

Rail Sectioning Front Compartment - Side Upper

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: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

Caution: Refer to SIR Caution on page 1-1 in General Information.

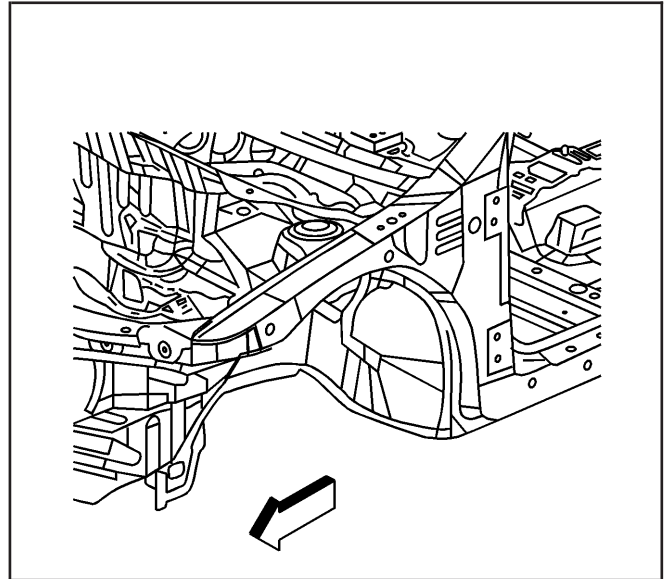
1. Disable the SIR system.

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.

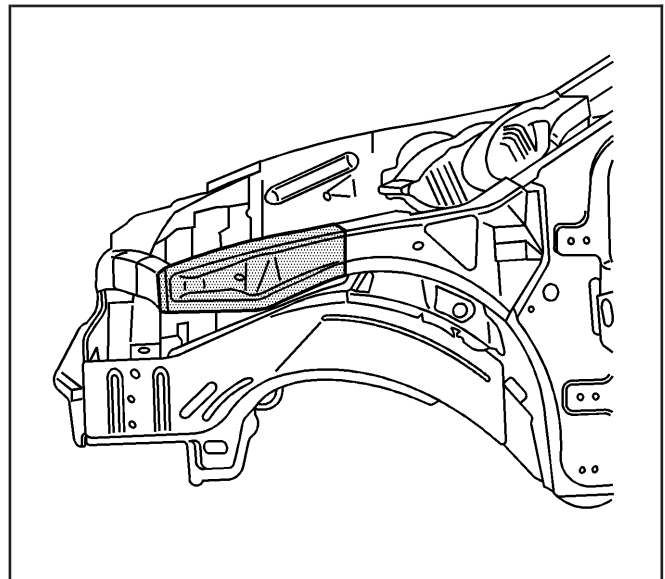
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible. Refer to *Dimensions - Body* on page 3-7.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.

Important: Note the number and location of the factory welds for installation of the front compartment of the side upper rail.

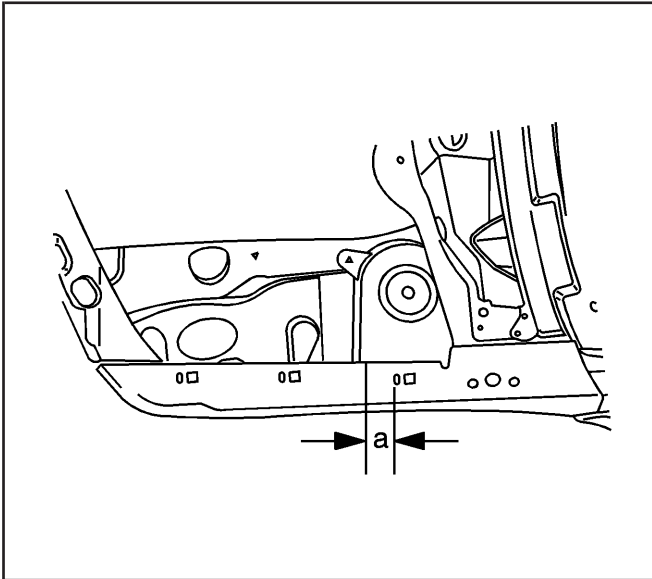
6. Locate and drill out all the necessary factory welds.



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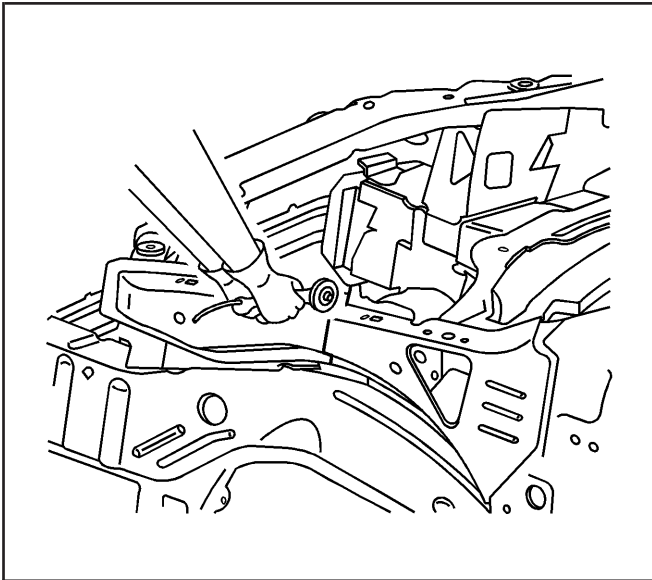


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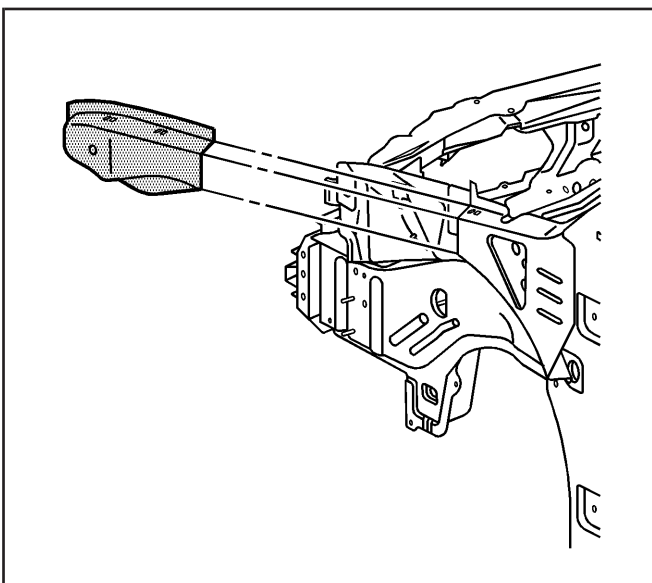
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7. Measure forward 50 mm (2 in) (a) of the center of the third fender bolt hole location. Mark the location.
8. Using the mark made in the previous step as a starting point, use a sliding square to transfer a line on the top, side, and bottom of the rail.



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9. Cut the side upper rail at the marked location.

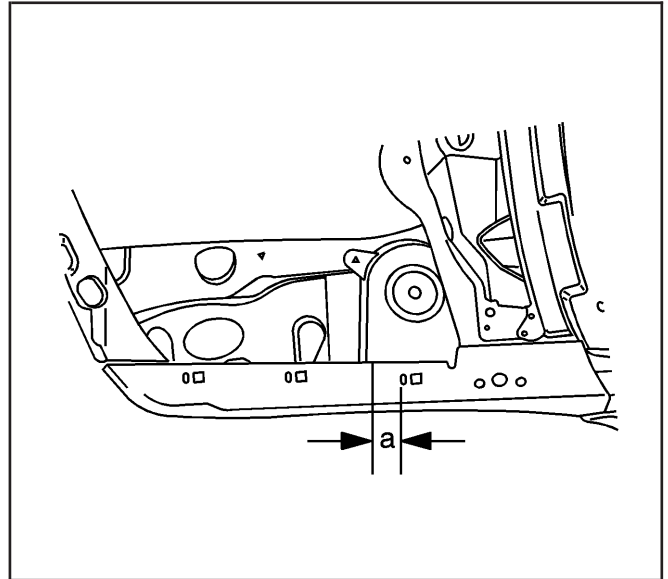


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10. Remove the front portion of the side upper rail.
11. Drill 2 8 mm (5/16 in) plug weld holes 10 mm (1/2 in) rearward from the edge of the top, bottom, and outer side on the front edge of the remaining portion of the side upper rail on the vehicle.

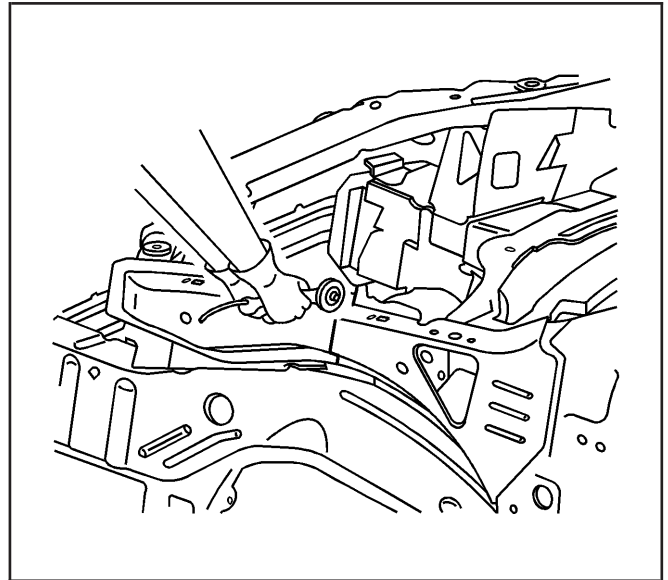
Installation Procedure

1. Measure a section on the service part that is 25 mm (1 in) (a) forward of the third fender bolt hole. Mark this section.
2. Using the mark made in the previous step as a starting point, use a sliding square to transfer a line on the top, side, and bottom of the rail.



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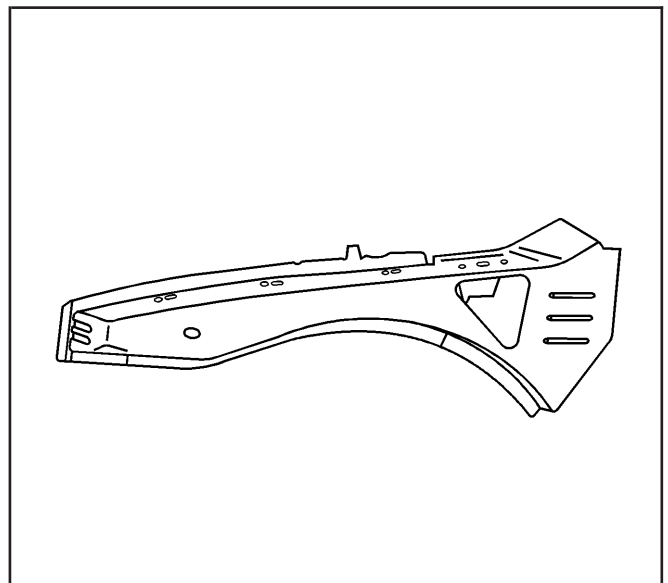
3. Cut the service part at the marked location.



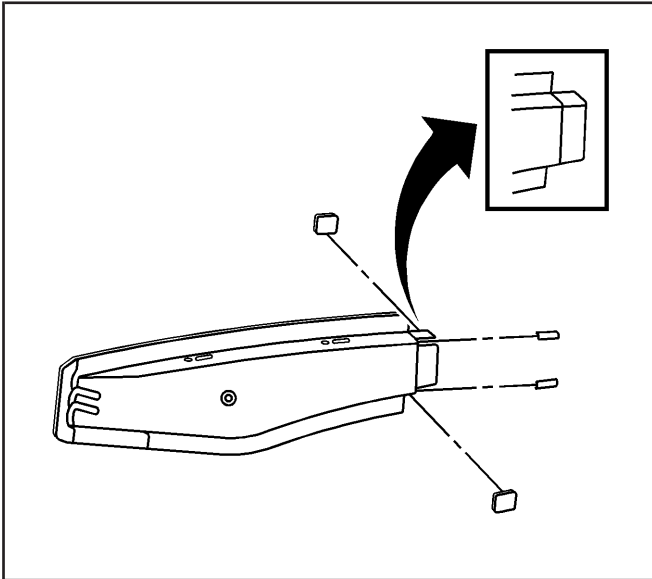
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Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

4. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted on the original panel.
5. Prepare all mating surfaces as necessary.
6. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.
7. Measure 25 mm (1 in) forward from the cut area. Mark the location on top of the rail.
8. Using the mark made in the previous step as a starting point, use a sliding square to transfer a line on the top, side, and bottom of the rail.



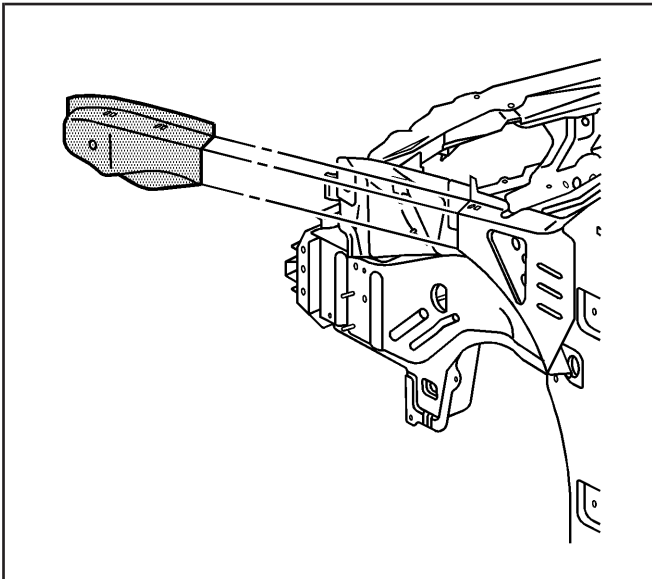
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Important: Do not cut past the scribed line.

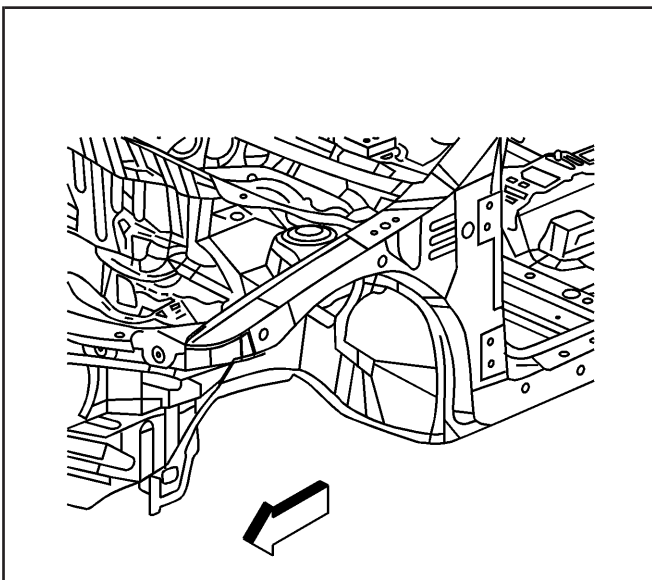
9. At the weld flange areas of the rail and at each radius, cut toward the scribed line. This will aid in the flange-forming process.
10. Bend the cut area of the rail inward to create a 25 mm (1 in) step flange for the weld joint.



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Important: Flanges on the service part will slide inside the rail portion of the vehicle.

11. Position the side upper rail to the vehicle using 3-dimensional measuring equipment. Clamp the rail in place.



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12. Stitch and plug weld accordingly.
13. Clean and prepare all of the welded surfaces.
14. Install all of the related panels and components.
15. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
16. Paint the repaired area.
17. Connect the negative battery cable.
18. Enable the SIR system.