

Rail Sectioning – Lower

Removal Procedure

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

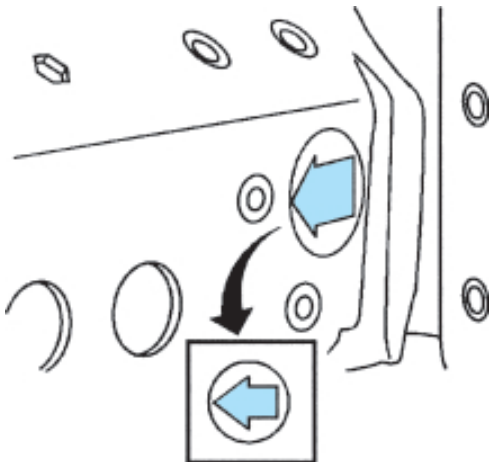
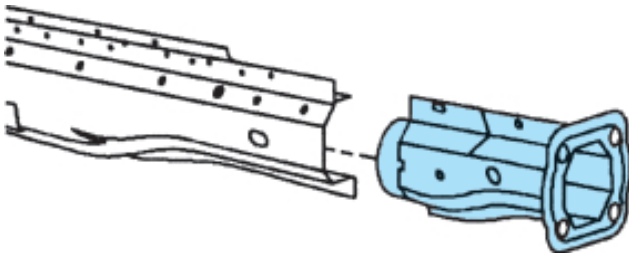
IMPORTANT: If front rail damage is limited to 205 mm from the front end, a pre-sleeved service section is available. This service section includes the front bumper mounting bracket.

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.
3. Remove all of the related panels and the components. Including the left front wheelhouse mounting bracket to the rail
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. Restore as much as the damage as possible.

6. Locate the diemarks on the inner and outer rail.

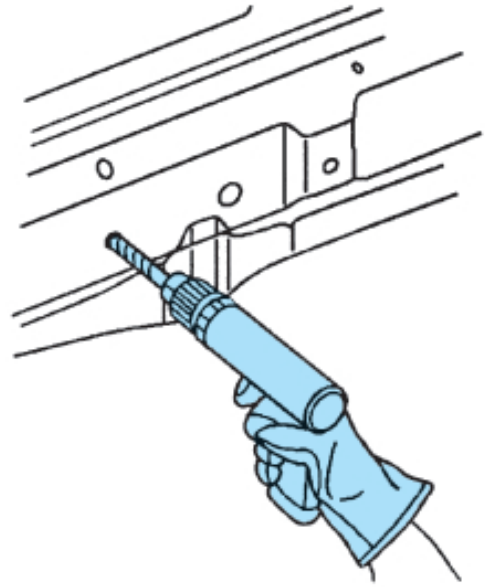
IMPORTANT: Do not damage the rail rear of the diemarks. Scribe a line 360 degrees around the frame rail at the die marks.

7. Cut at the marked location.
8. Remove the damaged component from the vehicle.

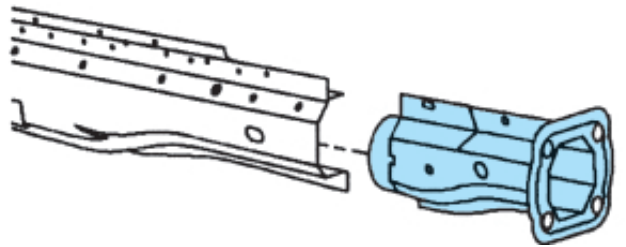


Installation Procedure

1. Drill 4 plug weld holes; 2 at the inside and 2 at the outside, 13 mm (1/2 in.) from the cut line and 50 mm (2 in.) apart on the existing frame rail.
2. Prepare all of the bare metal surfaces with a suitable weld-through primer.



3. Install and position the replacement service section using 3-dimensional measuring.



4. Tack weld the part into position at the initial plug weld holes.
5. Inspect the service part for proper dimensions using 3-dimensional measuring equipment.
6. Stitch weld along the entire sectioning joint. Make 25 mm (1 in.) welds along the seam with 25 mm (1 in.) gaps between.
7. Complete the stitch weld.
8. Clean and prepare the welded surfaces.
9. Position the tie bar mounting bracket. Weld the bracket in place.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Cautions and Notices.
11. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems in Cautions and Notices.
12. Install all of the related panels and components.
13. Enable the SIR system. Refer to Enabling the SIR System in Cautions and Notices.
14. Connect the negative battery cable. Refer to Battery Negative Cable Disconnect/Connect Procedure in Cautions and Notices.

