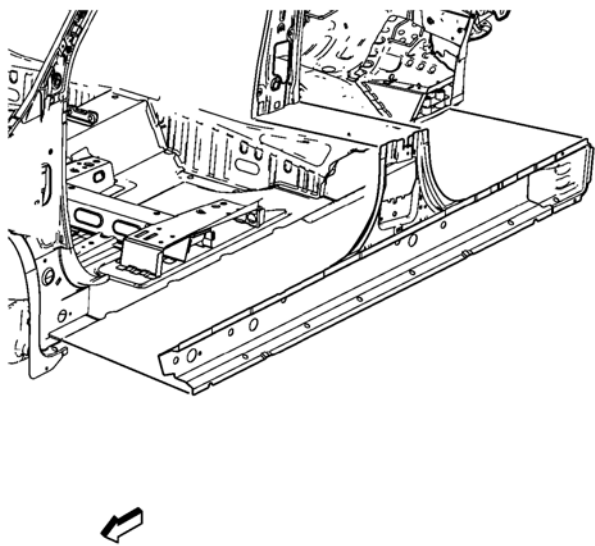
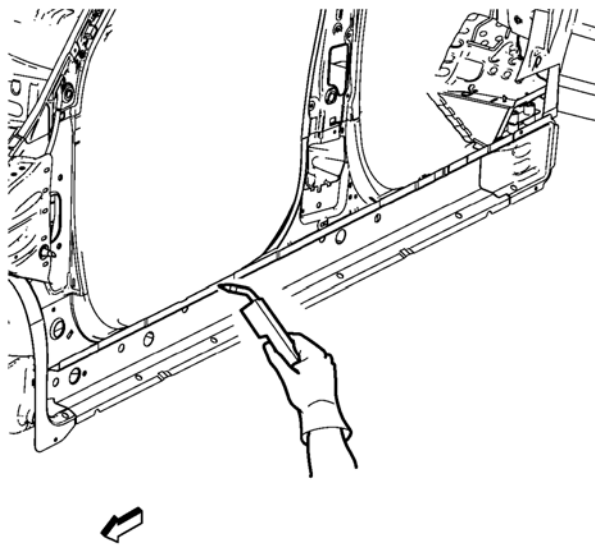


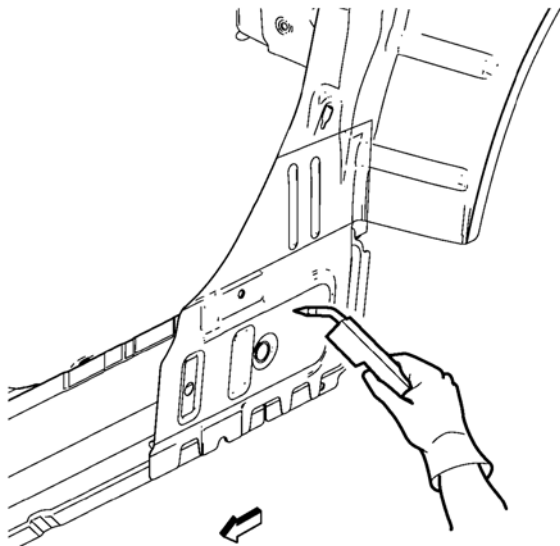
2. Drill 8 mm (5/16 in) for plug welding along the edges of the quarter outer panel as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.



4. Position the rocker inner panel on the vehicle.
5. Verify the fit of the quarter outer panel.
6. Clamp the rocker inner panel into position.



7. Plug weld accordingly.



8. Plug weld accordingly.
9. 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.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).
11. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#).
12. Install all related panels and components.
13. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
14. Enable the SIR system. Refer to [SIR Disabling and Enabling](#).