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Remove all related panels and components. 4. Repair as much of the damage as possible. Refer to Dimensions - Body on page 3-7 . 5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. 2003 Saturn Ion 3-155... Page 156 1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the corresponding locations noted on the original panel.

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