

4. Front Wheelhouse Assembly

The front wheelhouse service panel is available as a complete assembly, which includes the upper front strut mounting surface (figure 4-1).

— Notice —

Sectioning of the front wheelhouse assembly is not recommended.

The upper strut mounting surface is a dimensionally critical area, and three-dimensional measuring equipment should be used to locate the front wheelhouse assembly. The front apron close-out panels are available and serviced separately.

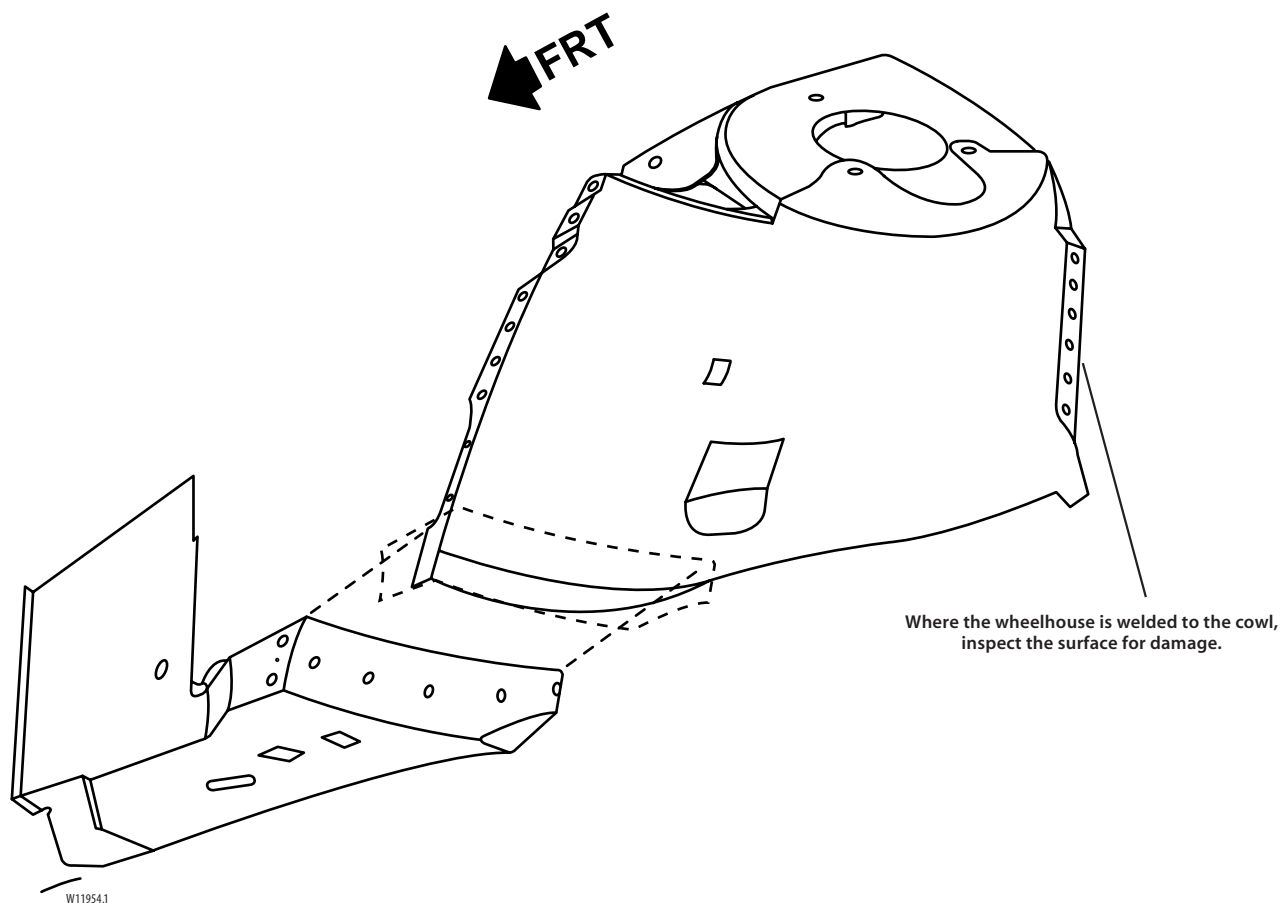


Figure 4-1:
Front Apron Panels

Front Wheelhouse Assembly Service Procedure

Remove or Disconnect

1. Remove all related panels and components, including the front upper rail assemblies.

— **Notice** —

Some interior components must be removed to access the welds attaching the wheelhouse to the front of the cowl panel. Be sure to 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.

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 wheelhouse assembly.

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 (figure 4-1). NOTE: If original locations are damaged beyond recognition, locate holes for plug welding 40mm (1½ inches) apart.
3. Position the wheelhouse on the vehicle. Check for proper fit using three-dimensional measuring equipment.
4. When the service assembly is correctly positioned, plug weld accordingly, measuring frequently to ensure proper fit and alignment.

— **Notice** —

Some of the plug welding may be performed from inside the vehicle. Make sure before welding that there is no chance of damage to components or panels from welding sparks and heat. Take necessary precautions for fire prevention.

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.