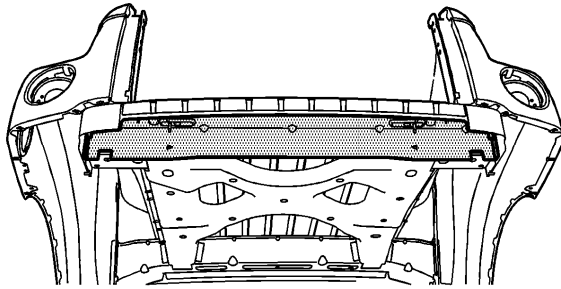


Cross Bar No.5 Replacement - Floor Panel

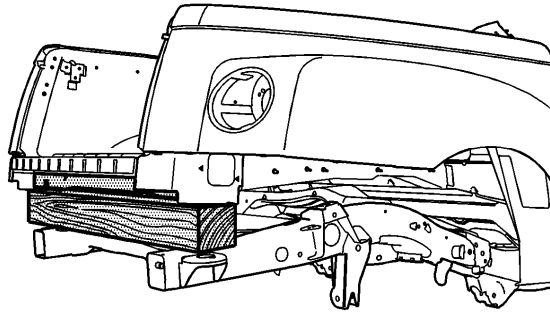
Removal Procedure

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 including the end gate. Refer to [Endgate Replacement](#) in Body Rear End.
4. Repair as much of the damage as possible to factory specifications. Refer to the Rear Compartment section of [Dimensions - Body](#) .
5. Loosen all mounting bolts that secure the body to the frame. Remove all of the bolts EXCEPT the 2 in the front tie bar and the 2 bolts under the front hinge pillar. Refer to [Frame Cushion or Insulator Replacement](#) in Frame and Underbody.

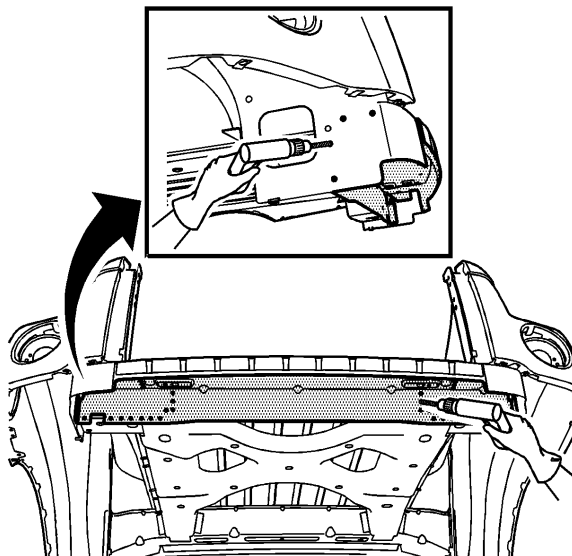


Important: Note the location and remove or disconnect any component that could be damaged while raising the rear portion of the body off of the frame.

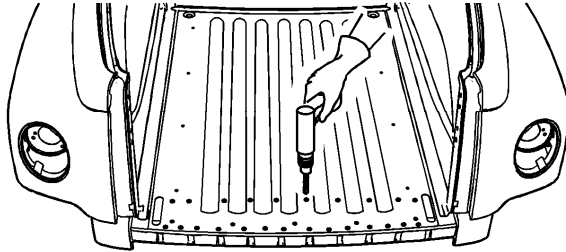
6. Lift the rear of the body approximately 15 cm (6 in) off of the frame onto a wooden block as shown.

Caution: Refer to [Foam Sound Deadeners Caution](#) in Cautions and Notices.

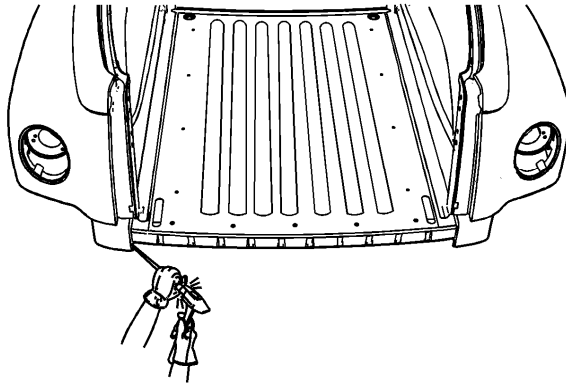
7. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.



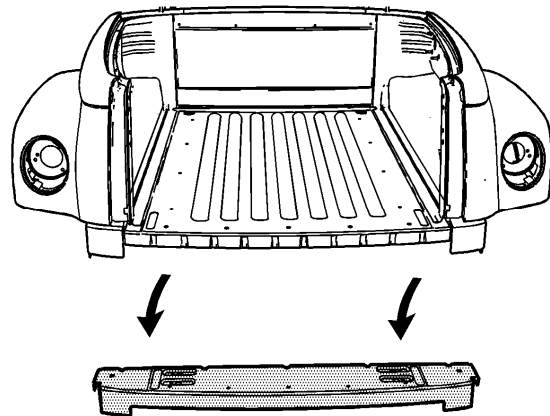
8. Locate and drill out all of the factory welds in the underbody. Drill completely through all of the layers of metal.



9. Locate and drill out all factory welds in the rear compartment floor. Drill completely through all of the layers of metal.

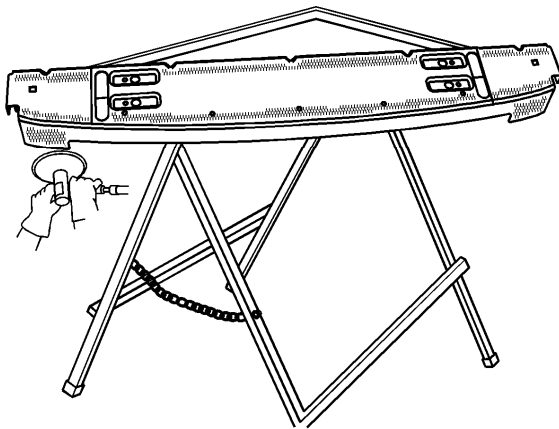


10. Verify the existence of structural weld-through adhesive. Refer to [Structure Adhesive - Identification](#) . If necessary use a chisel to separate the crossbar from the adjacent panels.



11. Remove the damaged cross bar.

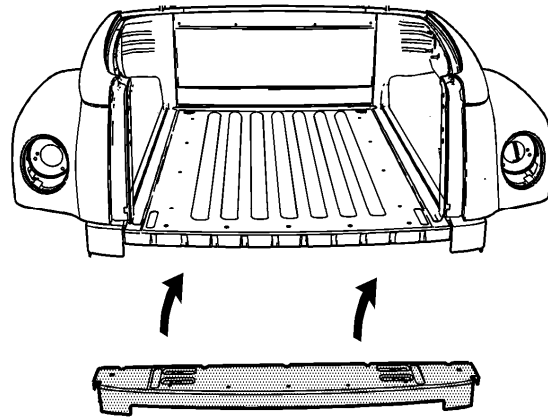
Installation Procedure



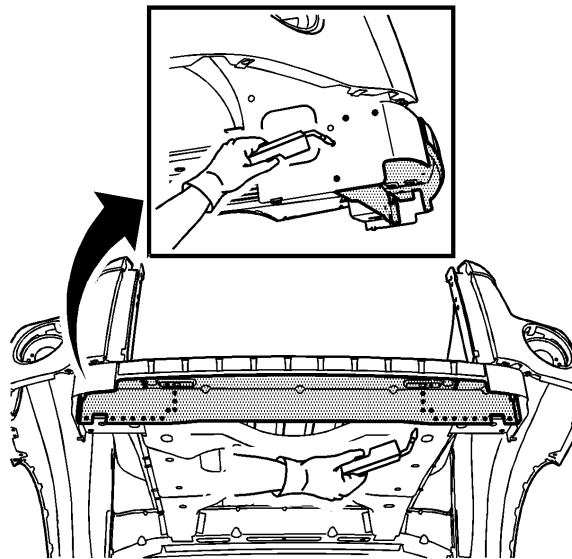
Important: Do NOT drill plug weld holes in the service part.

1. Prepare all attachment surfaces as necessary.
2. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .

3. Replace the structural adhesive with an additional plug weld between the existing plug welds, if necessary.



4. Position the service part.



5. Plug weld accordingly.
6. Clean and prepare all welded surfaces.
7. Apply the sealers and the anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
8. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.

Notice: Refer to [Fastener Notice](#) in Cautions and Notices.

9. Lower the body to the frame and reattach the mounting bolts.

Tighten

Tighten the bolts to 140 N·m (103 lb ft).

10. Install all related panels including the end gate. Refer to [Endgate Replacement](#) in Body Rear End.
11. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.
12. Enable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.