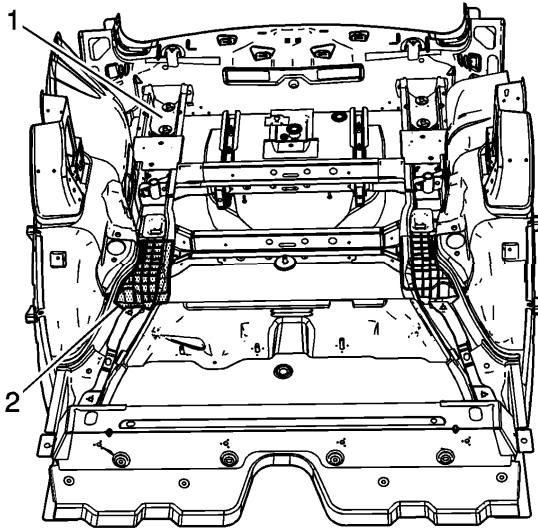


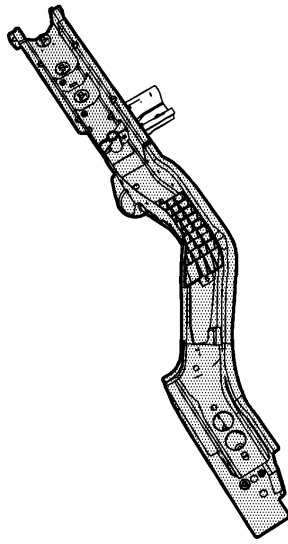
Structure Foam Replacement

Removal Procedure



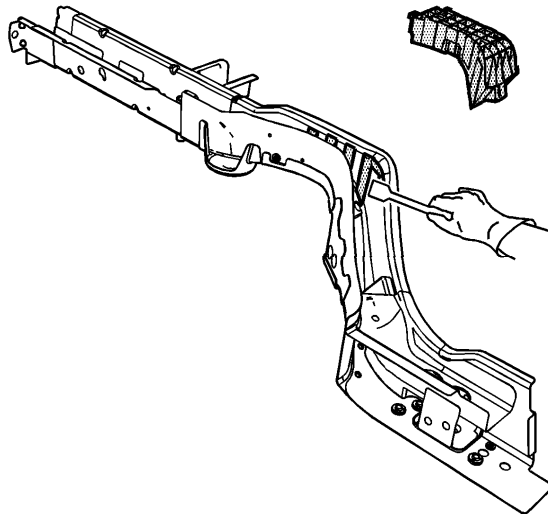
Important: A structural nylon block (1) is located between the rear floor panel and the frame rail (2) on both the right and the left side of the vehicle. Precast structural nylon replacement blocks are available if necessary, and can be ordered separately. Failure to replace any damaged structure nylon reinforcement as described could compromise the structural integrity of the vehicle.

Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.



Important: Some vehicles have a metal top plate attached to the nylon block. This component is removable after the adhesive has been removed.

1. Remove the rear frame rail. Refer to [Rail Replacement - Rear](#) .
2. Remove the damaged structural nylon reinforcement.



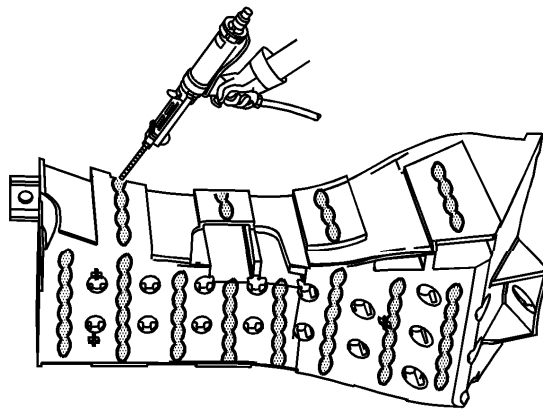
Important: Do NOT remove existing primer from the inner panels when removing the structural block.

3. If the floor panel is not being replaced, use a chisel or equivalent to remove the excess and loose structural adhesive from the floor panel.

Installation Procedure

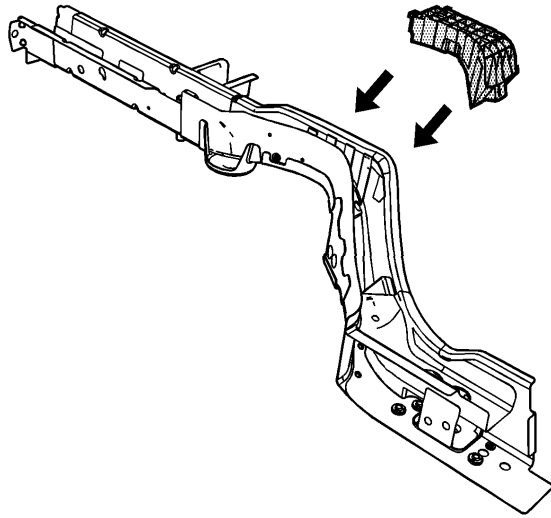
Important: Use only enough naphtha solvent to dampen a cloth. Too much solvent may saturate the structural foam reinforcement and may migrate out later, affecting the bond strength of the adhesive.

1. Clean the replacement structural nylon reinforcement and all of the mating surfaces with naphtha solvent and allow to dry thoroughly.



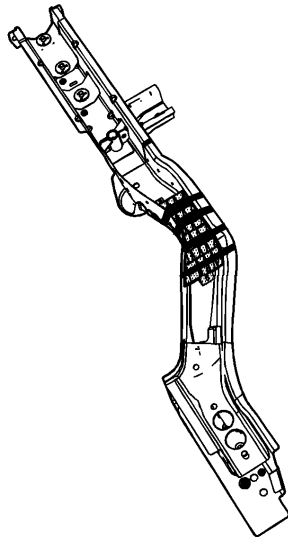
Important: The adhesive has a 40-50 minute work time. Do NOT allow the adhesive to cure prior to installing the structural foam reinforcement to the vehicle and to the inner hinge pillar reinforcement.

2. Apply 9-13 mm beads of Fusor 120 adhesive GM P/N 12345726 to the reinforcement mating surface of the rail assembly.



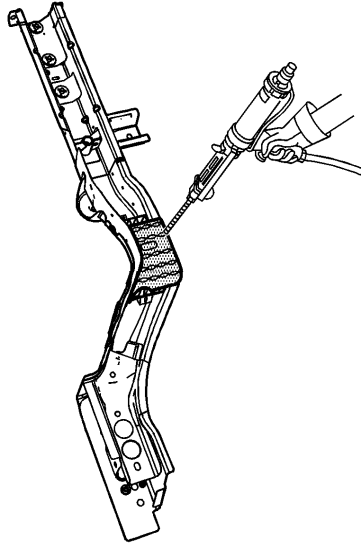
Important: Do NOT pull the structural nylon reinforcement apart from the adjacent panels after the panels have been joined together. Slide the reinforcements from side to side, or up and down, for proper alignment.

3. Position the structural nylon reinforcement to the rail. Push the nylon reinforcement firmly into place.



4. Temporarily hold the structural nylon reinforcement in place with tape.

5. Remove the tape from the structural nylon block.



6. Apply 9-13 mm beads of Fusor 120 adhesive GM P/N 12345726 (Canadian P/N 10953521) to the reinforcement mating surface of the floor panel, as shown. Apply the adhesive between the nylon reinforcement and the reinforcement metal top plate.

Important: Do NOT pull the frame rail assembly apart from the structural nylon reinforcement after the parts have been joined together. Slide the outer panel from side to side, or up and down, for proper alignment.

7. Position the frame rail assembly and clamp into place. Refer to [Rail Replacement - Rear](#).