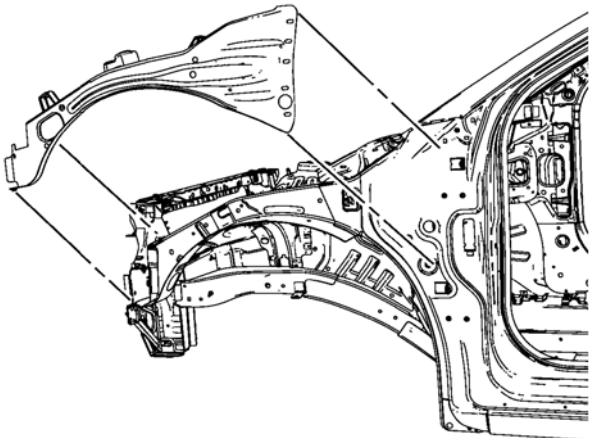
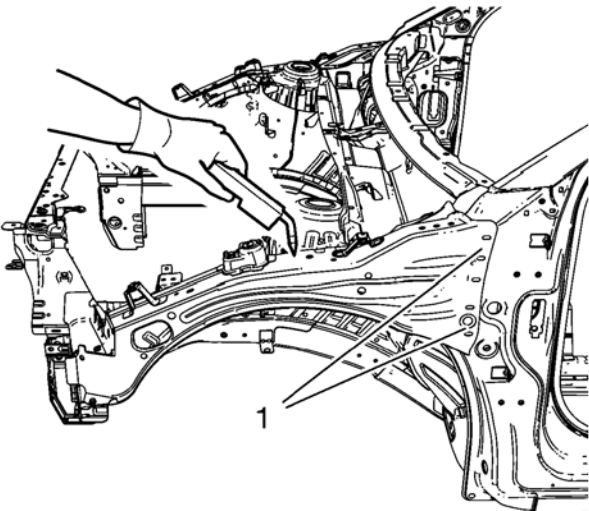


1. Create 5 x 18 mm (4/16 x 11/16 in) slots for MIG-brazing (1).
 2. Clean and prepare the attaching surfaces for spot welding and brazing.
- Note:** In MIG-brazing areas 50 mm (2 in) must be kept clear of structural adhesive.
3. Apply structural adhesive to all attaching surfaces.



4. Position the front compartment upper side rail on the vehicle.
5. Verify the fit of the front compartment upper side rail.
6. Clamp the front compartment upper side rail into position.



- Note:** MIG-braze factory slots in the front hinge pillar body area (1) as noted from the original panel.
7. Braze accordingly.