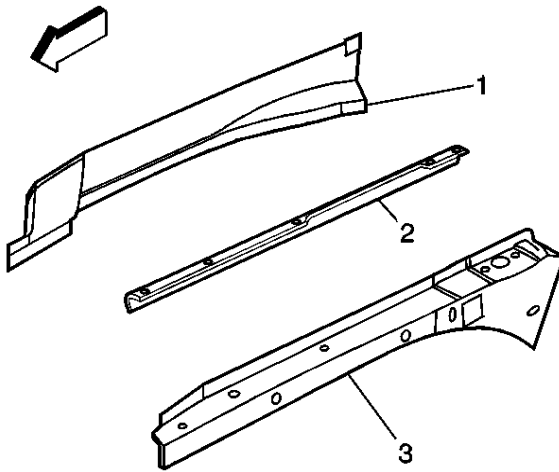


Upper Rail Replacement

Removal Procedure

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

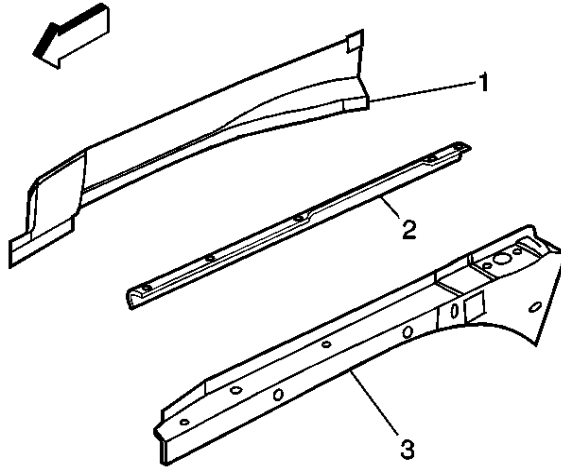


Important: The front upper rail is serviced as 2 components: inner (1) and outer (3) panels. The outer panel is serviced as a sub-assembly and includes an inner reinforcement (2). After the outer rail has been removed, the inner rail is completely accessible and can be serviced at the factory seams.

Important: Sectioning of the front upper rails is not recommended.

1. Remove all related panels and components.
2. Remove sealers and anti-corrosion materials as necessary.
3. Locate, mark, and drill out all factory welds attaching the outer rail.
4. Remove the damaged outer rail (3).
5. Locate, mark, and drill out the welds attaching the inner rail (1).
6. Remove the damaged inner rail.

Installation Procedure

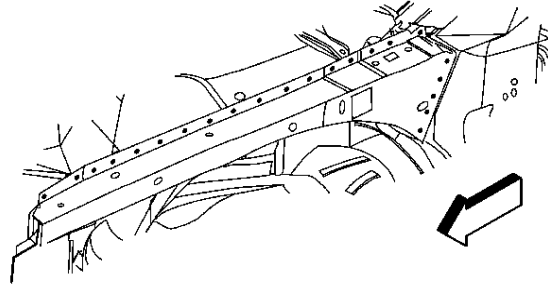


1. Prepare the mating surfaces as necessary. Inspect for proper fit of the service part.
2. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the original panels.

Important: If the original plug weld locations can not be determined, locate the holes for plug welding 40 mm (1½ in) apart.

3. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
4. Temporarily position the inner (1) and outer (3) rails on the vehicle.
5. Use 3-dimensional measuring to locate and mark front fender mounting-bolt holes in the outer rail (2).

6. Drill 5.5 mm (7/32 in) holes for self-tapping bolts as marked.



7. When the service panels are correctly positioned, remove the outer panel and plug weld the inner panel as necessary.
8. Reposition the outer rail with frequent measurements to ensure proper fit and alignment.
9. Plug weld accordingly.
10. Clean and prepare all of the welded surfaces.

Important: Prior to refinishing, refer to GM 4901MD-99 Refinish Manual for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

11. Prime with 2-part catalyzed primer.
12. Apply the sealers and the anti-corrosion materials as necessary.
13. Install all of the related panels and components.