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1. Disable the SIR system. 872724 2003 Saturn Ion 3-147... Page 148 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. 872746 7. Remove the rear rail. 872751 3-148 2003 Saturn Ion... Page 149 4. If an extension panel is required, drill out the spot welds. 872744 5.

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