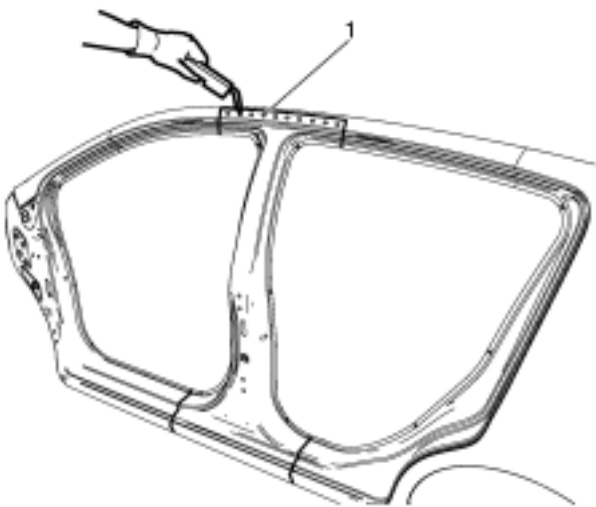
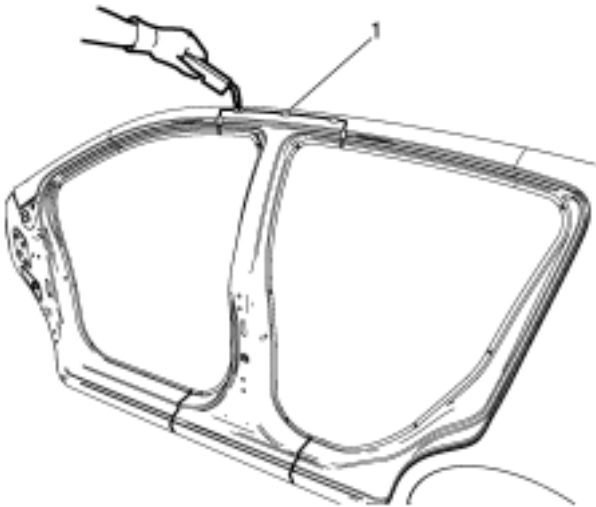


4. Position the center pillar outer panel (1) to the vehicle. Clamp the pillar in place.



5. Plug weld accordingly (1).



6. To create a solid weld with minimum heat distortion, make a 25 mm (1 in) stitch weld along the seam with gaps of 25 mm (1 in) gaps between them. Go back and complete the stitch weld (1).
7. Clean and prepare all of the welded surfaces
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](#) .