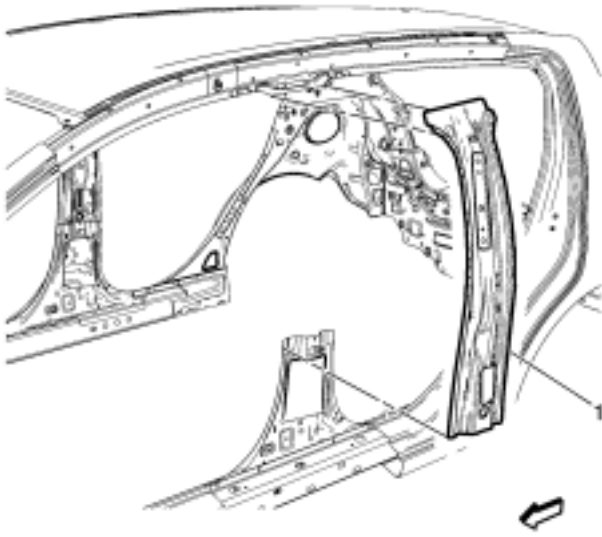
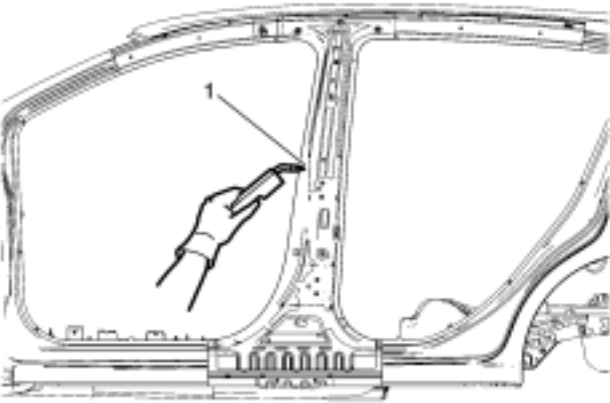


- 3. Drill **8 mm (5/16 in)** holes for plug welding along the edges of the center pillar inner panel (1) as noted from the original panel.
- 4. Clean and prepare the attaching surfaces for welding.



- 5. Position the center pillar inner panel on the vehicle (1).
- 6. Verify the fit of the center pillar inner panel.
- 7. Clamp the center pillar inner panel into position.



- 8. Plug weld accordingly (1).
- 9. 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 them. Then go back and complete the stitch weld.
- 10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
- 11. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
- 12. Install all related panels and components.
- 13. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
- 14. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .