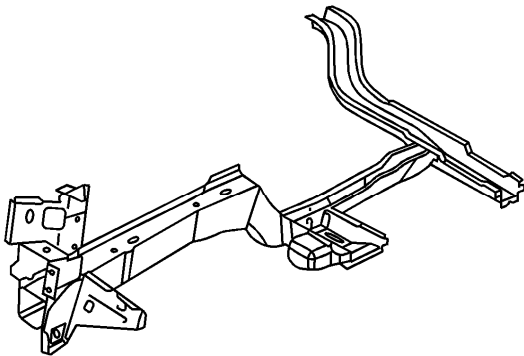


Lower Rail Sectioning

Removal Procedure

Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.



Important:

- Sectioning procedures have been developed to simplify repair of the lower rails, providing the majority of the damage can be returned to factory specifications. This allows the damaged front section to be replaced without performing a full rail replacement.
 - If the damage exceeds the recommended area for sectioning and the rail cannot be straightened, the complete rail must be replaced.
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.

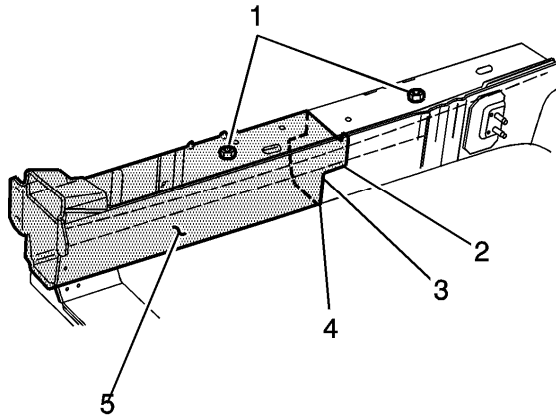
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .

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 front wheelhouse. Refer to [Front Wheelhouse Replacement](#) .

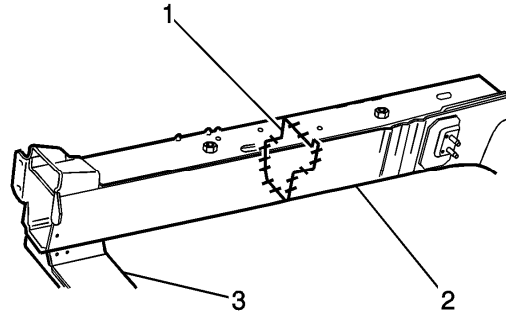
Important: It is not necessary to completely remove the powertrain or front frame for rail sectioning.

9. Support the powertrain assembly.
10. Position the front frame away from the rail.



11. Cut the front lower rail half-way through its depth (2), mid-way between the two front frame mounting bolt holes (1).
12. Step the cut forward (3) by 50 mm (1.97 in), so that the load is not concentrated through a single line.
13. Cut the remaining section (4) of the lower rail.
14. Remove the damaged section of the lower rail (5).

Installation Procedure



1. Accurately step cut the required section (2) from a new lower side rail assembly and clamp or tack weld the new section in position.
2. Clamp the lower tie bar (3) into position. Make sure the alignment of the lower rail (2) and the lower tie bar is correct. Refer to [Dimensions - Body](#) .
3. Clean and prepare the mating surfaces as necessary.
4. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
5. Butt-weld the stepped longitudinal sections together (1). The weld should extend around the entire circumference of the cut.
6. Install the front wheelhouse. 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. Inspect the measurements frequently to ensure proper fit and alignment. Refer to [Dimensions - Body](#) .
10. Clean and prepare all welded surfaces.
11. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
12. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint /Coatings.
13. Install all related panels and components.
14. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
15. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.