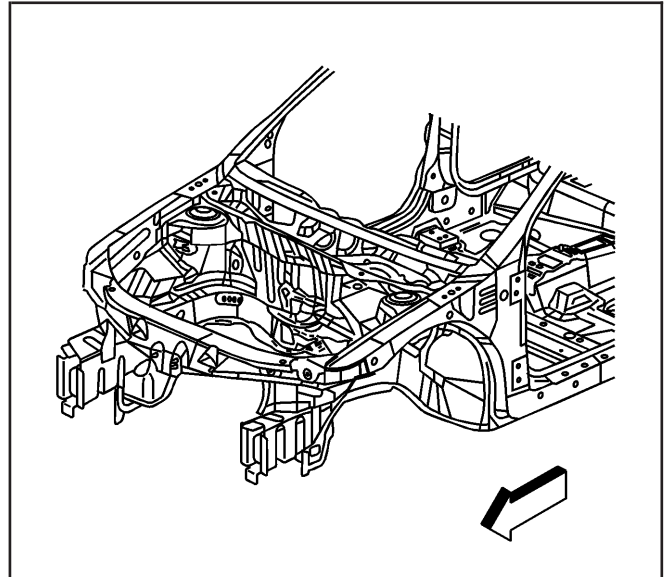


4. Plug weld accordingly.
5. Clean and prepare all of the welded surfaces.
6. Install all of the related panels and components.
7. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
8. Paint the repaired area.
9. Connect the negative battery cable.
10. Enable the SIR system.



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## Tie Bar Replacement

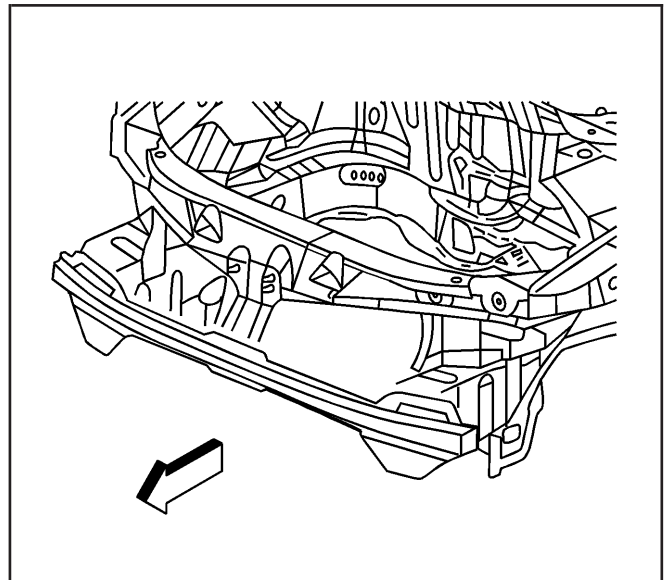
### Removal Procedure

**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.

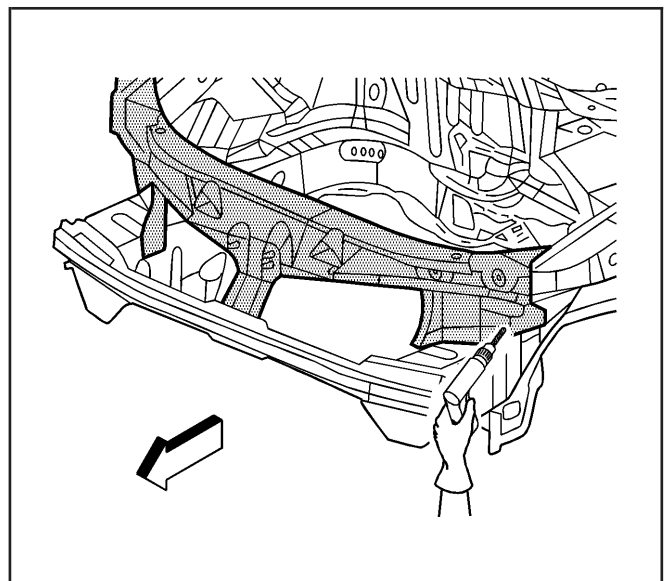
1. Disable the SIR system.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to *Dimensions - Body* on page 3-7.
5. Note the location and remove the sealers and anti-corrosion materials from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

**Important:** Do not damage any inner panels or reinforcements.

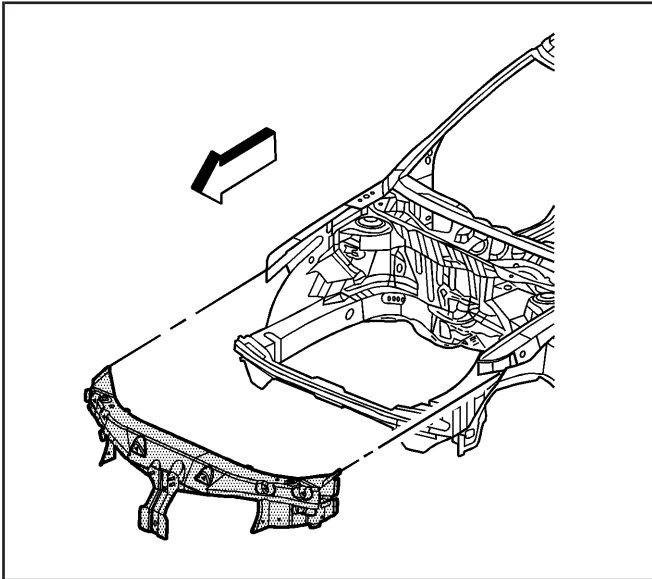
6. Locate and drill out all factory welds. Note the number and location of the welds for installation of the tie bar.



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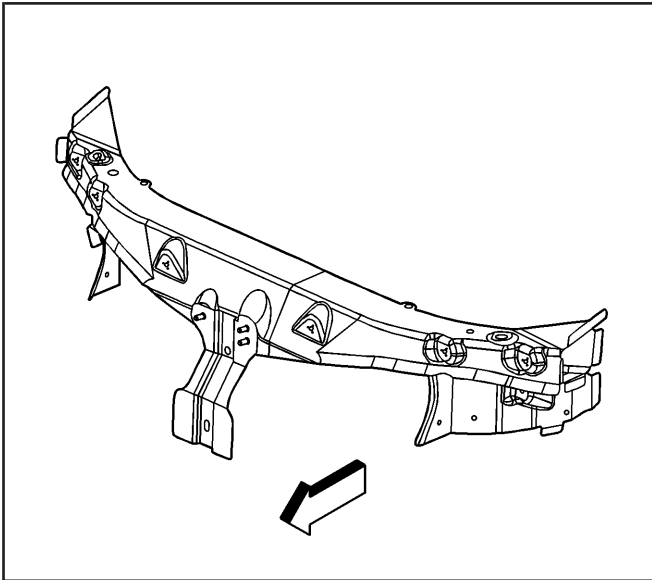


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7. Remove the damaged tie bar.

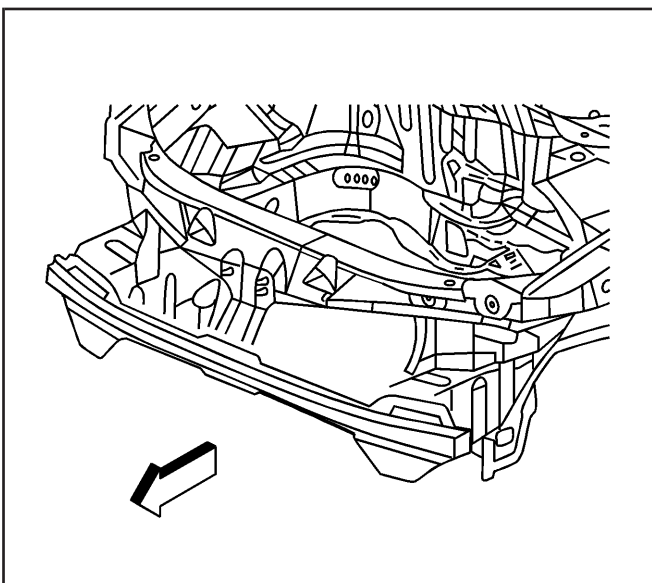


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### Installation Procedure

**Important:** If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Prepare all mating surfaces as necessary.
3. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.



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4. Position the tie bar to the vehicle using 3-dimensional measuring equipment. Clamp the tie bar into place.
5. Plug weld accordingly.
6. Clean and prepare all welded surfaces.
7. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
8. Paint the repair area.
9. Install all related panels and components.
10. Connect the negative battery cable.
11. Enable the SIR system.