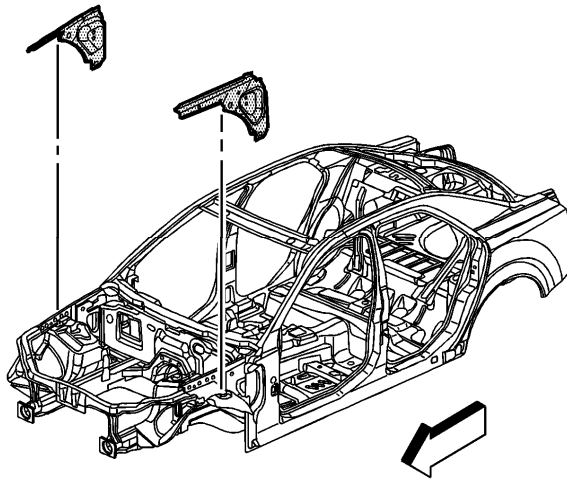


Upper Rail Replacement

Removal Procedure

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

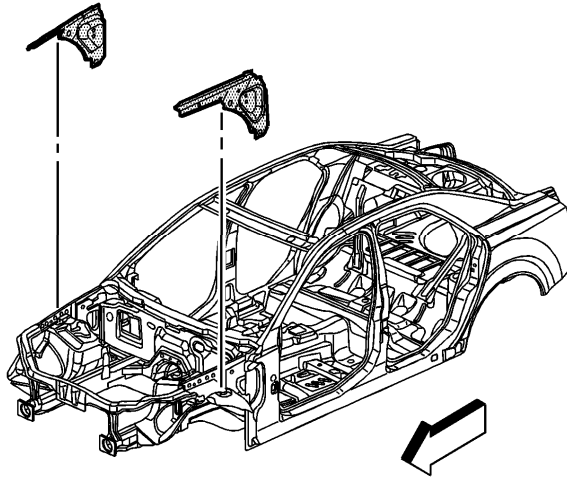
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.



Important: Sectioning of the front upper rails is not recommended.

3. Remove all related panels and components.
4. Restore as much of the damage as possible .
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
6. Locate, mark, and drill out all factory welds attaching the outer rail.
7. Remove the damaged outer rail.

Installation Procedure



1. Prepare the mating surfaces as necessary.
2. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).

Important: If the location of the original plug weld holes can not be determined, or if structural weld-thru adhesive is present, space the plug weld holes every 40 mm (1½ in).

3. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the original panels.
4. Temporarily position the outer rail on the vehicle.
5. Verify the location using 3-dimensional measuring equipment.
6. Plug weld accordingly.
7. Clean and prepare welded surfaces.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
9. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
10. Install all of the related panels and components.
11. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
12. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.