

## Wheelhouse Replacement - Front

### 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:** The upper strut mounting surface is a dimensionally critical area, and 3-dimensional measuring equipment should be used to locate the front wheelhouse assembly. The front wheelhouse can be serviced as a complete assembly for both the left and right wheelhouses. A wheelhouse front panel is also available to service separately on the left or the right sides.

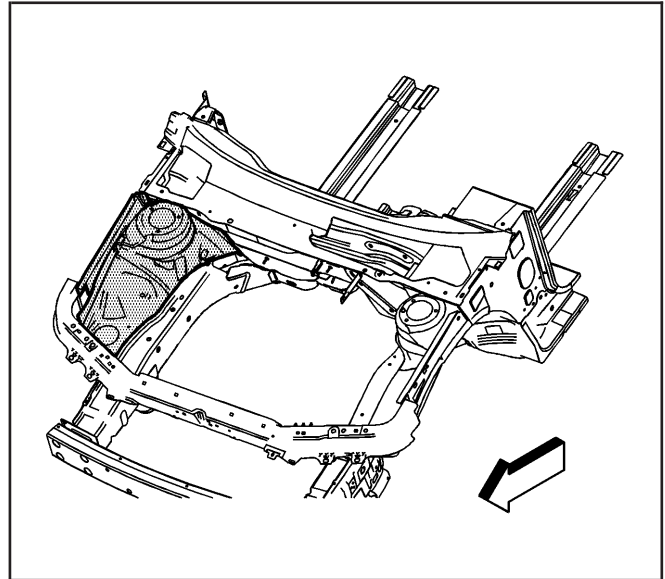
3. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to *Anti-Corrosion Treatment and Repair*.

**Important:** Inspect the front of the cowl and dash panel for damage. If the metal surface is damaged, repair the cowl panel to restore the structural integrity of the vehicle.

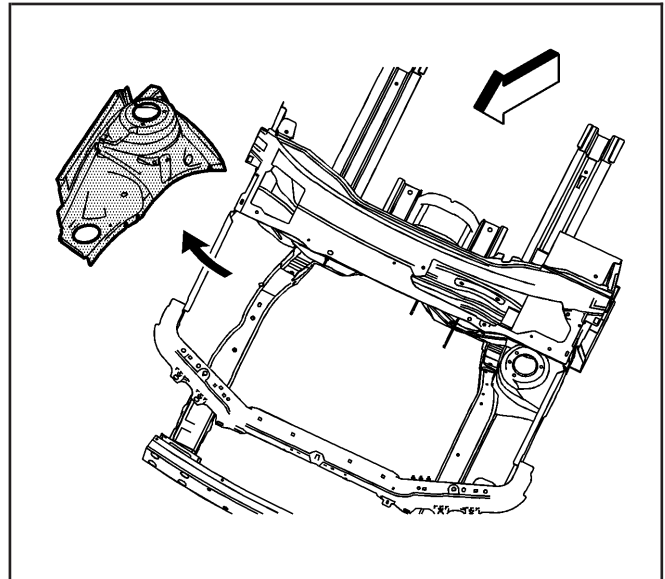
4. Visually inspect the damaged area. Repair as much of the damage as possible. Refer to *Dimensions - Body (Sedan)* on page 1-2.
5. Locate and drill out all factory welds.

**Important:** Note the number and location of welds for installation of the front wheelhouse

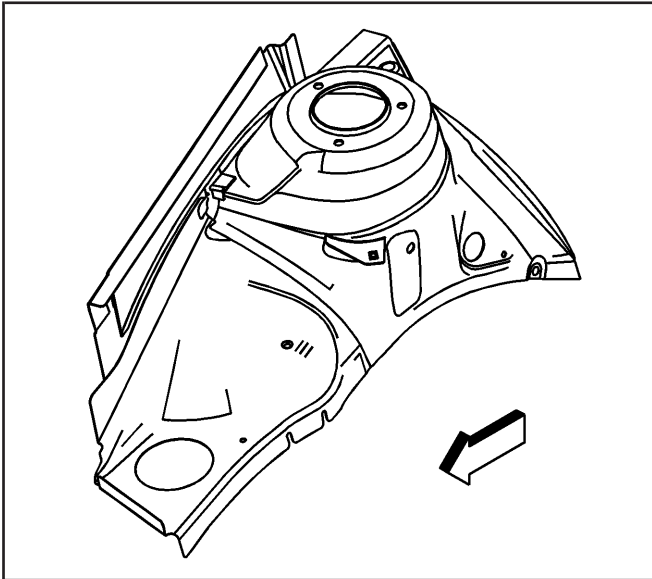
6. Remove the front wheelhouse from the vehicle.



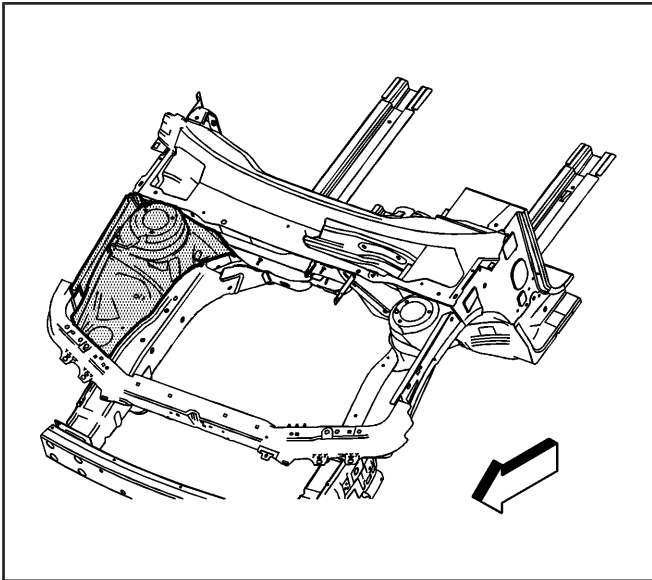
1210950



1210984



1210992



1210950

## Installation Procedure

**Important:** If you cannot determine the location of the original plug weld holes, space the plug weld holes every 40 mm (1½ in) apart.

1. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the original assembly.
2. Prepare the mating surfaces as necessary.
3. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.
4. Position the front wheelhouse in the vehicle using 3-dimensional measuring equipment. Clamp the wheelhouse in place.

5. Plug weld accordingly.
6. Clean and prepare all of the welded surfaces.
7. Install all 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.