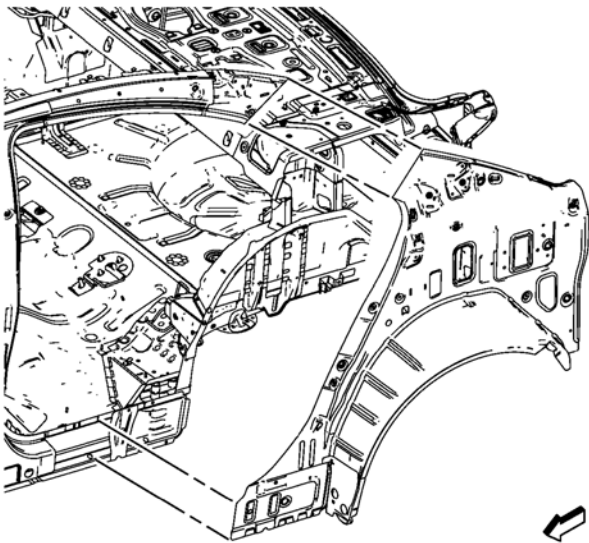


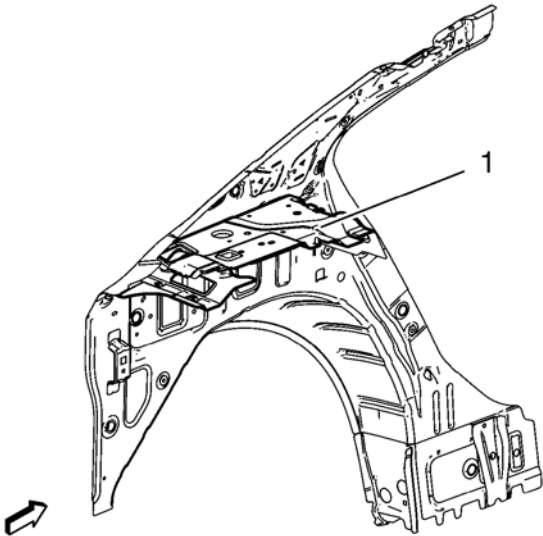
**Note:** Drill hidden factory welds where body side outer rear panel drain gutter (1) and body side inner panel overlap.

- 13. Locate and mark all the necessary factory welds of the body side inner panel.
- 14. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

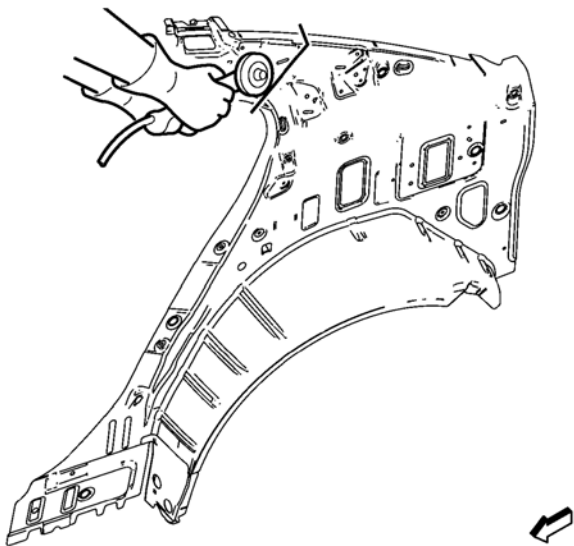


- 15. Remove the damaged body side inner panel.

Installation Procedure



- 1. Remove rear end upper panel extension (1) from service part.



- 2. Cut the body side inner panel 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.
- 3. Create a 50 mm (2 in) backing plate from the unused portion of the service part.
- 4. 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.
- 5. Prepare all mating surfaces as necessary.
- 6. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.
- 7. Align the body side inner panel.