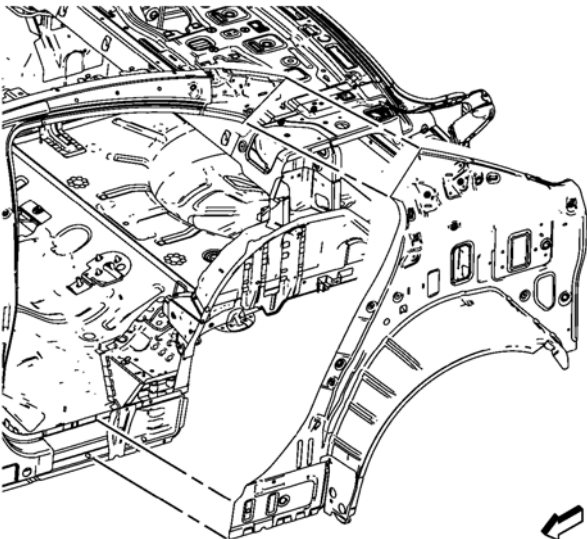
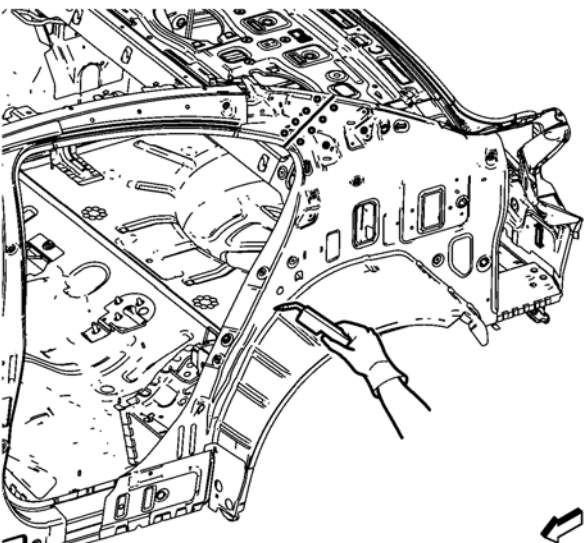


- 8. Drill 8 mm (5/1 in) for plug welding along the edges of the body side inner panel as noted from the original panel.
- 9. Clean and prepare the attaching surfaces for welding.



- 10. Position the body side inner panel.
- 11. Verify the fit of the panel.
- 12. Clamp the body side inner panel into position.



- 13. Plug weld accordingly.
- 14. 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.

