

Front Bumper Impact Bar Replacement

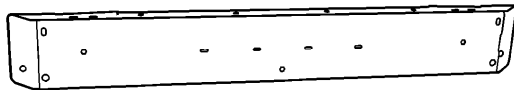
Tools Required

[J 42058](#) Frame Adapter Clamp

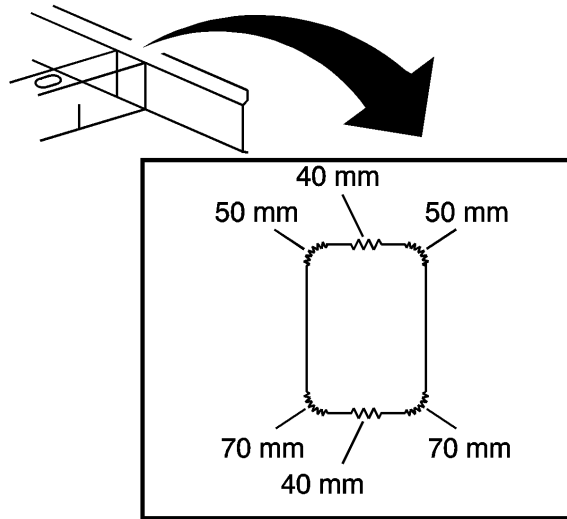
Removal Procedure

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

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. Remove or reposition the wiring to avoid damage.
5. Repair as much of the damage as possible to the factory specifications.

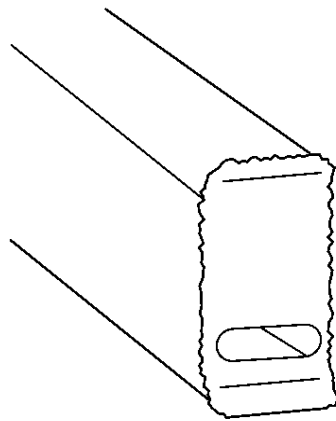


6. Use [J 42058](#) to secure the vehicle if pulling and straightening are required.
7. Note the location and remove the sealers and anti-corrosion materials from the repair area. Refer to [Anti-Corrosion Treatment and Repair](#).



Important: Do not cut into the frame rails.

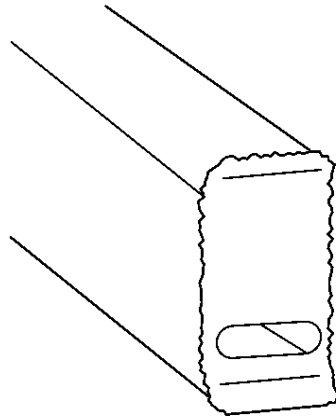
8. Cut the welds around the perimeter of the frame rail ends. Cut the welds favoring the impact bar side of the joint.
9. Remove the damaged impact bar.



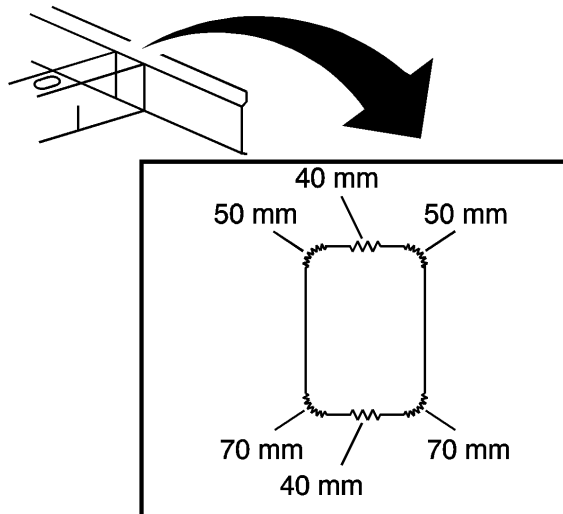
10. Extract pieces of the impact bar which are left attached to the rail ends.
11. Straighten and deburr the rail ends. Keep the perimeter and shape of the rail end as original as possible.

Installation Procedure

1. Temporarily position the impact bar for proper fit and alignment.



2. Clean and prepare all of the welded mating surfaces.
3. Apply GM-approved weld-thru coating or equivalent as necessary and to the inside of the rail ends. Refer to [Anti-Corrosion Treatment and Repair](#).
4. Position the bumper impact bar to the vehicle using 3-dimensional measuring equipment.



Important: If no trace of the original welds is present, follow the pattern specified for welding the side rails to the impact bar.

5. Using a metal inert gas (MIG) welder, stitch weld the front bar to the frame rail ends.
 6. Apply the sealers and anti-corrosion materials to the repair area. Refer to [Anti-Corrosion Treatment and Repair](#).
 7. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#).
 8. Install all 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](#).
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