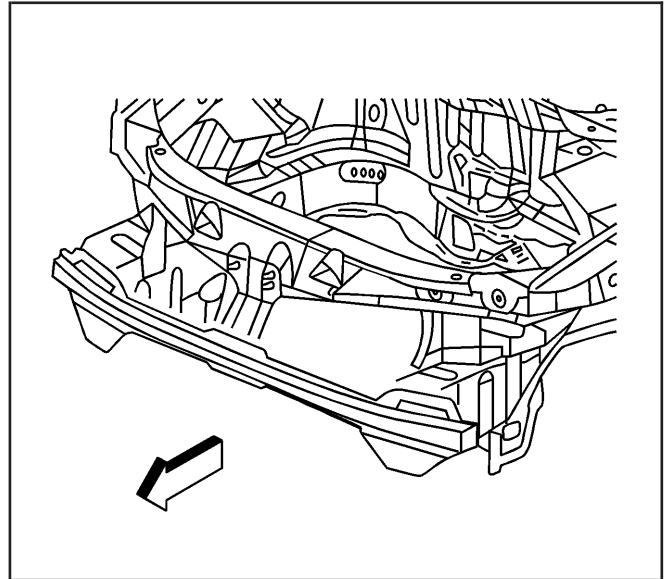


5. Plug weld accordingly.
6. Clean and prepare all of the welded surfaces.
7. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
8. Paint the repaired area.
9. Install all of the related panels and components.
10. Connect the negative battery cable.
11. Enable the SIR system.



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Rail Replacement Front Compartment - Front Half

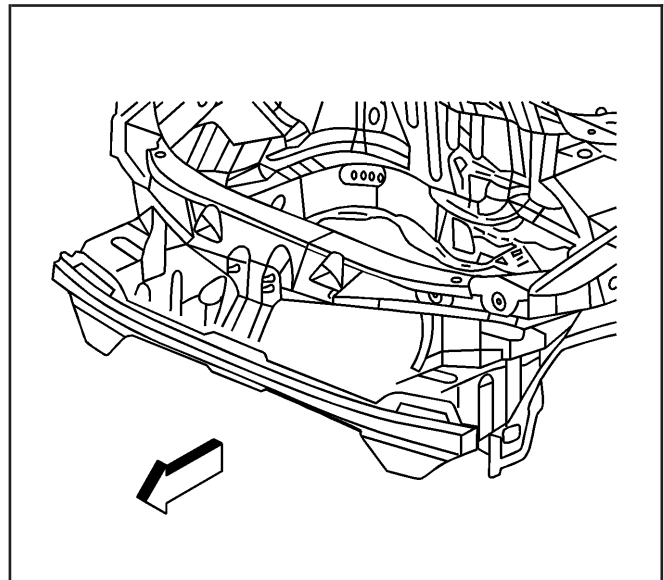
Removal Procedure

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.

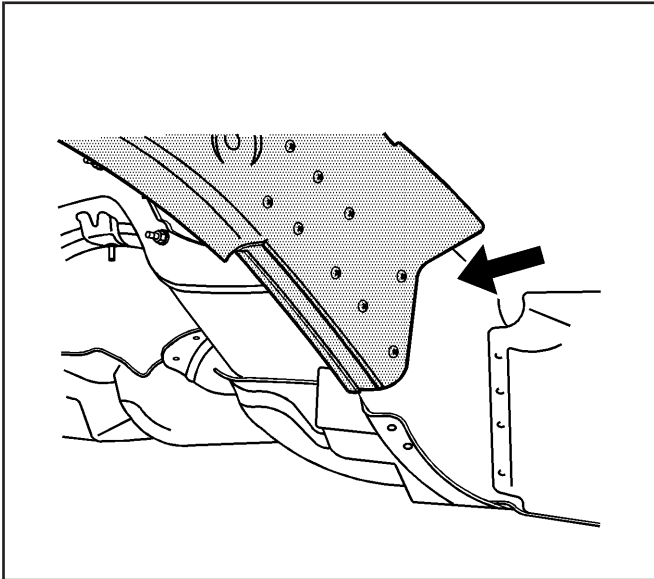
Important: The service part is developed from a complete assembly and will require the spot weld removal at the rail mid joint. The lower rail service part comes as a complete front rail assembly, including all the brackets and the reinforcements.

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.

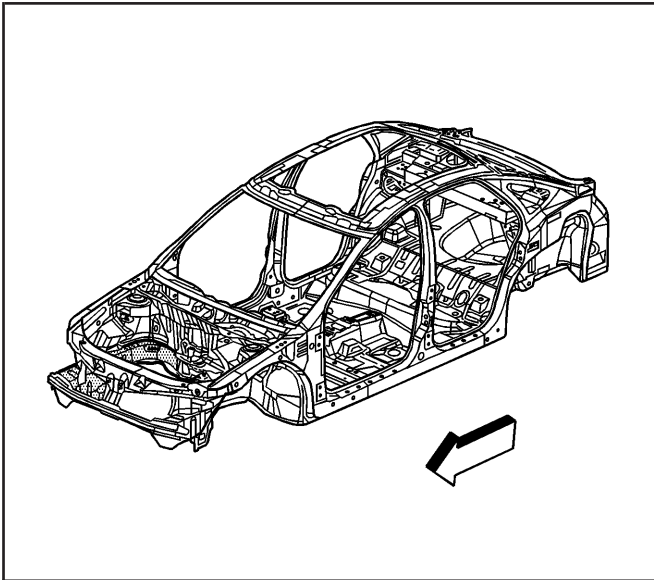


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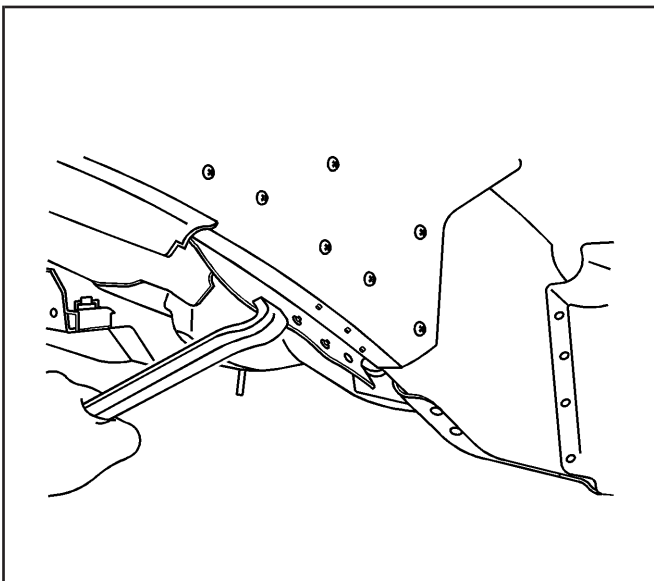
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6. Locate the area where the front compartment will be separated from the rail.



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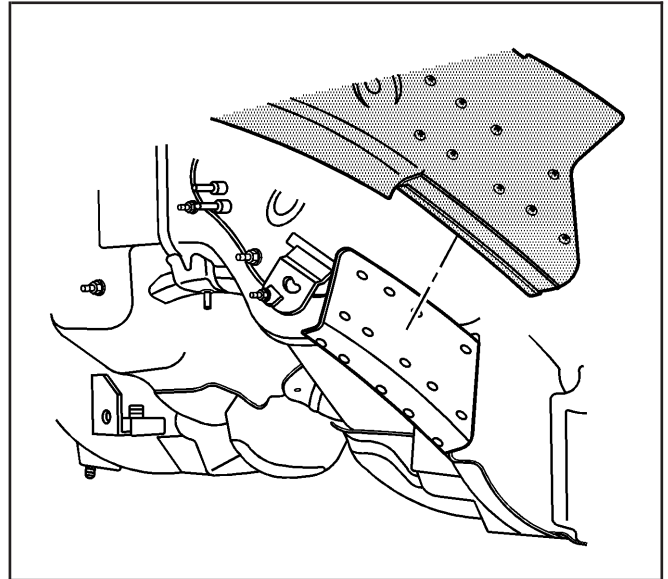
7. Locate and drill the factory welds along the flanges of the rail, only up to and including the rail mid joint just forward of the dash panel.
8. Drill out the factory welds.



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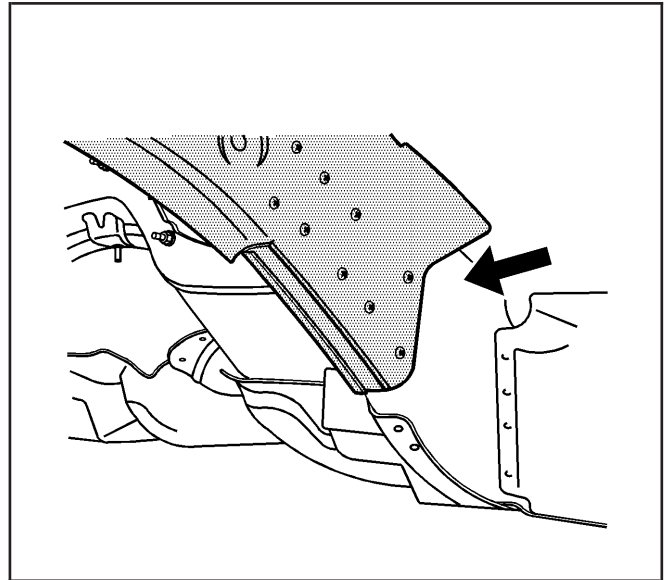
9. Pry open the outer layer of the rail at the front rail mid joint to allow the front portion of the rail to be removed from the vehicle.

10. Remove the damaged front lower rail.



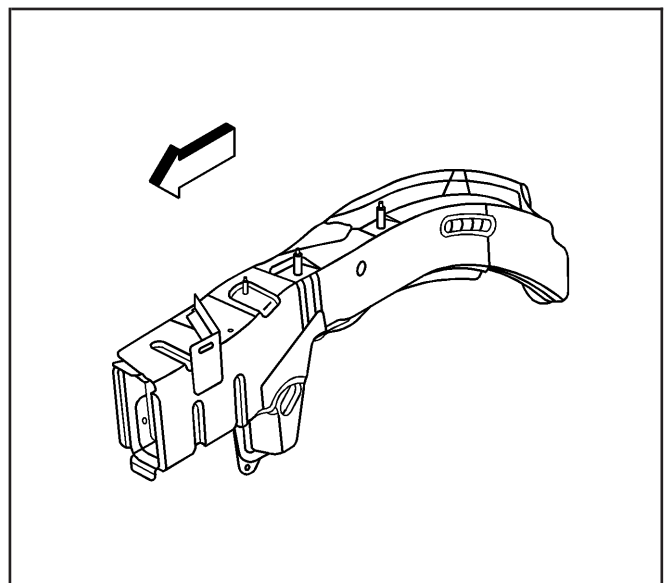
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11. Drill out the factory welds at the service rail assembly mid joint.
12. Remove the forward portion of the front rail assembly at the mid joint.

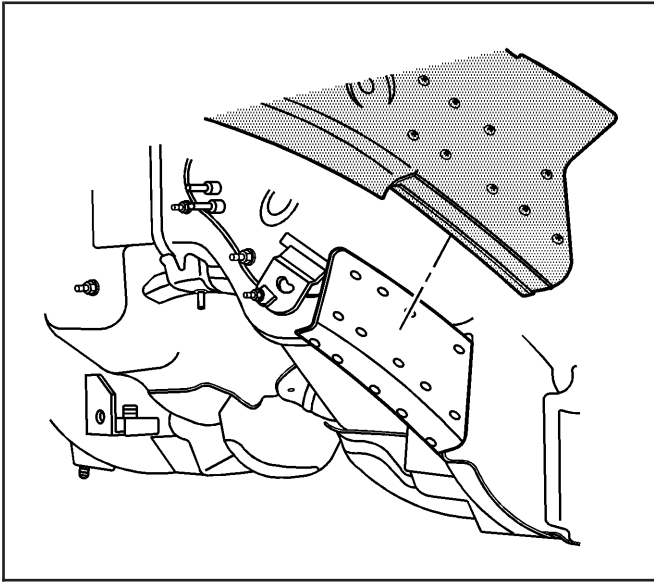


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13. Prepare the mating surfaces as necessary.
14. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.



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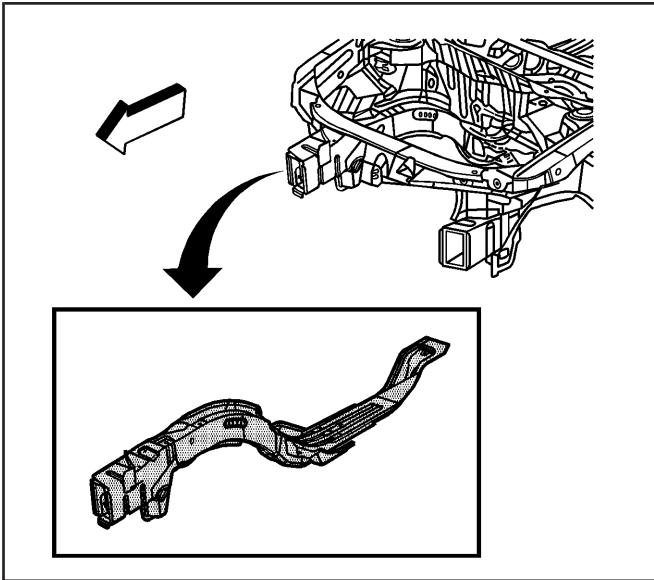


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Installation Procedure

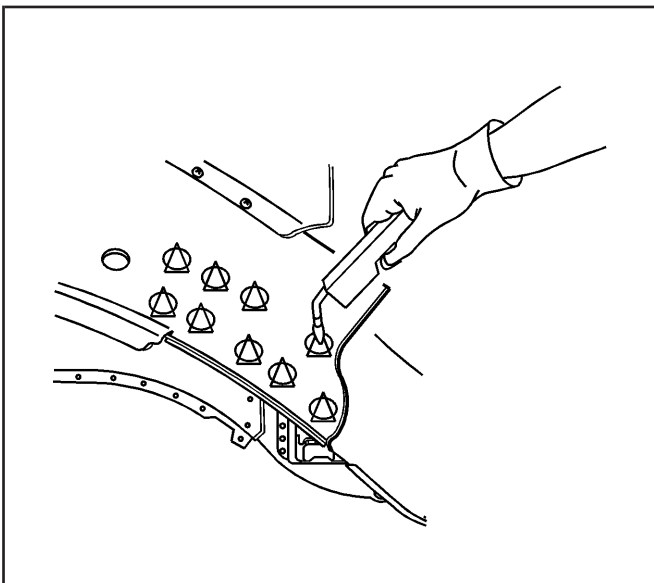
Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

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.



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4. Position the rail to the vehicle.



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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 sealers and anti-corrosion materials to the repair area, as necessary.

Notice: Use the correct fastener in the correct location. Replacement fasteners must be the correct part number for that application. Fasteners requiring replacement or fasteners requiring the use of thread locking compound or sealant are identified in the service procedure. Do not use paints, lubricants, or corrosion inhibitors on fasteners or fastener joint surfaces unless specified. These coatings affect fastener torque and joint clamping force and may damage the fastener. Use the correct tightening sequence and specifications when installing fasteners in order to avoid damage to parts and systems.

9. Install the suspension crossmember.

Tighten

Tighten the fasteners to 100 N·m (74 lb ft) + 180 degrees.

Rail Sectioning 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.

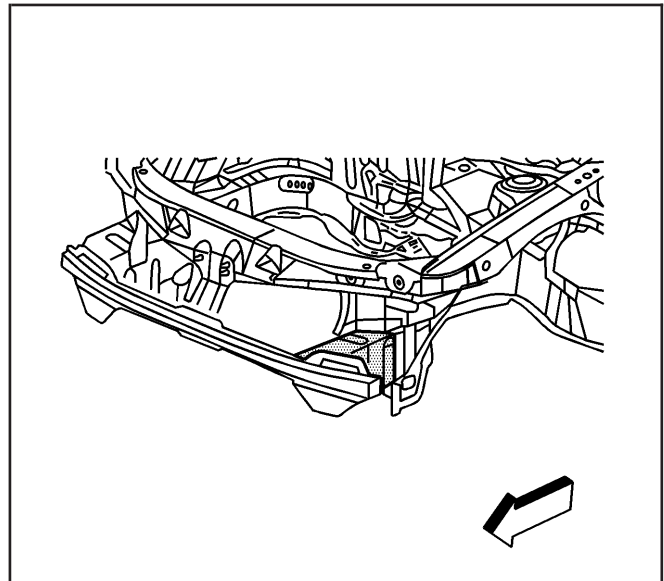
Caution: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

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



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