

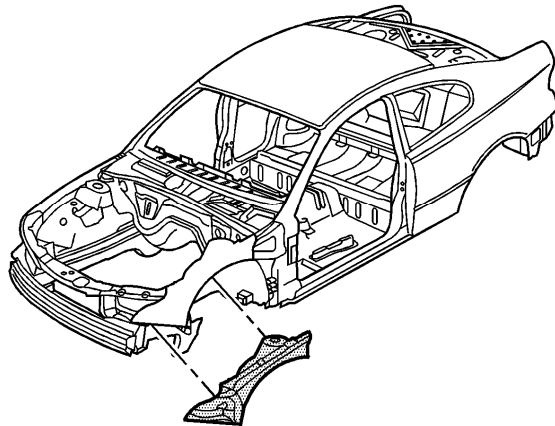
Front Wheelhouse Replacement

Removal Procedure

Caution: Refer to [Approved Equipment for Collision Repair 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.

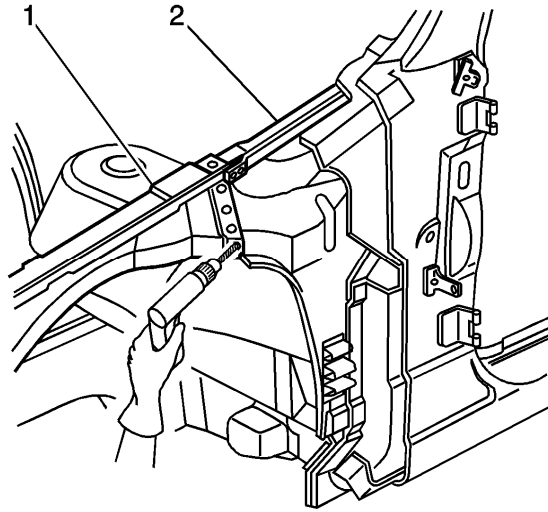
Important: . The front wheelhouse service panel is serviced as a complete assembly, which includes the upper front strut mounting surface. The upper strut mounting surface is a dimensionally critical area. Use 3-dimensional measuring equipment to locate the front wheelhouse assembly.



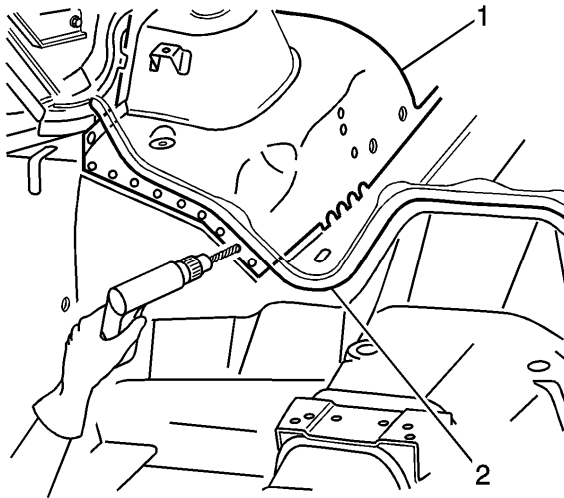
3. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
4. Remove the upper tie bar. Refer to [Upper Tie Bar Replacement](#) .
5. Remove the upper rail. Refer to [Rail Replacement - Upper](#) .

Important: Inspect the front of the cowl for damage. If the metal surface is damaged, the cowl panel must be repaired to restore the structural integrity of the vehicle.

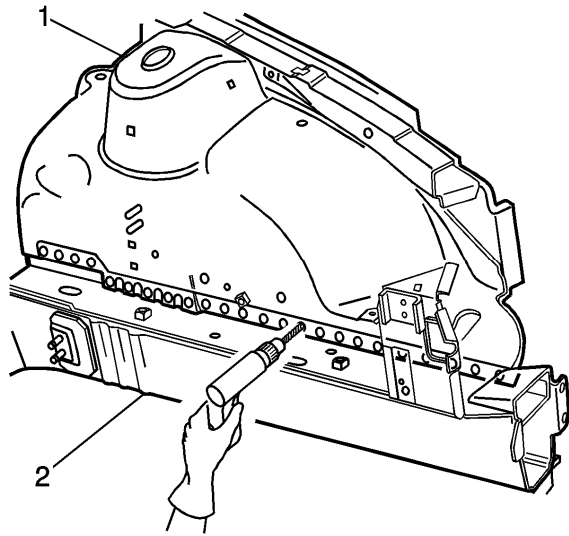
6. Repair as much of the damage as possible.



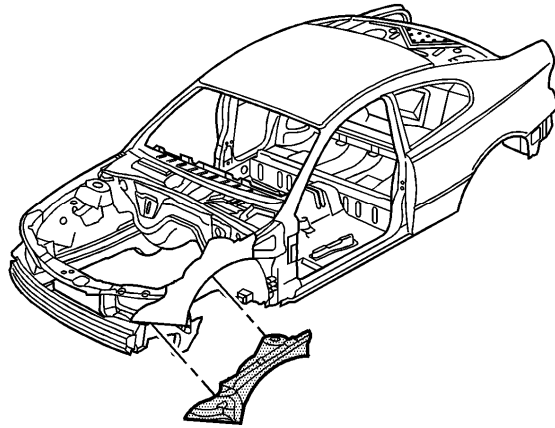
7. Locate, mark, and drill out all factory welds attaching the front wheelhouse panel (1) to the hinge pillar inner panel (2). Note the number and location of welds for installation of the service assembly.



8. Locate, mark, and drill out all factory welds attaching the wheelhouse panel (1) to the floor panel extension (2) and hinge pillar inner panel.

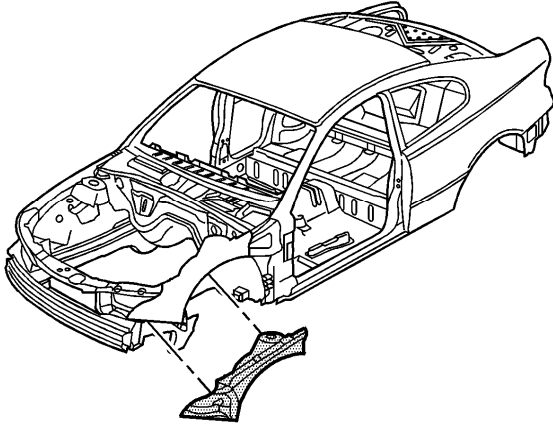


9. Locate, mark and drill out all factory welds attaching the wheelhouse panel (1) to the front lower rail (2).



10. Remove the wheelhouse from the vehicle.

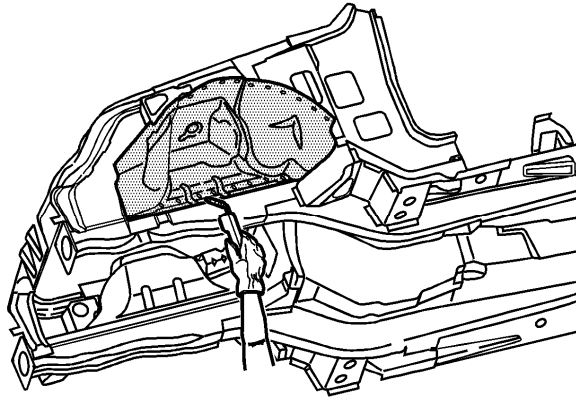
Installation Procedure



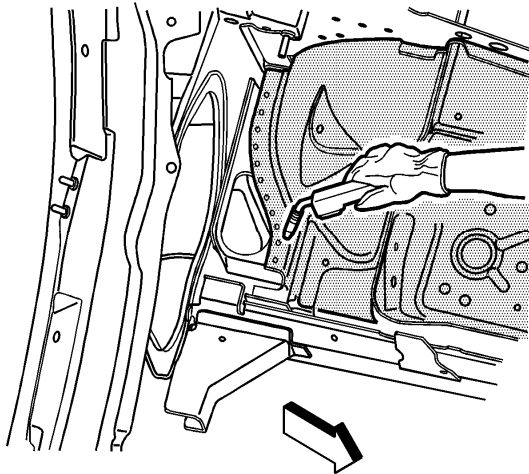
1. Prepare the mating surfaces as necessary.
2. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
3. Drill 8-mm (5/16-in) plug weld holes, as necessary, in the locations noted from the original assembly.

Important: If the location of the original plug weld holes can not be determined, or if structural weld-thru adhesive is present, space the plug weld holes every 40 mm (1½ in).

4. Position the wheelhouse on the vehicle. Check for proper fit using 3-dimensional measuring equipment.



5. When the service assembly is correctly positioned, plug weld accordingly.
6. Install the upper rail. Refer to [Rail Replacement - Upper](#) .
7. Install the upper tie bar. Refer to [Upper Tie Bar Replacement](#) .



8. Measure frequently to ensure proper fit and alignment.
9. Clean and prepare all welded surfaces.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
11. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
12. Install all related panels and components.
13. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
14. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.