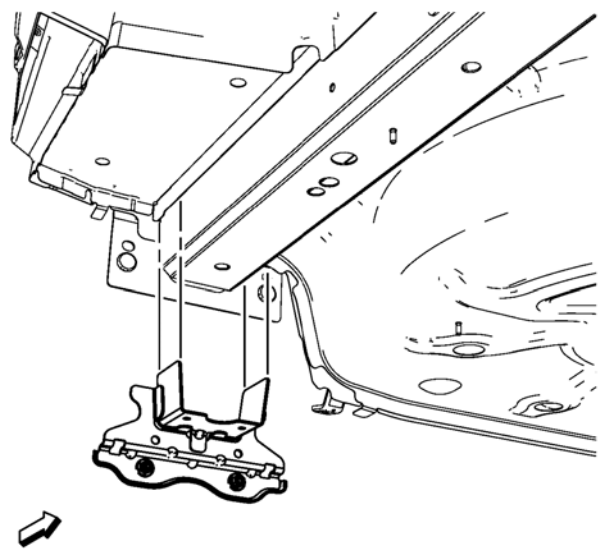
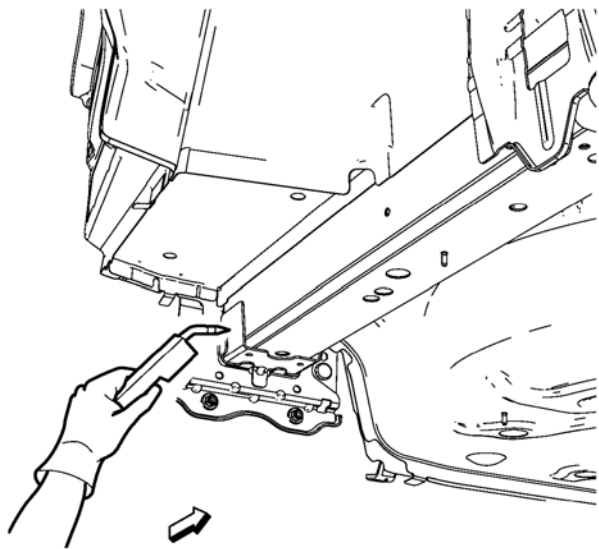


- the original panel.
2. Clean and prepare the attaching surfaces for brazing.



3. Position the underbody rear side rail reinforcement on the vehicle.
4. Verify the fit of the underbody rear side rail reinforcement.
5. Clamp the underbody rear side rail reinforcement into position.



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