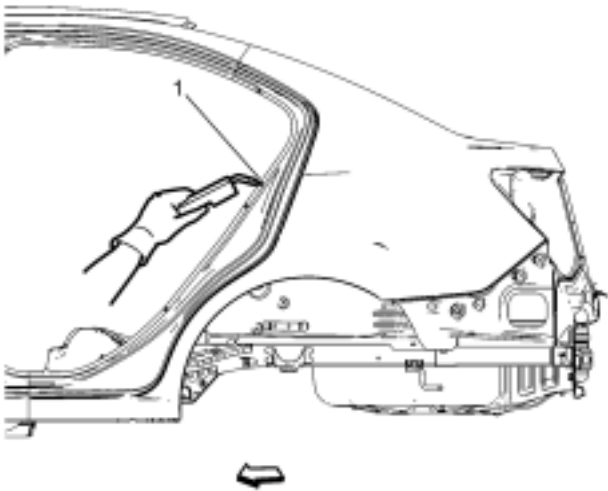
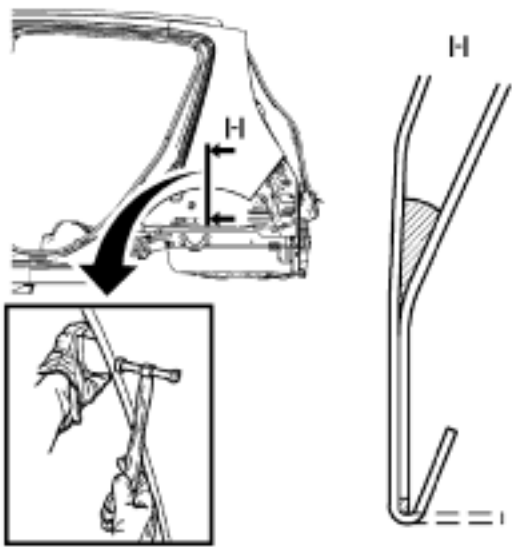


- 6. Position the quarter outer panel on the vehicle (1).
- 7. Verify the fit of the quarter outer panel.
- 8. Clamp the quarter outer panel into position.



- 9. Plug weld accordingly (1).
- 10. 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.
- 11. Pre-flange the flange with *BO-6396* pliers and *BO-6392* tool kit.



- 12. Finish closing the wheelhouse flanging.
- 13. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
- 14. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
- 15. Install all related panels and components.
- 16. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
- 17. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .