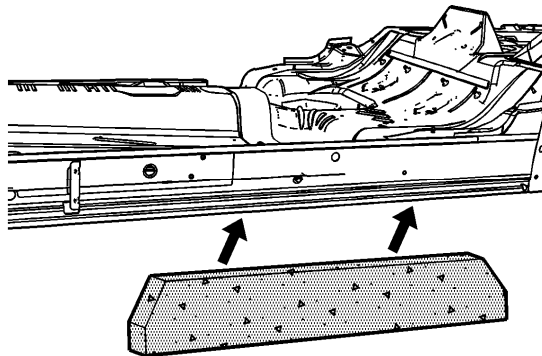
Important: Use only enough naphtha solvent to dampen a cloth. Too much solvent may saturate the structural foam reinforcement and may migrate out later, affecting the bond strength of the adhesive.

1. Clean the replacement structural foam reinforcement and all of the mating surfaces with naphtha solvent and allow to dry thoroughly.



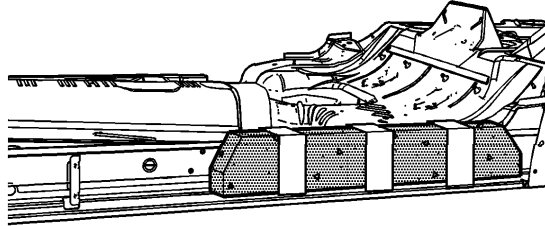
Important: The adhesive has a 40-50 minute work time. Do NOT allow the adhesive to cure prior to installing the structural foam reinforcement to the vehicle and to the inner hinge pillar reinforcement.

2. Apply 9-13 mm beads of Fusor 120 adhesive GM P/N 12345726 to the reinforcement mating surface of the inner rocker.

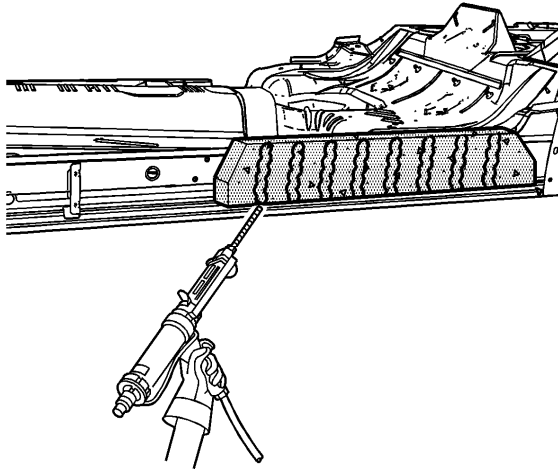


Important: Do NOT pull the structural foam reinforcement apart from the adjacent panels after the panels have been joined together. Slide the reinforcements from side to side, or up and down, for proper alignment.

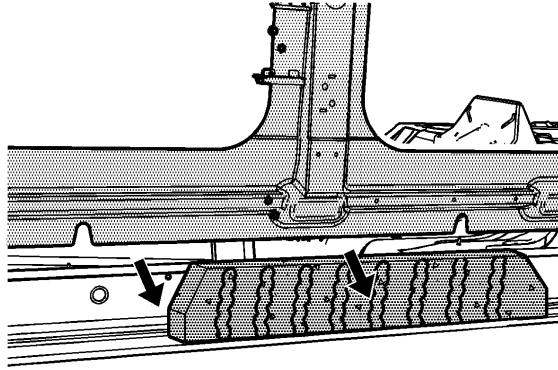
3. Position the structural foam reinforcement to the body and push firmly into place.



4. Temporarily hold the structural foam reinforcement in place with tape.
5. Remove the tape from the structural foam block.



6. Apply 9-13 mm beads of Fusor 120 adhesive GM P/N 12345726 (Canadian P/N 10953521) to the reinforcement mating surface of the inner body side, as shown.



Important: Do NOT pull the outer body side assembly apart from the structural foam reinforcement after the parts have been joined together. Slide the outer panel from side to side, or up and down, for proper alignment.

7. Position the body side inner assembly and clamp into place. Refer to [Pillar Lock Front Door Sectioning Replacement - Inner](#) .