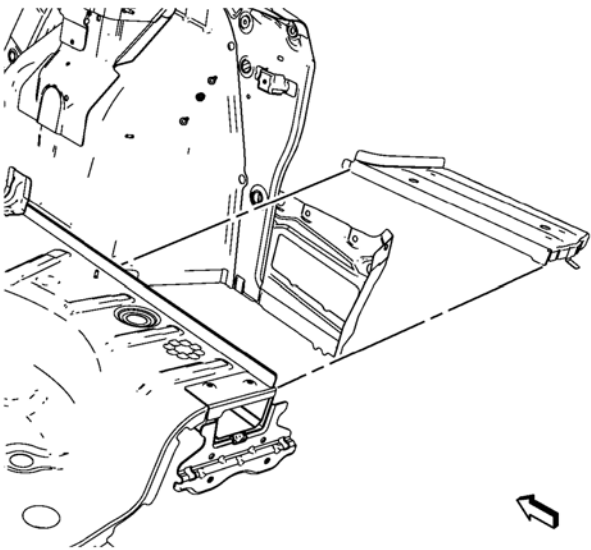
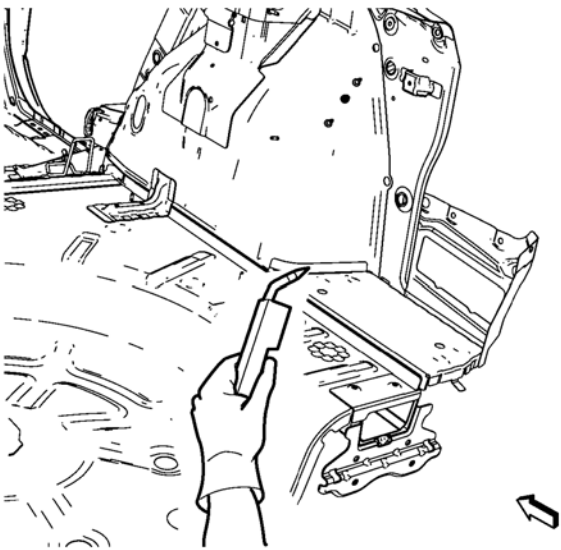


Note: If the location of the original plug weld holes can not be determined, space the braze holes every 40 mm (1½ in).

1. Create 5 x 18 mm (4/16 x 11/16 in) slots for MIG-brazing along the edges of the rear floor panel filler as noted from the original panel.
2. Clean and prepare the attaching surfaces for welding.



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



6. Braze 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](#).