

3. Front Upper Rail Assembly

The front upper rail assembly is serviced as two components: inner and outer panels. The outer panel is serviced as a sub-assembly which includes an inner reinforcement (figure 3-1). The inner rail is completely accessible, after the outer rail has been removed.

Front Upper Rail Assembly Service Procedure

Remove or Disconnect

1. Remove all related panels and components.
2. Visually inspect and restore as much of the damage as possible to factory specifications.
3. Remove sealers and anti-corrosion materials as necessary.
4. Locate, mark, and drill out all factory welds. Note the number and location of welds for installation of the service assembly.
5. Remove the damaged front upper rail assembly.

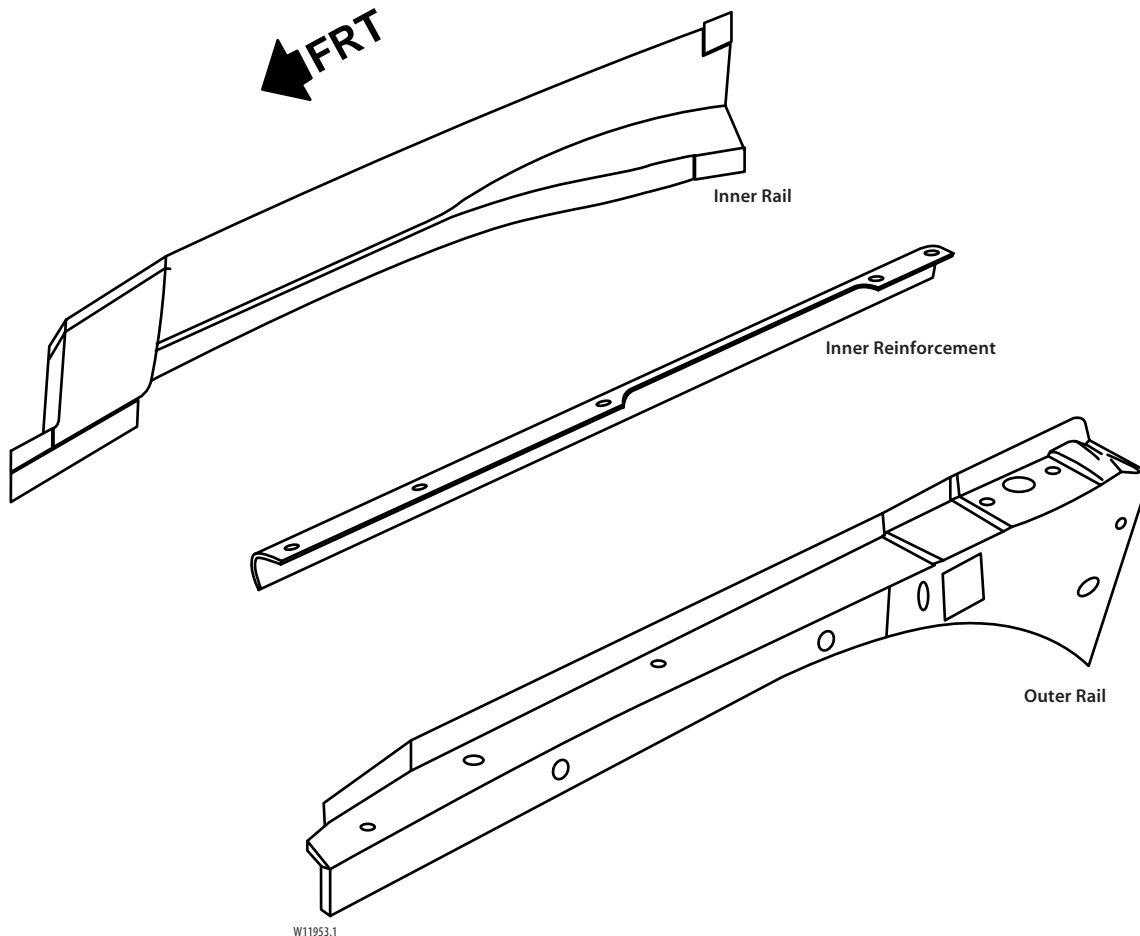
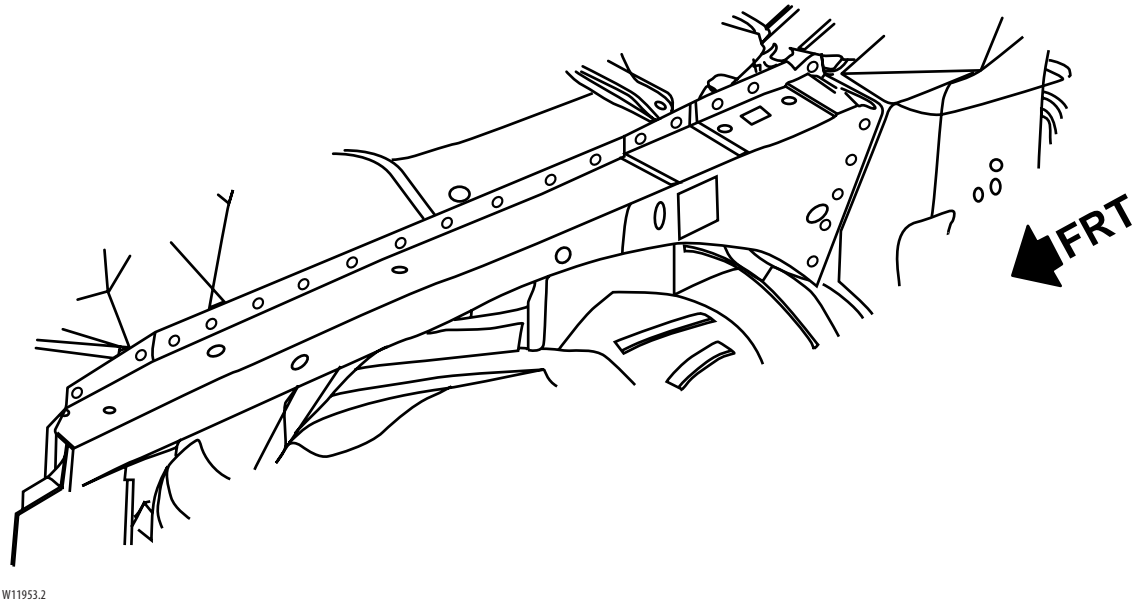


Figure 3-1:
Front Upper Rail Assembly



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**Figure 3-2:
Plug Weld the Outer Rail**

**Front Upper Rail Assembly
Service Procedure (cont'd)**

Install or Connect

1. Prepare the mating surfaces as necessary.
2. Drill 8mm ($\frac{5}{16}$ inch) plug weld holes as necessary in the locations noted from the original assembly. NOTE: If original locations are damaged beyond recognition, locate holes for plug welding 40mm (1½ inches) apart.
3. Temporarily position the inner and outer rails on the vehicle. Using three-dimensional measuring equipment, locate and mark front fender mounting bolt holes in the outer rail. Drill 5.5mm holes for self-tapping bolts as marked.
4. When the service assembly is correctly positioned, and with the outer rail removed, plug weld the inner rail as necessary. Reposition the outer panel with frequent measurements to ensure proper fit and alignment, and plug weld accordingly (figure 3-2).
5. Clean and prepare all welded surfaces. Prime with two-part catalyzed primer. Apply sealers and anti-corrosion protection materials as necessary. Do not combine paint systems. Refer to paint manufacturer's recommendations.
6. Install all related panels and components.