

Repair Instructions

Impact Bar Bracket Replacement - Front Bumper

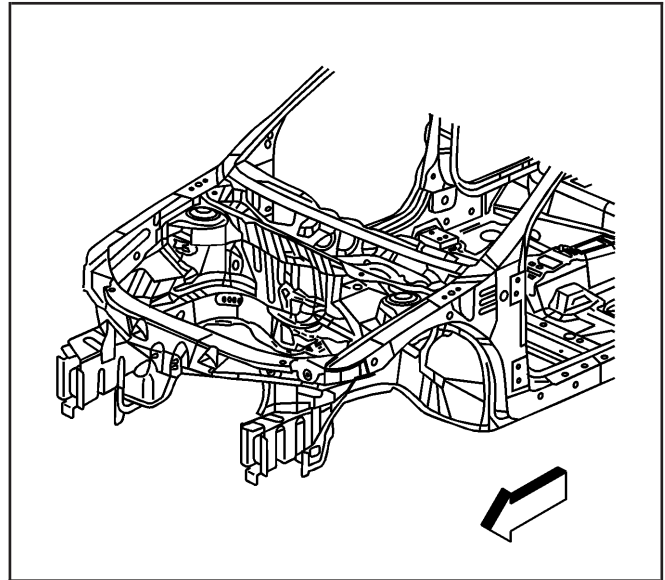
Removal Procedure

Caution: To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

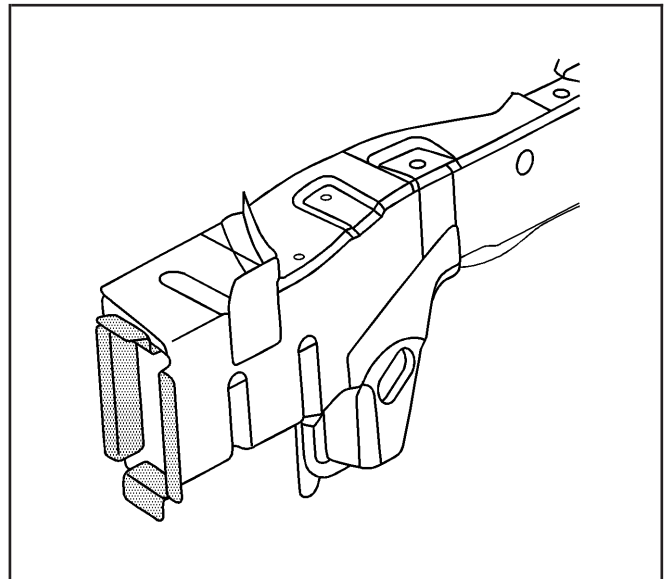
1. Disable the SIR system.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible. Refer to *Dimensions - Body on page 3-7*.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.

Important: Note the number and location of the factory welds for installation of the impact bar bracket - front bumper

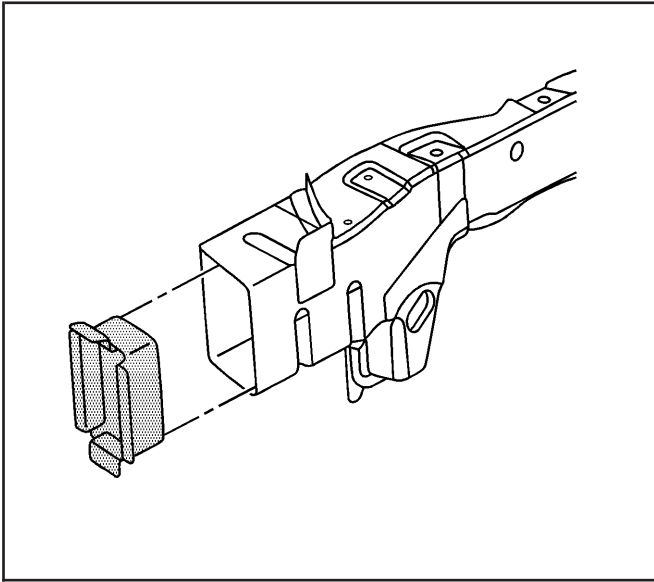
6. Locate and drill out all the factory welds from the outside surface of the rail.



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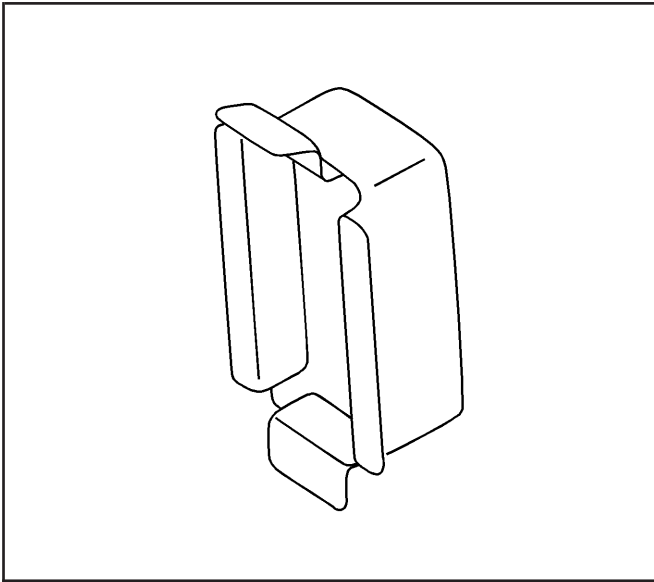


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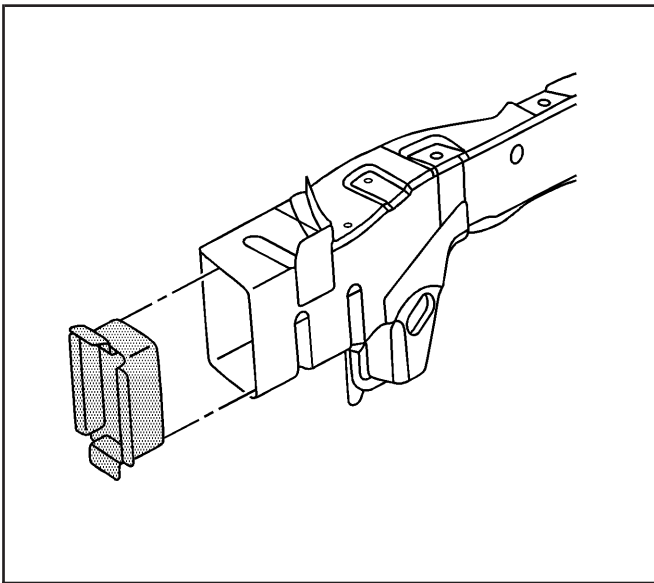
7. Remove the front bumper impact bar bracket.



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Installation Procedure

1. Prepare all mating surfaces as necessary.
2. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.

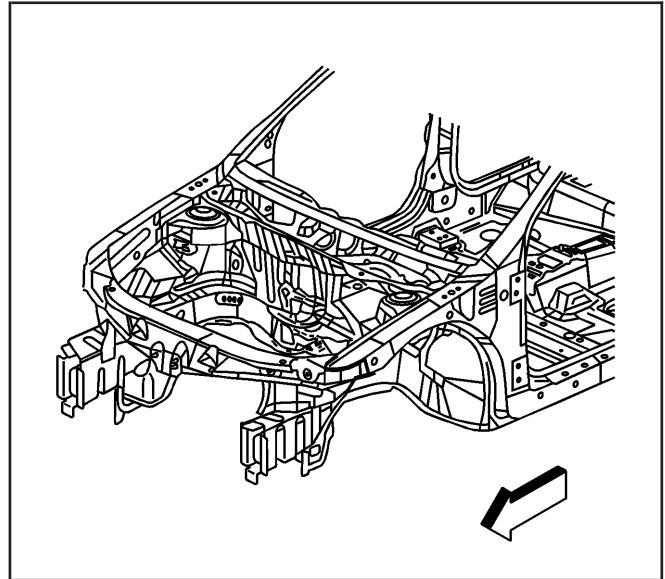


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Important: Verify the location of the front rail using 3-dimensional measuring equipment.

3. Position the impact bar bracket on the rail and clamp in place.

4. Plug weld accordingly.
5. Clean and prepare all of the welded surfaces.
6. Install all of the related panels and components.
7. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
8. Paint the repaired area.
9. Connect the negative battery cable.
10. Enable the SIR system.



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Tie Bar Replacement

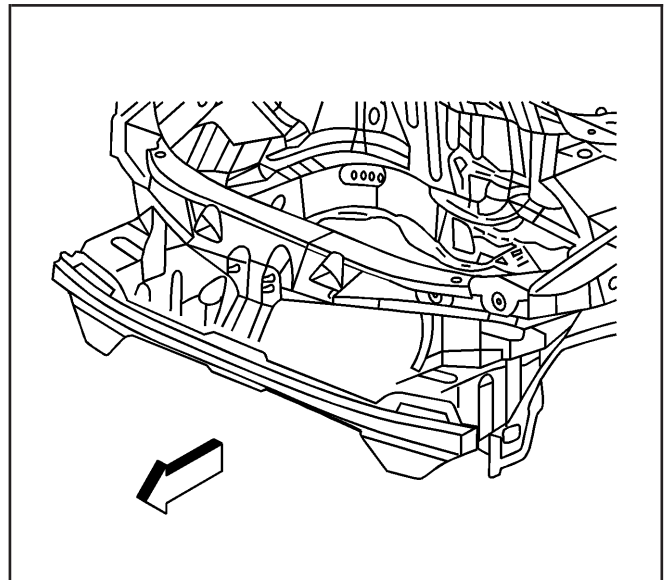
Removal Procedure

Caution: To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

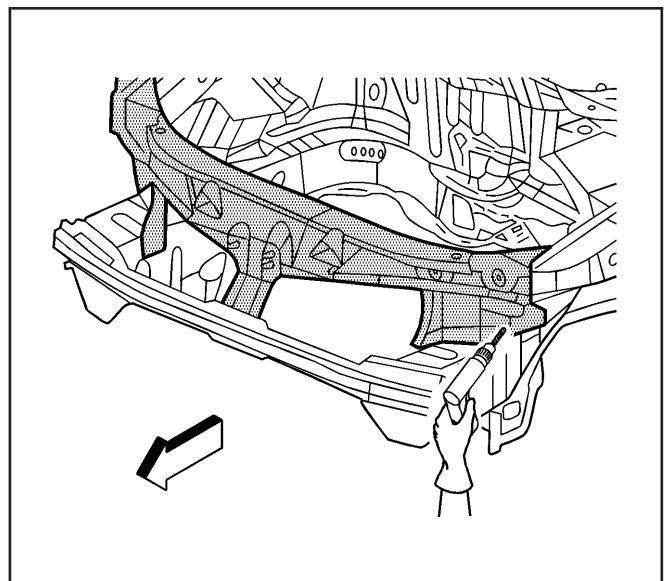
1. Disable the SIR system.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to *Dimensions - Body* on page 3-7.
5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary.

Important: Do not damage any inner panels or reinforcements.

6. Locate and drill out all factory welds. Note the number and location of the welds for installation of the tie bar.



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