

# Rear Bumper Impact Bar Replacement

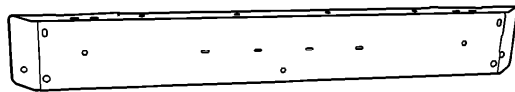
## Tools Required

[J 42058](#) Frame Adapter Clamp

## Removal Procedure

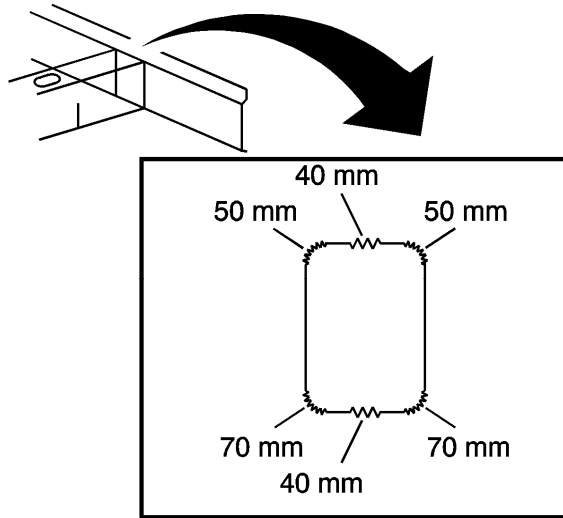
**Caution:** Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

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.



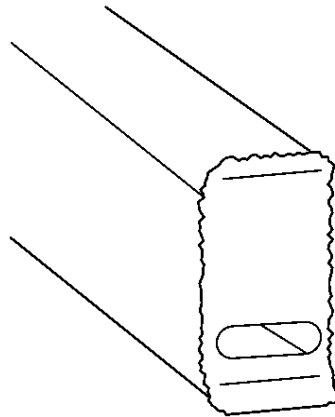
6. Use [J 42058](#) to secure the vehicle if pulling and straightening are required.
7. Note the location and remove the sealers and anti-corrosion materials from the repair area. Refer to [Anti-Corrosion Treatment and Repair](#).

8. Apply heat and pry apart to separate the impact bar from the rear compartment panel.



**Important:** Do not cut into the frame rails.

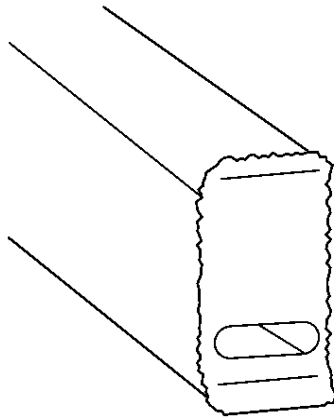
9. Cut the welds around the perimeter of the frame rail ends. Cut the welds favoring the impact bar side of the joint.
10. Remove the damaged impact bar.



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

## Installation Procedure

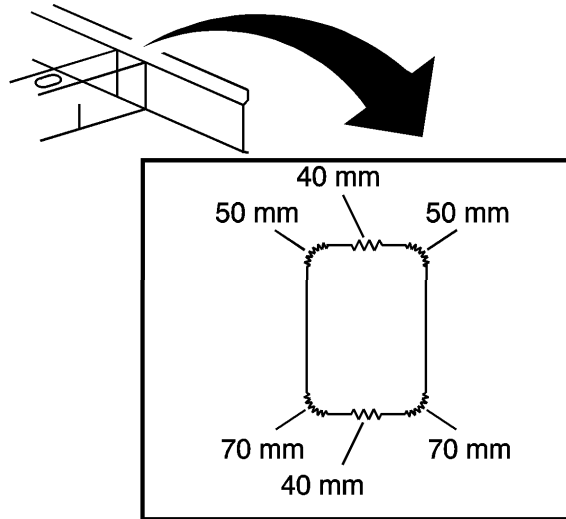
1. Temporarily position the impact bar for proper fit and alignment.



2. Clean and prepare all of the welded surfaces.
3. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).

**Important:** DO NOT top coat the bonding surface of the rear bar. Use primer only on bonding surfaces. Refer to adhesive manufacturer's recommendations.

4. Clean and prepare all bonding mating surfaces according to adhesive manufacturer's recommendations.
5. Apply a consistent bead of structural adhesive to the top impact bar to bond to the rear compartment panel. Refer to [Sheet Molded Compound \(SMC\) Panel Bonding](#).
6. Position the bumper impact bar to the vehicle using 3-dimensional measuring equipment.



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

7. Using a metal inert gas (MIG) welder, stitch weld the rear bar to the frame rail ends.
  8. Apply the sealers and anti-corrosion materials to the repair area. Refer to [Anti-Corrosion Treatment and Repair](#).
  9. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#).
  10. Install all related panels and components.
  11. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
  12. Enable SIR system. Refer to [SIR Disabling and Enabling](#).
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