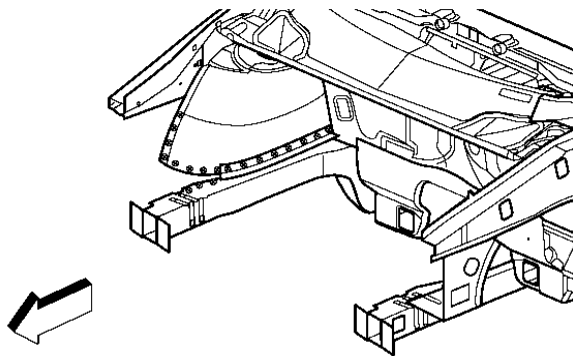
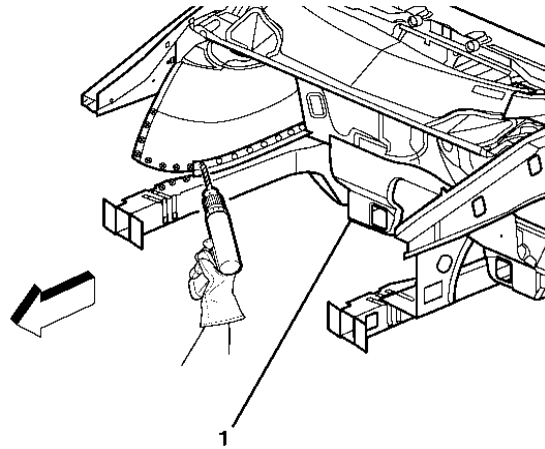


Front Lower Rail Sub-Assembly Replacement

Removal Procedure



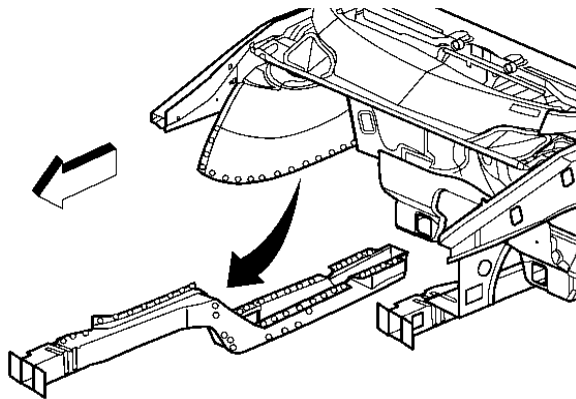
1. Remove all related panels and components.
2. Restore as much of the damage as possible to factory specifications.
3. Note the location and remove the following as necessary:
 - Sealers
 - Sound deadeners
 - Anti-corrosion materials



4. Separate the floor pan reinforcement (1) weld flanges from the inside of the lower rail. Care must be taken not to damage the weld flanges.

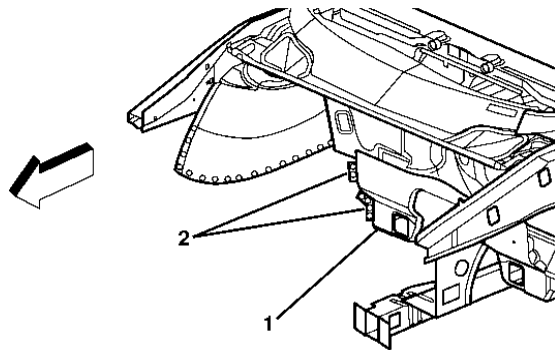
Important: Do not damage any inner panels or reinforcements

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

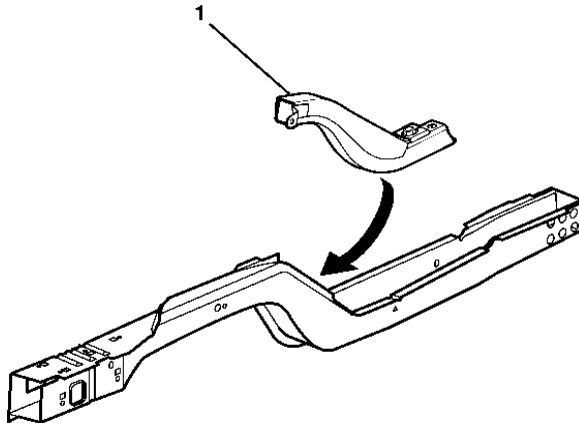


6. Remove the damaged rail.

Installation Procedure

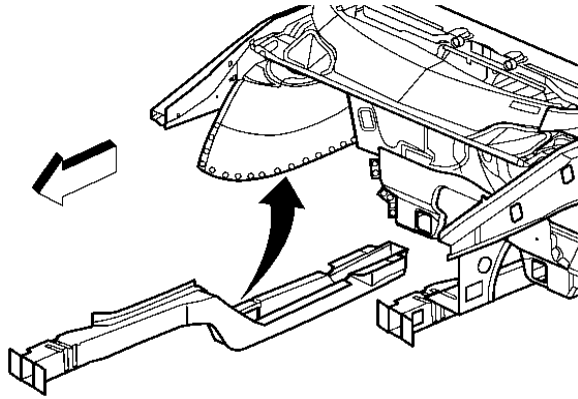


1. Prepare the mating surface of the floor pan reinforcement (1).
2. Turn the weld flanges outward (2) to be welded to the front lower rail.
3. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the removal.

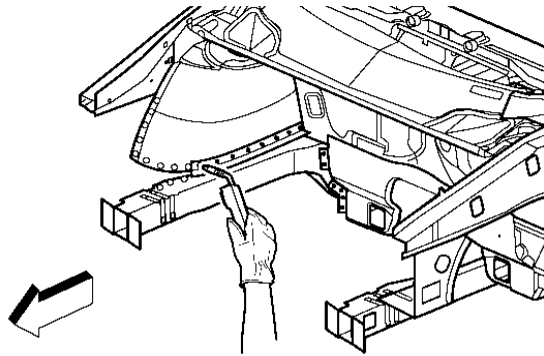


4. Position the front rail reinforcement inner (1).
5. Prepare all attachment surfaces as necessary.

6. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces.
Refer to [Anti-Corrosion Treatment and Repair](#) .

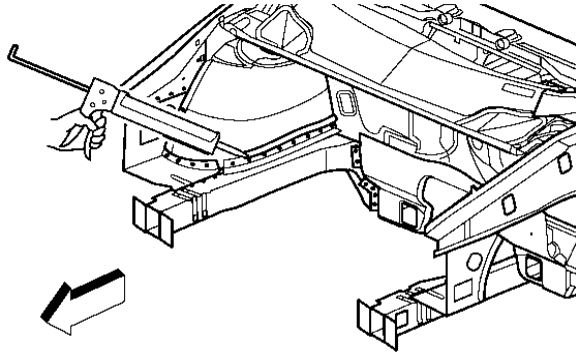


7. Position the service part.



8. Plug weld accordingly.

9. Clean and prepare all of the welded surfaces.



10. Apply the following as necessary:

- Anti-corrosion materials
- Sound deadeners
- Sealers

13. Refinish as necessary.

14. Install all related panels and components.