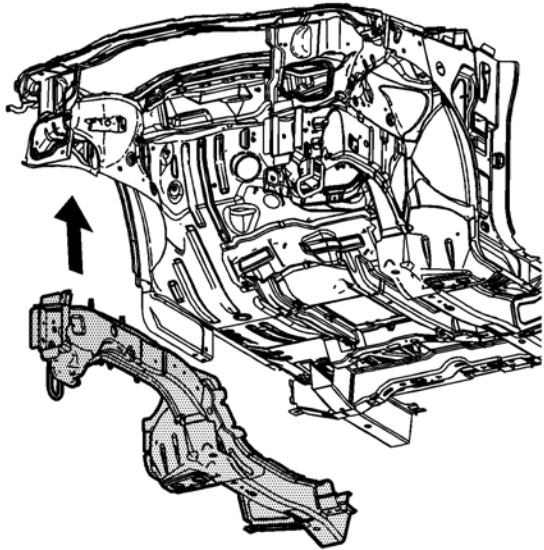
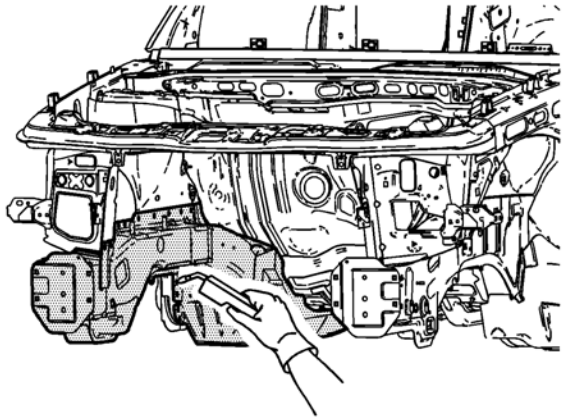


Some panels may have structural weld-thru adhesive. It is necessary to replace the weld-thru adhesive with an additional spot weld between each factory spot weld.

1. Drill 8-mm (5/16-in) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Prepare all mating surfaces as necessary.
3. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.



4. Position the front lower rail to the vehicle using 3-dimensional measuring equipment. Clamp the front lower rail into place.



5. Plug 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](#).
8. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#).
9. Install all related panels and components.
10. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
11. Enable the SIR system. Refer to [SIR Disabling and Enabling](#).