
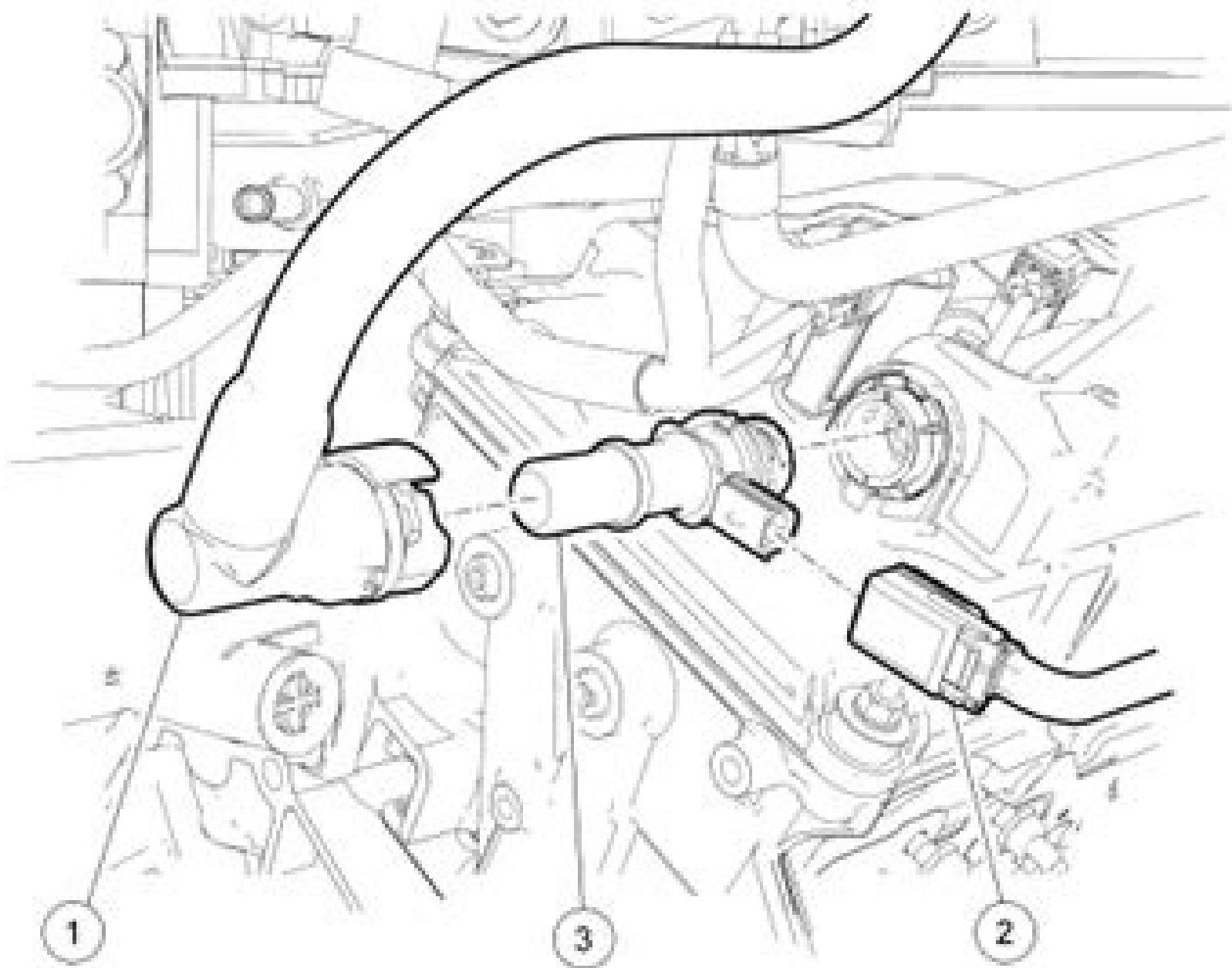
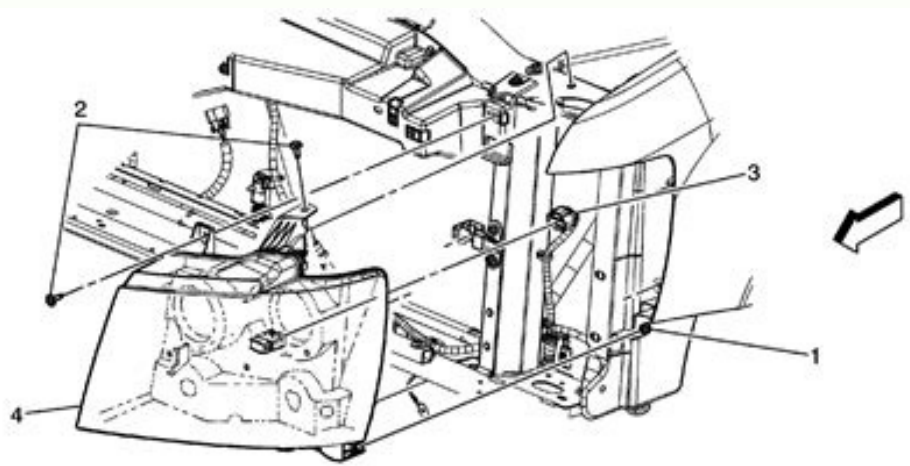


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If the repair does not require the dash panel, remove the dash panel before you install the lower plenum panel. Disconnect the negative battery cable. 868718 868716 868719 3-36 2003 Saturn Ion 36. Locate and drill out all factory welds. 18. Position the impact bar bracket on the rail and clamp in place. Important: Note the number and location of the factory welds for installation of the front wheelhouse extension. Underbody 876938 3-10 2003 Saturn Ion 10. 867424 867470 865257 3-22 2003 Saturn Ion 22. Position the side rail bracket to the front compartment lower rail and tie bar side panel. Note the number and location of the welds for installation of the tie bar. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted on the original panel. Remove the front wheelhouse extension. 868668 867608 2003 Saturn Ion 3-15 2003SaturnIon 15. Important: Note the number and location of the factory welds for installation of the front wheelhouse. Failure to observe the correct procedure could cause deployment of the SIR components, personal injury, or unnecessary SIR system repairs. Important: Verify the location of the front rail using 3-dimensional measuring equipment. Position the tie bar to the vehicle using 3-dimensional measuring equipment. Position the upper plenum panel to the vehicle using 3-dimensional measuring equipment. 870823 870823 2003 Saturn Ion 3-45 2003SaturnIon 45. Important: Flanges on the service part will slide inside the rail portion of the vehicle. Remove the right tie bar panel from the vehicle. Position the side upper rail to the vehicle using 3-dimensional measuring equipment. 11. Tie Bar Replacement - Lower 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. Tie Bar Replacement - Left 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. Location Description Length = x Width = y Height = z Point to Point a Rear Upper Hinge Upper Hole 3301 746 776 x b Quarter Panel Dog Leg Outer Attachment Hole 4226 779 768 x c Fascia Bracket Rear Upper Hole 4974 746 596 x d Quarter Panel Dog Leg Outer Attach Hole 4068 767 617 x e Quarter Panel Dog Leg Outer Attachment Hole 3991 767 437 x f Quarter Panel Dog Leg Outer Attachment Hole 3780 762 250 x g Rear Lower Hinge Rear Hole 3289 746 430 x h Rear Lower Hinge Front Hole 3254 747 430 x i Front Lower Hinge Rear Hole 2259 748 396 x j Rear Cradle Attachment Hole 2100 332 201 x k Front Lower Hinge Front Hole 2225 740 396 x l Front Rail Outer Panel Hole 1840 463 430 x m Front Cradle Attachment Hole 1371 500 280 x n Weld Nut Hole Washer Bottle Attachment 1222 540 409 x o Front Upper Outer Rail Front Hole 1880 743 760 x p Body Side Control Hole 2175 745 640 x q Front Upper Hinge Front Hole 2224 737 754 x r Front Upper Hinge Rear Hole 2260 737 754 x s Front Door Latch Striker Upper Hole 3263 748 574 x t Rear Upper Hinge Lower Hole 3299 754 741 x u Rear Latch Striker Upper Hole 4145 739 736 x v Rear Door Opening Point to Point Measurements to Weld Flange Die Marks — — — 1015 w Rear Door Opening Point to Point Measurement to Weld Flange Die Marks — — — 1188 x Front Door Opening Point to Point Measurement to Weld Flange Die Marks — — — 970 y Front Door Opening Point to Point Measurement to Weld Flange Die Marks — — — 1337 All dimensions are measured from a zero line, a center line, and a common datum. 867612 867617 3-30 2003 Saturn Ion 30. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect the negative battery cable. At the weld flange areas of the rail and at each radius, cut toward the scribed line. Position the front wheelhouse in the vehicle using 3-dimensional measuring equipment. If the repair does not require the plenum, remove the plenum before you install the dash panel. Mark the location on top of the rail. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. 868868 867423 867488 2003 Saturn Ion 3-17 2003SaturnIon 17. Clamp the support into place. Remove the damaged tie bar. Position the latch primary support on the vehicle using 3-dimensional measuring equipment. Cut the side upper rail at the marked location. Remove the front wheelhouse from the vehicle. Locate and drill out all the necessary factory welds. 1. Prepare the mating surfaces as necessary. 867504 865272 867504 3-20 2003 Saturn Ion 20. Remove all related panels and components. 865272 867504 867423 2003 Saturn Ion 3-25 2003SaturnIon 25. Panel Identification Identifying Symbol Chemical Composition or Plastic "Family" Name Typical Area where Used 2003SaturnIon 23. Location Description Length = x Width = y Height = z Point to Point a Door Opening Point to Point Measurement to Weld Flange Die Marks x x x 1588 r Door Opening Point to Point Measurement to Weld Flange Die Marks x x x 1868 All dimensions are measured from a zero line, a center line, and a common datum. Repair as much of the damage as possible. Position the front wheelhouse extension to the vehicle using 3-dimensional measuring equipment. Clamp the extension in place. Structure Identification Structure Identification Number Description Procedure 1 Impact Bar Bracket Replacement - Front Bumper Impact Bar Bracket Replacement - Front Bumper on page 3-15 2 Tie Bar Replacement Tie Bar Replacement on page 3-17 3 Tie Bar Replacement - Lower Tie Bar Replacement - Lower on page 3-21 4 Latch Primary Support Replacement - Hood Latch Primary Support Replacement - Hood on page 3-26 5 Tie Bar Replacement - Left Tie Bar Replacement - Left on page 3-19 6 Tie Bar Replacement - Right Tie Bar Replacement - Right on page 3-23 7 Bracket Replacement Side Rail - Front Compartment Bracket Replacement Front Compartment - Side Rail on page 3-30 867419 3-4 2003 Saturn Ion 4. The front wheelhouse can be serviced as a complete assembly for both the left and right wheelhouses. Before beginning any repair, identify the type of material involved. Pull the body side panel outward and upward. 867495 867507 865277 2003 Saturn Ion 3-33 2003SaturnIon 33. Latch Primary Support Replacement - Hood 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. Tie Bar Replacement - Right 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. A wheelhouse front panel is also available to service separately on the left or the right sides. January 23, 2022January 23, 2022January 23, 2022January 22, 2022January 21, 2022January 21, 2022 Motor Era Automotive Blog Classic Car Info RSS Feed Contact Us I participate in the Amazon Services LLC Associates Program, an affiliate advertising program designed to provide a means for sites to earn advertising fees by advertising and linking to amazon.com. Rail Sectioning Front Compartment - Side Upper 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. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the corresponding locations noted on the original panel. Position the battery tray to the vehicle. Locate and drill out all of the necessary factory welds at the following locations: • The dash panel to the lower plenum • The inside ends of the lower plenum • On the rear top portion of the front upper rail to the plenum 8. Component Locator Panel Identification Legend (1) PA + PPE (2) ABS + PC (3) PA + PPE (4) ABS + PC (5) PET (6) Steel (7) ABS + PC (8) TPO (9) PET (10) PA + PPE (11) ABS + PC (12) PA + PPE (13) TPO (14) PET 873924 3-2 2003 Saturn Ion 2. 7. Position the right tie bar panel to the vehicle using 3-dimensional measuring equipment. Dash Panel Replacement 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. 867612 867478 3-32 2003 Saturn Ion 32. Rail Replacement Front Compartment - Side Upper 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. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision. Important: Be sure to inspect the front of the cowl and dash panel for damage. Tie Bar Replacement 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. 9. 6. Sedan Side 876943 2003 Saturn Ion 3-13 2003SaturnIon 13. As an Amazon Associate I earn from qualifying purchases. Important: Note the number and location of the factory welds for installation of the impact bar bracket - front bumper 6. Location Description Length = x Width = y Height = z Point to Point 2 Center Line — — — x a Rear Cradle Attachment

Hole 21100 332 201 x b Front Rail Outer Torque Box Master Gage Hole 22118 600 121 x c Floor Pan Drain Hole Front Hole 2420 542 190 x d Front Rail Rear Hole 2675 421 134 x e Floor Pan Sled Rail Front Hole 2585 162 133 x f Front Rail Hole Rear of Rear Portion 3171 601 167 x g Floor Pan Sled Rail Rear Hole 3374 170 144 x h Floor Pan Rear Drain Hole 3378 521 190 x i Rear Rail Torque Box Master Gage Hole 3593 592 203 x j Front Rail Hole 3826 600 184 x k 5 Bar Outer Hole 4235 180 354 x l Rear Rail Rear Slot 4757 487 372 x m Rear Compartment Floor Pan Drain Hole 5000 40 221 x t Front Cradle Attachment Hole 1371 474 231 x n to o Rear Rail Rear Hole to Rear Rail Master Gage Hole — — — 1174 o to p Rear Rail Master Gage Hole to Front Rail Rear Hole — — — 419 p to q Front Rail Rear Hole to Front Rail Master Gage Hole — — — 956 q to s Front Rail Master Gage Hole to Front Cradle Attachment Hole — — — 847 r to s Rear Cradle Attachment Hole to Front Cradle Attachment Hole — — — 742 s to t Front Cradle Attachment Hole to Front Cradle Attachment Hole — — — 948 t to r Front Cradle Attachment Hole to Opposite Rear Cradle Attachment — — — 1087 r to f Rear Cradle Attachment Hole to Opposite Rear Rail Rear Hole — — — 1756 r to i Rear Cradle Attachment Hole to Rear Rail Master Gage Hole — — — 1756 f to o Front Rail Rear Hole to Opposite Rear Rail Master Gage Hole — — — 1243 o to l Rear Rail Master Gage Hole to Opposite Rear Rail Rear Hole — — — 1591 l to n Rear Rail Rear Hole to Rear Rail Rear Hole — — — 974 All dimensions are measured from a zero line, a center line, and a common datum. Bend the cut area of the rail inward to create a 25 mm (1 in) step flange for the weld joint. Important: Note the number and location of the factory welds for installation of the lower tie bar. Repair as much of the damage as possible. Enable the SIR system. Front End Location Description Length = x Width = y Height = z Point to Point 2 Center Line — — — x a Front Lamp Assembly Inner Attach Hole 1146 327 675 x b Front Lamp Assembly Center Attach Hole 1208 458 682 x c Front Lamp Assembly Outer Attach Hole 1271 589 676 x d Front Lamp Assembly Lower Attach Hole 1307 561 594 x e Lower Tie Bar Outer Hole 1989 314 428 x f Center Brace Hole 1089 17 568 x g Lower Tie Outer Slot 998 314 428 x h Front Header Panel Roof Attachment Hole (Sedan and Coupe) 2799 297 1307 x All dimensions are measured from a zero line, a center line, and a common datum. Refer to Dimensions - Body on page 3-7. Different materials require different procedures for preparing and refinishing. Important: This panel is replaced at factory seams. Locate and drill out all the factory welds from the outside surface of the hole. 867500 867504 3-24 2003 Saturn Ion 24. Repair as much of the damaged area as possible. Remove the lower tie bar. Plenum Panel Replacement - Lower 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. Cut the service part at the marked location. The right hand procedure is similar. Thank you very much for your reading. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel. 4. Installation Procedure Important: The service part comes as an assembly that includes the lower dash panel. Exterior body panels are constructed of various materials, due to the increased dent and corrosion resistance of modern composites. Installation Procedure Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart. Important: The upper strut mounting surface is a dimensionally critical area, and 3-dimensional measuring equipment should be used to locate the front wheelhouse assembly. 874296 874298 874290 2003 Saturn Ion 3-41 2003SaturnIon 41. Clamp the wheelhouse in place. 874296 874298 874299 3-40 2003 Saturn Ion 40. Important: Note the number and location of the factory welds for installation of the dash panel. Position the left tie bar to the vehicle using 3-dimensional measuring equipment. 867423 867511 3-26 2003 Saturn Ion 26. 870810 870809 865505 2003 Saturn Ion 3-49 2003SaturnIon 49. Disable the SIR system. Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart. 867618 865267 867618 2003 Saturn Ion 3-31 2003SaturnIon 31. 867514 865273 867514 2003 Saturn Ion 3-27 2003SaturnIon 27. 5. Important: Note the number and location of the factory welds for installation of the bracket side rail-front compartment. Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart. Installation Procedure Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart. Important: Do not cut past the scribed line. 868720 868722 868719 3-38 2003 Saturn Ion 38. Clamp the panel in place, 9. Refer to SIR Disabling and Enabling Zones. Important: Do not damage any inner panels or reinforcements. 12. Clean and prepare all of the welded surfaces. Clamp the tie bar into place. Installation Procedure 1. Note the number and location of the welds for installation of the front upper rail. Remove the damaged front upper rail. Measure forward 50 mm (2 in) (a) of the center of the third fender bolt hole location. Position the tie bar on the vehicle using 3-dimensional measuring equipment. Clamp the bracket in place. Clean and prepare all welded surfaces. 872732 872732 872730 2003 Saturn Ion 3-29 2003SaturnIon 29. 870855 870847 870855 3-44 2003 Saturn Ion 44. 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. Remove the front bumper impact bar bracket. Prepare all mating surfaces as necessary. 5. Specifications Dimensions - Body Rear End Location Description Length = x Width = y Height = z Point to Point 2 Center Line — — — x a Rear Tail Lamp Pocket Hole 5162 532 683 x b Rear Impact Beam Upper Outer Attach Hole 5149 587 447 x c Rear Impact Beam Lower Outer Attach Hole 5176 439 327 x d (Sedan) Rear Header Panel Roof Attachment Hole 4133 306 1326 x d (Coupe) Rear Header Panel Roof Attachment Hole 4068 306 1285 x All dimensions are measured from a zero line, a center line, and a common datum. The hood, roof, and deck are steel. 875630 874299 868719 3-42 2003 Saturn Ion 42. Refer to Dimensions - Body on page 3-7. Position the lower plenum panel to the vehicle. 876936 2003 Saturn Ion 3-9 20033SaturnIon 9. Structure Identification (cont'd) Number Description Procedure 8 Wheelhouse Replacement - Front Wheelhouse Replacement - Front on page 3-32 9 Wheelhouse Extension Replacement - Front Wheelhouse Extension Replacement - Front on page 3-34 10 Rail Replacement Front Compartment - Side Upper Rail Replacement Front Compartment - Side Upper on page 3-36 11 Rail Sectioning Front Compartment - Side Upper Rail Sectioning Front Compartment - Side Upper on page 3-39 12 Plenum Panel Replacement - Upper Plenum Panel Replacement - Upper on page 3-43 13 Plenum Panel Replacement - Lower Plenum Panel Replacement - Lower on page 3-45 14 Dash Panel Replacement Dash Panel Replacement on page 3-48 15 Cross Bar New Replacement - Floor Panel Cross Bar No.1 Replacement - Floor Panel on page 3-51 16 Rail Replacement Front Compartment - Front Rail Replacement Front Compartment - Front on page 3-53 17 Rail Replacement Front Compartment - Front Half Rail Replacement Front Compartment - Front Half on page 3-55 18 Rail Sectioning Front Compartment - Front Rail Sectioning Front Compartment - Front on page 3-59 19 Rail Replacement Front Side Underbody - Outer Rail Replacement Front Side Underbody - Outer on page 3-63 20 Suspension Support Replacement - Front Suspension Support Replacement - Front on page 3-66 21 Extension Replacement Front Compartment Side Rail - Rear Extension Replacement Front Compartment Side Rail - Rear on page 3-68 22 Windshield Frame Reinforcement Replacement - Inner Upper Windshield Frame Reinforcement Replacement - Inner Upper on page 3-70 23 Hinge Pillar Body Replacement - Front Inner Hinge Pillar Body Replacement - Front Inner on page 3-75 24 Hinge Pillar Body Reinforcement Replacement - Front Inner Hinge Pillar Body Reinforcement Replacement - Front Inner on page 3-73 25 Hinge Pillar Body Sectioning - Front Hinge Pillar Body Sectioning - Front on page 3-78 26 Roof Panel Replacement - Outer Roof Panel Replacement - Outer on page 3-81 27 Windshield Frame Header Panel Replacement - Front Windshield Frame Header Panel Replacement - Front on page 3-85 28 Rear Window Frame Header Panel Replacement - Rear Rear Window Frame Header Panel Replacement - Rear on page 3-87 29 Floor Panel Replacement - Center Floor Panel Replacement - Center on page 3-89 30 Rocker Panel Replacement - Inner Rocker Panel Replacement - Inner on page 3-93 31 Rocker Panel Extension Replacement - Inner Rocker Panel Extension Replacement - Inner on page 3-95 32 Rocker Panel Reinforcement Replacement - Inner Rocker Panel Reinforcement Replacement - Inner on page 3-97 33 Rocker Panel Reinforcement Sectioning - Inner Rocker Panel Reinforcement Sectioning - Inner on page 3-100 2003 Saturn Ion 3-5 20033SaturnIon 5. If the metal surface is damaged, the cowl panel must be repaired to restore the structural integrity of the vehicle. Drill 2.8 mm (5/16 in) plug weld holes 10 mm (1/2 in) rearward from the edge of the top, bottom, and outer side on the front edge of the remaining portion of the side upper rail on the vehicle. Coupe Side Location Description Length = x Width = y Height = z Point to Point a Rear Lower Hinge Lower Hole 3996 770 555 x b Rear Lower Hinge Upper Hole 4046 759 649 x c Rear Upper Hinge Lower Hole 4067 747 758 x d Rear Upper Hinge Upper Hole 4056 738 863 x e Fascia Bracket Rear Upper Hole 4989 768 798 x f Quarter Panel Rear Inner Lower Hole 4822 730 445 x g Quarter Panel Dog Leg Outer Attach Hole 3955 762 320 x h Quarter Panel Dog Leg Outer Attach Hole 3961 762 235 x i Rocker Panel Rear Hole 3780 762 250 x j Rocker Panel Center Hole 3228 756 234 x k Rocker Panel Front Hole 2432 762 250 x l Front Lower Hinge Rear Hole 2260 750 396 x m Front Lower Hinge Front Hole 2225 750 396 x n Body Side Control Hole 2175 745 640 x o Front Upper Hinge Front Hole 2225 739 754 x p Front Upper Hinge Rear Hole 2260 739 754 x 876935 3-8 2003 Saturn Ion 8. 2003 Saturn Ion 3-11 2003SaturnIon 11. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces. 3. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Mark this section. Remove the lower plenum panel from the vehicle. Repair Instructions Impact Bar Bracket Replacement - Front Bumper 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. Plenum Panel Replacement - Upper 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. Remove the latch primary support. Plug weld accordingly. Failure to follow these precautions may cause personal injury and/or damage to the vehicle or its components. Refer to Dimensions - Body on page 3-7. 867423 872730 3-28 2003 Saturn Ion 28. 13. Paint the repair area. 870828 870842 870838 3-46 2003 Saturn Ion 46. 15. 870823 868877 3-48 2003 Saturn Ion 48. 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. Caution: Sectioning should be performed only in the recommended areas. Measure a section on the service part that is 25 mm (1 in) (a) forward of the third fender bolt hole. Clamp the rail in place. 876940 3-12 2003 Saturn Ion 12. 868719 874293 2003 Saturn Ion 3-39 2003SaturnIon 39. Stitch and plug weld accordingly. Structure Identification (cont'd) Number Description Procedure 34 Pillar Lock Front Door Sectioning - Outer Pillar Lock Front Door Sectioning - Outer on page 3-103 35 Pillar Lock Front Door Reinforcement Replacement - Outer Pillar Lock Front Door Reinforcement Replacement - Outer on page 3-107 36 Pillar Lock Front Door Reinforcement Replacement - Lower Front Rear Window Reinforcement Replacement - Lower Front on page 3-114 40 Rear Window Panel Replacement Rear Window Panel Replacement on page 3-116 41 Rear Window Reinforcement - Rear Rear Window Reinforcement Replacement - Rear on page 3-119 42 Pillar Lock Rear Door Replacement - Inner Pillar Lock Rear Door Replacement - Inner on page 3-121 43 Body Side Panel Replacement - Outer Body Side Panel Replacement - Outer on page 3-123 44 Rear Compartment Floor Panel Sectioning Rear Compartment Floor Panel Sectioning on page 3-126 45 Wheelhouse Replacement - Rear Inner Wheelhouse Replacement - Rear Inner on page 3-130 46 Quarter Panel Sectioning - Outer Quarter Panel Sectioning - Outer on page 3-133 47 Quarter Panel Replacement - Inner Quarter Panel Replacement - Inner on page 3-136 48 Cross Bar No. 4 Replacement - Floor Panel Cross Bar No. 4 Replacement - Floor Panel on page 3-140 49 Cross Bar No. 4 Extension Replacement - Floor Panel Cross Bar No.4 Extension Replacement - Floor Panel on page 3-138 50 Cross Bar No. 5 Replacement - Floor Panel Center Cross Bar No.5 Replacement - Floor Panel on page 3-145 51 Cross Bar No. 5 Extension Replacement - Floor Panel Cross Bar No.5 Extension Replacement - Floor Panel on page 3-143 52 Rail Replacement Rear Side Underbody Rail Replacement Rear Side Underbody on page 3-147 53 Rail Sectioning Rear Side Underbody Rail Sectioning Rear Side Underbody on page 3-150 54 Rail Side Underbody Gusset Replacement - Rear Rail Underbody Gusset Replacement - Rear on page 3-155 55 Rail Side Underbody Reinforcement Replacement - Rear Rail Underbody Reinforcement Replacement - Rear on page 3-157 56 Impact Bar Anchor Plate Replacement - Rear Bumper Impact Bar Anchor Plate Replacement - Rear Bumper on page 3-160 57 Body Rear End Panel Replacement Body Rear End Panel Replacement on page 3-162 58 Battery Tray Replacement Battery Tray Replacement on page 3-28 3-6 2003 Saturn Ion 6. Bracket Replacement Front Compartment - Side Rail 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. Clamp the battery tray in place. Front and rear fascias are constructed of thermoplastic olefin (TPO). 867609 867597 867609 3-16 2003 Saturn Ion 16. Please Click Here Then Get More Information. Remove the battery tray. Install all related panels and components. 6. 870823 870852 2003 Saturn Ion 3-43 20033SaturnIon 43. Remove the dash panel. 876934 2003 Saturn Ion 3-7 2003SaturnIon 7. Install all of the related panels and components. Important: Note the number and location of the factory welds for installation of the battery tray. 868721 868722 2003 Saturn Ion 3-37 20033SaturnIon 37. Installation Procedure Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1 1/2 in) apart. Visually inspect the damaged area. Remove the left tie bar. 8. Important: Note the number and location of the factory welds for installation of the upper plenum panel. Remove the side rail bracket from the front compartment lower rail. Installation Procedure 1. Battery Tray Replacement 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. Connect the negative battery cable. Refer to Dimensions - Body on page 3-7. Paint the repaired area. Apply the sealers and anti-corrosion materials to the repair area, as necessary. 3-14 2003 Saturn Ion 14. 7. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the original assembly. 870834 870826 870828 2003 Saturn Ion 3-47 2003SaturnIon 47. Caution: Refer to SIR Caution on page 1-1 in General Information. 868717 868718 865281 2003 Saturn Ion 3-35 20033SaturnIon 35. 1. Clamp the tie bar in place. 14. Measure 25 mm (1 in) forward from the cut area. Important: Note the number and location of the factory welds for installation of the latch primary support. 10. Position the front upper rail on the vehicle using 3-dimensional measuring equipment. Prepare all mating surfaces for welding as necessary. All dimensions are symmetrical unless otherwise specified. Installation Procedure Important: The service part comes as an assembly that includes the plenum lower panel. Repair as much of the damage as possible to factory specifications. 867491 865271 867423 3-18 2003 Saturn Ion 18.

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