

Wheelhouse Replacement – Front

Removal Procedure

CAUTION: Refer to Glass and Sheet Metal Handling in Cautions and Notices.

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 wheelhouse assembly is not recommended. The front wheelhouse service panel is serviced as a complete assembly, which includes the upper front strut mounting surface. The upper strut mounting surface is a dimensionally critical area, and 3-dimensional measuring equipment should be used to locate the front wheelhouse assembly.

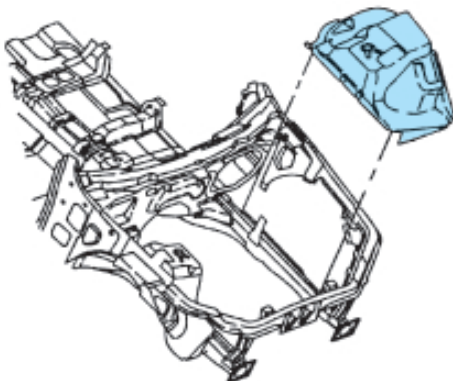
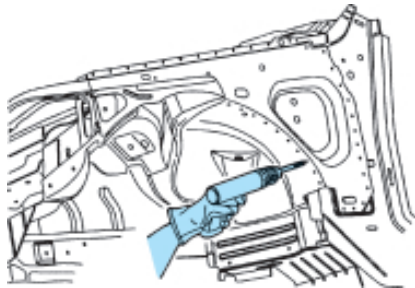
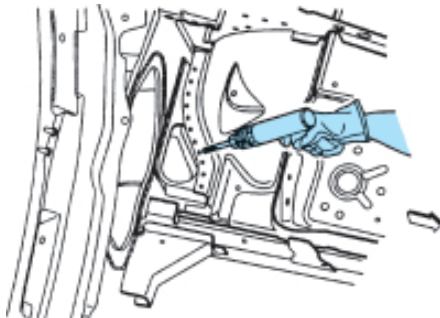
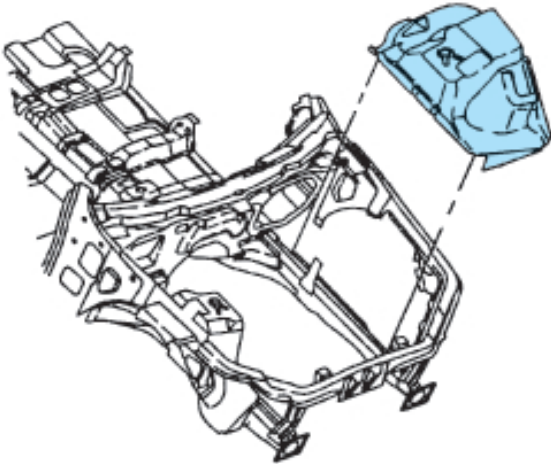
3. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Cautions and Notices.

IMPORTANT: Be sure to inspect the front of the cowl for damage. If the metal surface is damaged, the cowl panel must be repaired to restore the structural integrity of the vehicle.

4. Visually inspect and restore as much of the damage as possible.
5. Locate, mark, and drill out all factory welds. Note the number and location of welds for installation of the service assembly.

6. Remove the spot welds that attach the wheelhouse to the frame rail by drilling from the outside of the wheelhouse.

7. Remove the wheelhouse from the vehicle

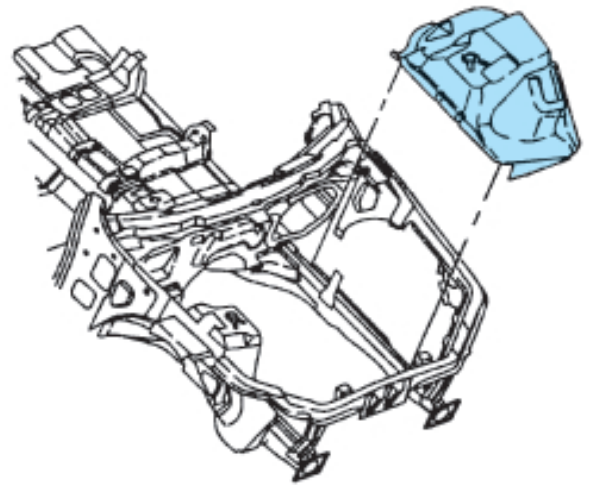


Installation Procedure

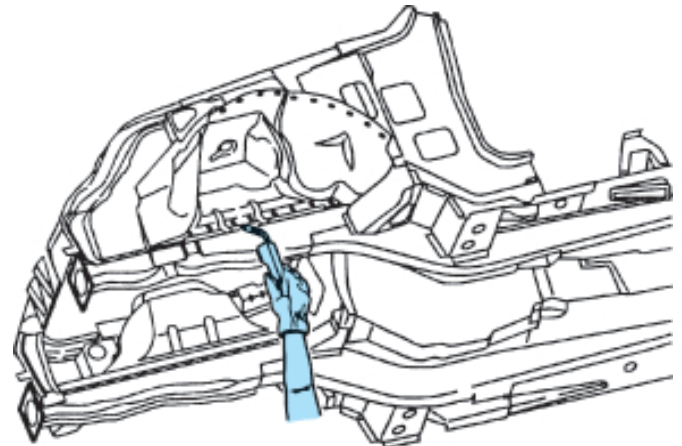
1. Prepare the mating surfaces as necessary.
2. Drill 8 mm (5/16 in.) plug weld holes as necessary in the locations noted from the original assembly.

IMPORTANT: If the original locations are damaged beyond recognition, locate holes for plug welding 40 mm (1-1/2 in.) apart.

3. Position the wheelhouse on the vehicle. Check for proper fit using 3-dimensional measuring equipment



4. Measure frequently to ensure proper fit and alignment.



5. When the service assembly is correctly positioned, plug weld accordingly.
6. Clean and prepare all welded surfaces.
7. Prime with 2-part catalyzed primer.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Cautions and Notices.
9. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems in Cautions and Notices.
10. Install all related panels and components.
11. Connect the negative battery cable. Refer to Battery Negative Cable Disconnect/Connect Procedure in Cautions and Notices.
12. Enable the SIR system. Refer to Enabling the SIR System in Cautions and Notices.

