

# Front Floor Panel

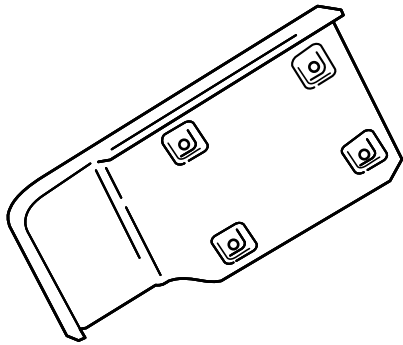


Fig. 3.43 — Floor Panel Service Part

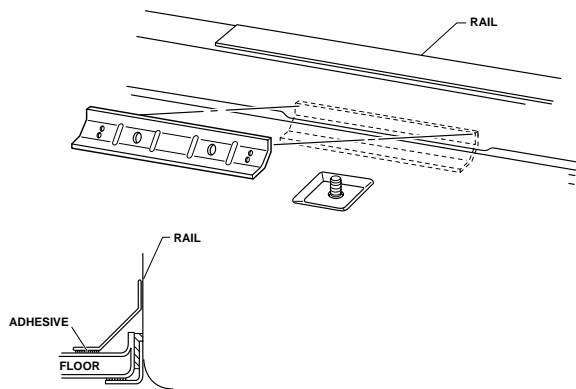


Fig. 3.44 — Remove Reinforcement

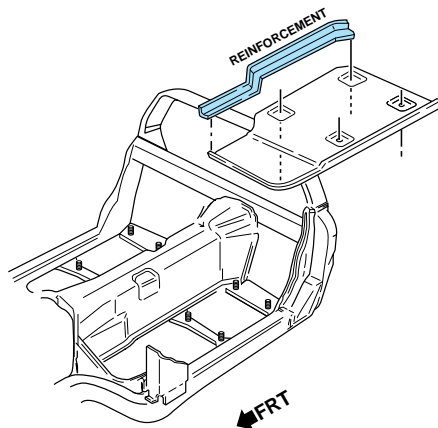


Fig. 3.45 — Reinforcement Bonded to Tunnel and Floor

The floor panel is serviced as separate left and right side components (Fig. 3.43). The panels are bonded around the outer edges and across the seat mounting braces. For repair other than full panel replacement see *SMC Repair Procedures*.

— REMOVE OR DISCONNECT —

- 1 Remove all panels and components to gain access to the floor panel. This will include removing seat and carpeting.

**Notice:** When servicing the right front floor panel, the bonded and bolted electrical component mounting brackets must be removed. Remove or reposition electrical components and wiring harness as necessary to avoid damage.

- 2 Visually inspect for damage to the frame rail and seat mounting brace, restore as much of the damage as possible to specifications using three-dimensional measuring procedures.
- 3 Remove the side reinforcement bonded to the floor panel and the frame rail (Fig. 3.44).
- 4 Remove the side reinforcement bonded to the floor panel and the tunnel area (Fig. 3.45). NOTE: Use care when removing the reinforcement, if damaged during the removal process replacement will be necessary.
- 5 Apply upward force and heat simultaneously to the floor panel as necessary to detach adhesive. Remove damaged floor panel.

**Important:** Save wiring harness clips (3 per side), for transfer to service floor panel.

— INSTALL OR CONNECT —

- 1 Remove all original adhesive using suitable tool. Scuff all bonding surfaces to ensure proper adhesion. (Refer to *SMC Repair Procedures*.)
- 2 Clean and prepare all bonding surfaces as necessary. (Refer to *SMC Repair Procedures*.)  
**Important:** Prior to refinishing, refer to *GM P/N 4901 Refinish Manual for recommended products*.
- 3 Apply approved anti-corrosion primer.  
**Notice:** DO NOT top-coat any bonding surface.

- 4 Temporarily position the service panel and check for proper fit, make sure the perimeter of the floor panel and the seat mount cross-brace fit flush. Remove service panel.
- 5 After primer is fully cured, apply adhesive to the mating flanges as necessary, (Keep adhesive away from seat studs to minimize squeeze out), and install service floor panel. Apply even pressure to all bonding surfaces to ensure the floor panel fits flush and level (Fig. 3.46).

**Important: Use US Chemical and Plastics 82014B System 2000 Structural Adhesive, a PLIOGRIP® adhesive manufactured by Ashland Chemical Company, or equivalent. Note the 9 minute working time and 1 hour cure time.**

- 6 Apply adhesive to the floor panel support bracket, and install to attach floor panel to tunnel as in Fig. 3.47. Apply adhesive to the floor panel brace and install as shown in Fig. 3.48. Screw the ends of the brace securely to the floor panel, apply pressure evenly for uniform adhesive 'wet-out' (Fig. 3.47). Apply adhesive to wiring harness clips (3), and install at the etched indicators on the service panel by pressing firmly into place.
- 7 Temporarily install the seat mounting nuts to 'wet-out' the adhesive at the cross brace. Smooth adhesive squeeze-out around perimeter of floor panel from underside of vehicle to form a consistent, leak-proof seal.
- 8 Apply constant firm pressure in the 'toe-pan' area until the adhesive is fully cured. After the adhesive is fully cured, remove the seat mounting nuts.
- 9 Finish and feather-edge the repair areas as necessary to resemble OEM.
- 10 Prime the body with suitable primer. Apply sealers and anti-corrosion materials as necessary.
- 11 Apply top-coat over all primed areas. Refer to paint manufacturer's recommendations. Do not combine paint systems.
- 12 Install all related panels and components.

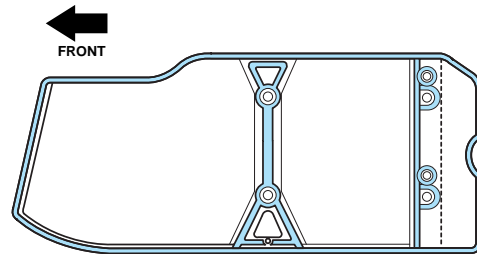


Fig. 3.46 — Shaded Area Represents Bond

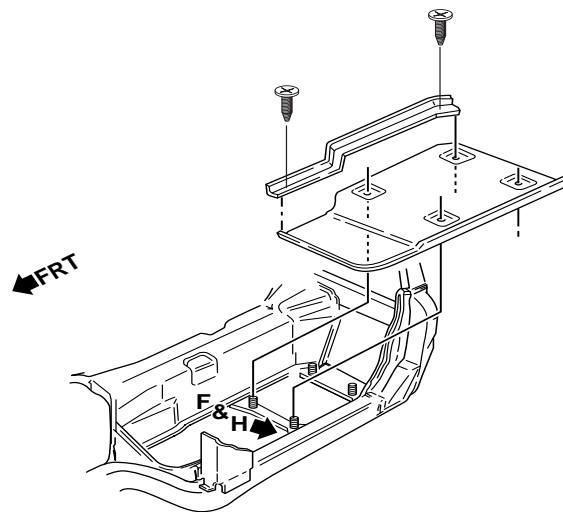


Fig. 3.47 — Trim Screws May Be Necessary to Secure Panel While Adhesive Cures

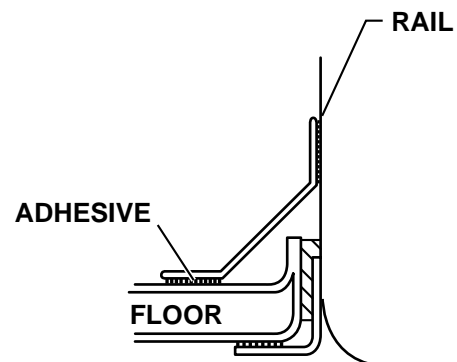


Fig. 3.48 — Cross Section of Floor and Rail Brace