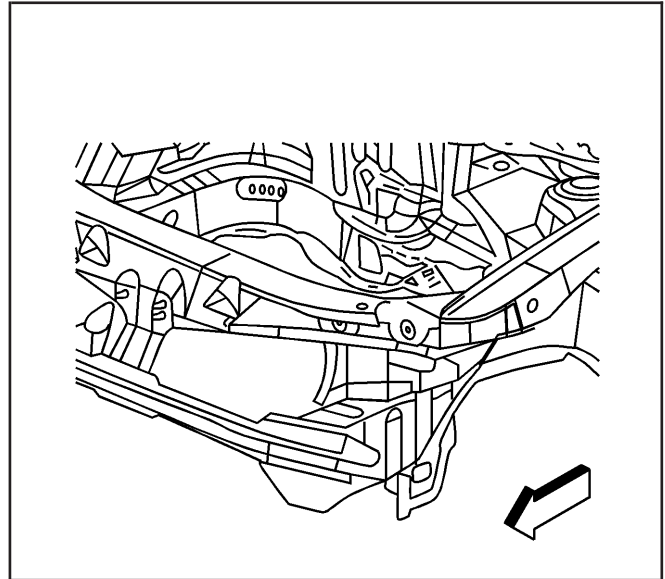


5. Plug weld accordingly.
6. Clean and prepare all of the welded surfaces.
7. Install all of the related panels and components.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
9. Paint the repaired area.
10. Connect the negative battery cable.
11. Enable the SIR system.



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## Rail Replacement Front Compartment - 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.

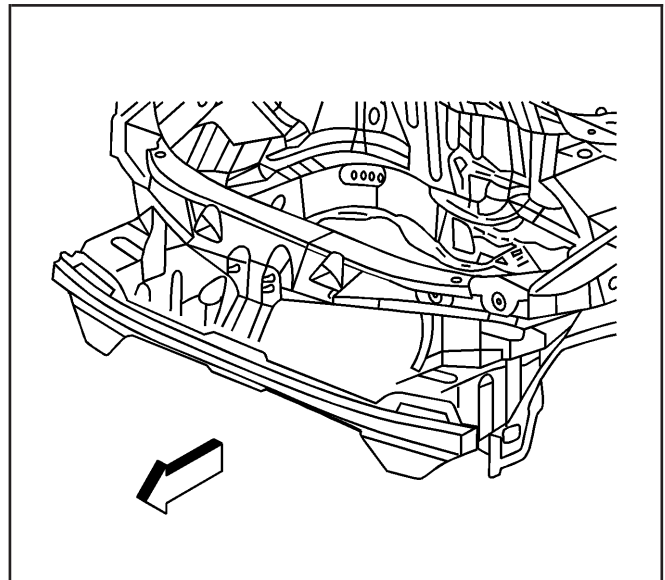
1. Disable the SIR system.

**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.

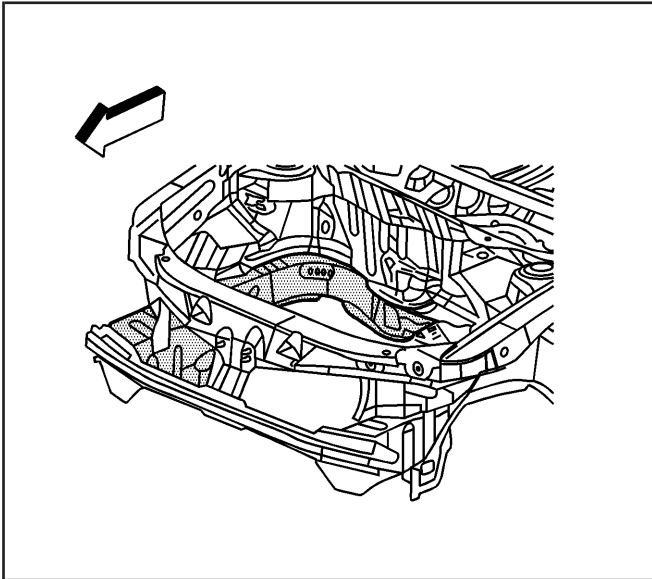
2. Disconnect the negative battery cable.

**Important:** This assembly is replaced at factory seams.

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.



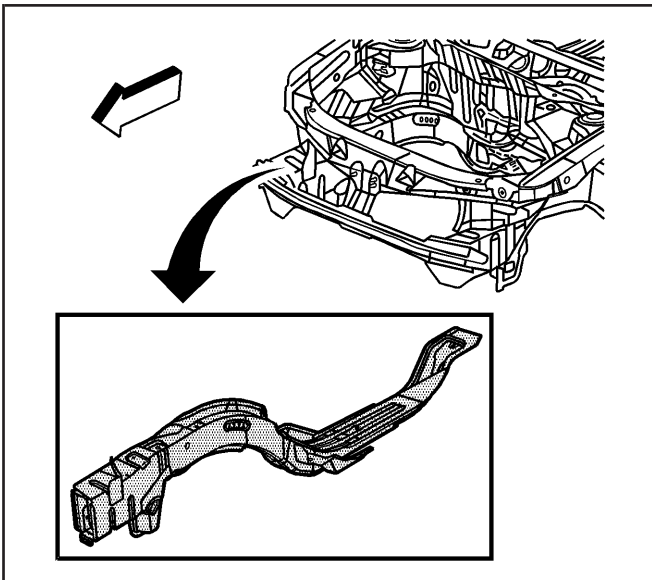
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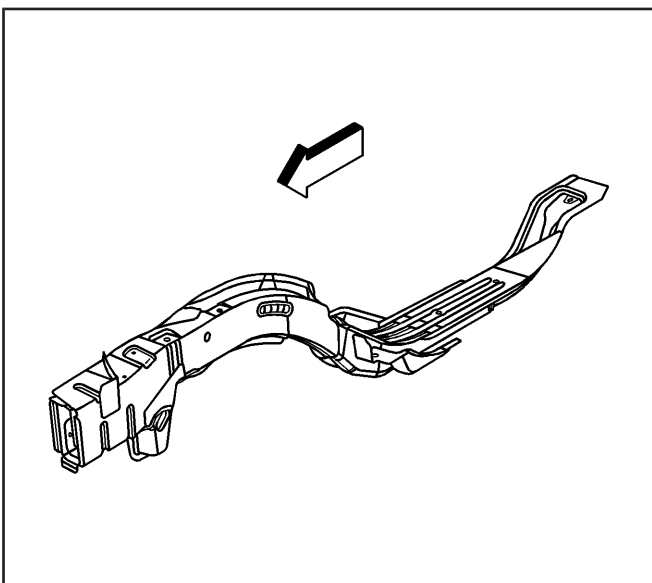
**Important:** Note the number and location of the factory welds for installation of the full rail service part.

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



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7. Remove the full rail.



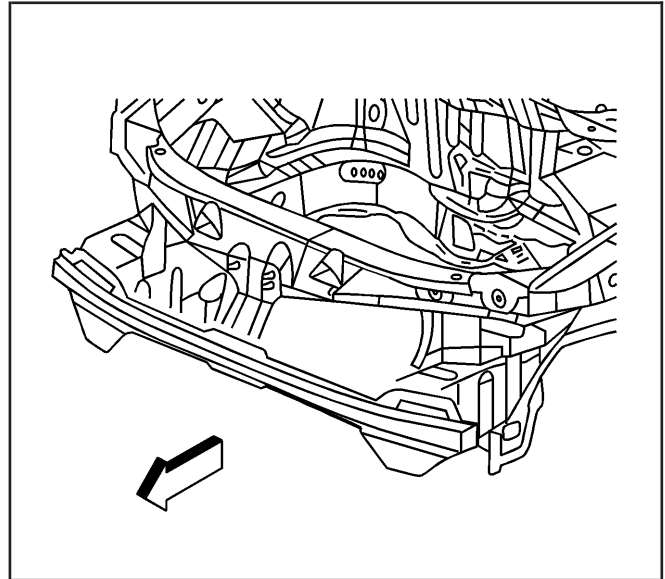
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### Installation Procedure

**Important:** If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ 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.
4. Position the full rail service part to the vehicle using 3-dimensional measuring equipment. Clamp the rail in place.

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



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## Rail Replacement Front Compartment - Front Half

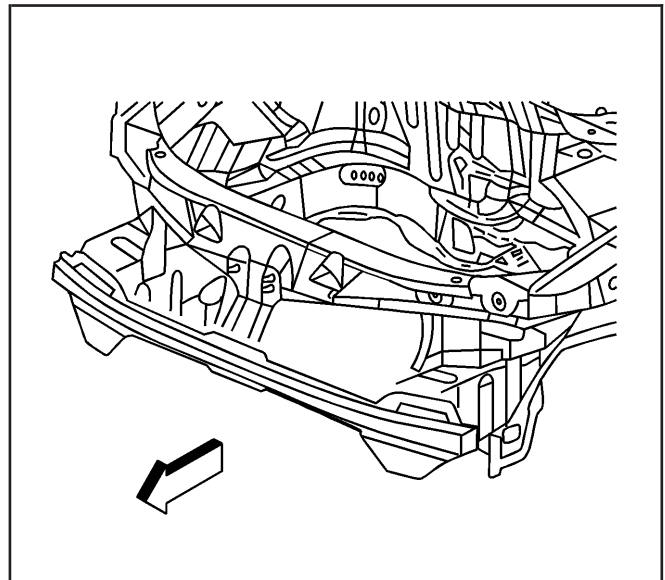
### Removal Procedure

**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.

**Important:** The service part is developed from a complete assembly and will require the spot weld removal at the rail mid joint. The lower rail service part comes as a complete front rail assembly, including all the brackets and the reinforcements.

**Important:** Loosen and protect the fuel and brake lines during rail replacement.

1. Support the engine and the transmission with suitable equipment.
2. Remove the fasteners to the engine and the transmission.
3. Remove all the other related panels and components as necessary, including the suspension and the crossmember,.
4. Visually inspect the damaged area. Repair as much of the damage as possible to factory specifications. Refer to *Dimensions - Body* on page 3-7.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.



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