

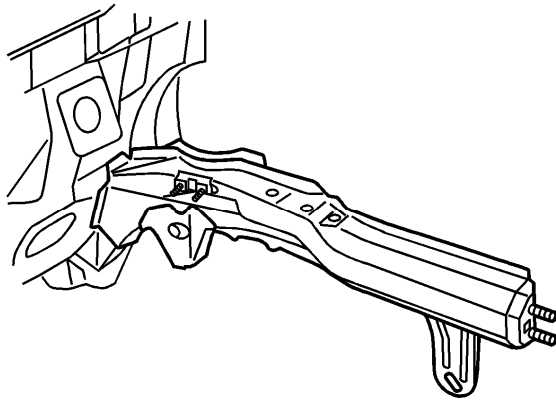
Lower Rail Replacement

Removal Procedure

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

Important: When replacing panels that involve servicing of stationary glass, refer to [Urethane Adhesive Installation of Stationary Windows](#) before performing any priming or refinishing.

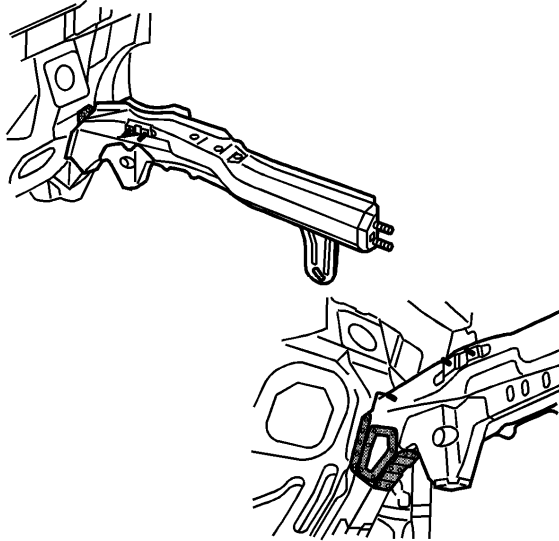
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.



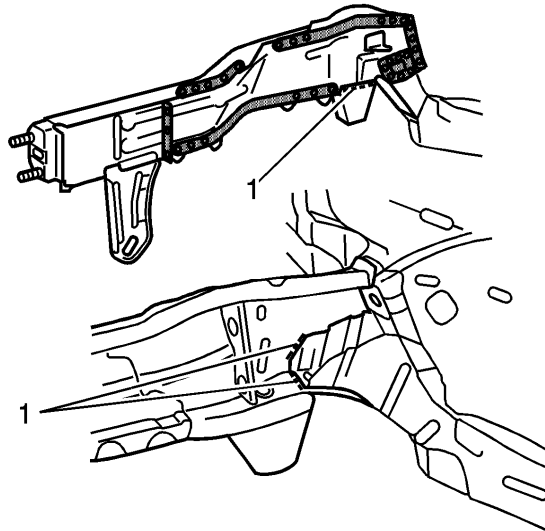
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#).

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 and Coatings.
6. Perform the necessary procedures to gain access to the repair area. Refer to [Upper Tie Bar Replacement](#) , [Tie Bar Replacement - Left Side](#) , if necessary, [Tie Bar Replacement - Right Side](#) , if necessary , [Lower Tie Bar Replacement](#) , [Upper Rail Replacement](#) , [Front Wheelhouse Replacement](#) .



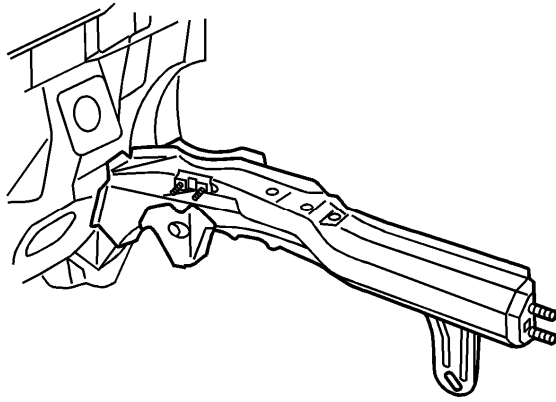
7. Locate and drill out all factory welds, on the rear of the front lower rail. Note the number and location of the welds for installation of the front lower rail



Important: Do not damage any inner panels or reinforcements.

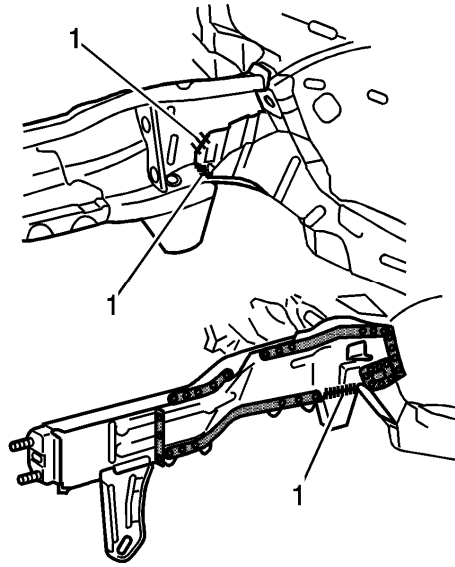
8. Locate and drill out all factory welds, on the side of the front lower rail. Note the number and location of the welds for installation of the front lower rail.
9. Cut the front lower rail in the areas as shown (1).
10. Remove the damaged rail.

Installation Procedure

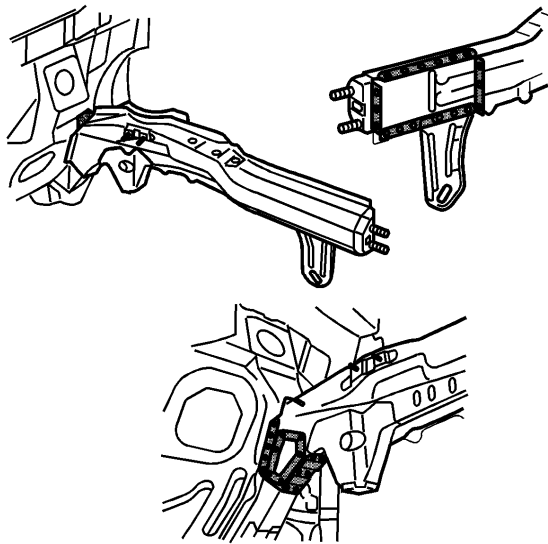


1. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the removal.
2. Prepare all mating surfaces as necessary.
3. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
4. Position the service part.

5. Align and check fit with 3-dimensional measuring. Refer to [Dimensions - Body](#) .



6. Stitch weld along the entire joints (1).
7. Make 25 mm (1 in) welds along the seams with 25 mm (1 in) gaps between.
8. Go back and complete the stitch weld to create a solid weld joint with minimal heat distortion.
9. Plug weld the side of the front lower rail accordingly.



10. Complete the remaining plug welds to the rear and front sides of the front lower rail accordingly.
11. Complete the necessary procedures. Refer to [Upper Tie Bar Replacement](#) , [Tie Bar Replacement - Left Side](#) , if necessary, [Tie Bar Replacement - Right Side](#) , if necessary, [Lower Tie Bar Replacement](#) , [Upper Rail Replacement](#) , [Front Wheelhouse Replacement](#) .

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