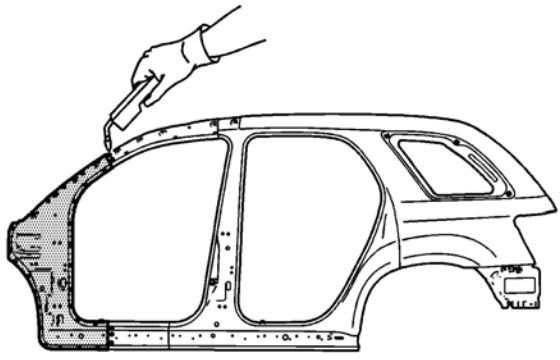


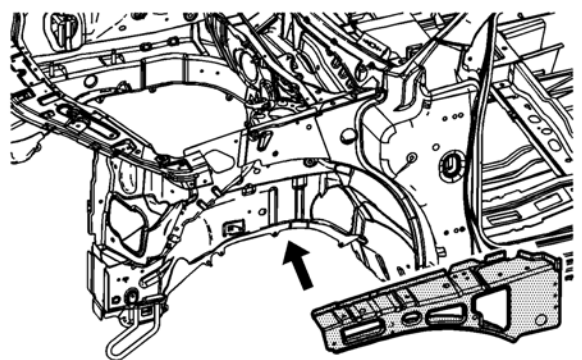
- 7. Fit the backing plate (2) halfway into the sectioning joint, clamp and plug weld to the vehicle.
- 8. Position the service part.



- 9. Plug weld accordingly.

**Important:** To create a solid weld with minimum heat distortion make 25-mm (1-in) stitch welds along the seam with 25-mm (1-in) gaps between. Then go back and complete the stitch weld.

- 10. Stitch weld the sectioning joint.
- 11. Clean and prepare all welded surfaces.



- 12. Install the front upper rail. Refer to [Front Compartment Upper Side Rail Replacement](#) .
- 13. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
- 14. Paint and repair the area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
- 15. Install all related panels and components.
- 16. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
- 17. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .