

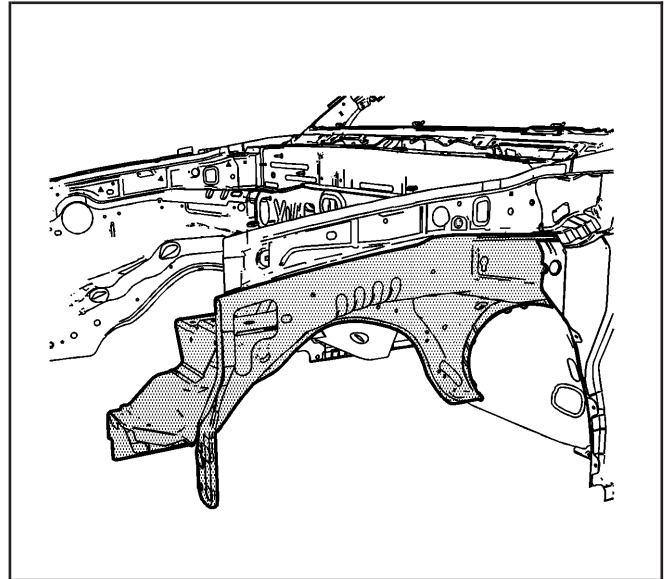
## Wheelhouse Replacement - Front

### Removal Procedure

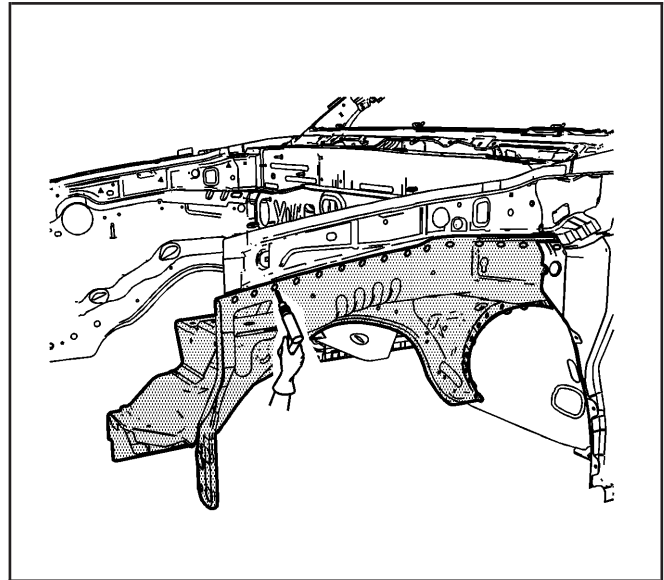
**Caution:** To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves,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

1. Disable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-81.
  2. Disconnect the negative battery cable.
  3. Remove all related panels and components.
  4. Repair as much of the damage as possible to factory specifications. Refer to *Dimensions - Body* on page 2-2.
  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* on page 1-5 in General Information.
  6. Remove the radiator support. Refer to *Radiator Support Replacement* on page 2-32.
- Important:** Do not damage any inner panels or reinforcements.
7. Locate and drill out all factory welds. Note the number and location of welds for installation of the service part.

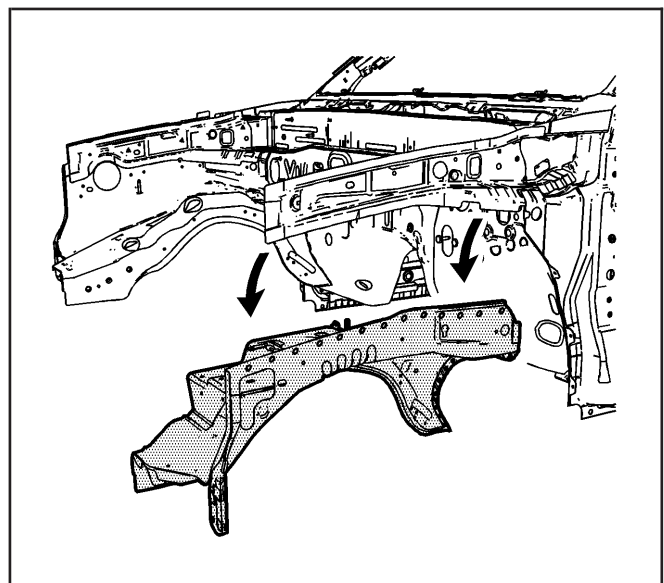
8. Remove the damaged apron extension.



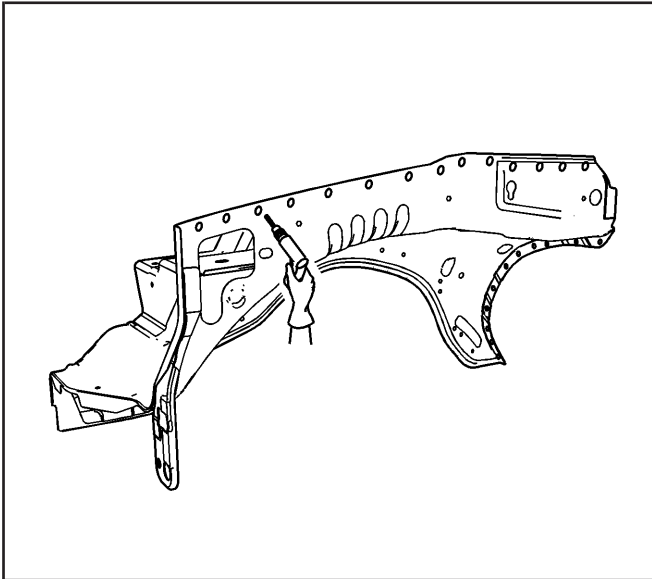
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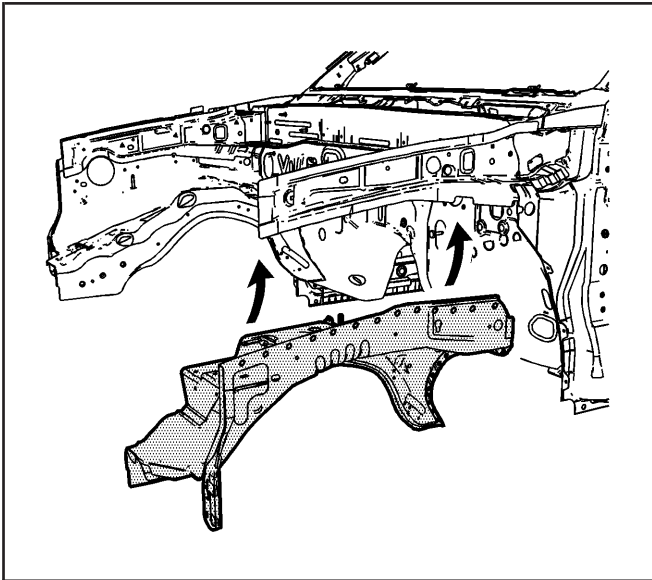


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## Installation Procedure

**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) apart.

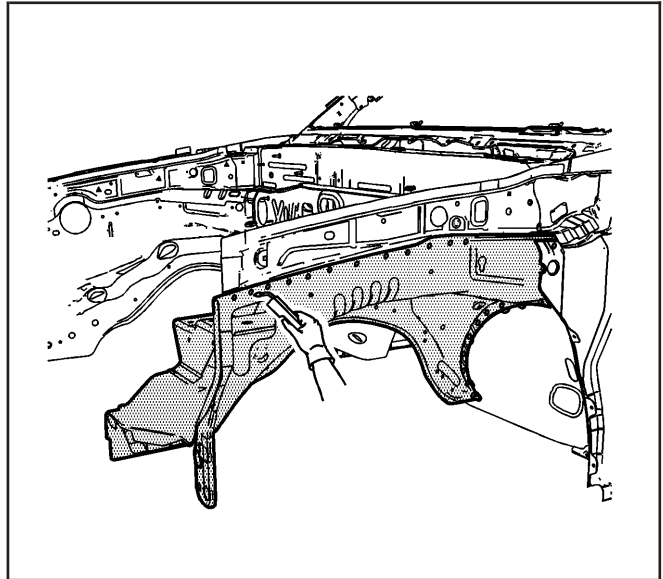
1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Prepare all mating surfaces as necessary.
3. Apply 3M® Weld-Thru coating P/N 05916 or equivalent to all mating surfaces.



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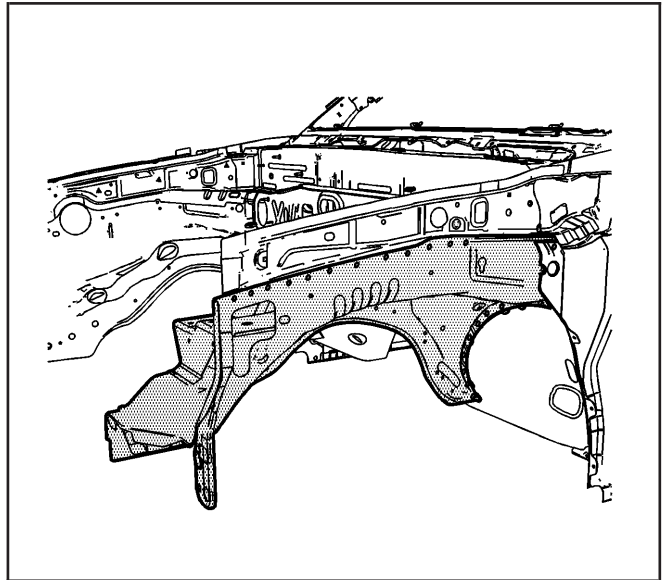
4. Position the front wheelhouse.

5. Plug weld accordingly.
6. Install the radiator support. Refer to *Radiator Support Replacement on page 2-17*



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7. Clean and prepare all welded surfaces.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to *Anti-Corrosion Treatment and Repair on page 1-5* in General Information.
9. Paint and repair the area. Refer to *Basecoat/Clearcoat Paint Systems on page 1-7* in General Information.
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 2-81*.



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