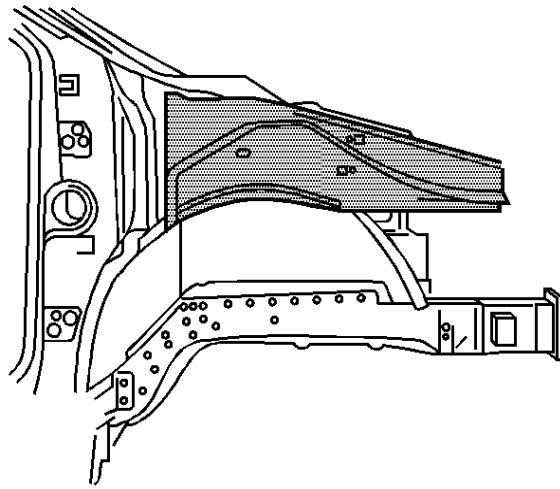
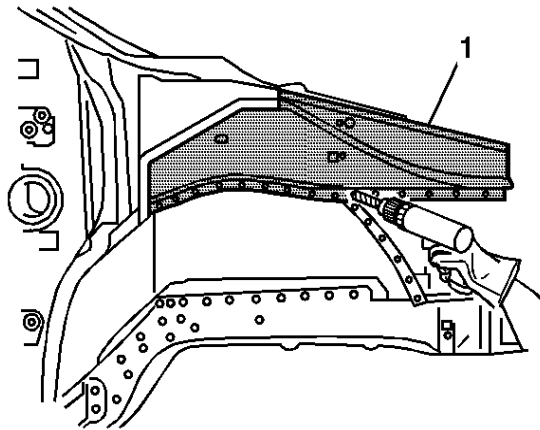


Rail Replacement - Front Inner Upper

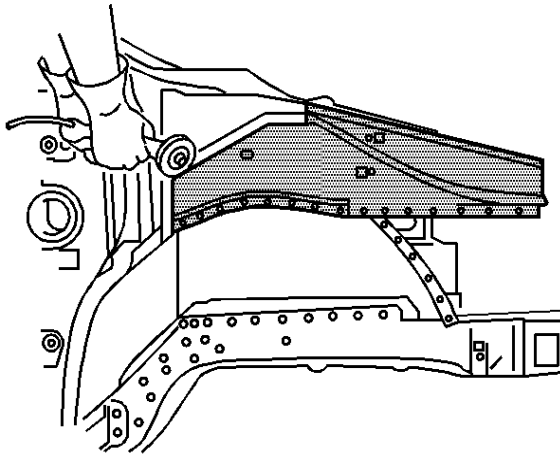
Removal Procedure



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. Perform the necessary procedures to gain access to repair. Refer to [Radiator Support Replacement - Upper Rail Replacement - Upper](#) , [Radiator Support Replacement - Lower](#) , or to [Wheelhouse Sectioning - Front](#) .

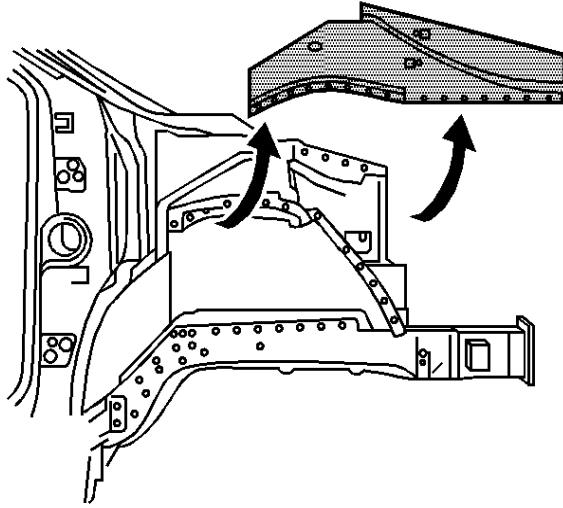


5. Locate and drill out all factory welds. Note the number and location of welds for installation of the service part.



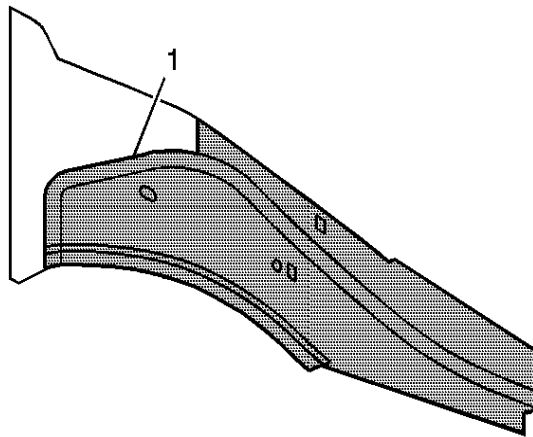
Body and Accessories-Collision Repair Important: Do not damage any inner panels or reinforcements.

6. Cut the inner-upper rail.

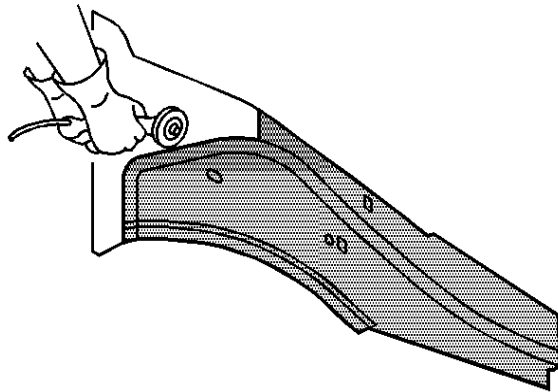


7. Remove the damaged front inner upper rail.

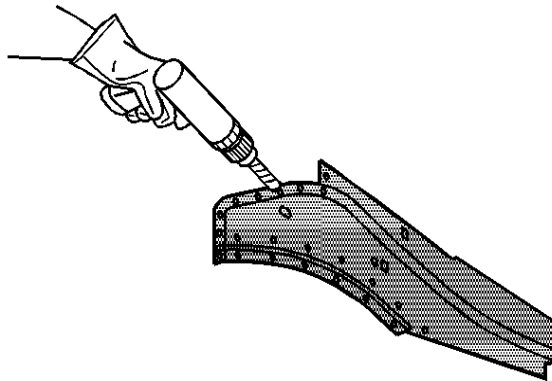
Installation Procedure



1. Mark the service part at the inboard contour (1) to create a weld flange.



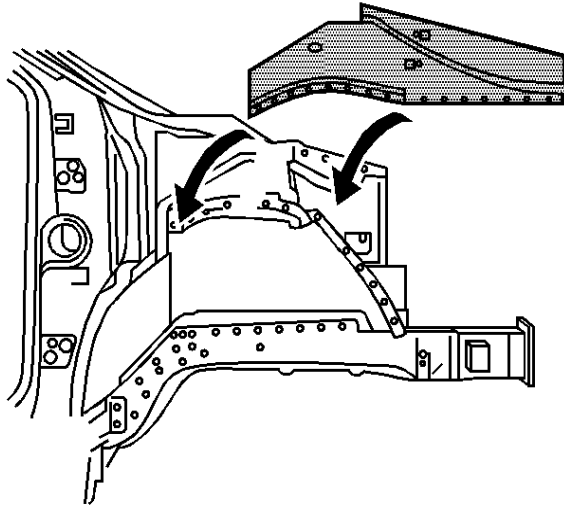
2. Cut the service part.



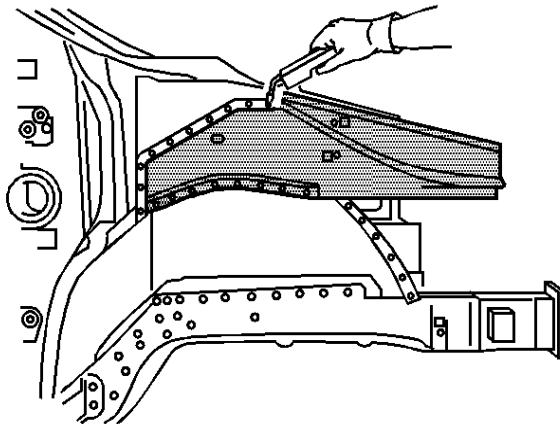
Important: In any area damaged beyond recognition, space plug weld holes every 40 mm (1 1/2 in) apart.

3. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel.
4. Drill 8 mm (5/16 in) plug weld holes along the sectioning cut on the service part. Locate these holes 40 mm (1 1/2 in) apart.
5. Prepare all attachment surfaces as necessary.

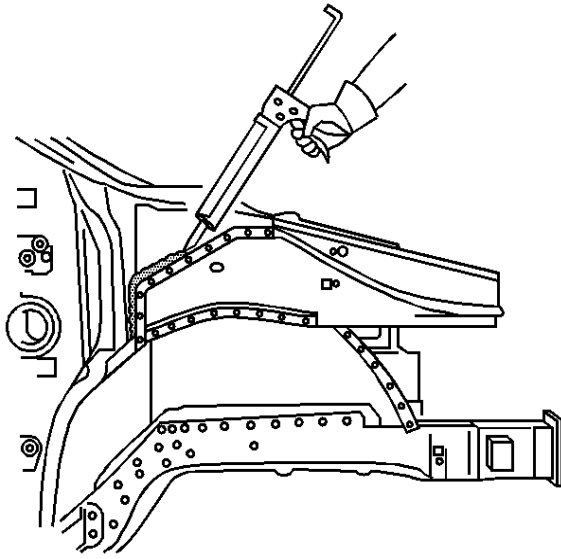
6. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



7. Align the service part over the stepped tab using dimensional measuring equipment.



8. Plug weld accordingly.



9. Clean and prepare all welded surfaces.

Important: Prior to refinishing, refer to publication GM 4901M-D-01 GM Approved Refinish Materials, for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

10. Apply an approved anti-corrosion primer.
11. Apply sealers and refinish as necessary.
12. Complete the necessary procedures. Refer to [Radiator Support Replacement - Upper Rail Replacement - Upper](#) , [Radiator Support Replacement - Lower](#) , or to [Wheelhouse Sectioning - Front](#) .
13. Install all other related components.