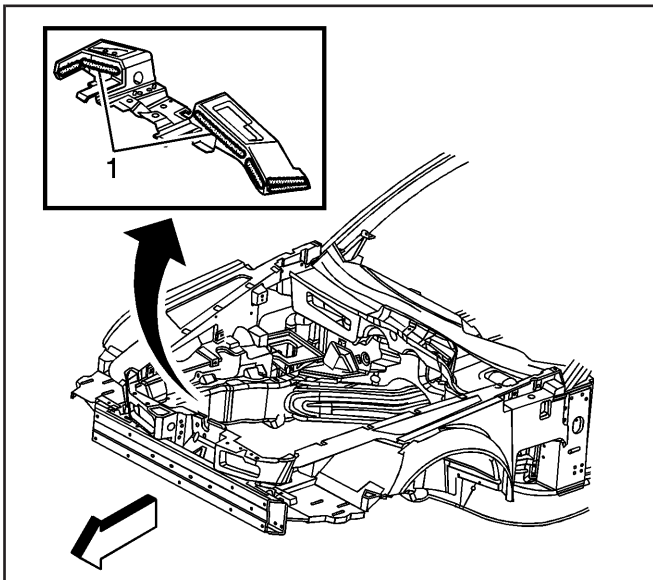


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Panel Replacement - Front End

Tools Required

J 42058 Frame Adapter Clamp

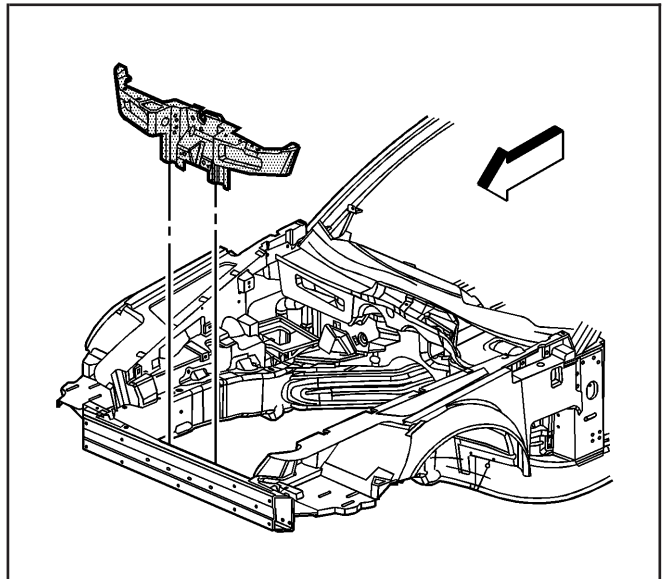
Removal Procedure

Caution: To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

The front end panel is made of sheet molded compound (SMC), and is bonded to the front structure and frame rails with structural adhesive.

1. Disable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-66.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Remove the bolts that attach the front end panel to the front impact bar.
5. Remove the front end panel by applying heat and pry to detach the adhesive along the bonding surface (1).

6. Remove the front end panel from the vehicle.
7. Save any and all brackets, mounting studs, and accessories for transfer to the new front end panel.
8. Note the location of the adhesive and remove all remaining loose adhesive.
9. Inspect the front structure and frame rails for damage.
10. Restore as much of the damage as possible to the factory specifications. Refer to *Dimensions - Body* on page 2-2 and *Measurements - Underbody* on page 2-4.
11. Use *J 42058* to secure the vehicle if pulling and straightening is required.



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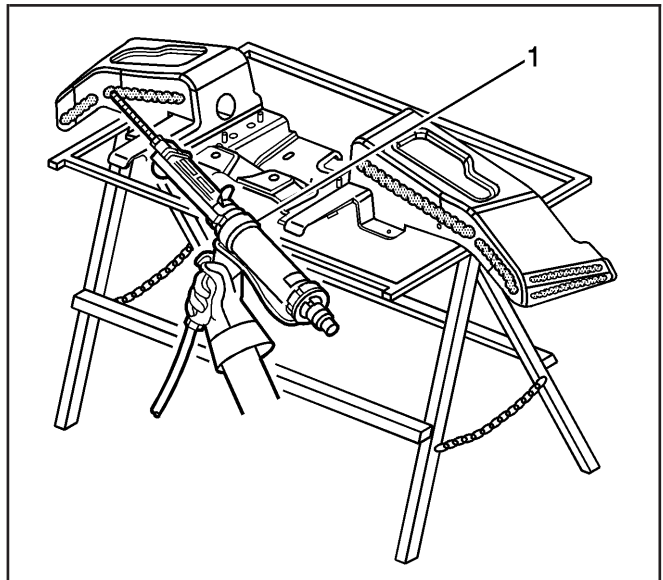
Installation Procedure

Important: Shims may be necessary to achieve proper panel alignment.

1. Before applying adhesive dry fit the front end panel for proper fit and alignment.

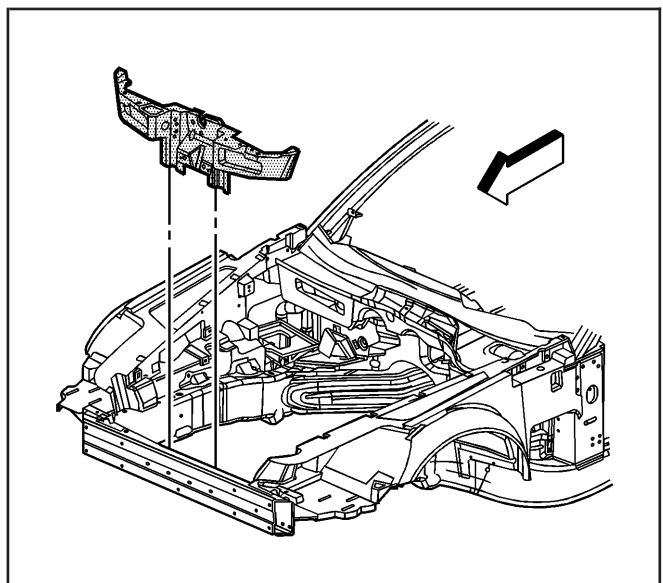
Important: DO NOT top coat any bonding surface. Use primer only on bonding surfaces. Refer to adhesive manufacturer's recommendations.

2. Clean and prepare all bonding mating surfaces according to adhesive manufacturer's recommendations.
3. Apply a consistent bead of structural adhesive (1) 10 mm (3/8 in) in diameter to the front end panel to mate with the front structure and frame rails. Refer to *Sheet Molded Compound (SMC) Panel Bonding* on page 2-56.

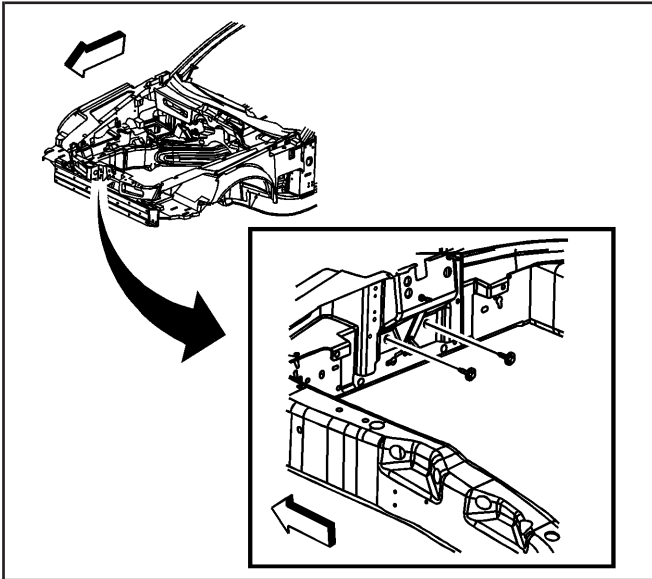


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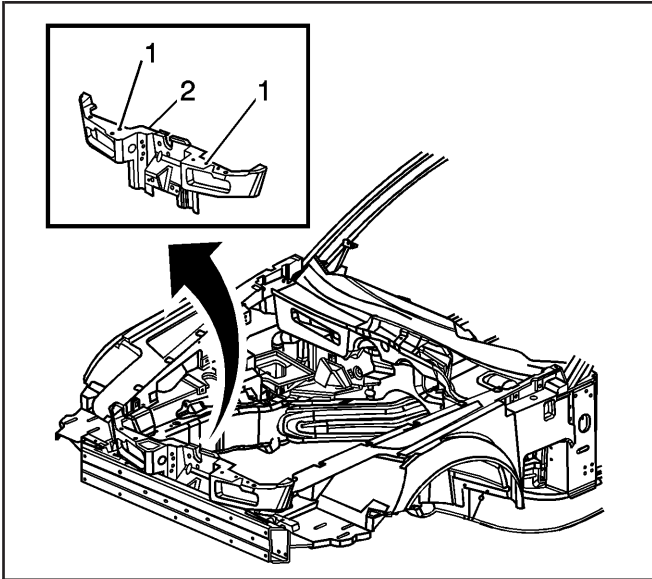
4. Install the front end panel to the vehicle.
5. Apply pressure to the front end panel to set the adhesive.



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Notice: Use the correct fastener in the correct location. Replacement fasteners must be the correct part number for that application. Fasteners requiring replacement or fasteners requiring the use of thread locking compound or sealant are identified in the service procedure. Do not use paints, lubricants, or corrosion inhibitors on fasteners or fastener joint surfaces unless specified. These coatings affect fastener torque and joint clamping force and may damage the fastener. Use the correct tightening sequence and specifications when installing fasteners in order to avoid damage to parts and systems.

6. Hand tighten the bolts (1) that attach the front end panel to the front impact bar.

Tighten

Tighten the bolts to 25 N·m (18 lb ft).

7. Clamp or mechanically fasten the front end panel into place as necessary.
8. Remove any excess adhesive.
9. Drill two 10 mm (3/8 in) holes (1) in the front end panel (2) for the inboard upper grille attachment points.
10. Install all related panels and components.
11. Connect the negative battery cable.
12. Enable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-66.