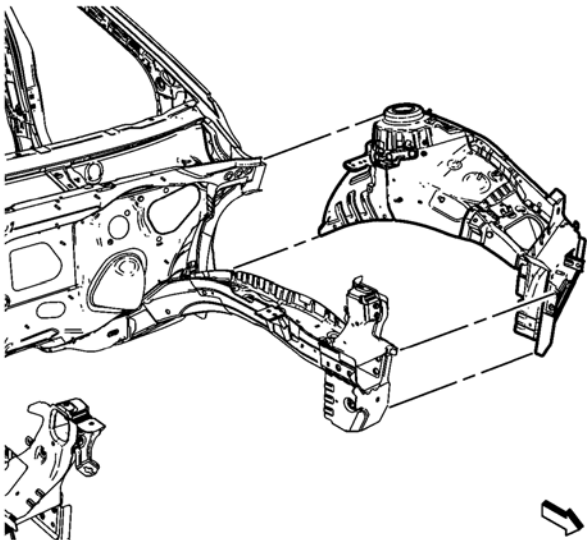
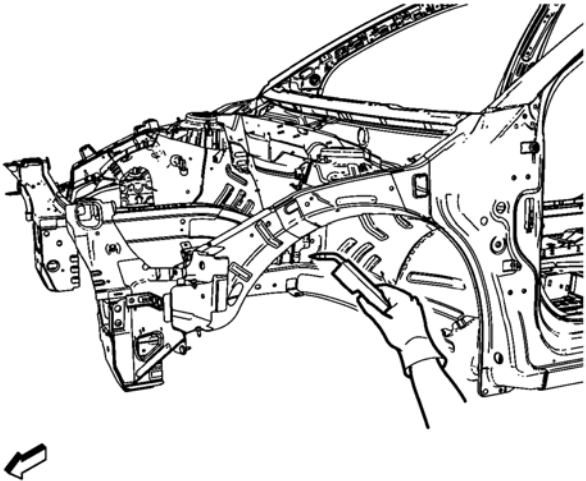


**Note:** In MIG-brazing areas 50 mm (2 in) must be kept clear of structural adhesive.

4. Apply structural adhesive on the front area (1) and create 6 x 20 mm (4/16 x 12/16 in) slots for MIG-brazing where the front wheelhouse and the front compartment side rail overlap (2).



5. Position the front wheelhouse on the vehicle.
6. Verify the fit of the front wheelhouse.
7. Clamp the front wheelhouse into position.



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