

Impact Bar Bracket Replacement - Front Bumper

Removal Procedure

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

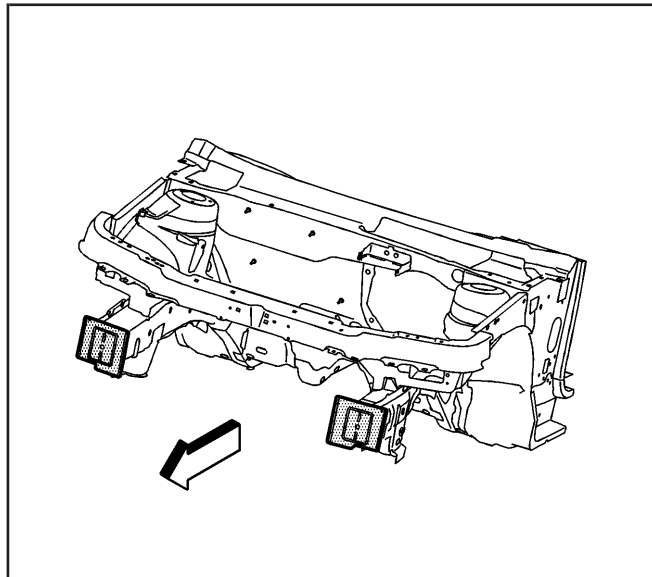
1. Disable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 1-129.

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

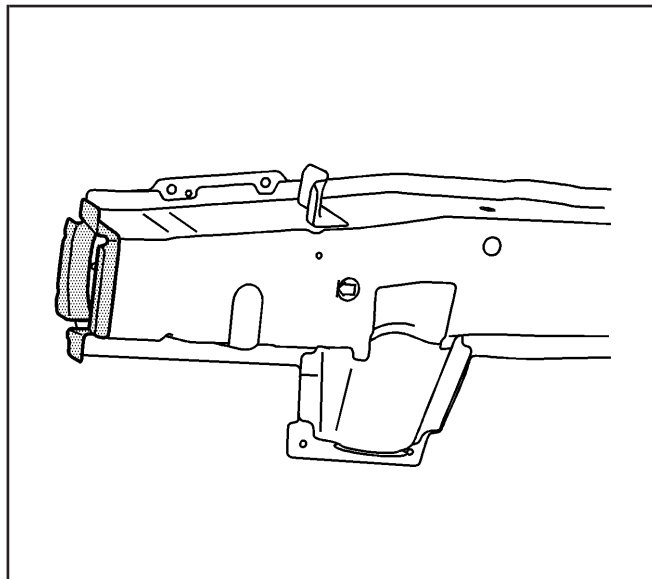
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible. Refer to *Dimensions - Body (Sedan)* on page 1-2.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to *Anti-Corrosion Treatment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

Important: Note the number and location of the factory welds for installation of the impact bar bracket - front bumper

6. Locate and drill out all the factory welds from the outside surface of the rail.

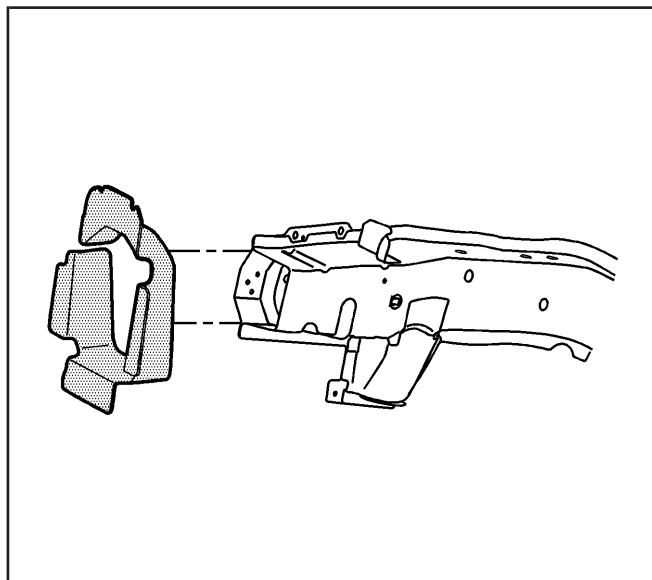


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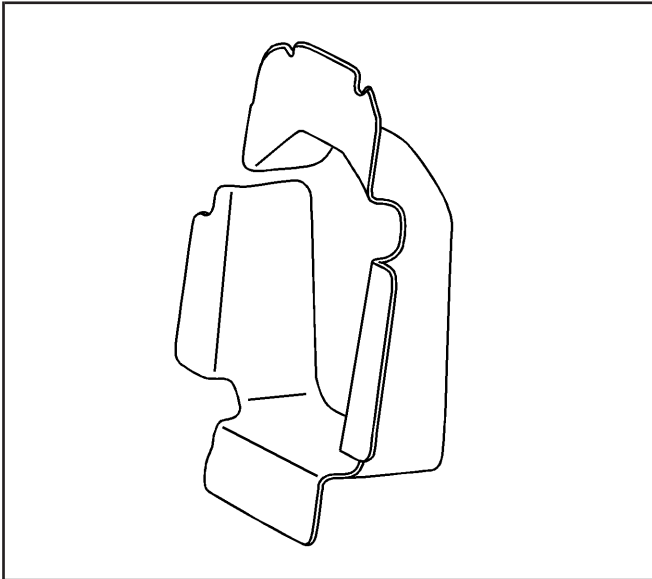


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7. Remove the front bumper impact bar bracket.



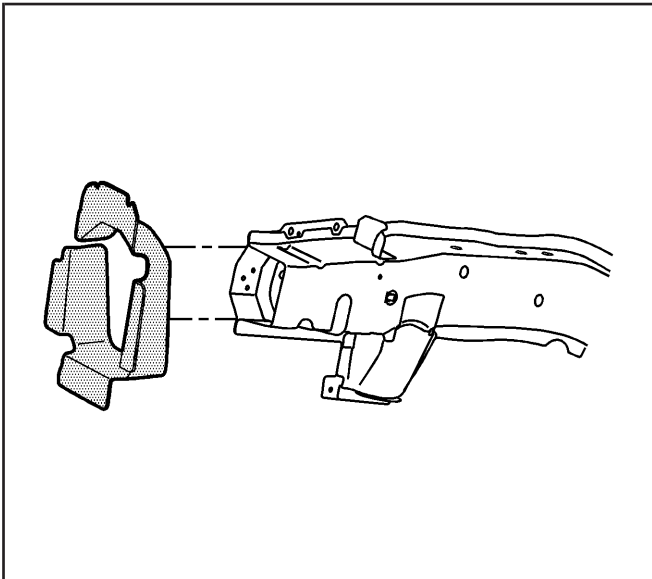
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Installation Procedure

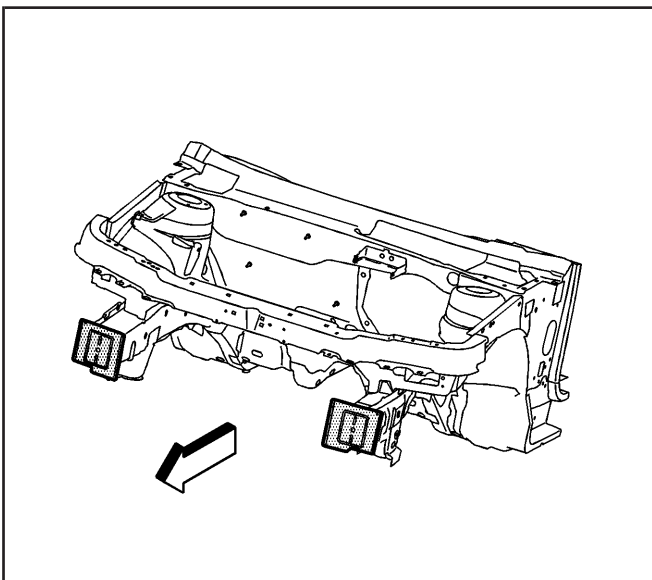
1. Prepare all mating surfaces as necessary.
2. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.



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Important: Verify the location of the front rail using 3-dimensional measuring equipment.

3. Position the impact bar bracket on the rail and clamp in place.



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

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

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