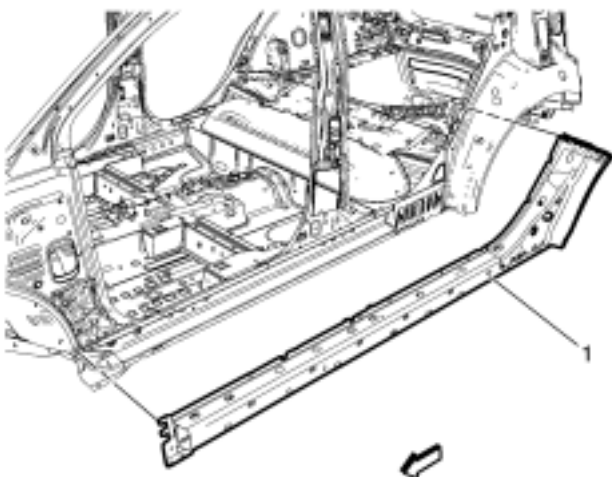
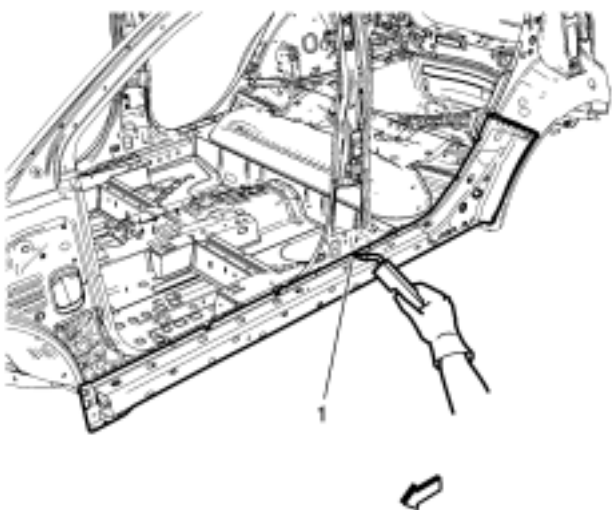


2. Drill a **8mm (5/16 in)**holes for plug welding along the edges of the quarter outer panel (1) as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.



4. Position the body side frame rocker reinforcement on the vehicle (1).
5. Verify the fit of the body side frame rocker reinforcement.
6. Clamp the body side frame rocker reinforcement into position.



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