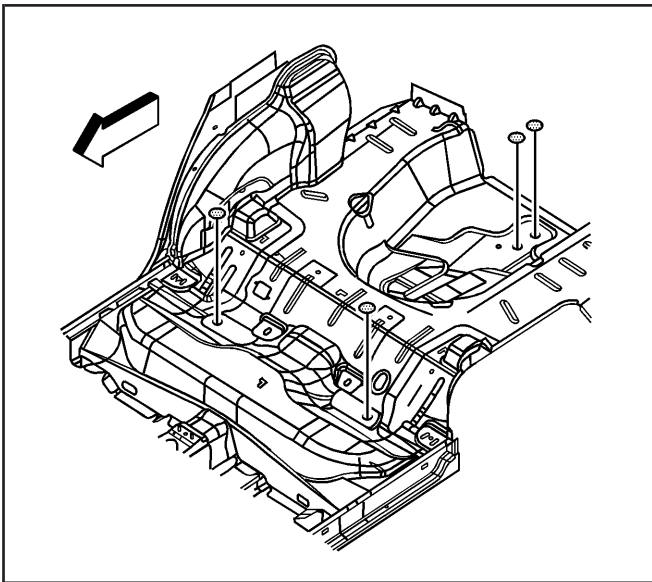


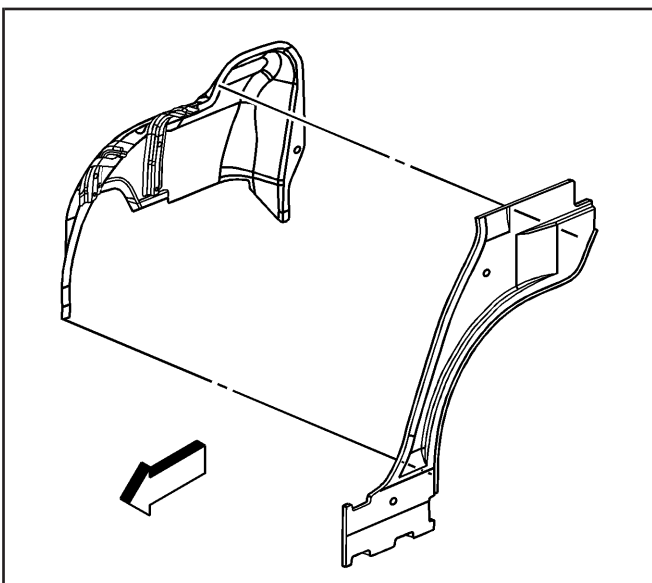
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10. Weld the seam along the front cut edge of the floor panel service part. To create a solid weld along the front of the service part with a minimum of heat distortion, make a stitch weld along the seam with 25 mm (1 in) gaps between each weld.
11. Clean and prepare all welded surfaces.
12. Apply sound deadening materials as necessary.
13. Paint the repaired area.



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14. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
15. Install all related panels and components.
16. Connect the negative battery cable.
17. Enable the SIR system.



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## Wheelhouse Replacement - Rear Inner

### Removal Procedure

**Caution:** To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

**Caution:** Refer to SIR Caution on page 1-1 in General Information.

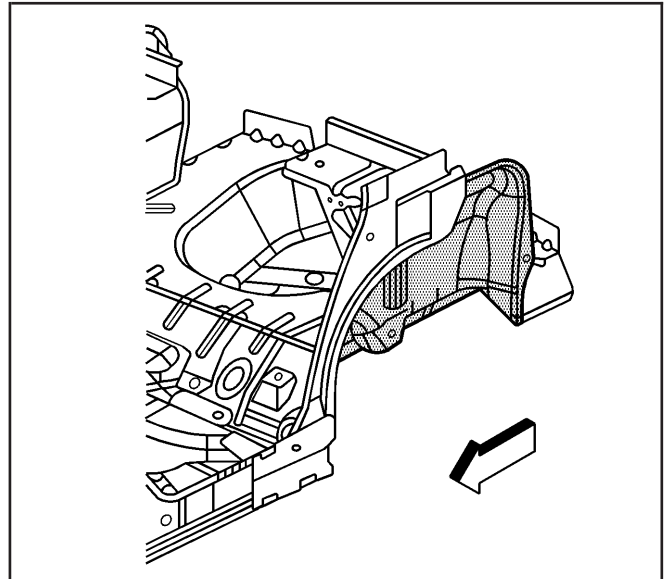
1. Disable the SIR system.

**Caution:** Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect the negative battery cable. Failure to follow these precautions may cause personal injury and/or damage to the vehicle or its components.

2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damaged area as possible. Refer to *Dimensions - Body* on page 3-7.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.

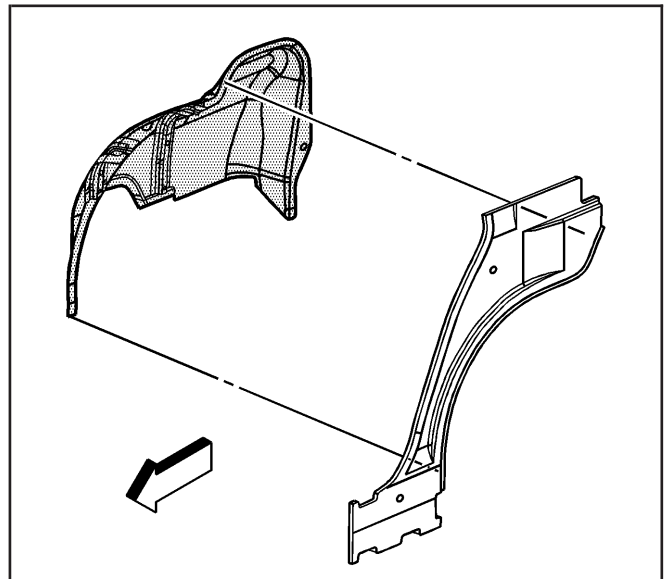
**Important:** Note the number and location of the factory welds for installation of the wheelhouse-rear inner.

6. Locate and drill out all the necessary factory welds.

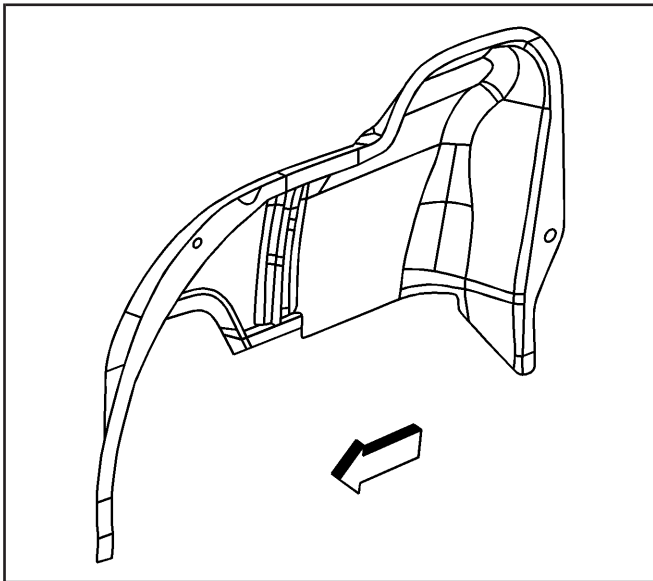


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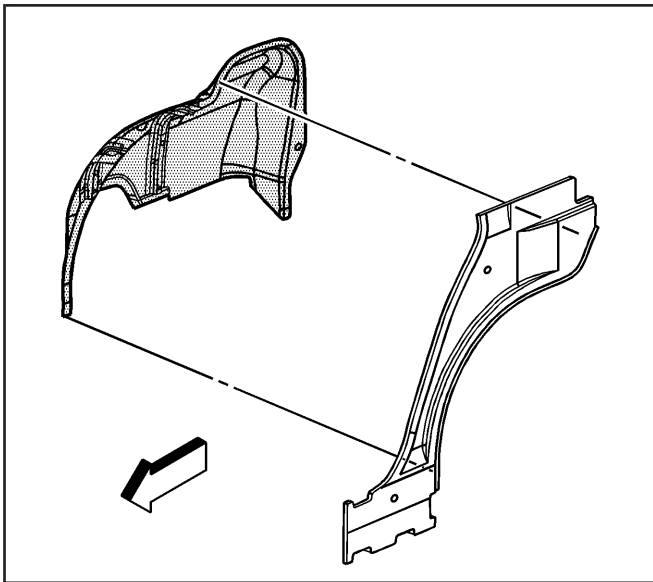
7. Remove the rear inner wheelhouse.



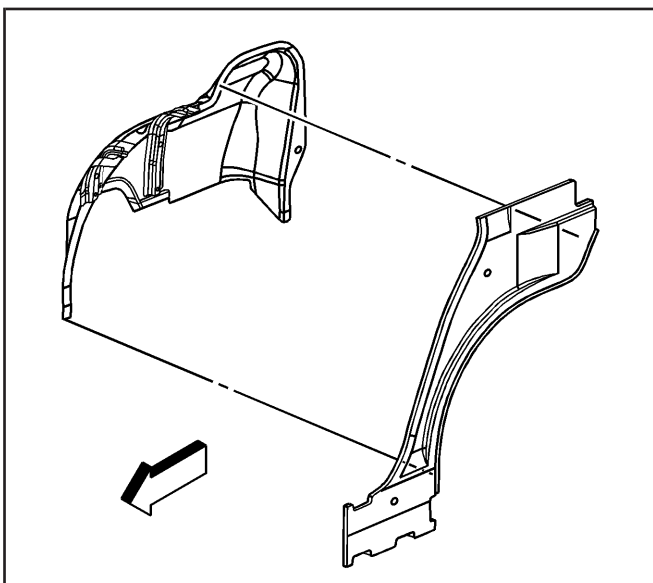
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## Installation Procedure

**Important:** If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Prepare all mating surfaces for welding as necessary.
3. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.

4. Position the rear inner wheelhouse to the vehicle. Clamp the part in place.

5. Plug weld accordingly.
6. Clean and prepare all of the welded surfaces.
7. Install all of the related panels and components.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
9. Paint the repaired area.
10. Connect the negative battery cable.
11. Enable the SIR system.