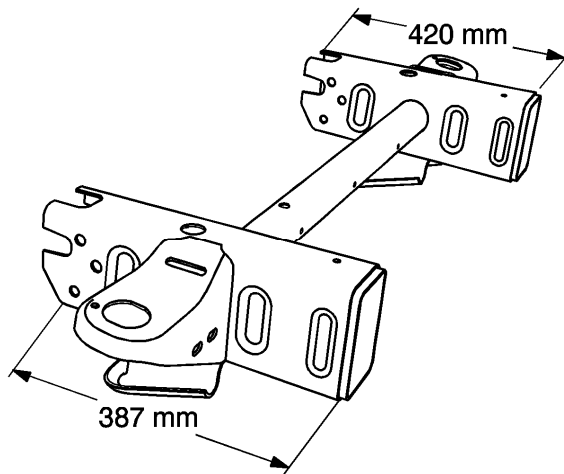


Front Full Frame Sectioning

Removal Procedure



The re-designed frame assembly for the new C/K Pick-Up and Utility Trucks is a mild steel, hydroformed frame assembly. A pre-sleeved replacement front frame service section, consisting of the left and right frame rail ends, body, mounting brackets and front connecting cross tube is available. Replacement bolt-on front bumper brackets are available and must be ordered separately.

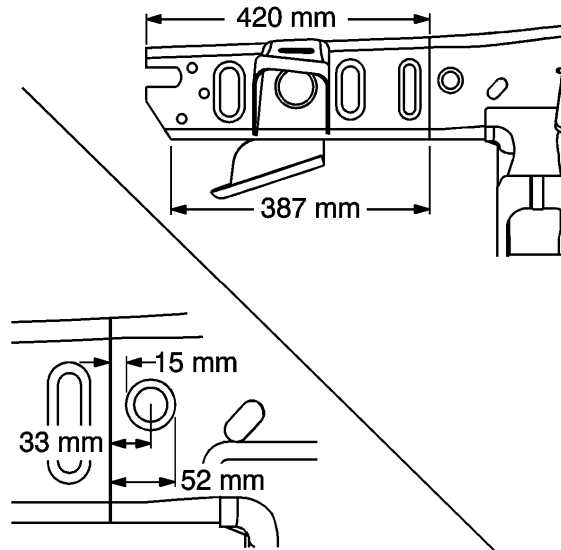
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

Caution: Refer to [Collision Sectioning Caution](#) in Cautions and Notices.

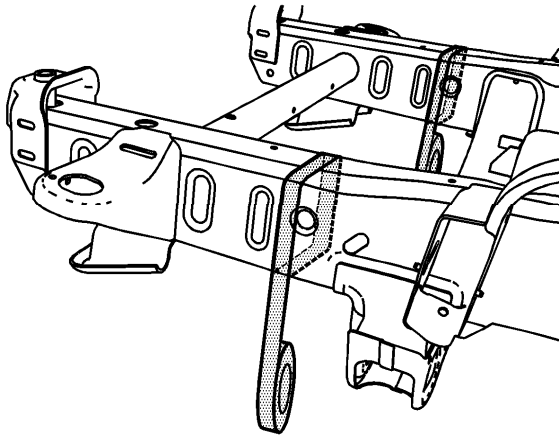
Important: Perform all of the steps on both of the rails for complete module replacement.

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

3. Remove all of the related panels and components.

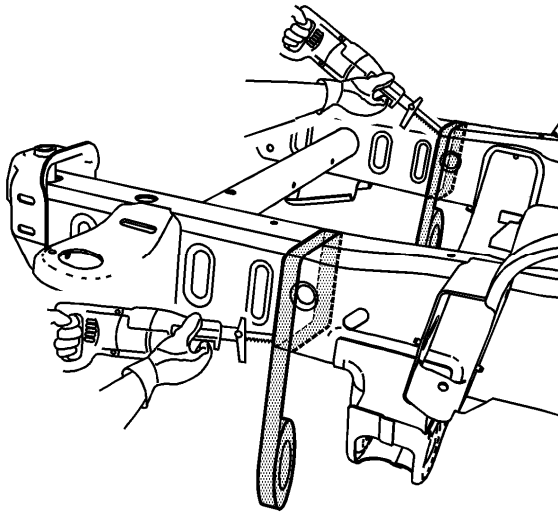


4. Locate and mark the sectioning location by using at least 2 of the measurements below for each frame rail:
 - Top of the frame rail edge rearward 420 mm (16 1/2 in) (with bumper bracket removed)
 - Bottom of the frame rail edge rearward 387 mm (15 3/16 in) (with bumper bracket removed)
 - Front edge of the gage hole forward 15 mm (9/16 in)
 - Center of the gage hole forward 33 mm (1 1/4)
 - Rear edge of the gage hole forward 52 mm (2 in)



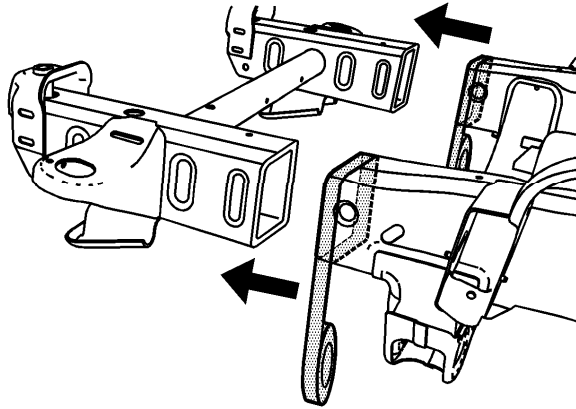
Important: Line up the masking tape with the tape edge facing the front of the vehicle on the sectioning location.

5. Apply masking tape completely around the frame rail next to the sectioning location as shown.



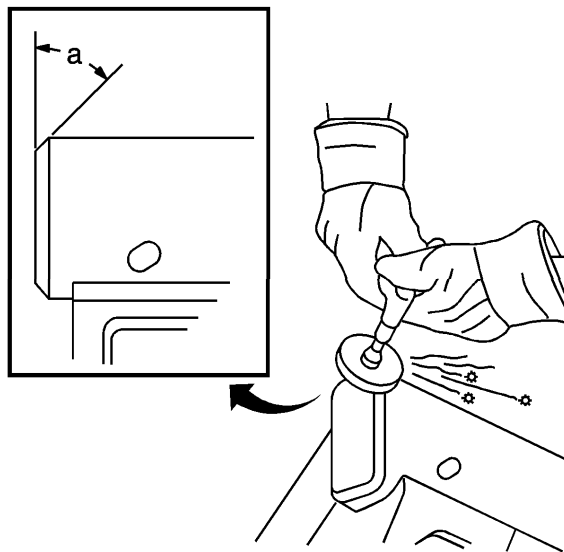
Important: The tape edge facing the front of the vehicle is the proper cut location.

6. Cut each frame rail at the front edge of the tape line using a reciprocating saw or equivalent, as shown.



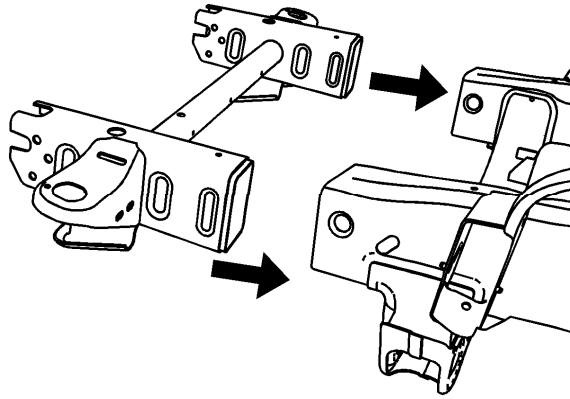
7. Remove the damaged frame section.

Installation Procedure

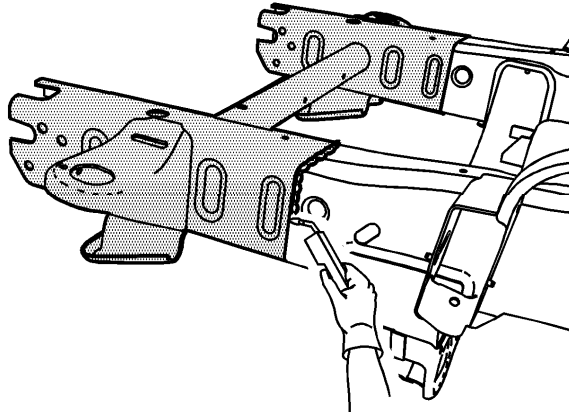


1. Grind the existing frame rail seam to taper seam at a 45 degree angle.
2. Prepare all of the attaching surfaces as necessary.

3. Apply the weld-thru primer to all of the welded surfaces.



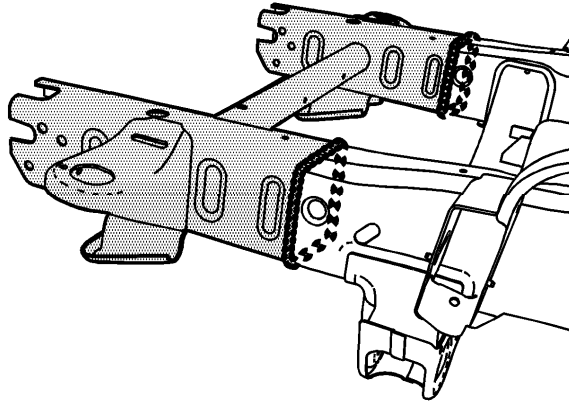
4. Position the service frame section to the existing frame and clamp in place.



Important: Verify the frame measurements 3-dimensionally to ensure proper position of the service frame.

5. Continuous-weld the upper and lower horizontal joints through each corner.

6. Continuous-weld the inner and outer vertical joints from corner to corner.



7. Clean and prepare all of the welded surfaces.
8. Install all of the related panels and components.
9. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
10. Enable the SIR system. Refer to [SIR Disabling and Enabling](#).