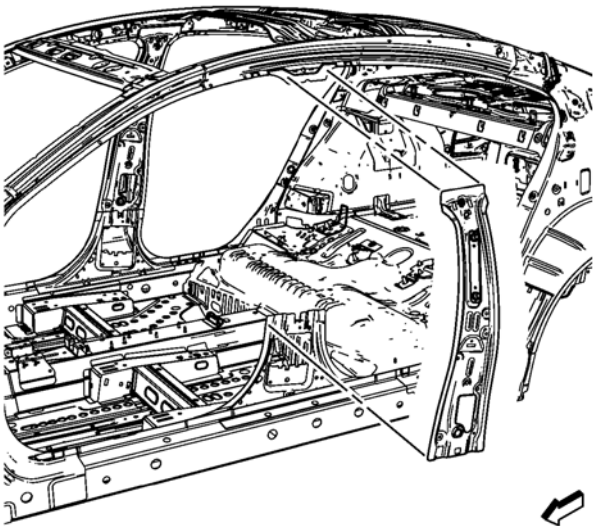
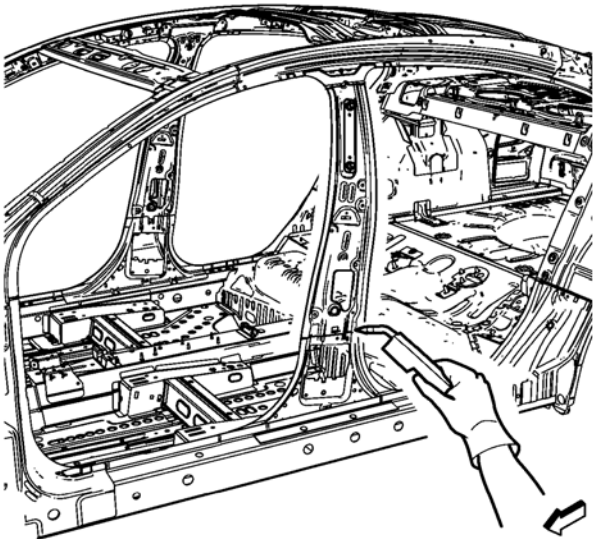


1. Drill 8 mm (5/16 in) for plug welding along the edges of the service panel as noted from the original panel.
2. Clean and prepare the attaching surfaces for welding.



3. Position the body lock pillar inner panel on the vehicle.
4. Verify the fit of the panel.
5. Clamp the body lock pillar inner panel into position.



6. Plug weld accordingly body lock pillar inner panel upper and lower.
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](#).