

## Wheelhouse Replacement - Front

### Tools Required

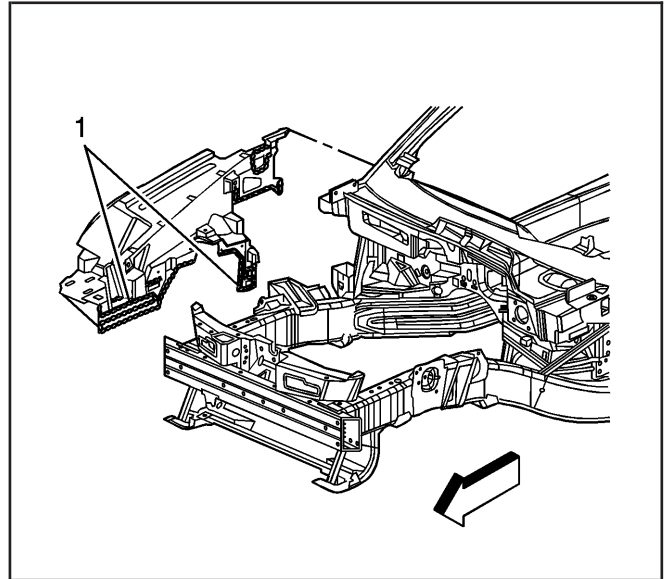
J 42058 Frame Adapter Clamp

### Removal Procedure

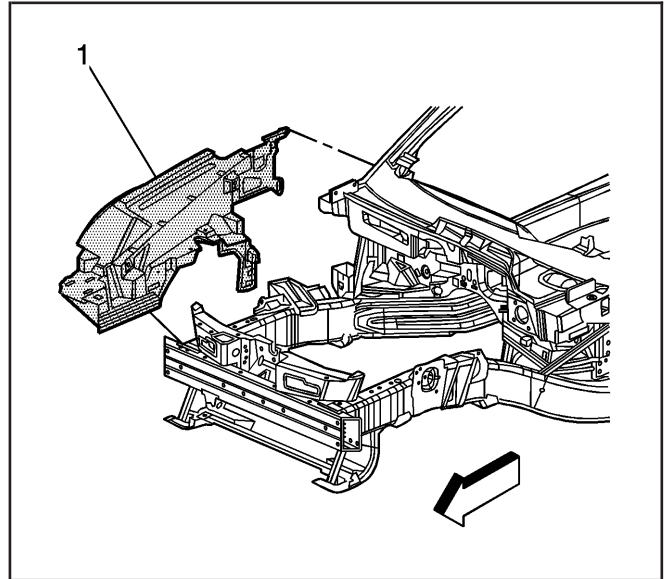
**Caution:** To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves,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

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

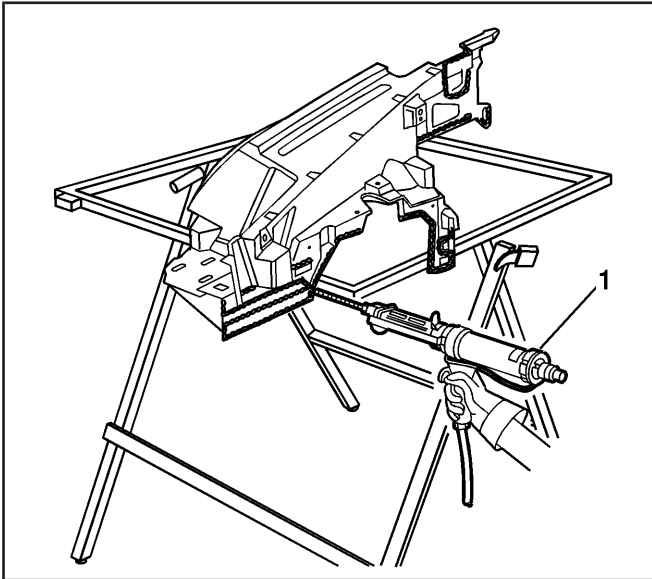
1. Disable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-66.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Remove the wheelhouse by applying heat and pry to detach adhesive along the bonding surface (1).
5. Remove the wheelhouse (1) from the vehicle.
6. Save any and all brackets, mounting studs, and accessories for transfer to the new front wheelhouse.
7. Note the location of the adhesive and remove all remaining loose adhesive.
8. Inspect the front structure and frame rails for damage.
9. 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.
10. Use J 42058 to secure the vehicle if pulling and straightening is required.



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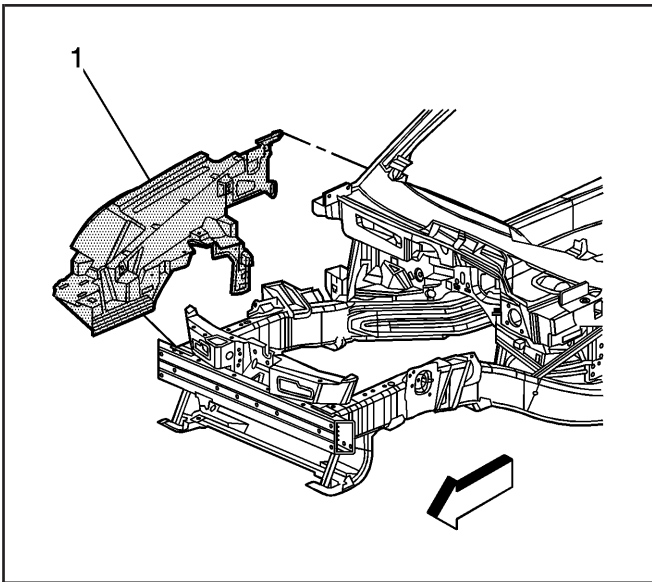
## Installation Procedure

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

1. Before applying adhesive dry fit the wheelhouse for proper fit and alignment.

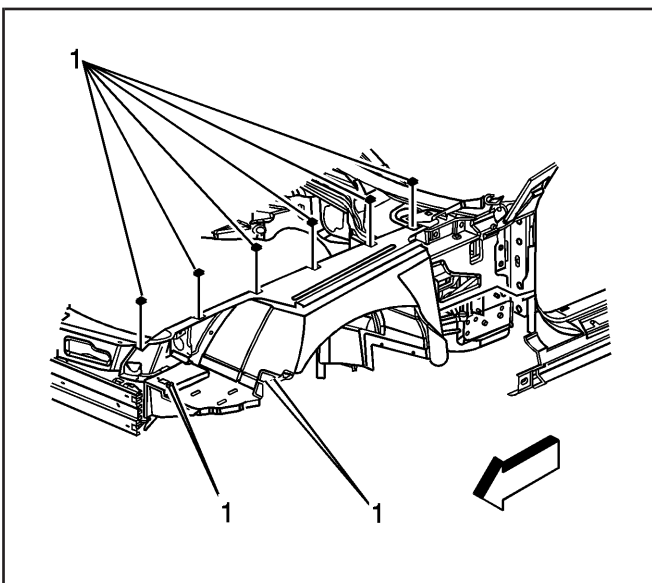
**Important:** DO NOT top coat any bonding surface. Use primer only on bonding surfaces. Refer to adhesive manufacturer's recommendations.

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 wheelhouse to mate with the front structure and frame rail. Refer to *Sheet Molded Compound (SMC) Panel Bonding* on page 2-56.



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4. Install the wheelhouse (1) to the vehicle.
5. Apply pressure to the wheelhouse to set the adhesive.
6. Clamp or mechanically fasten the wheelhouse into place as necessary.
7. Remove any excess adhesive.



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8. Drill 10 mm (3/8 in) holes (1) in the wheelhouse for the fender attachment points.
9. Install all related panels and components.
10. Connect the negative battery cable.
11. Enable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-66.