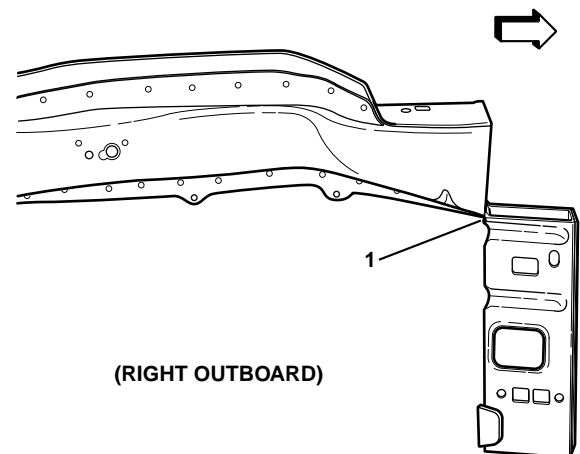
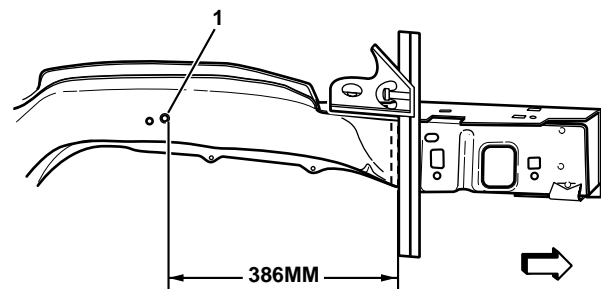
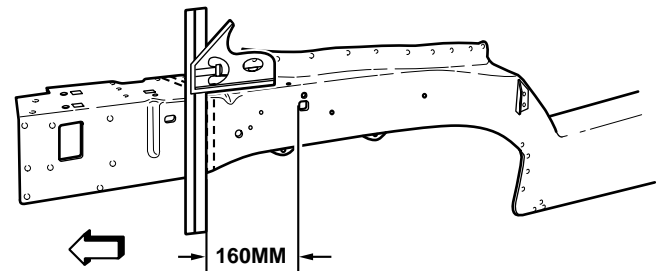
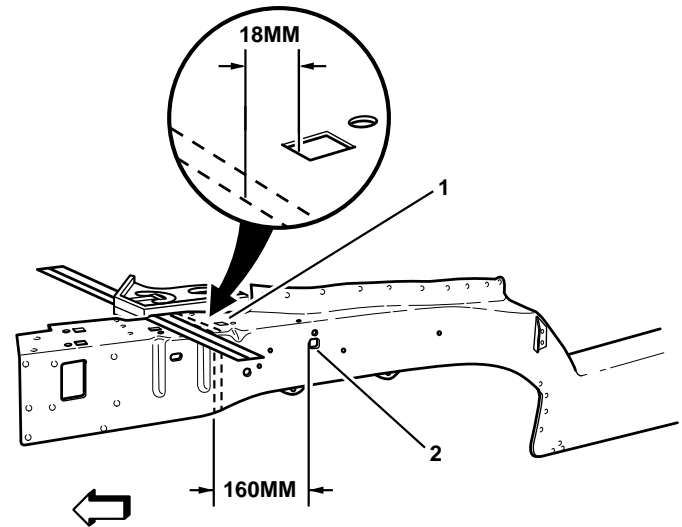


# Right Front Lower Rail Sectioning

## Removal of Damaged Right Front Rail

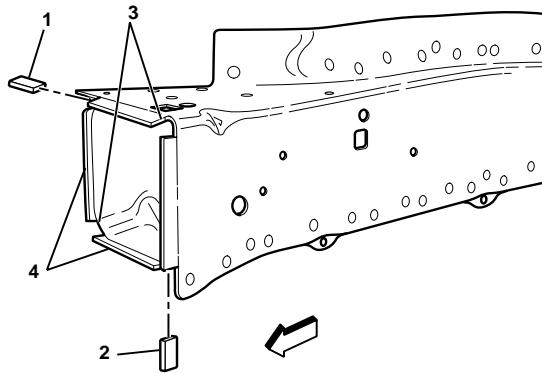
1. On top of rail, locate the last cut-out square. From the rear edge of the square (1), measure forward 8 mm (5/16 in.) and scribe a line.
2. Add 10 mm and scribe a second line. The second line is the cut location. The additional 10 mm (13/32 in.) will be used to create a flange for welding the new service part to the vehicle.
3. On the outboard side of the rail, locate the fixturing hole (2). Measure forward 150 mm (5-29/32 in.) and mark location. Scribe a straight line on the rail.
4. Measure forward 10 mm (13/32 in.) and scribe a second line. The second line [160 mm (6-5/16 in.)] is the cut location.
5. On the inboard side of the rail, locate the brake line pass-thru hole (1). At the larger hole, pull the tape measure from the forward edge of the hole and mark a line at 376 mm. Scribe a line with a straight edge, making sure it is square to inboard and top rail markings.
6. Measure forward 10 mm and scribe a second line. The second line (386 mm) is the cut location.
7. Make certain all three sides are aligned. Cut through three sides of the rail.
8. On the bottom of the damaged rail, scribe a line from the outboard to the inboard cut locations and cut the remainder of the rail (1) from the vehicle. Remove the damaged section of rail.



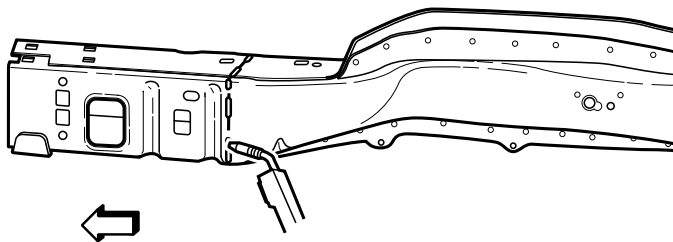
(RIGHT OUTBOARD)

# Right Front Lower Rail Sectioning

## Preparing the Undamaged Portion of the Rail for Installation



1. On original rail, cut and remove 10 mm of the outboard (1) and downward (2) turned flanges of the rail. Cut 10 mm gaps along the corners of the original rail.
2. Step the top, bottom and side tabs inward (3) to allow the service part to fit over the original rail.
3. Clean and prepare mating surfaces as necessary.



## Installation Procedure

1. Position the service part over the original rail. Align and check fit using three-dimensional measuring equipment.
2. Stitch weld along the entire sectioning joint. Make 25 mm (1 in.) welds along the seam with 25 mm (1 in.) gaps between them.
3. Go back and complete the stitch weld. This will create a solid weld joint with minimal heat distortion.
4. Clean and prepare all welded surfaces.

*IMPORTANT: Prior to refinishing, refer to publication GM4901M-D-01 GM Approved Refinish Materials for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.*

5. Prime with two-part catalyzed primer.
6. Apply sealers and anti-corrosion materials as necessary.
7. Install all related panels and components.