

867612

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

Wheelhouse Replacement - Front

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.

Caution: When performing service on or near the SIR components or the SIR wiring, the SIR system must be disabled. Refer to SIR Disabling and Enabling Zones. Failure to observe the correct procedure could cause deployment of the SIR components, personal injury, or unnecessary SIR system repairs.

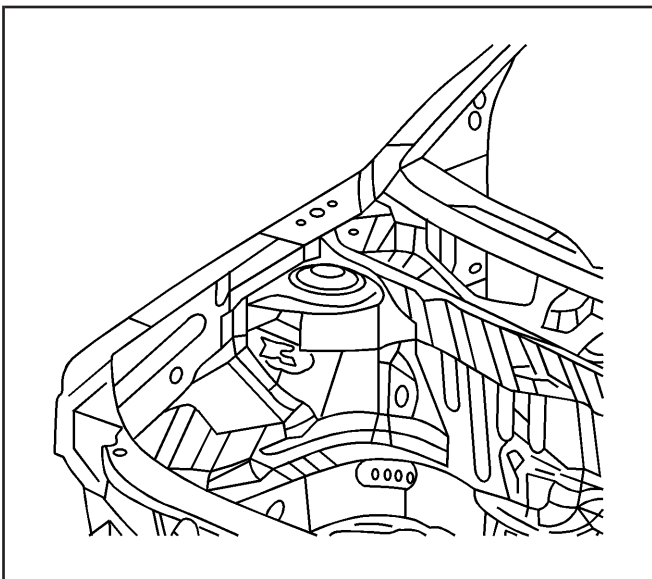
1. Disable the SIR system.
2. Disconnect the negative battery cable.

Important: The upper strut mounting surface is a dimensionally critical area, and 3-dimensional measuring equipment should be used to locate the front wheelhouse assembly. The front wheelhouse can be serviced as a complete assembly for both the left and right wheelhouses. A wheelhouse front panel is also available to service separately on the left or the right sides.

3. Remove the sealers and anti-corrosion materials from the repair area, as necessary.

Important: Be sure to inspect the front of the cowl and dash panel for damage. If the metal surface is damaged, the cowl panel must be repaired to restore the structural integrity of the vehicle.

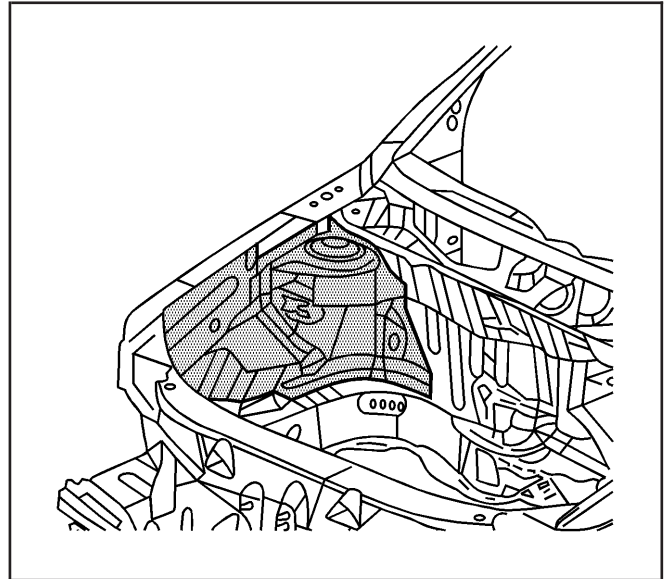
4. Visually inspect the damaged area. Repair as much of the damage as possible. Refer to *Dimensions - Body* on page 3-7.



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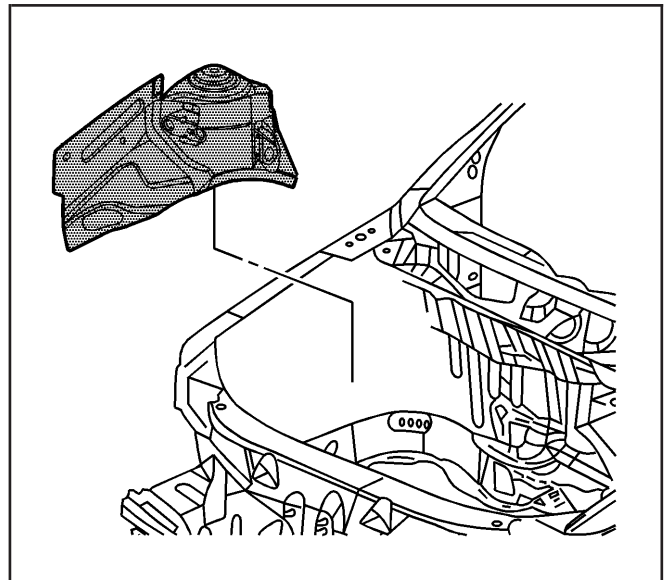
5. Locate and drill out all factory welds.

Important: Note the number and location of welds for installation of the front wheelhouse.



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6. Remove the front wheelhouse from the vehicle.

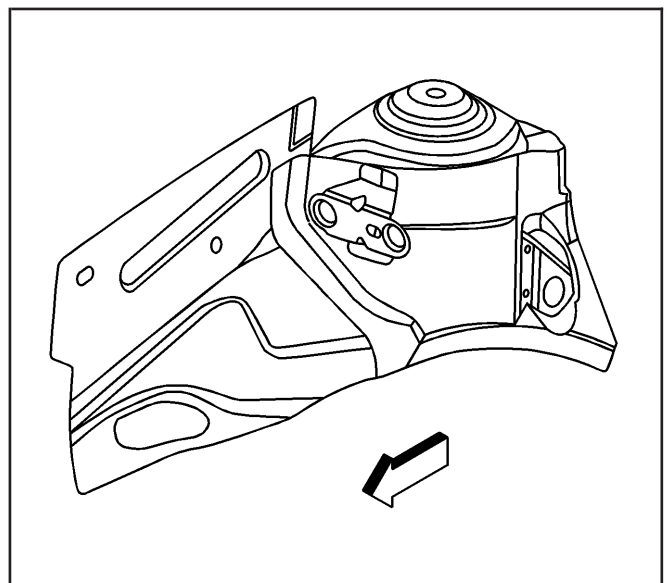


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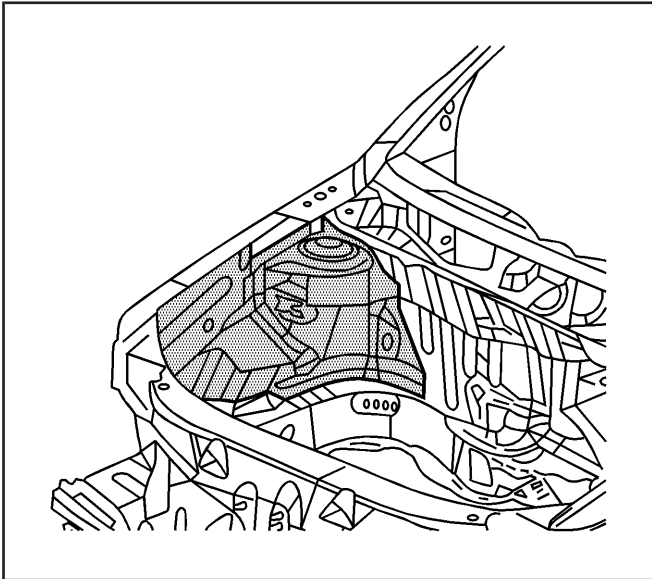
Installation Procedure

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 as necessary in the locations noted from the original assembly.
2. Prepare the mating surfaces as necessary.
3. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.
4. Position the front wheelhouse in the vehicle using 3-dimensional measuring equipment. Clamp the wheelhouse in place.

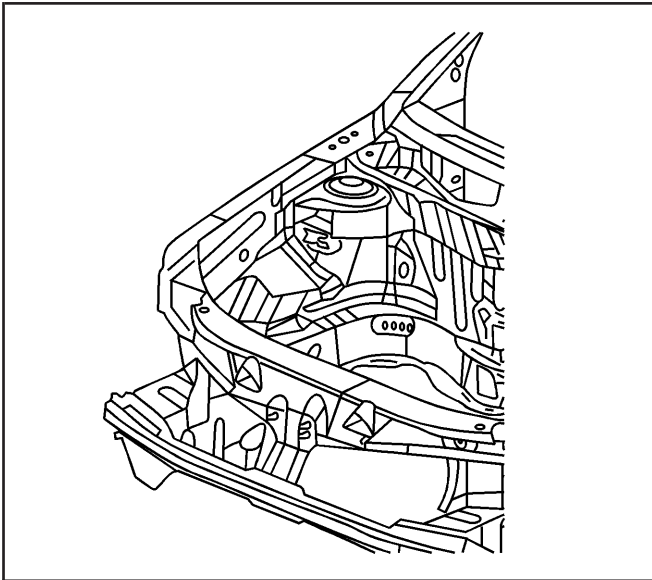


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5. Plug weld accordingly.
6. Clean and prepare all of the welded surfaces.
7. Install all related panels and components.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
9. Paint the repaired area.
10. Connect the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



868716

Wheelhouse Extension Replacement - Front

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.

Caution: When performing service on or near the SIR components or the SIR wiring, the SIR system must be disabled. Refer to SIR Disabling and Enabling Zones. Failure to observe the correct procedure could cause deployment of the SIR components, personal injury, or unnecessary SIR system repairs.

1. Disable the SIR system.

Caution: Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect the negative battery cable. Failure to follow these precautions may cause personal injury and/or damage to the vehicle or its components.

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.