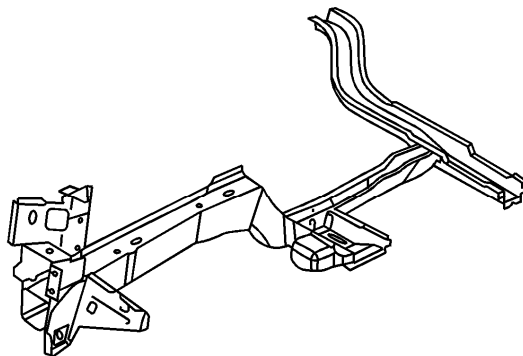


Lower Rail Replacement

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.



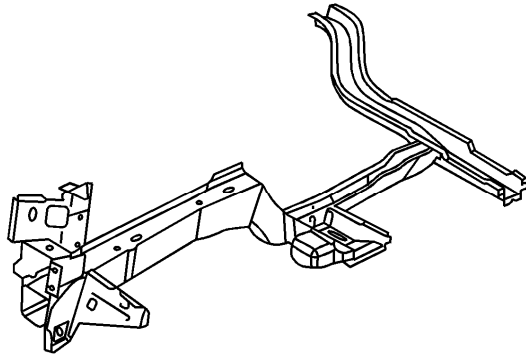
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#).

Caution: Refer to [Foam Sound Deadeners Caution](#) in Cautions and Notices.

5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
6. Remove the upper tie bar. Refer to [Upper Tie Bar Replacement](#).
7. Remove the lower tie bar. Refer to [Lower Tie Bar Replacement](#).
8. Remove the wheelhouse panel. Refer to [Front Wheelhouse Replacement](#).

9. Locate, mark, and drill out all factory welds. Note the number and location of welds for installation of the service rail and components.
10. Remove the damaged rail.

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. Position the service rail assembly on the vehicle.
4. Verify the fit with 3-dimensional measuring equipment. Refer to [Dimensions - Body](#).
5. Plug weld as necessary as noted from the original rail.
6. Install the wheelhouse panel. Refer to [Front Wheelhouse Replacement](#).
7. Install the lower tie bar. Refer to [Lower Tie Bar Replacement](#).
8. Install the upper tie bar. Refer to [Upper Tie Bar Replacement](#).
9. Clean and prepare all welded surfaces.
10. Apply the sealers and the anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
11. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint/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.