



13. Tack weld the part into position.
14. Inspect the service rear rail for proper dimensions, using 3-dimensional measuring equipment.
15. Plug weld at each **8 mm (5/16 in)** plug weld hole location.
16. Stitch weld along the entire sectioning joint. Make welds along the seam with **25 mm (1 in)** gaps between. Weld the gaps.
17. Clean and prepare the welded surfaces.
18. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
19. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
20. Install all related panels and components.
21. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
22. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .