

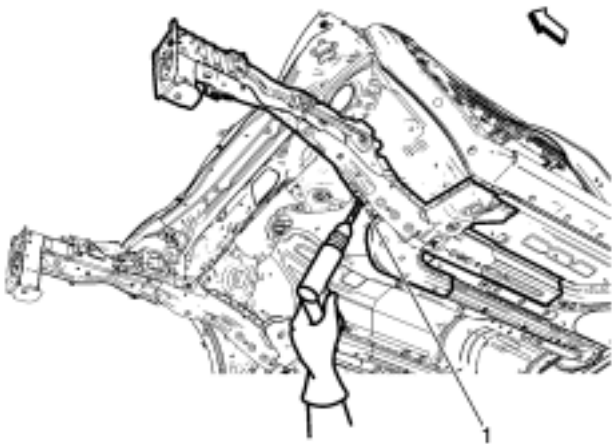
Front Compartment Side Rail Replacement

Removal Procedure

Warning: Refer to [Approved Equipment for Collision Repair Warning](#) .

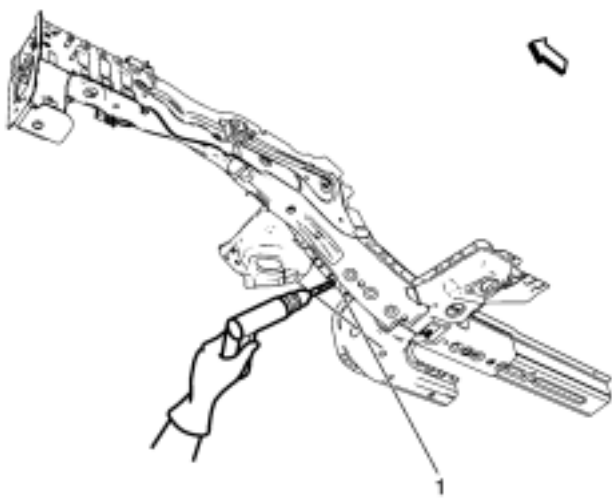
Warning: Refer to [Glass and Sheet Metal Handling Warning](#) .

1. Disable the SIR System. Refer to [SIR Disabling and Enabling](#) .
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
3. Remove all related panels and components.
4. Visually inspect the damage. Repair as much of the damage as possible.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .



6. Locate and mark all the necessary factory welds of the front compartment side rail.
7. Drill all factory welds (1). Note the number and location of welds for installation of the service assembly.
8. Remove the front compartment side rail.

Installation Procedure



1. Drill **8mm (5/16 in)** holes for plug welding along the edges of the front compartment side rail as noted from the original panel (1).
2. Clean and prepare the attaching surfaces for welding.