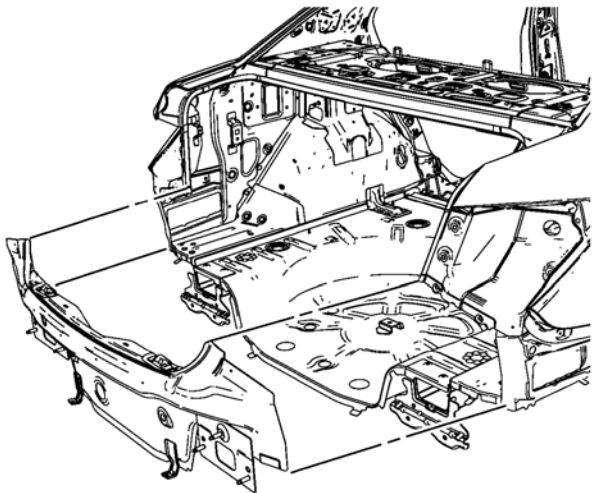
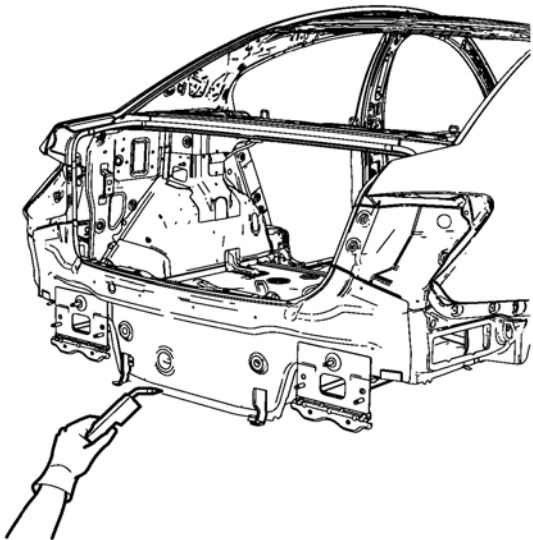


Note: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in).

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



3. Position the body rear end panel on the vehicle.
4. Verify the fit of the body rear end panel.
5. Clamp the body rear end panel into position.



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