1) Mark and cut out slot for LED assembly. Make a clean cut to minimize the weld process.

2) Assemble lens and steel plates and slip it into the slot. Position the assembly and mark where to trim. Make sure the bolt holes are accessible.

3) The back can be trimmed if you have clearance issues but it is not necessary.

4) Weld ends. This kit came with a 1/4" plate. Use this plate when welding. Align mount hole and clamp together with welding plate in the middle.

5) Make sure the back side has proper clearance for the electronics. Check both sides, there is a small resistor on the under side of this LED strip. (NOTE: not all LED strips have these components. This may or may not be necessary for you.)

6) Trim the steel pieces to fit, leaving a 1/8" of material. Do not trim the lens at the same time. Trim it separately.

7) Spot weld the housing into place with the 1/8" protruding. Always have the steel welding plug clamped in place.

8) The steel plug will help keep everything in alignment and work as a heat sink to minimize distortion.

9) Now weld completely. Go slow! Too fast and you will warp the panels beyond repair.