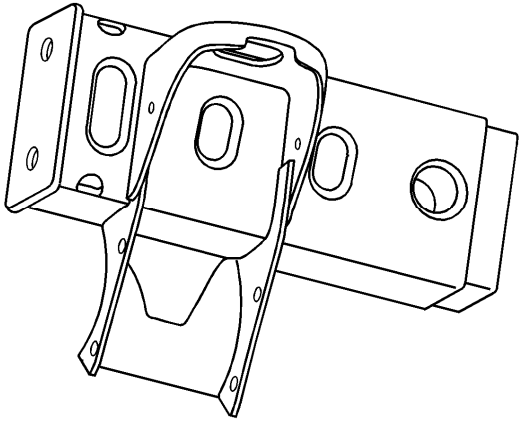


Front Full Frame Sectioning

Removal Procedure

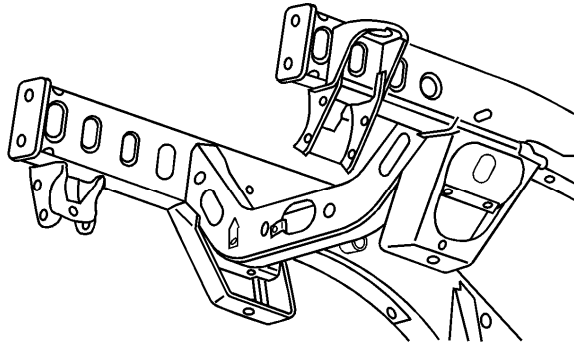


The service assemblies for the left and the right front frame rails are pre-sleeved, mild steel, hydro-formed parts, which correlate directly with the die marks located on the front frame rails. The assemblies include pre-welded support mounting brackets for the body and the radiator.

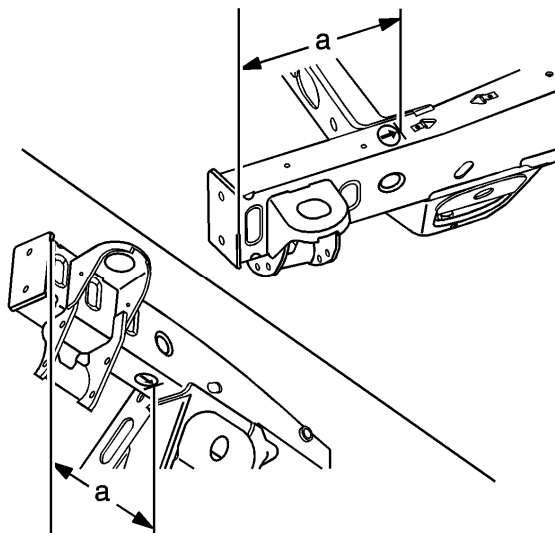
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

Caution: Refer to [Collision Sectioning Caution](#) in Cautions and Notices.

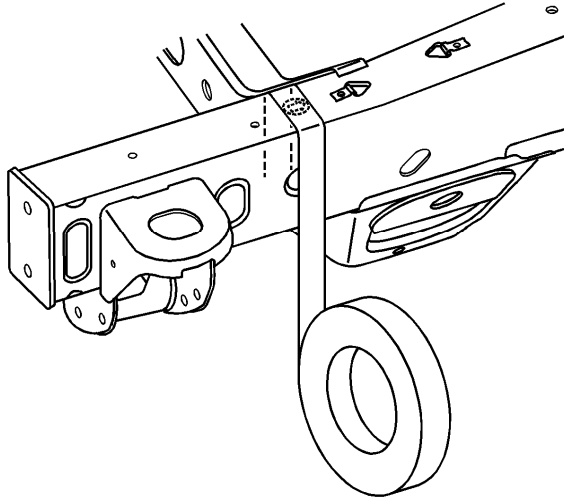
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.



3. Remove all of the related panels and components.

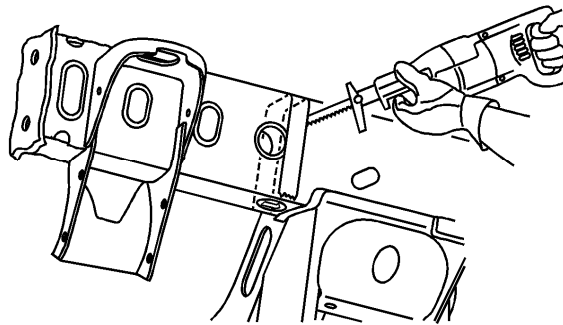


4. Locate the two die-marks on the damaged frame rail. The die marks are located 302 mm (11 7/8 in) rearward from the front frame rail bumper bracket, on the top and bottom side of each rail.



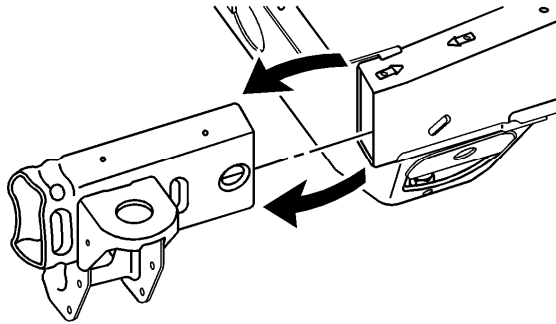
Important: Line up the masking tape with the point of each die mark arrow as shown.

5. Apply masking tape over the die-marks and down each frame rail side as shown, for the cut location.



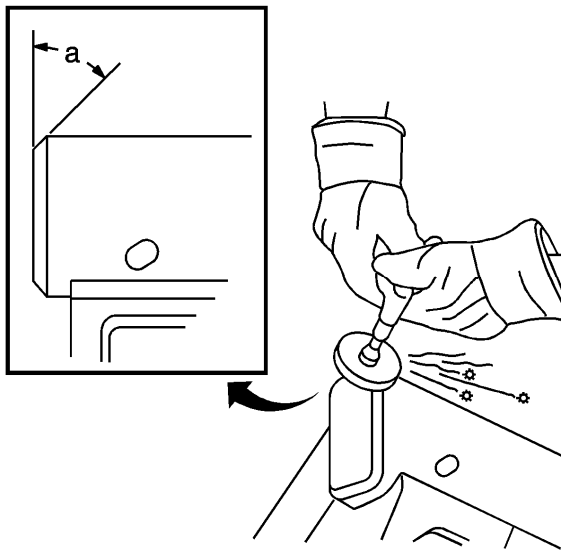
Important: The tape edge facing the rear of the vehicle is the proper cut location. The cut location is not to exceed 302 mm (11 7/8 in) of the front frame section.

6. Cut the damaged frame rail at the rear edge of the tape line using a reciprocating saw or equivalent, as shown.



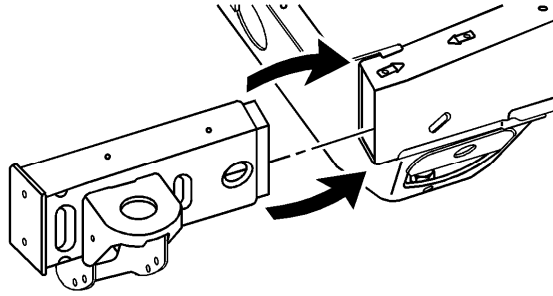
7. Remove the damaged frame section.

Installation Procedure

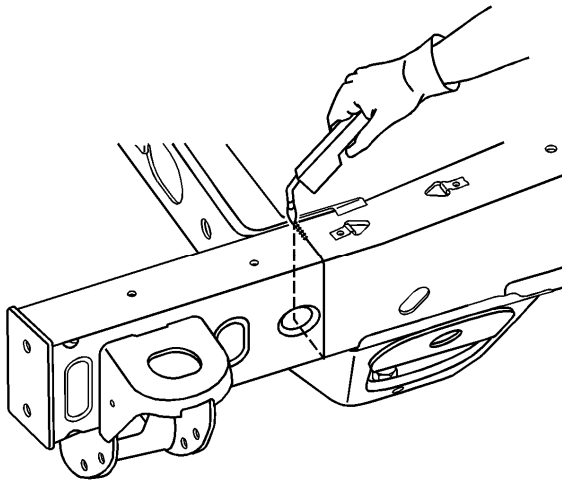


1. Grind the existing frame rail sectioning location to a 45 degree angle.

2. Prepare all of the attaching surfaces as necessary.

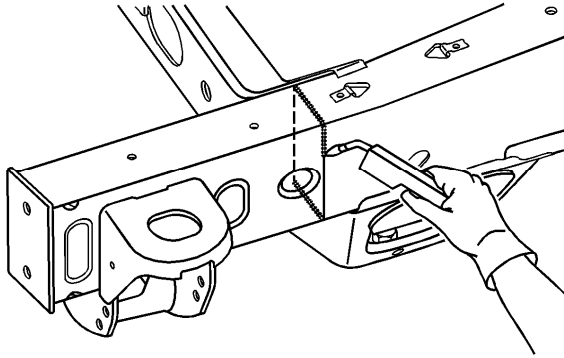


3. Position the service frame section to the existing frame and clamp in place.

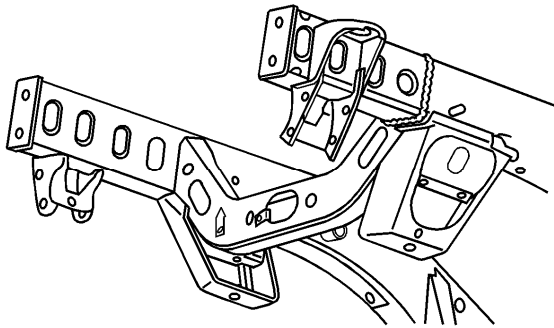


Important: Inspect the frame measurements three-dimensionally to ensure proper position of the service frame prior to welding.

4. Continuous-weld the upper and lower horizontal joints from corner to corner.



5. Continuous-weld the inner and outer vertical joints from corner to corner.



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