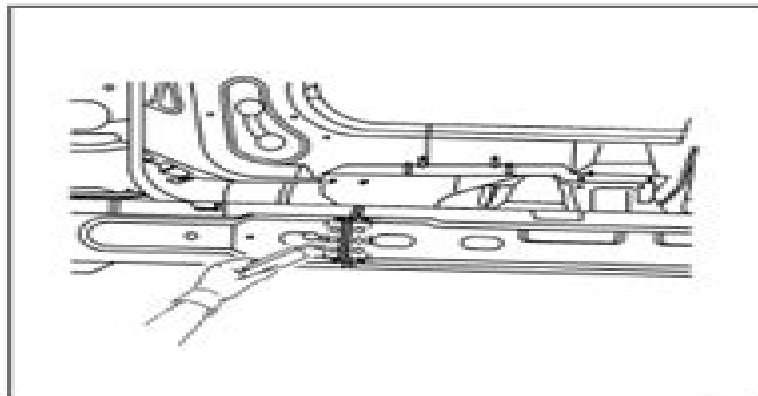


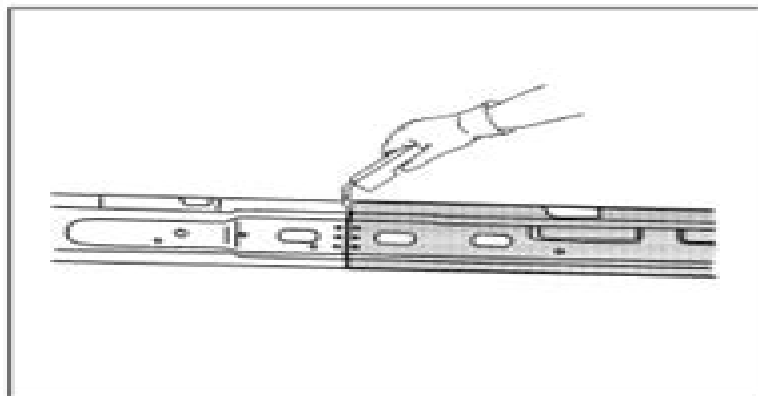
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8. Place the welding backer into the rocker panel backer reinforcement. Insert the welding backer about 50 mm (2 in), or about half-way.
9. Clamp the welding backer in place and weld at the plug weld locations.



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10. 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 1½ times the metal thickness at the sectioning joint.
11. Position the reinforcement to the vehicle. Clamp the reinforcement in place.
12. Stitch weld along the sectioning area at the butt weld location. Make 25 mm (1 in) stitch welds with 25 mm (1 in) between each weld. Complete the stitch weld.



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

# Sonoma 2002 Repair Manual

**Rose Army**



## **Sonoma 2002 Repair Manual:**

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