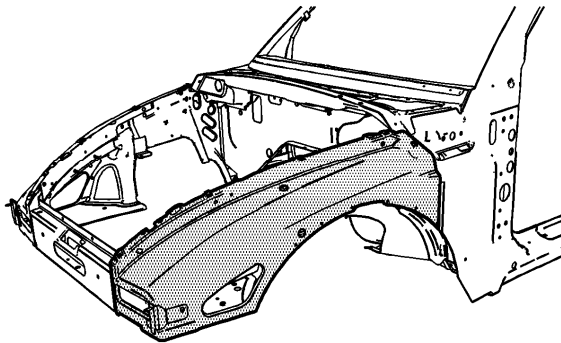


Front Fender Upper Rail Replacement

Removal Procedure

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

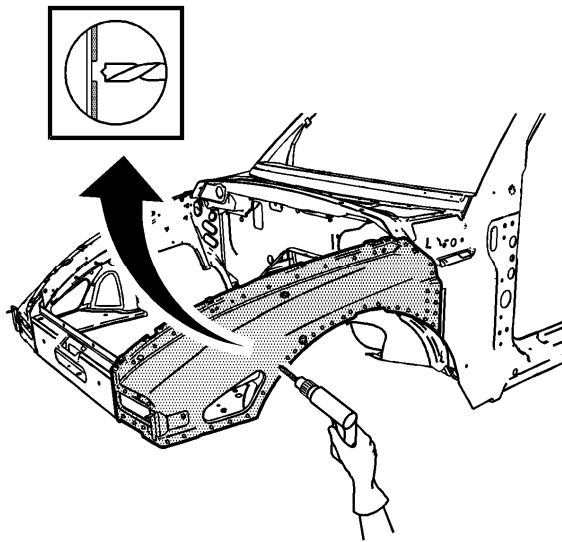
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.



3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to Motor Compartment in [Dimensions - Body](#) .

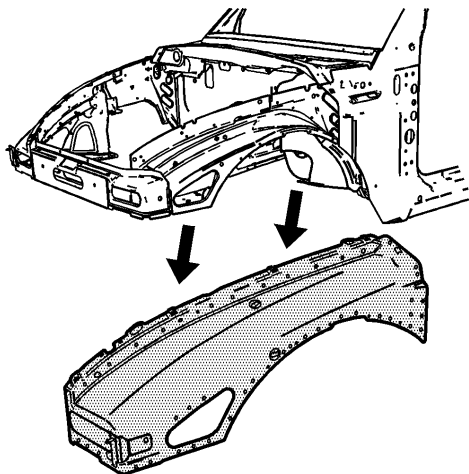
Caution: Refer to [Foam Sound Deadeners Caution](#) in Cautions and Notices.

5. 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.



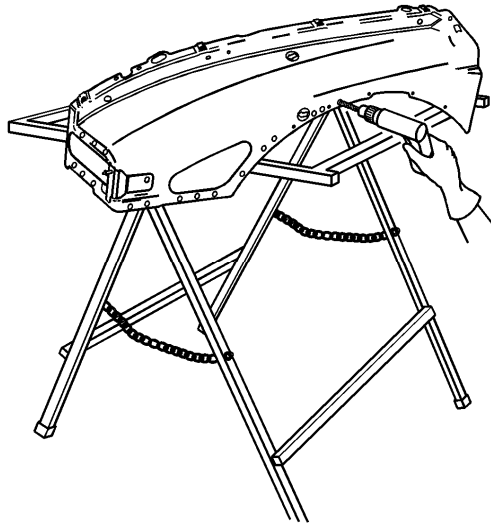
Important: Do not damage any inner panels or reinforcements.

6. Locate and drill out all factory welds. Note the number and location of welds for installation of the front upper rail.
7. Verify the existence of structural weld-through adhesive. Refer to [Structure Adhesive - Identification](#) . If necessary use a chisel to separate the front upper rail from the adjacent panels.

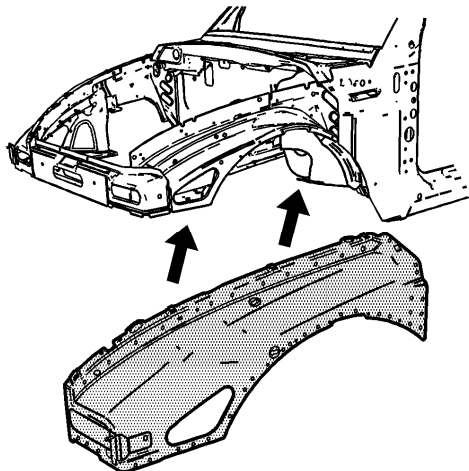


8. Remove the damaged front upper rail.

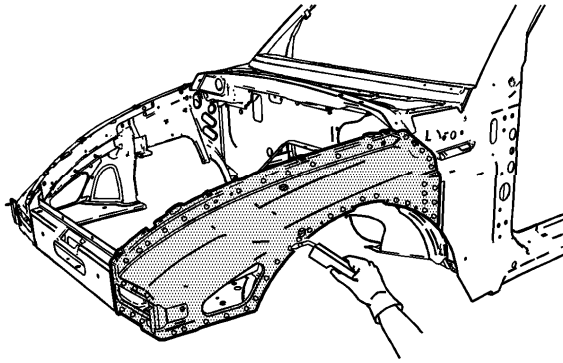
Installation Procedure



1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in locations noted from the original panel.
2. Replace the structural adhesive with an additional plug weld between the existing plug welds, where necessary.
3. Prepare all mating surfaces as necessary.
4. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



5. Position the upper rail. Align and inspect for proper positioning. Refer to Motor Compartment in [Dimensions - Body](#) .



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