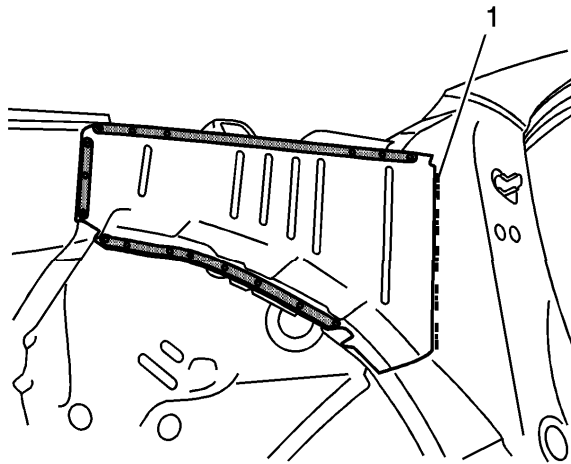


Upper Rail Replacement

[Removal Procedure](#)



1. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
2. Remove all related panels and components.

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

3. Restore as much of the damage as possible to factory specifications.
4. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
5. Perform the necessary procedures to gain access to the repair.

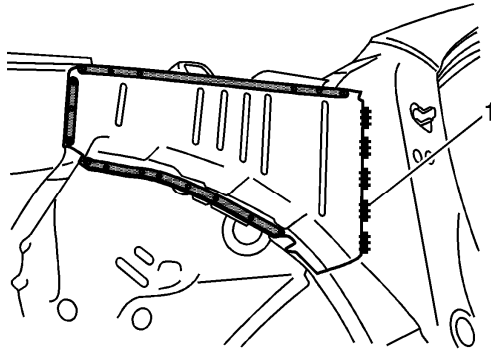
Important: Do not damage any inner panels or reinforcements.

6. Locate and drill out all factory welds. Note the number and location of welds for installation of the front upper rail.
7. Cut along the rear of the front upper rail (1) as shown.
8. Remove the damaged front upper rail.

Installation Procedure

Important: In any area damaged beyond recognition, space plug weld holes every 40 mm (1 in) apart.

1. Drill 8 mm (5/16) in plug weld holes as necessary in locations noted from the original front upper rail.
2. Prepare all attachment 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 upper rail.



5. Plug weld accordingly.
6. Stitch weld along the entire rear of the front upper rail (1).
7. Make 25 mm (1 in) welds along the seam 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. Clean and prepare all welded surfaces.
10. Complete the necessary procedures.
11. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
12. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
13. Install all related panels and components.
14. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .