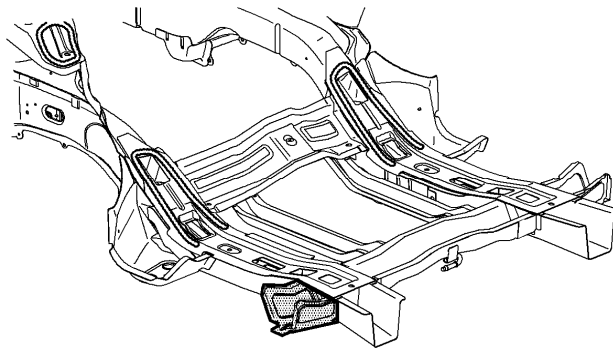


# Floor Panel Number 2 Cross Bar Extension Replacement

## Removal Procedure

**Caution:** Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.



1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#).
5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.

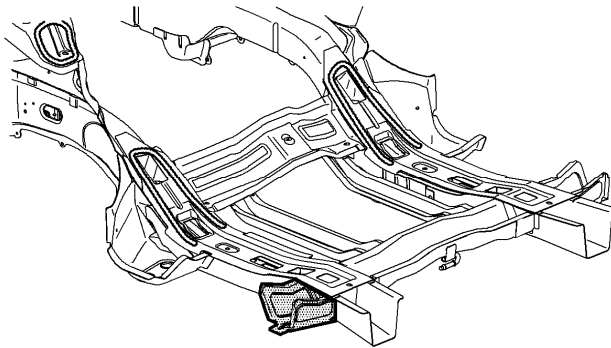
**Important:** Do not damage any inner panels or reinforcements.

6. Locate and drill out all factory welds. Note the number and location of the welds for installation of the No.2 cross bar extension.

**Important:** The rear flange connecting the No.2 cross bar extension to the rail will have to be chiseled apart due to the location of the spot welds. The new service part will have the flange bent outward for welding access.

7. Remove the damaged No.2 cross bar extension.

## Installation Procedure



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

Some panels may have structural weld-thru adhesive. It is necessary to replace the weld-thru adhesive with an additional spot weld between each factory spot weld.

1. Drill 8 mm (5/16 in) plug weld holes in the service part, as necessary, in the locations noted from the original panel.

**Important:** If reusing the original No.2 cross bar extension, bend the rear flange outward for welding access.

2. Prepare all mating surfaces, as necessary.

3. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
4. Position the No.2 cross bar extension to the vehicle using 3-dimensional measuring equipment. Clamp the No.2 cross bar extension into place.
5. Plug the weld accordingly.
6. Clean and prepare all welded surfaces.
7. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
8. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
9. Install all related panels and components.
10. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
11. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.