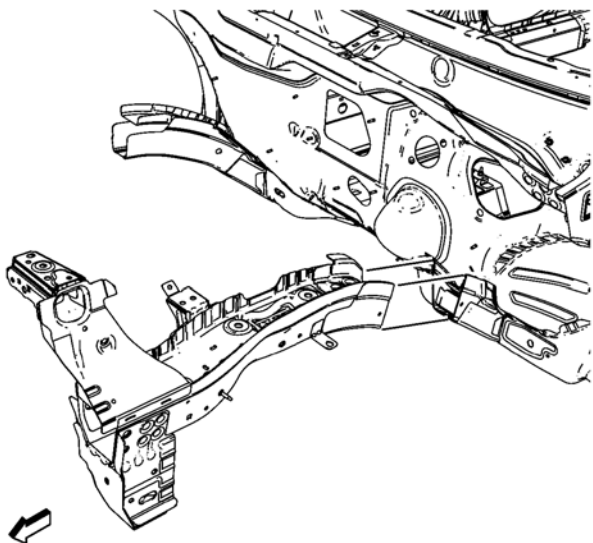
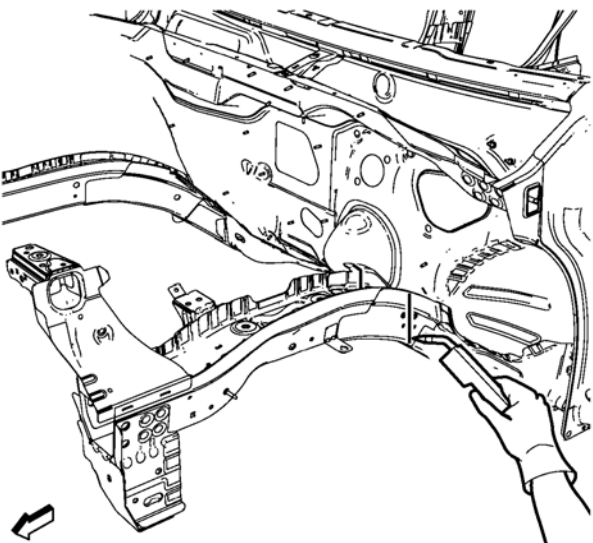


1. Cut the front compartment front rail in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
2. Create a 50 mm (2 in) backing plate from the unused portion of the service part and use where possible.
3. Create 5 x 18 mm (4/16 x 11/16 in) slots for MIG-brazing along the sectioning cut on the remaining original part. Locate these holes 13 mm (1/2 in) from the edge of part and spaced 40 mm (1 1/2 in) apart.
4. Prepare all mating surfaces as necessary.
5. Fit the backing plates halfway into the sectioning joints, clamp in place and braze to the vehicle.
6. Align the front compartment front rail.
7. Clean and prepare the attaching surfaces for brazing.



8. Position the front compartment front rail on the vehicle.
9. Verify the fit of the front compartment front rail.
10. Clamp the front compartment front rail into position.



11. Braze accordingly.
12. To create a solid braze with minimum heat distortion, make 25 mm (1 in) stitch brazes along the seam with 25 mm (1 in) gaps between them. Then go back and complete the stitch braze.
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](#).