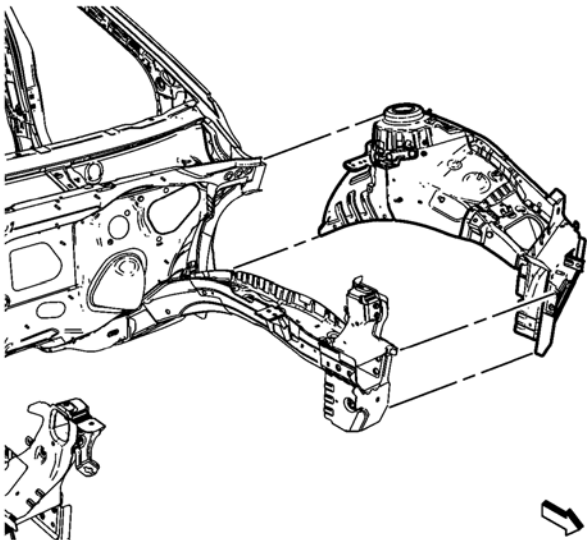
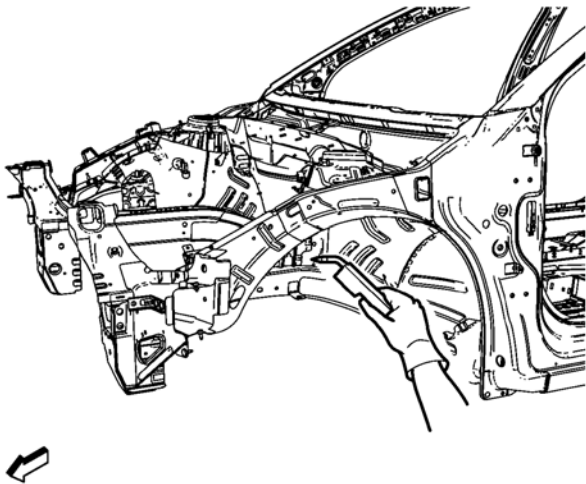


**Note:** Double the number of drills at the flange where front wheelhouse panel and front compartment side rail overlap (1).

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



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



- 8. Plug weld 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](#).