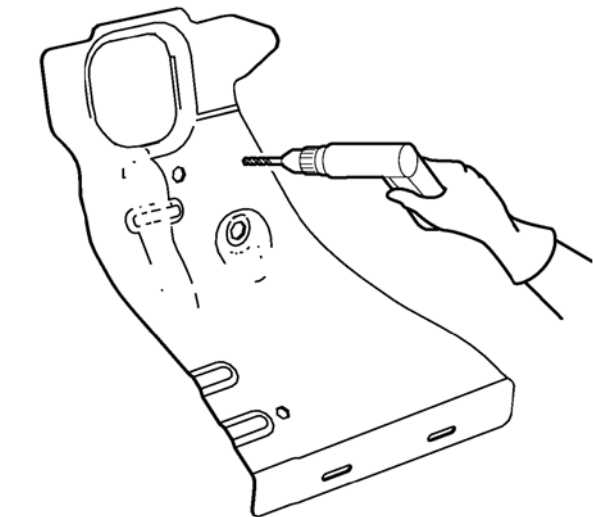
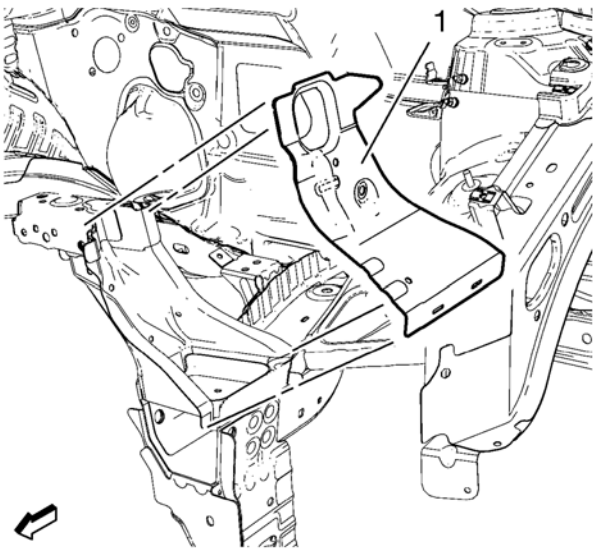


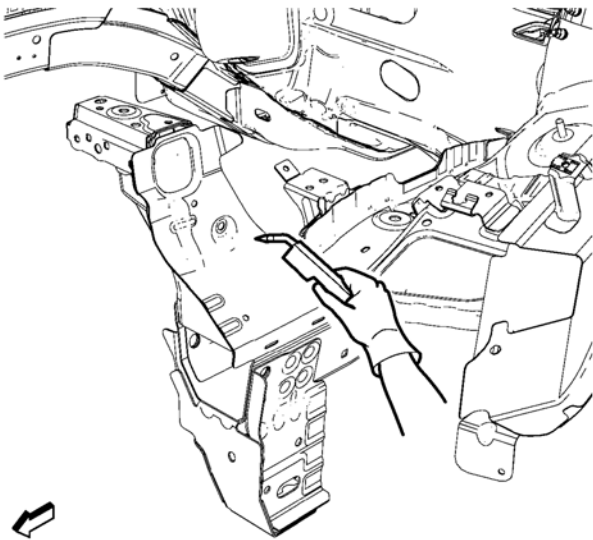
- 5. Weld seam accordingly.
- 6. Grind down weld seams as needed for related panels and components.



- 7. Drill 8 mm (5/16 in) for plug welding along the edges of the service panel as noted from the original panel.
- 8. Clean and prepare the attaching surfaces for welding.



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



- 12. Plug weld accordingly.
- 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](#)