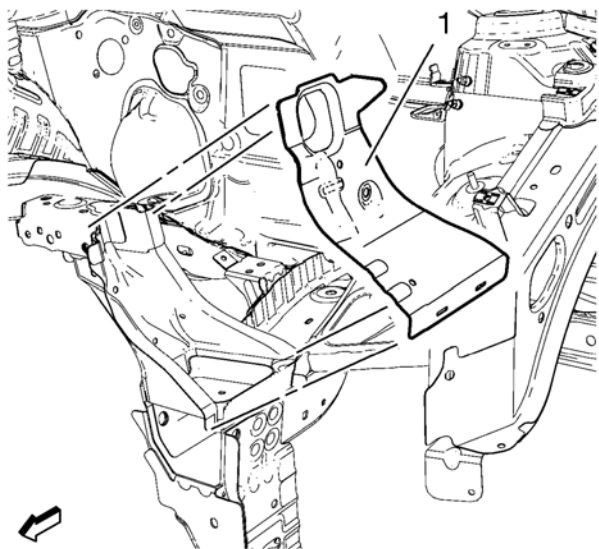
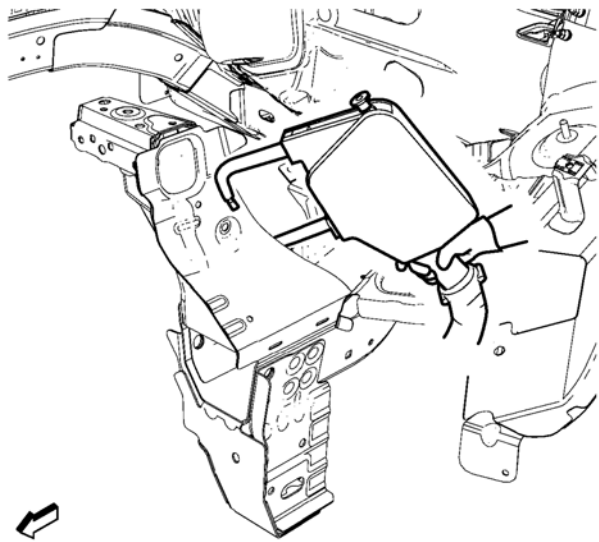


5. Braze accordingly.
6. Grind down weld seams as needed for related panels and components.
7. Clean and prepare the attaching surfaces for welding.



8. Position the front end sheet metal cross panel reinforcement (1) on the vehicle.
9. Verify the fit of the front end upper tie bar.
10. Clamp the front end sheet metal cross panel reinforcement into position.



11. Spot weld accordingly.
12. Use factory slots for slot brazing.
13. Install front bumper impact bar before applying the sealers and anti-corrosion materials.
14. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#)
15. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#)
16. Install all related panels and components.
17. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#)
18. Enable the SIR system. Refer to [SIR Disabling and Enabling](#)