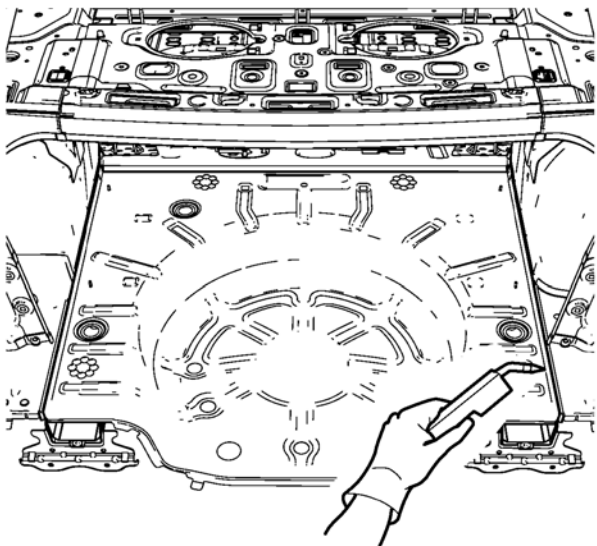
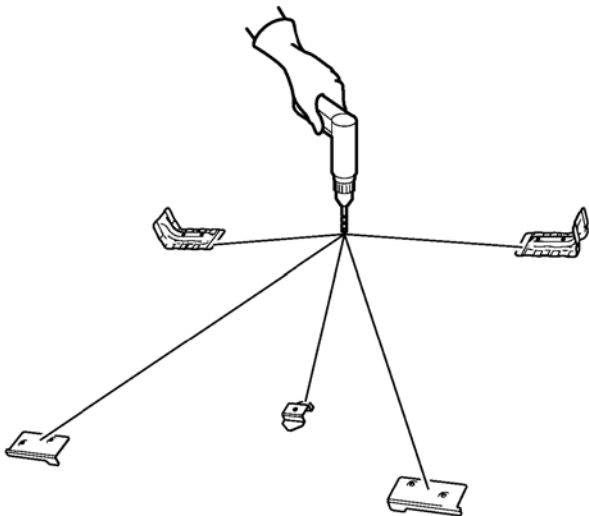


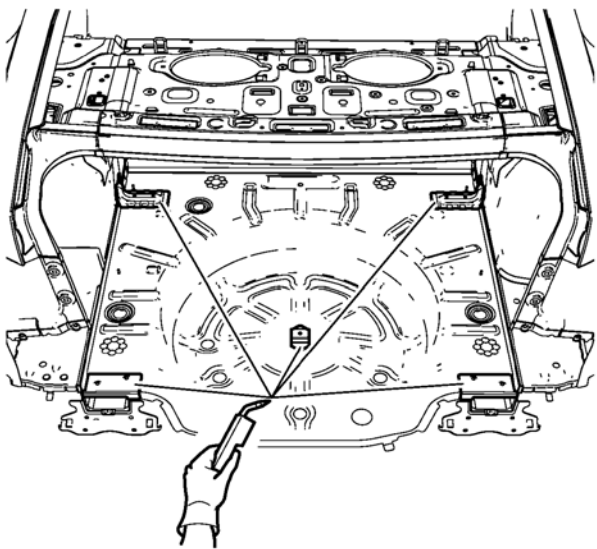
- 3. Clean and prepare the attaching surfaces for welding.
- 4. Position the rear compartment floor panel on the vehicle.
- 5. Verify the fit of the rear compartment floor panel.
- 6. Clamp the rear compartment floor panel into position.



- 7. Plug weld accordingly.



- 8. Drill 8 mm (5/16 in) for plug welding along the edges of the floor panel rear reinforcement, the spare wheel carrier bracket and the rear wheelhouse panel rear brace as noted from the original panel.
- 9. Clean and prepare the attaching surfaces for welding.
- 10. Position the floor panel rear reinforcement, the spare wheel carrier bracket and the rear wheelhouse panel rear brace on the vehicle.
- 11. Verify the fit of the floor panel rear reinforcement, the spare wheel carrier bracket and the rear wheelhouse panel rear brace.



- 12. Plug weld accordingly.
- 13. Weld accordingly the weld studs as noted.
- 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](#).