

# Rail Replacement – Upper

## Removal Procedure

1. Disable the SIR system. Refer to Disabling the SIR System in Cautions and Notices.
2. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnect/Connect Procedure in Cautions and Notices.  
**IMPORTANT: Sectioning of the front upper rails is not recommended. Remove all related panels and components.**
3. Restore as much of the damage as possible.
4. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Cautions and Notices.
5. Locate, mark, and drill out all factory welds attaching the outer rail.
6. Remove the damaged outer rail.

## Installation Procedure

1. Prepare the mating surfaces as necessary.  
**IMPORTANT: If the original locations are damaged beyond recognition, locate holes for plug welding 40 mm (1-1/2 in.) apart. Drill 8 mm (5/16 in.) plug weld holes as necessary in the locations noted from the original panels.**
2. Temporarily position the outer rail on the vehicle.
3. Check location using 3-dimensional measuring equipment.
4. Plug weld accordingly.
5. Clean and prepare welded surfaces.
6. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Cautions and Notices.
7. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems in Cautions and Notices.
8. Install all of the related panels and components.
9. Connect the negative battery cable. Refer to Battery Negative Cable Disconnect/Connect Procedure in Cautions and Notices.
10. Enable the SIR system. Refer to Enabling the SIR System in Cautions and Notices.

