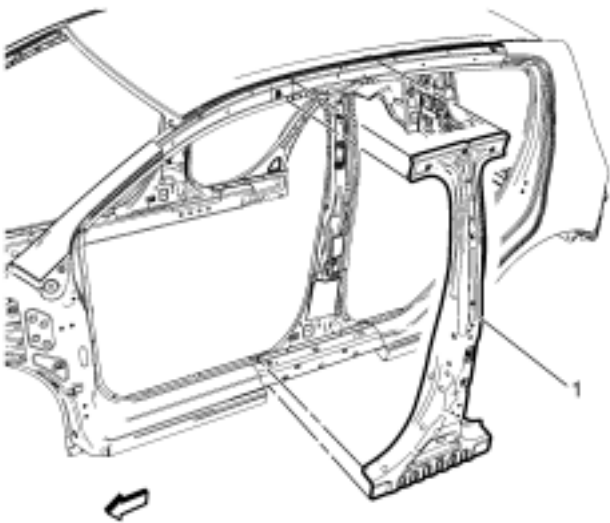
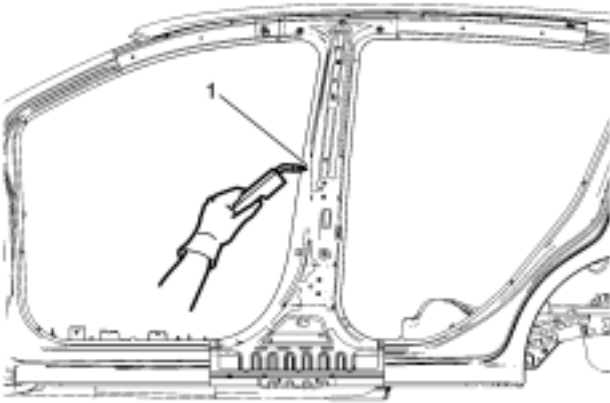


- 3. Drill a **8mm (5/16 in)**holes for plug welding along the edges of the center pillar reinforcement as noted from the original panel (1).
- 4. Clean and prepare the attaching surfaces for welding.



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



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