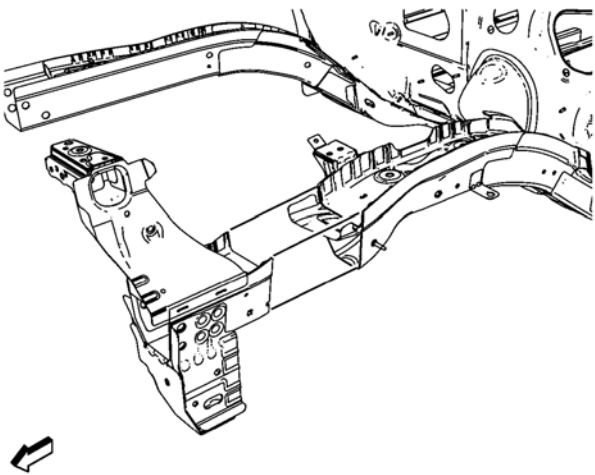
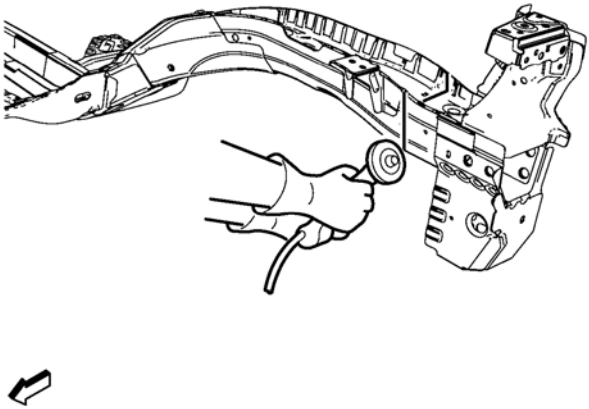


8. Locate and mark all the necessary factory welds of the front compartment front rail.
9. Drill all factory welds. Note the number and location of welds for installation of the service assembly.



10. Remove the damaged front compartment front rail.

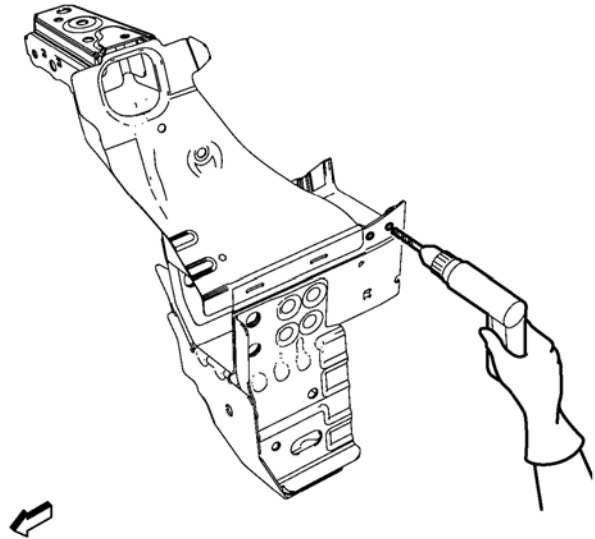
Installation Procedure



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.

Note: Place backing plate only in areas where adequate space is available.

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.



Note: Left side only.

7. Create 6 x 20 mm (4/16 x 12/16 in) slots for MIG-brazing along the edges of the front compartment front rail as noted from the original panel.
8. Clean and prepare the attaching surfaces for brazing.