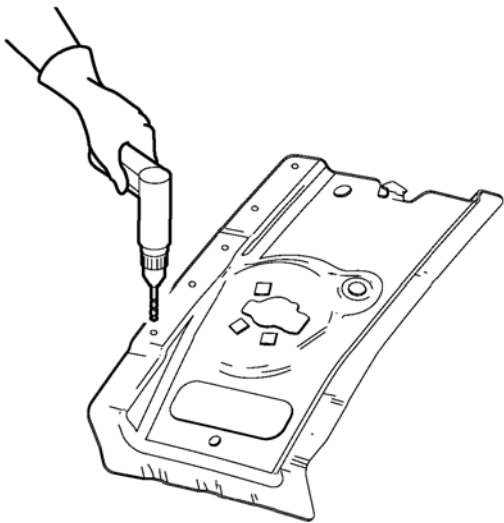
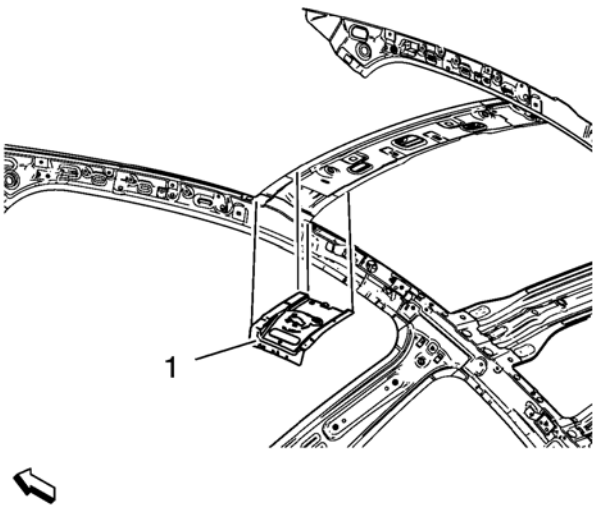


- 7. Plug weld accordingly.
- 8. To create a solid weld with minimum heat distortion, make 25 mm (1 in) stitch welds along the seam with 25 mm (1 in) gaps between them. Then go back and complete the stitch weld.



- 9. Drill 8 mm (5/16 in) for plug welding along the edges of the roof panel front bracket right as noted from the original panel.
- 10. Clean and prepare the attaching surfaces for welding.



- 11. Position the roof panel front bracket right (1) on the vehicle.
- 12. Verify the fit of the roof panel front bracket.
- 13. Clamp the roof panel front bracket right into position.

