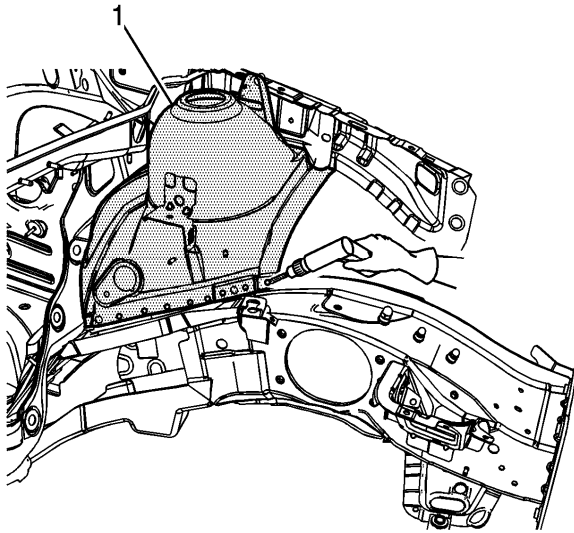


Front Wheelhouse Replacement

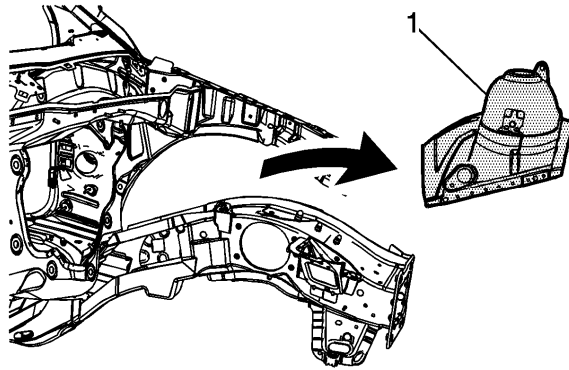
Removal Procedure

1. Disable to SIR system.
2. Disconnect the negative battery cable
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications.
5. Note the locations and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#)



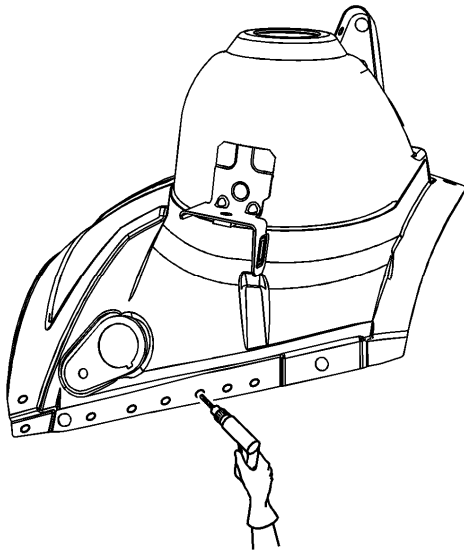
Important: Do not damage any inner panels or reinforcement.

6. Locate and drill out all factory welds in the front wheelhouse extension (1). Note the number and location for installation.



7. Remove the damaged front wheelhouse extension (1).

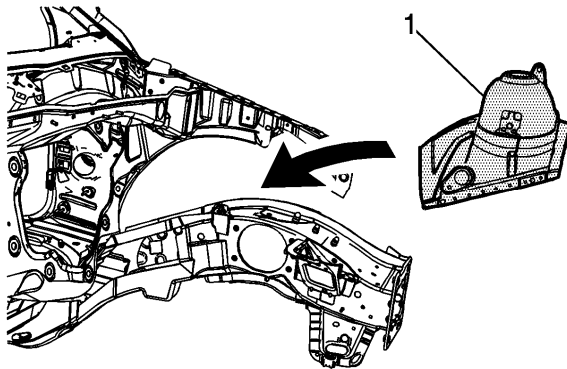
Installation Procedure



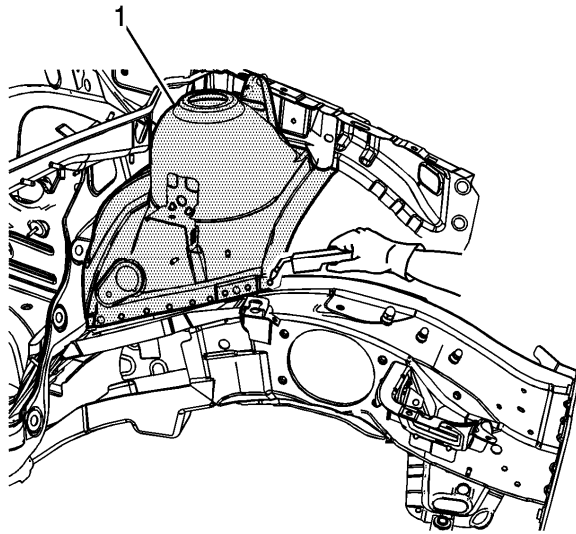
Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 in) apart. Some panels may have

structural weld-thru adhesive. It is necessary to replace the weld-thru adhesive with an additional spot weld between each factory spot weld.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original assembly.
2. Prepare the 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 front wheelhouse (1) to the vehicle using 3-dimensional measuring equipment. Clamp the wheelhouse in place.



5. Plug weld the front wheelhouse (1) accordingly.
 6. Clean and prepare all the welded surfaces.
 7. Apply the sealers and anti-corrosion materials to the repair area as necessary.
Refer to [Anti-Corrosion Treatment and Repair](#) .
 8. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
 9. Install all related panels and components.
 10. Connect the negative battery cable.
 11. Enable the SIR system.
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