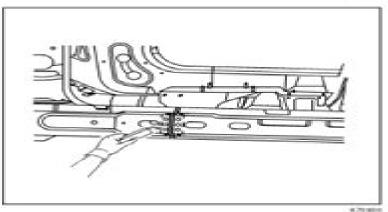
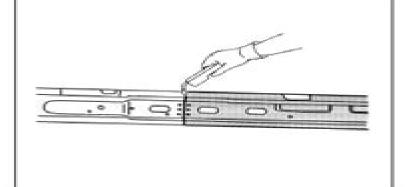


- Place the welding backer into the rocker panel backer reinforcement, Insert the welding backer about 50 mm (2 in), or about half-way.
- Clamp the welding backer in place and weld at the plug weld locations.



- Cut the outer center pillar in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of 1 ½ times the metal thickness at the sectioning joint.
- Position the reinforcement to the vehicle. Clamp the reinforcement in place.
- Stitch weld along the sectioning area at the but weld location. Make 25 mm (1 in) stitch welds with 25 mm (1 in) between each weld. Complete the stitch weld.



- 13. Plug weld accordingly.
- 14. Clean and prepare all of the welded surfaces.
- 15. Install all of the related panels and components.
- Apply the sealers and anti-comosion materials to the repair area, as necessary.
- 17. Paint the repaired area.
- 18. Connect the negative battery cable.
- 19. Enable the SIR system.

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