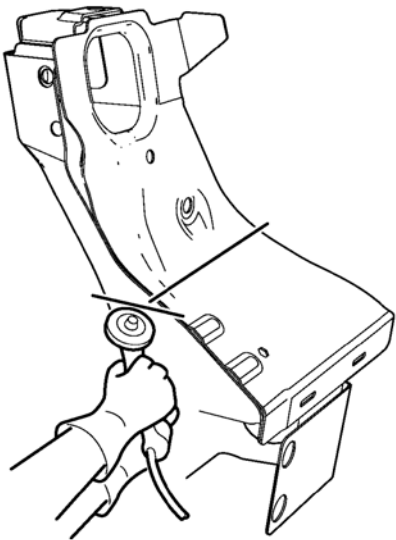
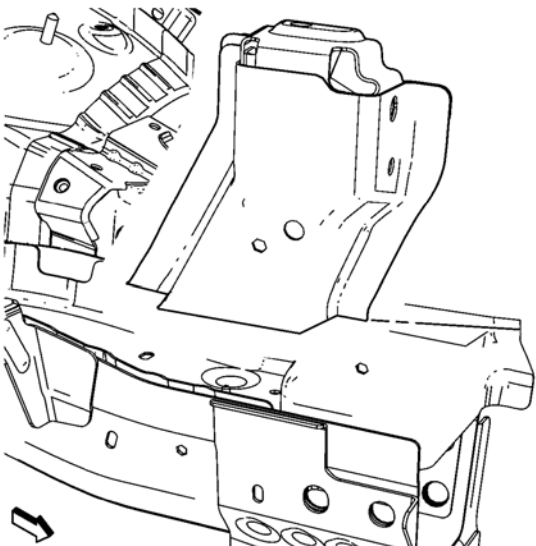


10. Remove the damaged front end upper tie bar.

Installation Procedure



1. Cut the front end upper tie bar 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.
2. Create a 50 mm (2 in) backing plate from the unused portion of the service part.
3. Create 5 x 18 mm (4/16 x 11/16) 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.
4. Prepare all mating surfaces as necessary.
5. Fit the backing plates halfway into the sectioning joints, clamp in place and braze to the vehicle.
6. Align the front end upper tie bar.
7. Clean and prepare the attaching surfaces for brazing.



8. Position the front end upper tie bar on the vehicle.
9. Verify the fit of the front end upper tie bar.
10. Clamp the front end upper tie bar into position.