

Repair Instructions

Impact Bar Replacement - Front Bumper

Removal Procedure

Caution: Refer to *Approved Equipment for Collision Repair Caution* on page 1-1.

1. Disable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 1-129.

Caution: Refer to *Battery Disconnect Caution* on page 1-1.

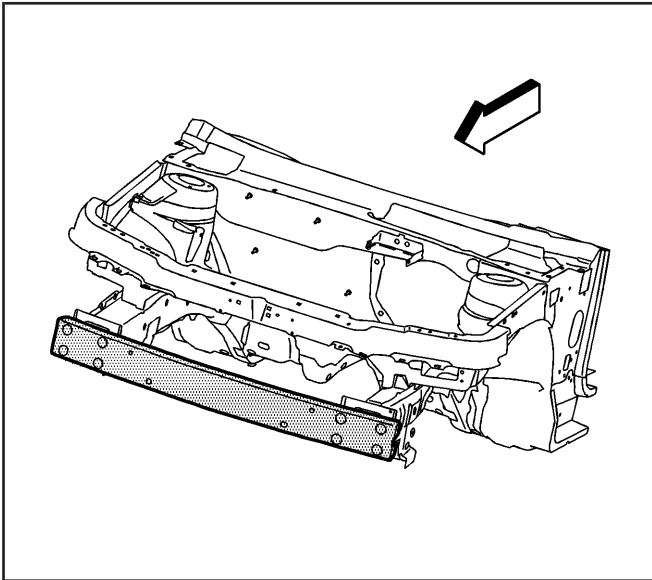
2. Disconnect the negative battery cable.

Important: This panel is replaced at factory welds

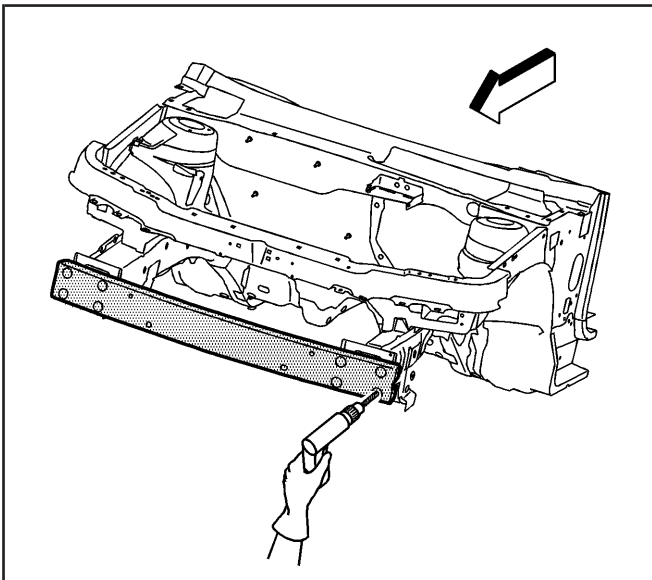
3. Remove all related panels and components.
4. Repair as much of the damage as possible. Refer to *Dimensions - Body (Sedan)* on page 1-2.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to *Anti-Corrosion Treatment and Repair*.

Important: Note the number and location of the factory welds for installation of the front impact bar.

6. Locate and drill out all the necessary factory welds.

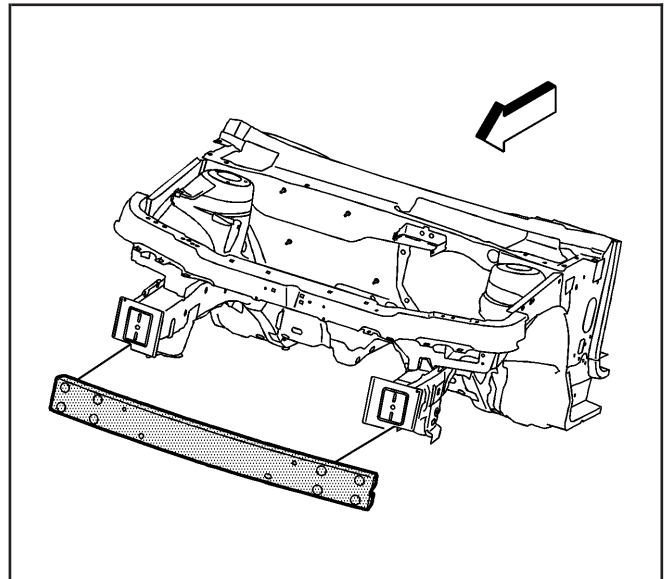


1210236



1210256

7. Remove the impact bar.

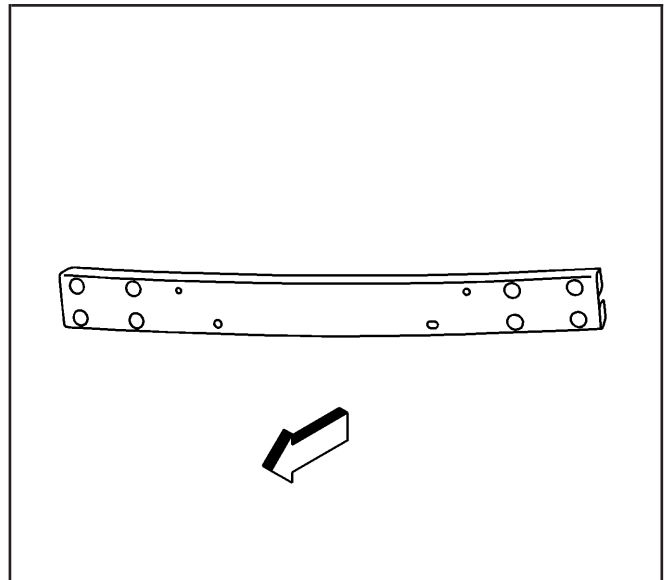


1210260

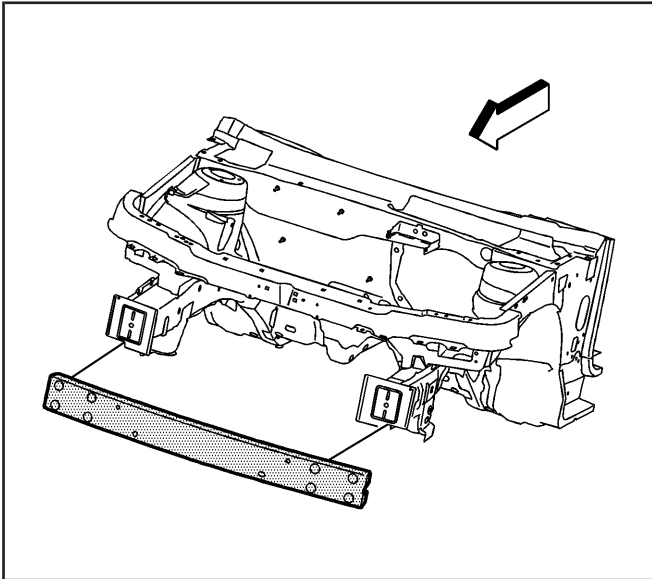
Installation Procedure

Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Prepare all mating surfaces as necessary.
3. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.

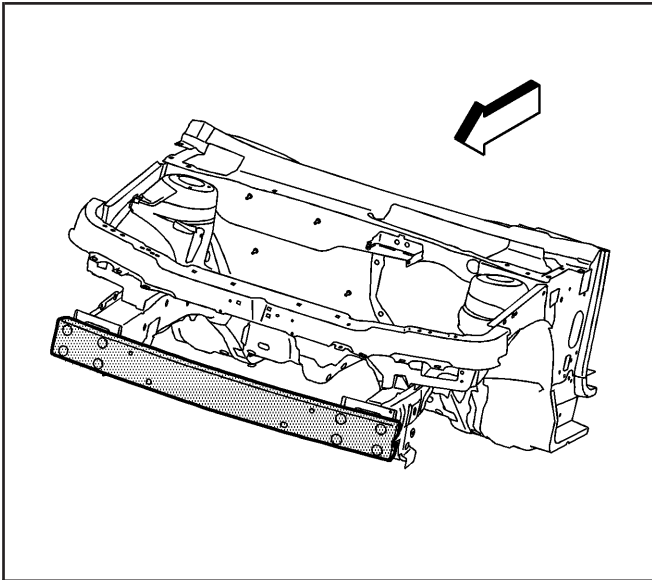


1210265



1210260

4. Position the impact bar on the vehicle using 3-dimensional measuring equipment. Clamp the tie bar into place.



1210236

5. Plug weld accordingly.
6. Clean and prepare all of the welded surfaces.
7. Install all of the related panels and components.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to *Anti-Corrosion Treatment and Repair*.
9. Paint the repaired area. Refer to *Basecoat/Clearcoat Paint Systems*.

Caution: Refer to **Battery Disconnect Caution** on page 1-1.

10. Connect the negative battery cable.
11. Enable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 1-129.