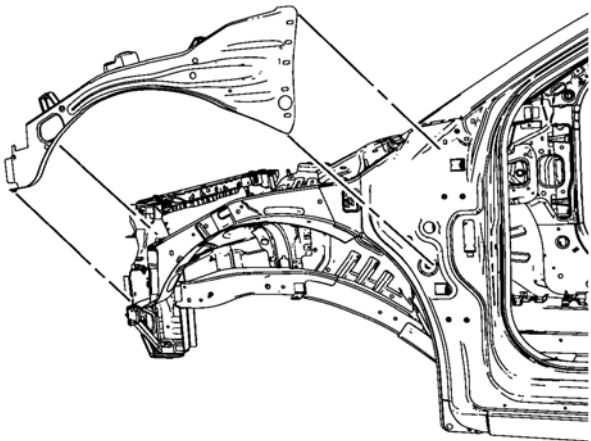
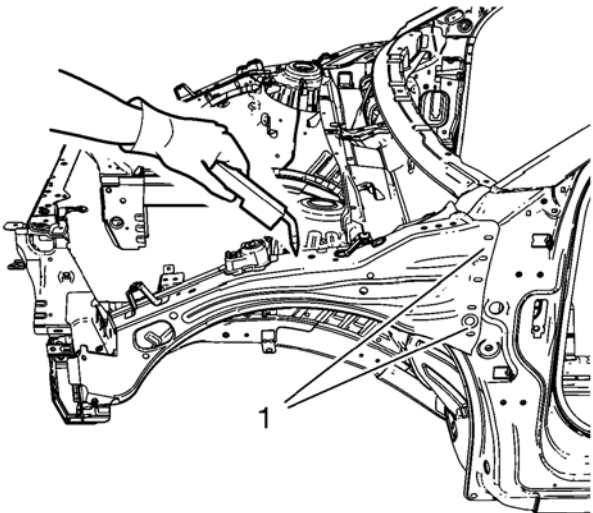


1. Drill 8 mm (5/16 in) for plug welding along the edges of the front compartment upper side rail as noted from the original panel.
2. Clean and prepare the attaching surfaces for welding.



3. Position the front compartment upper side rail on the vehicle.
4. Verify the fit of the front compartment upper side rail.
5. Clamp the front compartment upper side rail into position.



Note: Plug weld factory slots in the front hinge pillar body area (1) as noted from the original panel.

6. Plug weld 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](#).