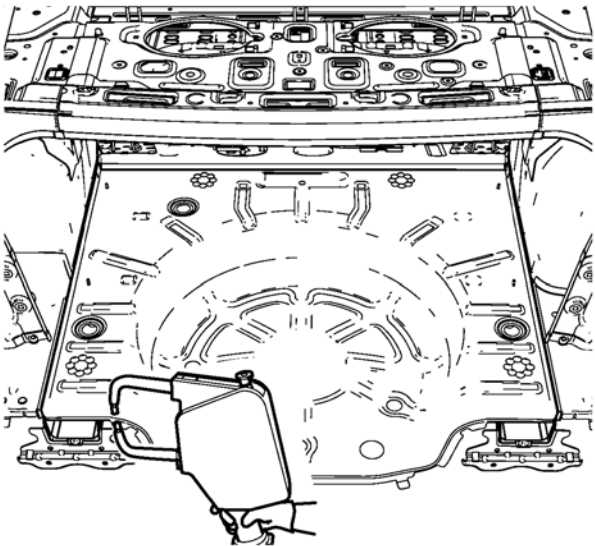
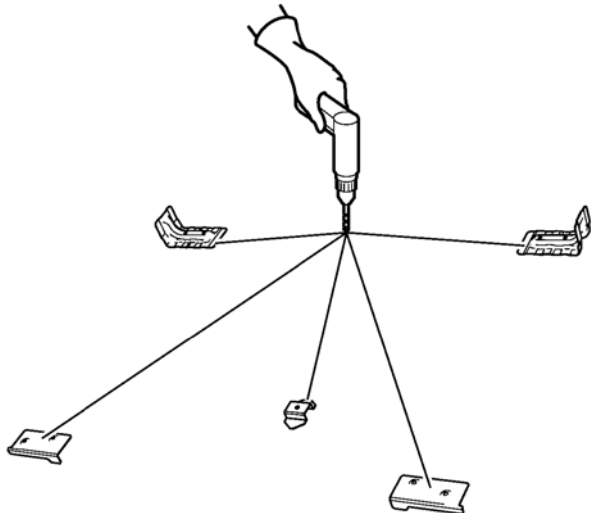


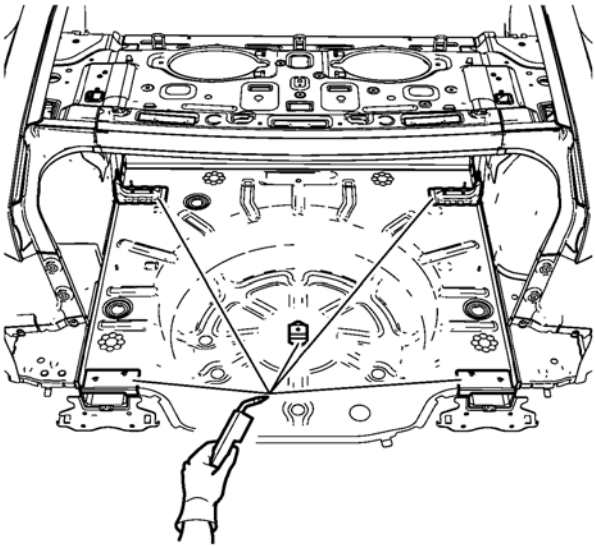
3. Clean and prepare the attaching surfaces for spot welding and riveting.
4. Apply structural adhesive to all attaching surfaces.
5. Position the rear compartment floor panel on the vehicle.
6. Verify the fit of the rear compartment floor panel.
7. Clamp the rear compartment floor panel into position.
8. Rivet the rear compartment floor panel.



9. Spot weld accordingly.



10. Create 5 x 18 mm (4/16 x 11/16 in) slots for MIG-brazing along the edges of the floor panel rear reinforcement, the spare wheel carrier bracket and the rear wheelhouse panel rear brace as noted from the original panel.
11. Clean and prepare the attaching surfaces for brazing.
12. Position the floor panel rear reinforcement, the spare wheel carrier bracket and the rear wheelhouse panel rear brace on the vehicle.
13. Verify the fit of the floor panel rear reinforcement, the spare wheel carrier bracket and the rear wheelhouse panel rear brace.



14. Braze accordingly.
15. Weld accordingly the weld studs as noted.
16. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).
17. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#).
18. Install all related panels and components.
19. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
20. Enable the SIR system. Refer to [SIR Disabling and Enabling](#).