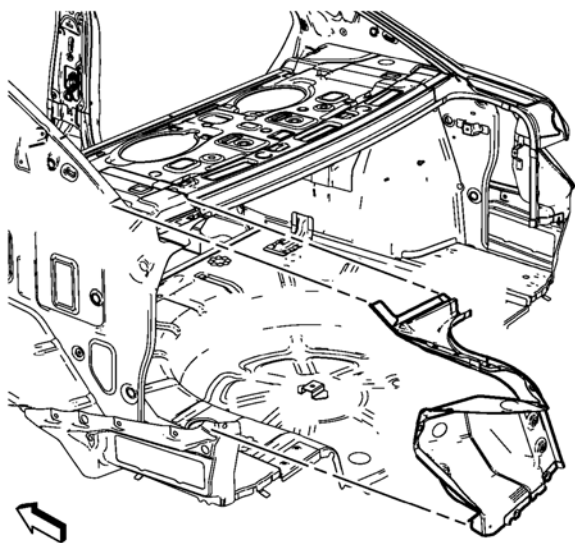


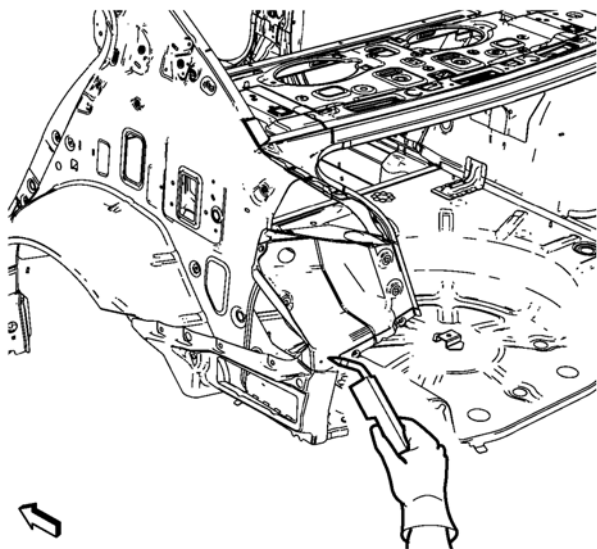
1. Create 5 x 18 mm (4/16 x 11/16 in) slots for MIG-brazing along the edges of the tail lamp pocket as noted from the original panel.

Note:

2. Clean and prepare the attaching surfaces for brazing.



3. Position the tail lamp pocket on the vehicle.
4. Verify the fit of the tail lamp pocket.
5. Clamp the tail lamp pocket 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](#).