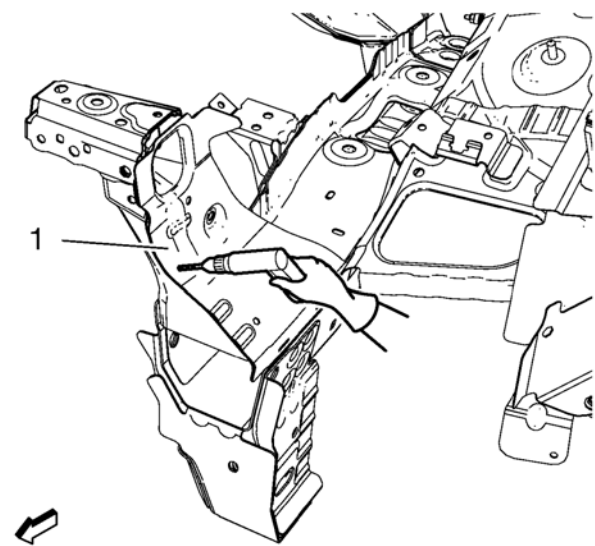


Front End Upper Tie Bar Replacement (MAG-Welding)

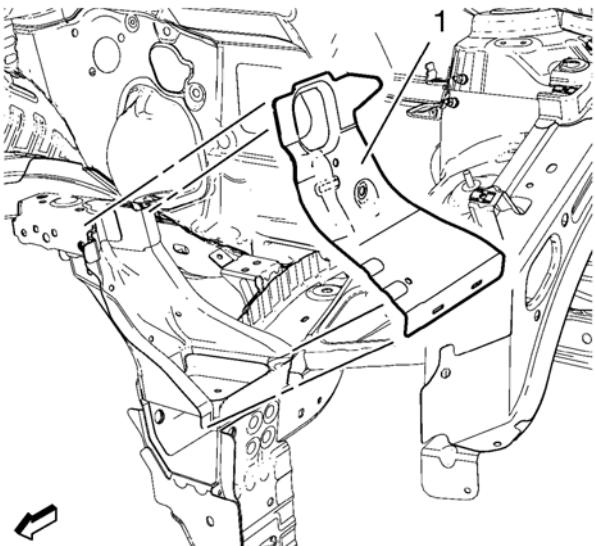
Note: According to different corrosion warranties, only the regional mandatory joining methods are allowed.

Removal Procedure

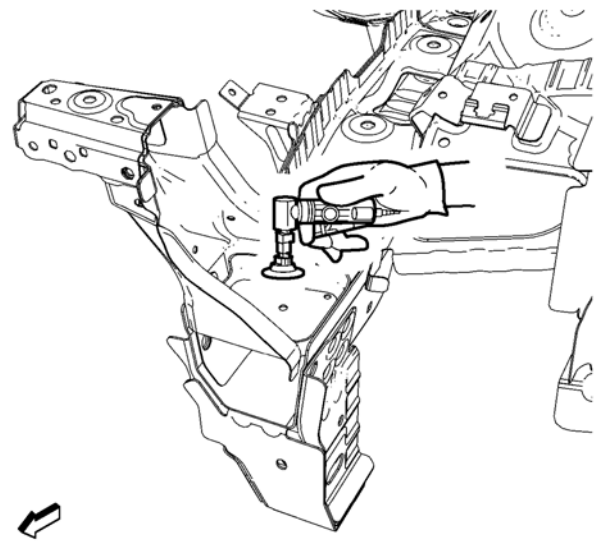
1. Disable the SIR System. Refer to [SIR Disabling and Enabling](#).
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
3. Remove all related panels and components.
4. Visually inspect the damage. Repair as much of the damage as possible.
5. Remove 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 end sheet metal cross panel reinforcement (1).
7. Drill all factory welds. Note the number and location of welds for installation of the service assembly.



8. Remove the front end sheet metal cross panel reinforcement (1).
9. Drill all factory welds.



10. Grind factory welds of the front end upper tie bar.