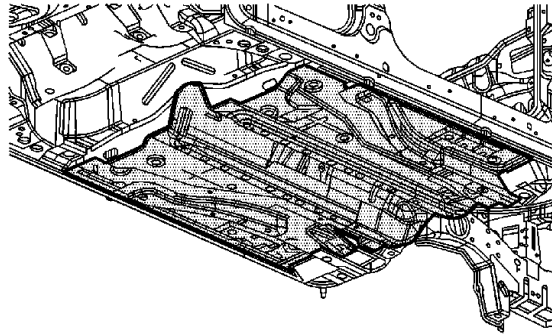


# Floor Panel Replacement - Center

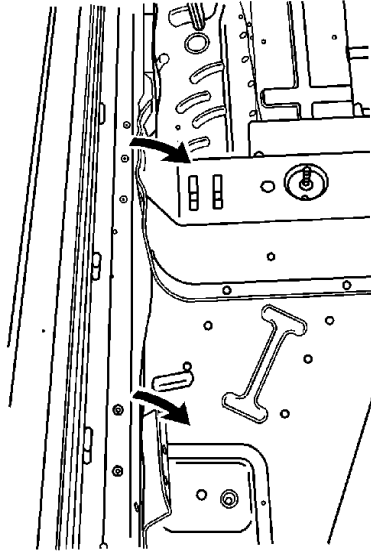
## Removal Procedure

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

1. Disable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.



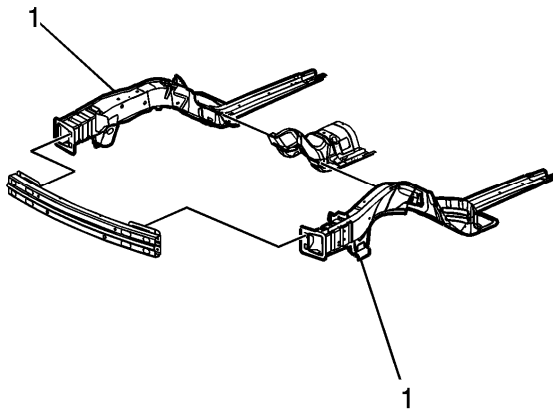
3. Remove all related panels and components.
4. Repair as much of the damaged area as possible. Refer to [Dimensions - Body](#) .
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.



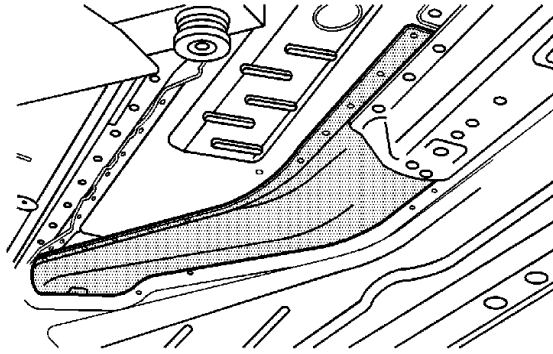
**Important:** Note the number and location of the factory welds for installation of the center floor panel.

**Important:** Do NOT damage or drill through adjacent panels.

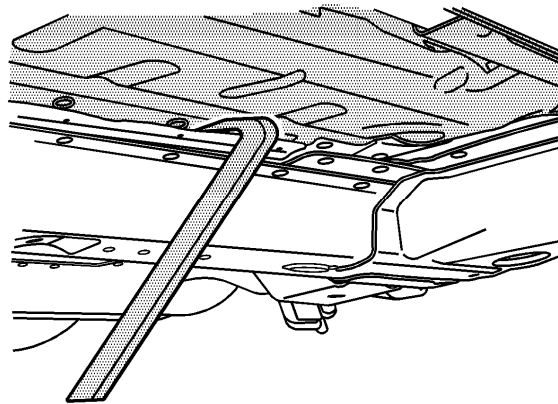
6. Locate and drill out the #2 and #3 bar attachments to the inner rocker panel.
7. Bend the upper weld flange up and away from the inner rocker panel.



8. Ensure that both front frame rails are removed (1). The center floor pan is removed through the bottom of the vehicle.

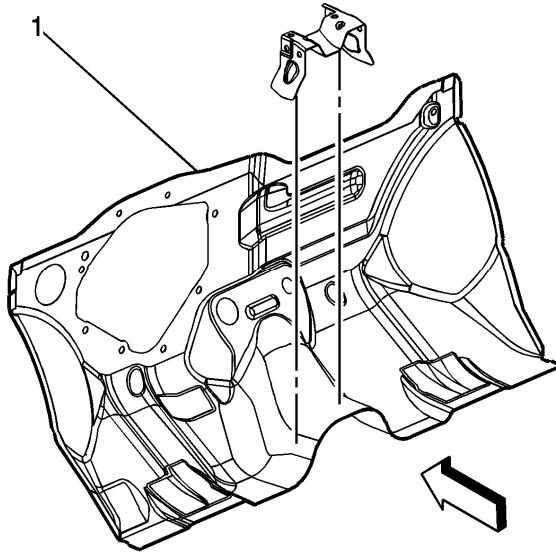


9. Drill out all plug welds in the rear portion of the front rail connected to the center floor panel. If the rail portion is undamaged, keep the portion for reinstallation.
10. Drill out all plug welds that attach the rear portion of the front rail to the intermediate portion of the front rail.

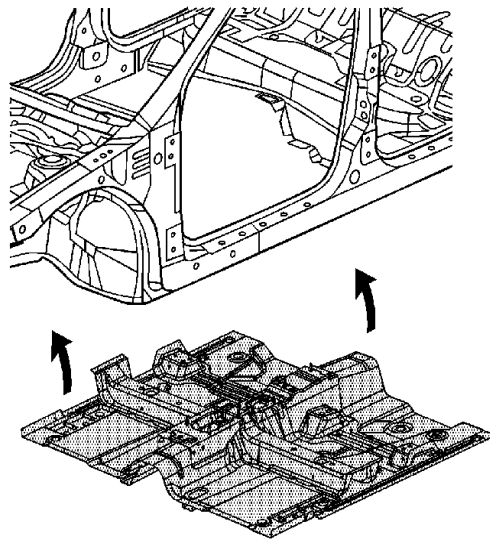


**Important:** Remove the rear section of the rail before you remove the center floor panel.

11. Using a 90 degree bent pry tool, pry the intermediate portion of the front rail apart from the rear portion of the rail far enough to allow the rear portion to slide free of the intermediate portion. Remove the rear portion of the front compartment rail.



12. Remove the foot well area (1) at the factory seams.

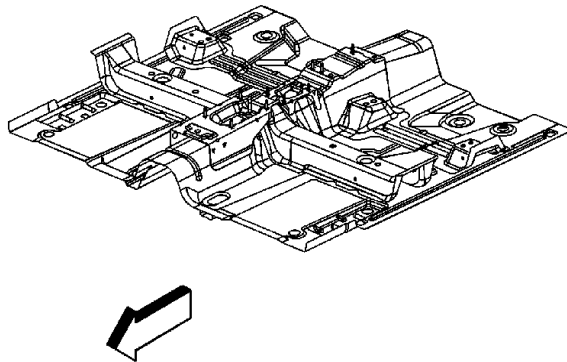


13. Locate and drill out all of the spot welds that attach the center floor pan to the following components:

- The dash and panel
- The #1 bar area
- The lower inner rockers
- The rear floor pan

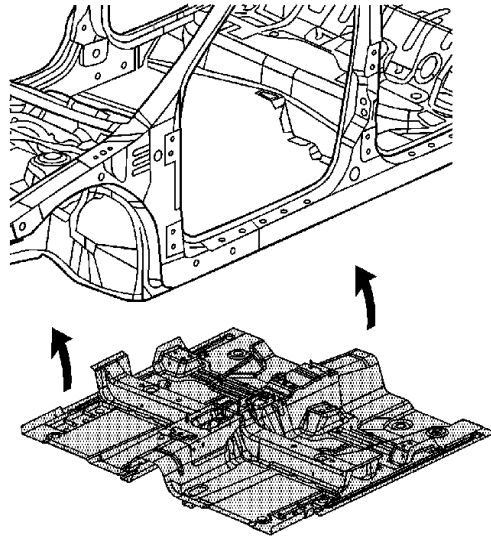
17. Remove the center floor panel by lowering the rear edge first and pulling down and rearwards until the floor pan is free from the vehicle.

### Installation Procedure

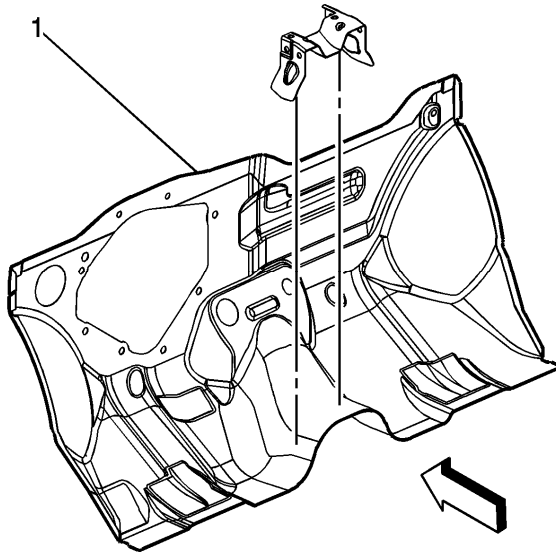


**Important:** If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

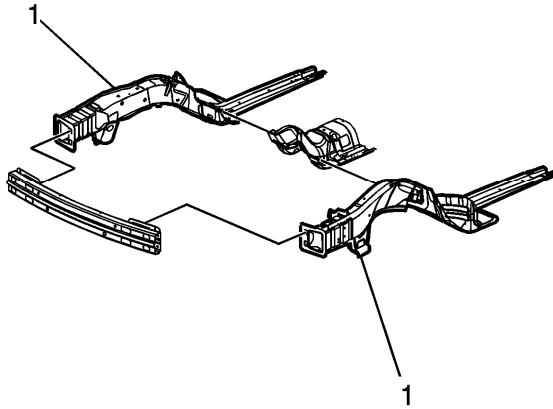
1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the corresponding locations noted on the original panel.
2. Prepare all mating surfaces as necessary.
3. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).



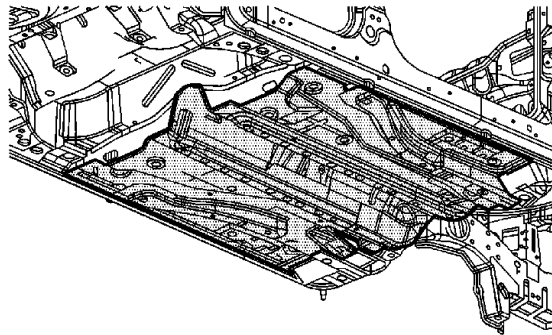
4. Position the center floor panel to the vehicle using 3-dimensional measuring equipment. Clamp the panel in place.



5. Install the foot well area (1).



6. Install the front frame rails (1).



7. Plug weld accordingly.
8. Clean and prepare all of the welded surfaces.
9. Install all of the related panels and components.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary.  
Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
11. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
12. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.
13. Enable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.