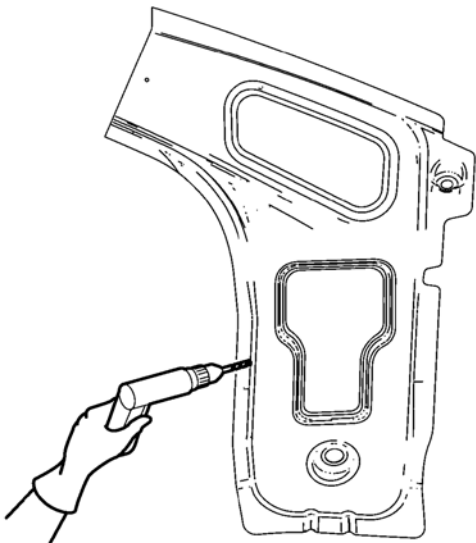
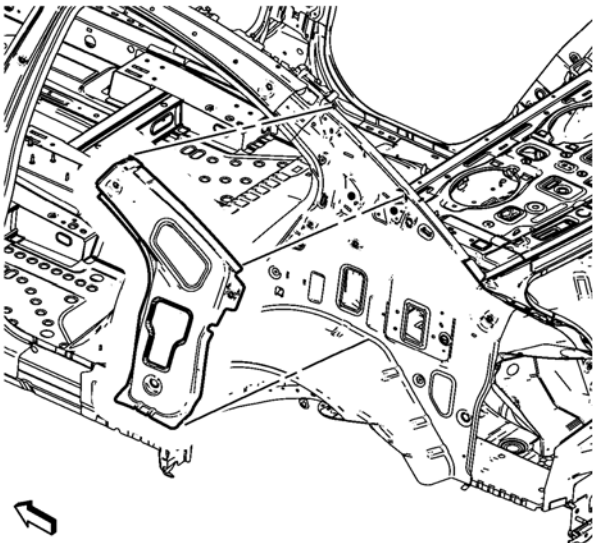


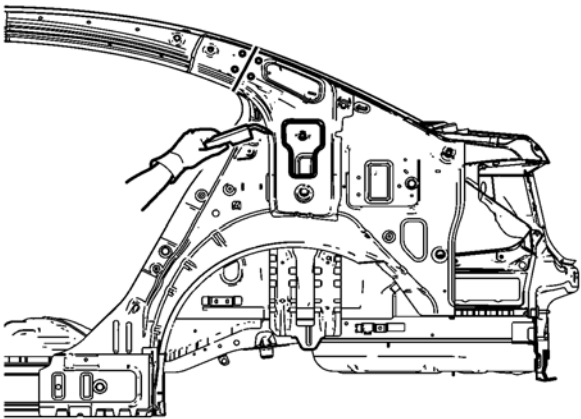
- 15. Cut the body lock pillar upper reinforcement in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
- 16. Create a 50 mm (2 in) backing plate from the unused portion of the service part.
- 17. Drill 8 mm (5/16 in) 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.
- 18. Prepare all mating surfaces as necessary.
- 19. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.
- 20. Align the body lock pillar upper reinforcement.



- 21. Drill 8 mm (5/1 in) for plug welding along the edges of the body lock pillar upper reinforcement as noted from the original panel.
- 22. Clean and prepare the attaching surfaces for welding.



- 23. Position the body lock pillar upper reinforcement.
- 24. Verify the fit of the panel.
- 25. Clamp the body lock pillar upper reinforcement into position.



- 26. Plug weld accordingly.
- 27. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).
- 28. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#).
- 29. Install all related panels and components.
- 30. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
- 31. Enable the SIR system. Refer to [SIR Disabling and Enabling](#).