

Underbody Outer Front Side Rail Sectioning

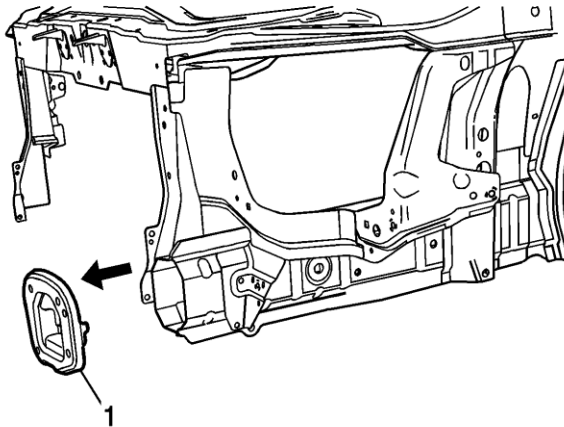
Removal Procedure

Warning: Refer to [Approved Equipment for Collision Repair Warning](#) in the Preface section.

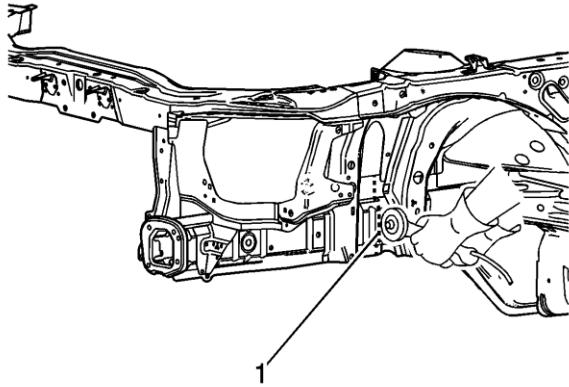
Warning: Refer to [Glass and Sheet Metal Handling Warning](#) in the Preface section.

Warning: Refer to [Collision Sectioning Warning](#) in the Preface section.

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 related panels and components.
4. Restore as much of the damage as possible to factory specifications.
5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).

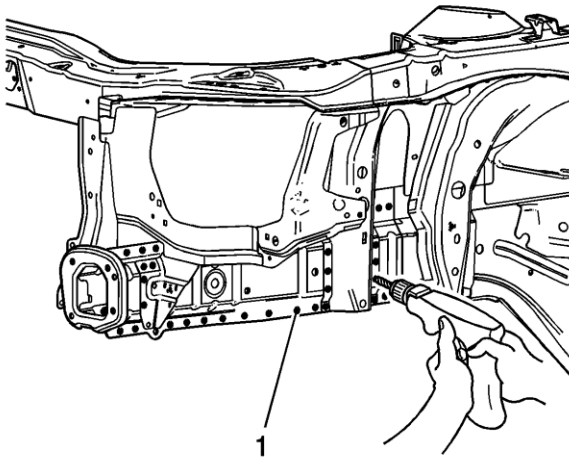


6. Remove the Front bumper Bracket (1).



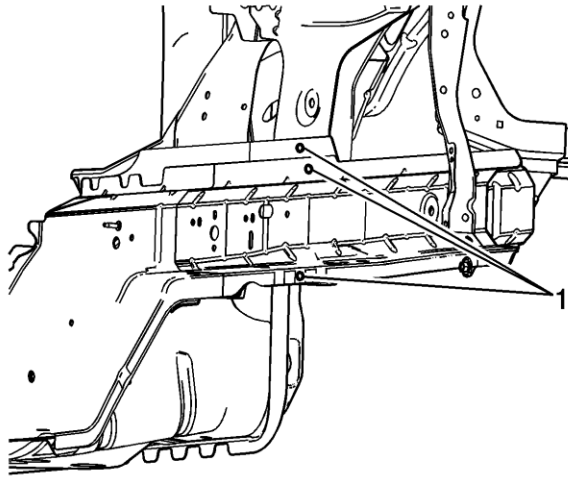
Note: Do not damage any inner panels or reinforcements.

7. Cut the Rail Front Outer Side at the rear edge of the strengthening bead located between the Wheelhouse reinforcements (1).

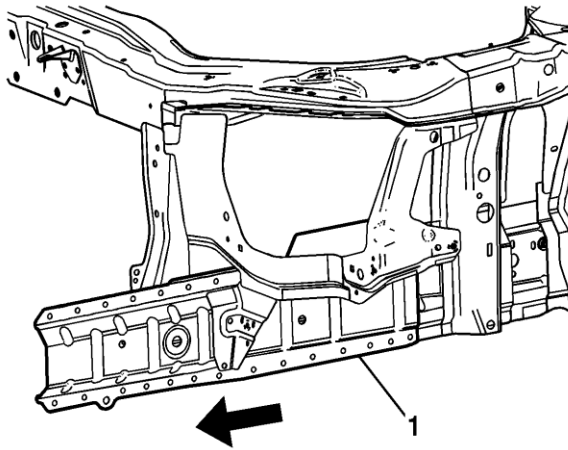


Note: Do not damage any inner panels or reinforcements.

8. Locate and drill out all factory welds. Note the number and note the location of the welds for installation of the service Rail Front Outer Side (1).

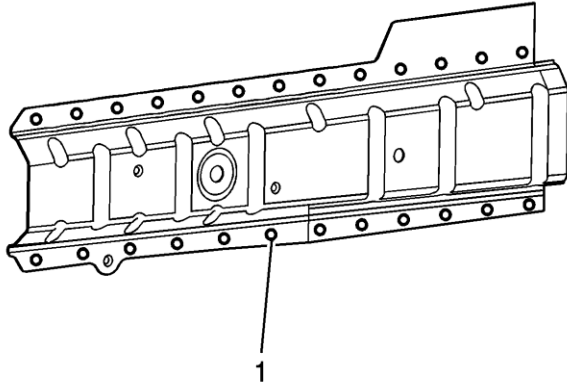


9. Locate and drill out the three hidden welds on the inside flange of the Rail (1). These welds must be drilled all the way through.



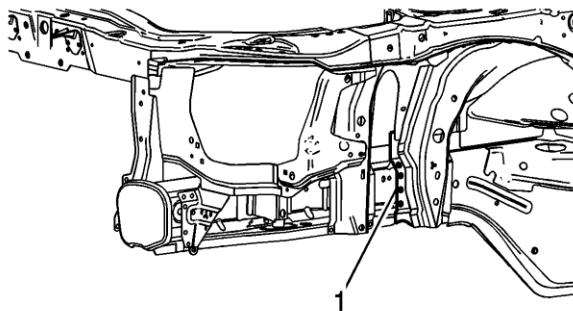
10. Remove the damaged Rail Front Outer Side (1).

Installation Procedure

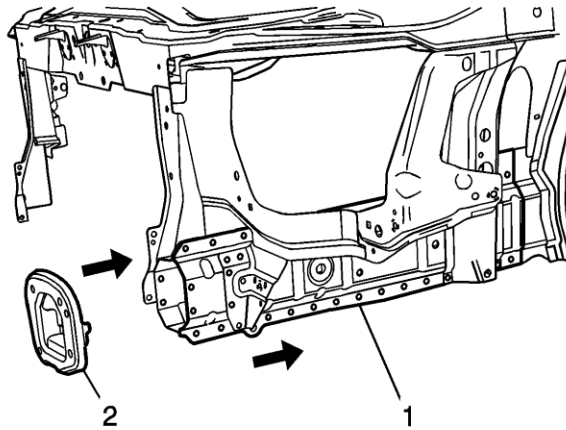


Note: In any area damaged beyond recognition, space plug weld holes every 40 mm (1½ in) apart.

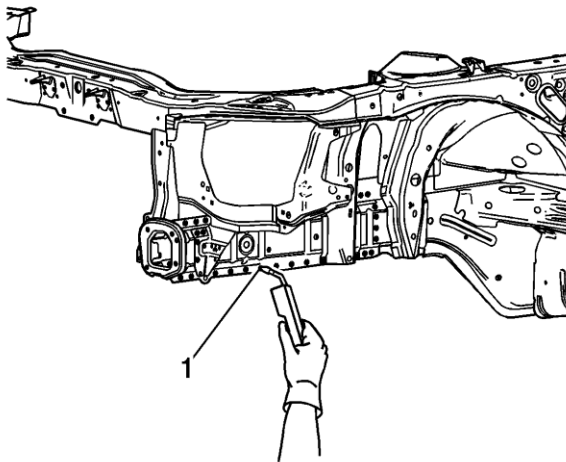
1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel (1).



2. Drill 8 mm (5/16 in) plug weld holes along the sectioning cut on the remaining original rail (1). Locate these holes 40 mm (1½ in) apart.
3. Prepare all attachment surfaces as necessary for welding.
4. Apply GM approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).

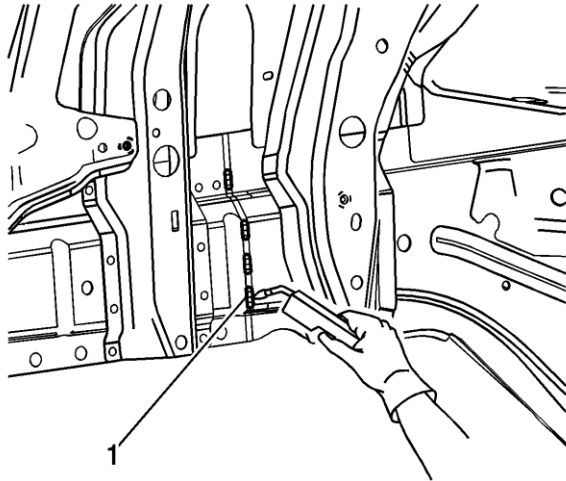


5. Position the service Rail Front Outer Side by sliding the pre-stepped portion of the service rail under the original rail (1).
6. Position the Front Bumper Bracket (2).
7. Clamp service parts in position.
8. Inspect the rail for proper position using 3-dimensional measuring equipment.



9. Tack weld the parts in position (1).

10. Plug weld accordingly.



11. Stitch weld along the entire sectioning joint (1), make 25 mm (1 in) welds along the seam with 25 mm (1 in) gaps between.
12. Complete the stitch welds.
13. Clean and prepare all welded surfaces.
14. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).
15. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#).
16. Install all related panels and components.
17. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
18. Enable the SIR system. Refer to [SIR Disabling and Enabling](#).

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