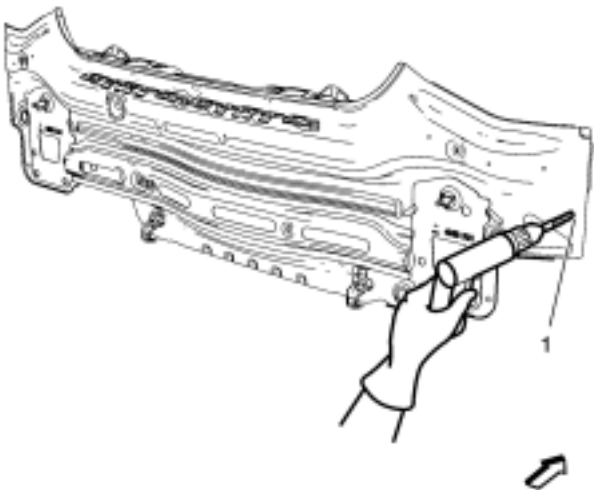
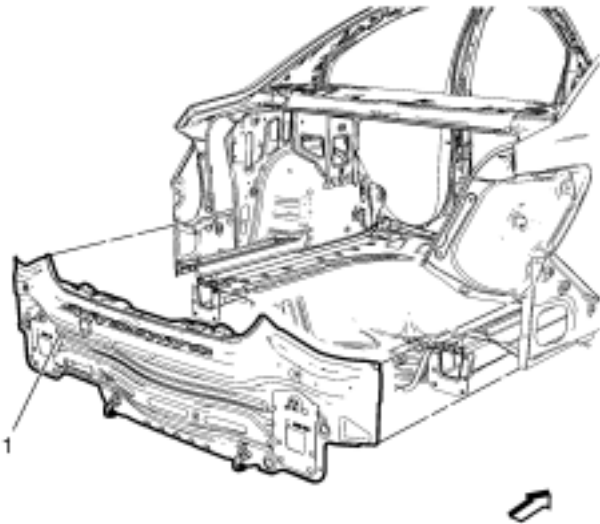


Installation Procedure

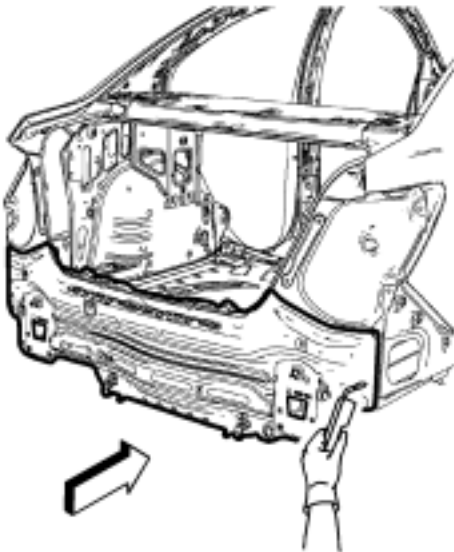


**Note:** If the location of the original plug weld holes can not be determined, space the plug weld holes every **40mm (1 1/2 in)**.

- 1. Drill **8mm (5/16 in)**holes for plug welding along the edges of the body rear end panel (1) as noted from the original panel.
- 2. Clean and prepare the attaching surfaces for welding.



- 3. Position the body rear end panel on the vehicle (1).
- 4. Verify the fit of the body rear end panel.
- 5. Clamp the body rear end panel into position.



- 6. Plug weld accordingly.
- 7. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
- 8. Paint the repaired 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](#) .