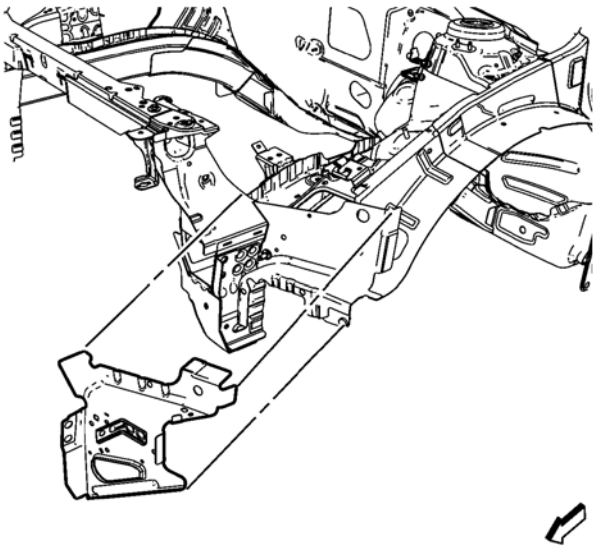
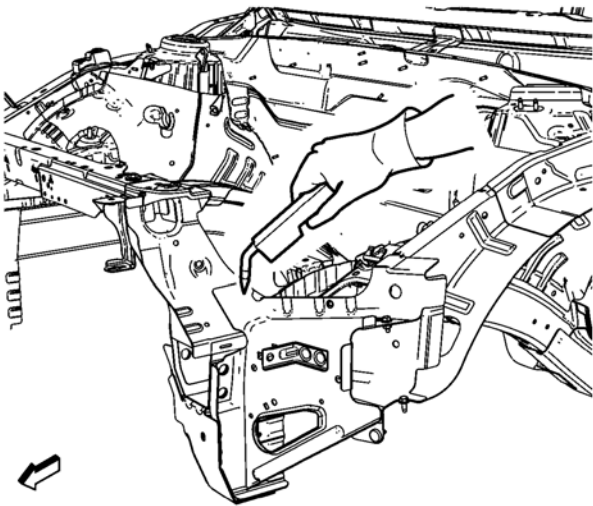


1. Drill 8 mm (5/16 in) for plug welding instead of the adhesive noted from the original panel.
2. Drill 8 mm (5/16 in) for plug welding along the edges of the headlamp mount panel as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.



4. Position the headlamp mount panel on the vehicle.
5. Verify the fit of the headlamp mount panel.
6. Clamp the headlamp mount panel into position.



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