

Outer Front Pillar, Center Pillar and Quarter Panel Sectioning

CAUTION: When performing service on or near the Supplemental Inflatable Restraint (SIR) components or the SIR wiring, the SIR system must be disabled. Failure to follow the correct procedure could cause air bag deployment, personal injury or unnecessary SIR system repairs.

The full body side outer panel comes as a one-piece assembly and can be replaced at factory seams after removal of glass and roof. Any one of these procedures can be performed separately, or in any combination, dependent upon the extent of damage to the vehicle. Sectioning must take place in specified areas only (Fig. 1-1). Remove front glass when sectioning front pillar and rear glass for rear pillar repair.

IMPORTANT: When replacing panels that involve servicing stationary glass, refer to GM Service Bulletin 43-10-48 before performing any priming or refinishing.

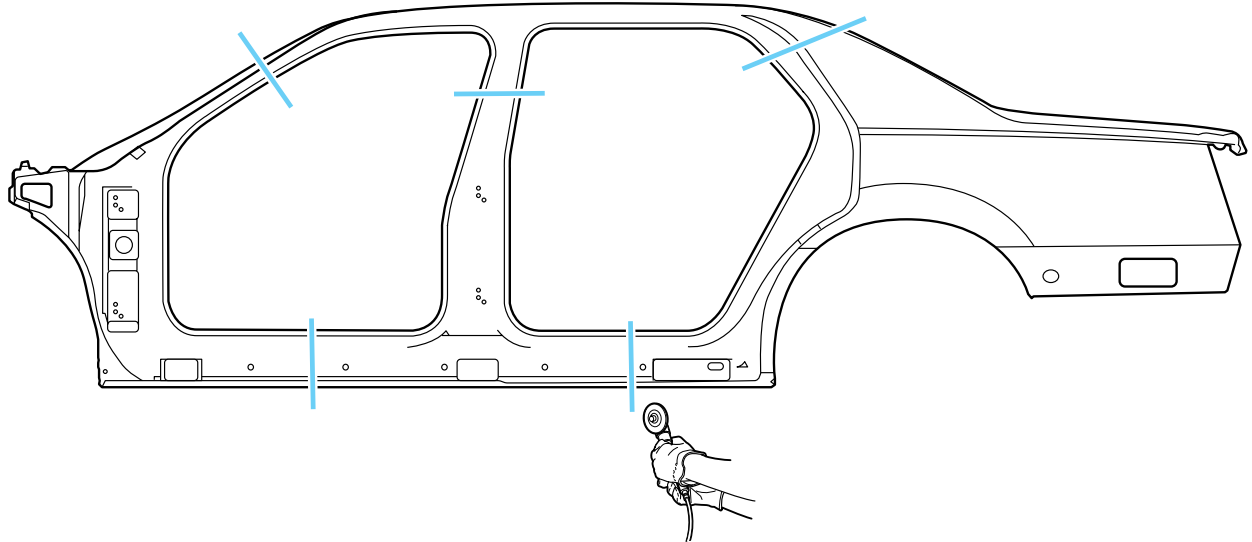


Fig. 1-1 — 2000 DeVille Outer Frame Sectioning Locations

Outer Front Pillar Sectioning

Removal Procedure

IMPORTANT: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle.

1. Visually inspect and restore as much of the damage as possible to factory specifications.
2. Remove the following:
 - Fender
 - Windshield
 - Door
 - Hinge pillar blocks
3. Determine sectioning locations. Section in approved areas only (see Fig. 1-1).
4. Mark locations and cut part through outer panel only.
5. Locate factory welds and drill out, noting number and locations of welds (Fig. 1-2).
6. Locate and drill out spot welds on weather strip retainer as necessary. It is not necessary to remove complete retainer.
7. Remove outer panel.
8. Note placement and number of foam baffles for new installation. If baffles are damaged, replacement service parts are available.

IMPORTANT: Hinge pillar blocks must be replaced if damaged.

9. Clean adhesive and sealer from hydroformed reinforcement tube as necessary. Note location for reinstallation.

Service Part Preparation

1. Cut service part in corresponding locations to fit original cut lines. Leave a gap of one-and-one half times the metal thickness of sectioning joint.
2. Create 100 mm (4 in) backing plate on rocker panel from unused portion of service part (Fig. 1-3).
3. In windshield pillar area, use the hydroformed inner rail for backing plate.
4. Drill 8 mm (5/16 in) plug weld holes in service part according to original locations as noted. Drill plug weld holes spaced 40 mm (1-5/8 in) apart along backing plate location 25 mm (1 in) from joint edge.

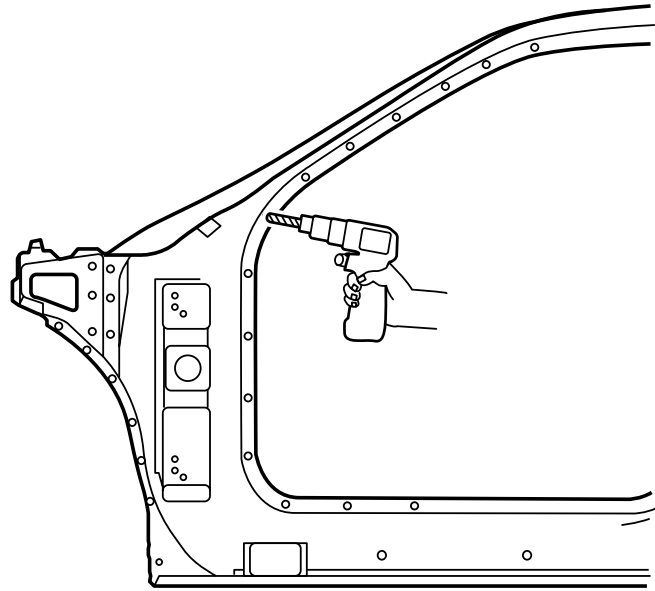


Fig. 1-2 — Drill Out Welds

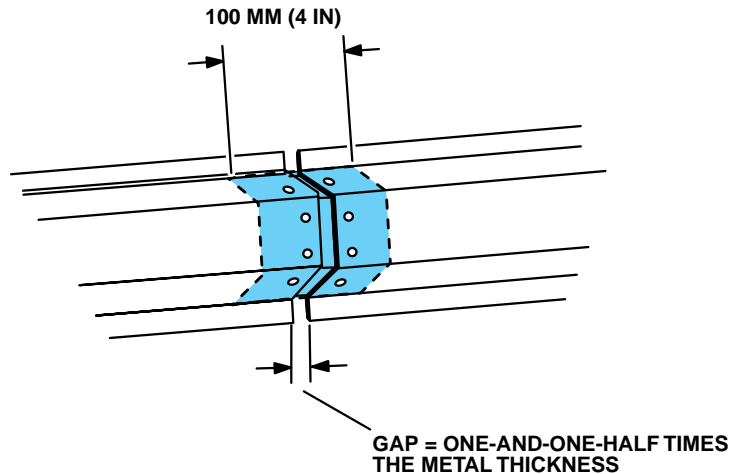


Fig. 1-3 — Rocker Panel Backing Plate

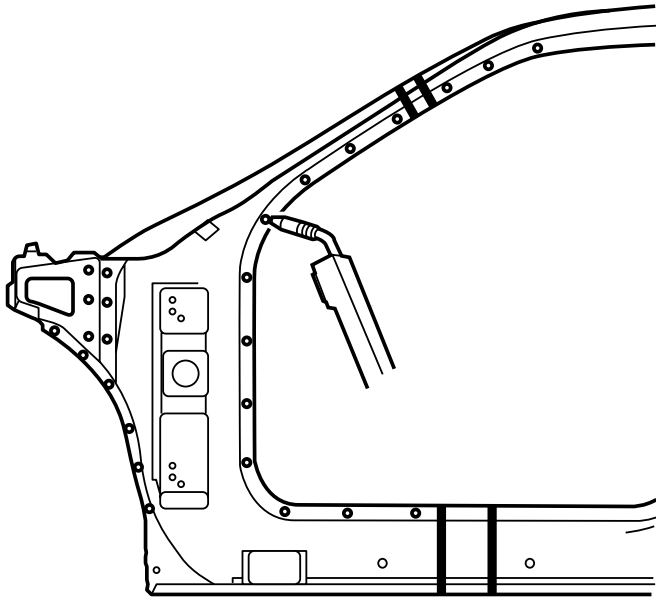


Fig. 1-4 — Plug Weld and Stitch Weld

Installation Procedure

IMPORTANT: Remove all foam prior to welding this section of the service panel.

1. Prepare mating surfaces.
2. Apply weld-through primer to mating surfaces prior to assembly.
3. Weld backing plates to vehicle at rocker.

IMPORTANT: Replace hinge pillar blocks prior to welding outer panel.

4. Apply windshield bonding adhesive to the hydroformed reinforcement as noted from removal procedure.
5. Position service part on vehicle. Clamp in place. Check for proper fit.
6. Plug weld accordingly (Fig. 1-4).
7. Stitch weld along both sectioning joints. Make 25 mm (1 in) welds along the seam with 25 mm (1 in) gaps between, then go back and complete the stitch weld to ensure structural integrity of the vehicle.
8. Install insulating foam as necessary in areas noted from original baffle locations.

IMPORTANT: Prior to refinishing, refer to the publication GM4901M-D-2000 "GM Approved Refinish Materials" for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

9. Refinish as necessary.

Outer Center Pillar Sectioning

Removal Procedure

IMPORTANT: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle.

1. Locate an approved sectioning area in the center pillar (Fig. 1-5).
2. Mark and scribe a line. This is the cut location.
3. Cut Center Pillar at cut line. Use caution not to cut inner reinforcement.
4. Create cut lines on rocker within approved sectioning locations. Cut the rocker vertically along cut lines.
5. Drill out factory welds. Note number and location of welds.
6. Remove the damaged part.
7. Note placement and number of foam baffles for new installation. If baffles are damaged, replacement service parts are available.

IMPORTANT: Hinge pillar blocks must be replaced if damaged.

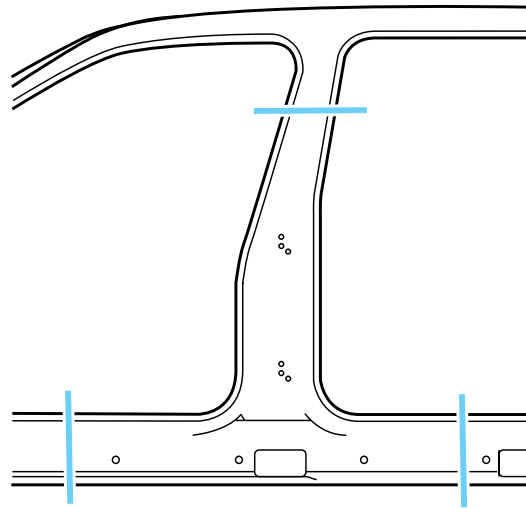


Fig. 1-5 — Outer Center Pillar - Sectioning Locations

Preparation Of Service Part

1. On the service part, at center pillar mark a horizontal line in corresponding locations to original sectioning cut. Leave a gap of one-and-one-half times the thickness of the metal at the sectioning joint (Fig. 1-6).
2. Mark vertical cut lines in rocker areas to correspond with original section lines. Leave a gap of one-and-one-half times the metal thickness (see Fig. 1-3).
3. Cut the outer doorframe opening service part along these three section lines.
4. Cut two 100 mm (4 in) pieces from the unused portion of the service part for backing plates in rocker.
5. Cut one 50 mm (2 in) backing plate for pillar (Fig. 1-6). Remove the flange on each side of the backing plates so that they will fit behind the sectioning joint.
6. Drill 8 mm (5/16 in) plug weld holes in service part according to original locations, as noted. Drill plug weld holes spaced 40 mm (1-5/8 in) apart along backing plate locations. Space these holes 25 mm (1 in) from the joint edge on the rocker panels and 13 mm (1/2 in) from the joint edge on the pillar.

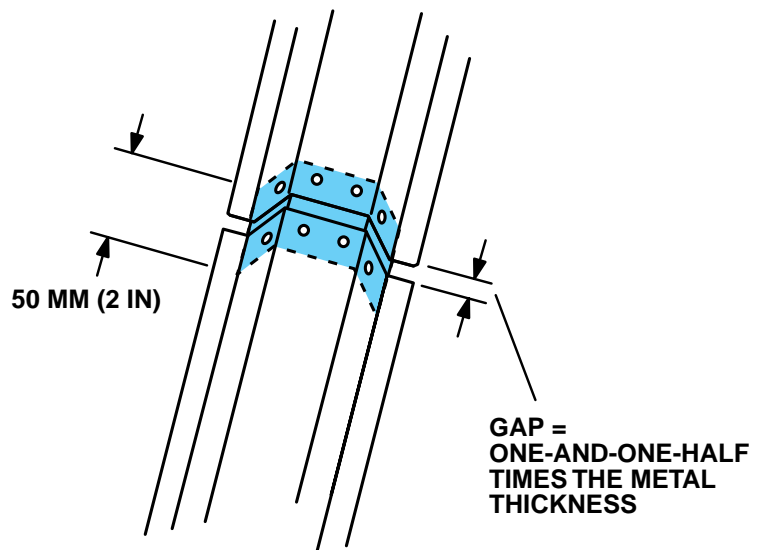


Fig. 1-6 — Create Pillar Backing Plate

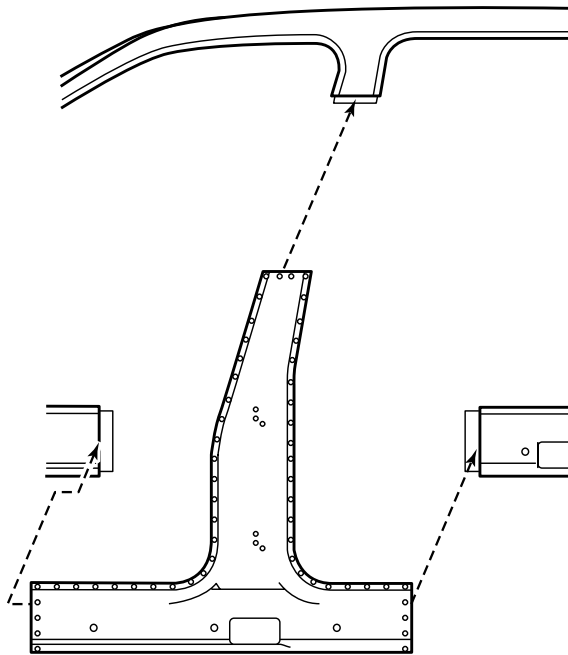


Fig. 1-7 — Outer Center Pillar – Installation

Installation Procedure

1. Install sleeves on vehicle at rocker and center pillar areas using plug welds.
2. Replace hinge blocks and bolts.
3. Prepare mating surfaces.

IMPORTANT: Prior to refinishing, refer to the publication GM4901M-D-2000 "GM Approved Refinish Materials" for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

4. Apply weld-through primer to mating surfaces prior to assembly.
5. Align part and clamp in place. Check fit (Fig. 1-7).
6. Spot blast plug weld areas.
7. Plug weld as necessary in original spot weld locations and at backing plates.
8. Stitch weld at section joints, one inch on and one inch off, as necessary, then go back and complete the stitch weld. This will create a solid joint with minimal heat distortion.
9. Dress welds and finish seams as necessary.
10. Refinish as necessary.

Quarter Panel Sectioning

Removal Procedure

The service part comes with lower quarter panel extension and taillamp pocket attached. These parts can be left on the vehicle if not damaged. Drill out factory welds on the car and service part and use the outer panel only.

IMPORTANT: When replacing panels that involve servicing stationary glass, refer to GM Service Bulletin 43-10-48 before performing any priming or refinishing.

IMPORTANT: Sectioning should be performed only in the recommended areas (Fig. 1-8). Failure to do so may compromise the structural integrity of the vehicle.

IMPORTANT: It may be necessary to unplug and remove one end of the body wiring harness that runs through quarter pillar lower extension if it is necessary to replace extension.

1. Visually inspect and restore as much of the damage as possible to the factory specifications.
2. Remove all related panels and components.
3. Remove all sealers, sound deadeners and anti-corrosion materials as necessary.
4. Determine sectioning locations in rocker area (Fig. 1-8).
5. Mark a line and cut in approved sectioning areas of rocker.
6. In upper quarter panel door opening, locate the fourth weatherstrip hole (1).
7. Measure down 25 mm (1 in) and mark a line.
8. In back-glass opening, locate rear edge of roof panel.
9. Measure down 25 mm (1 in), and scribe a second line. Connect marks at both locations to create a cut line.
10. Cut part at marked locations.
11. Locate, mark and drill out all factory welds. Note the number and location of welds for installation of the service assembly.
12. Remove damaged panel. Note placement and number of foam baffles for new installation. If baffles are damaged, replacement service parts are available.

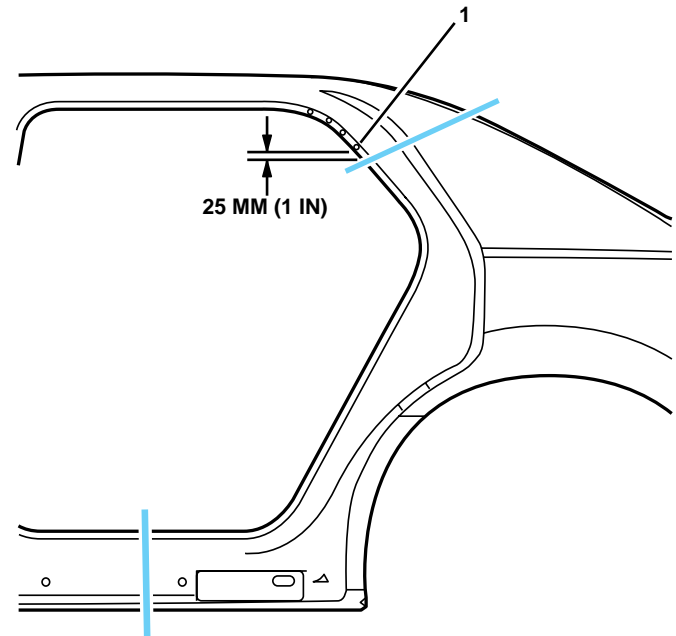


Fig. 1-8 — Outer Rear Pillar Sectioning

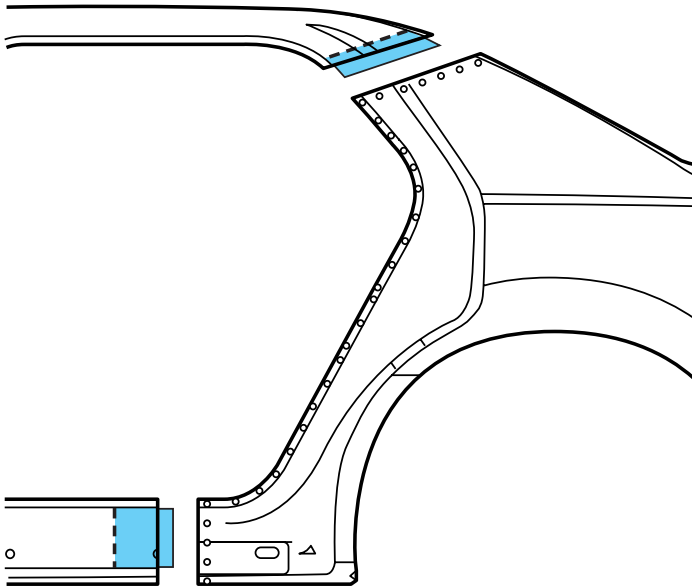


Fig. 1-9 — Outer Rear Pillar Preparation

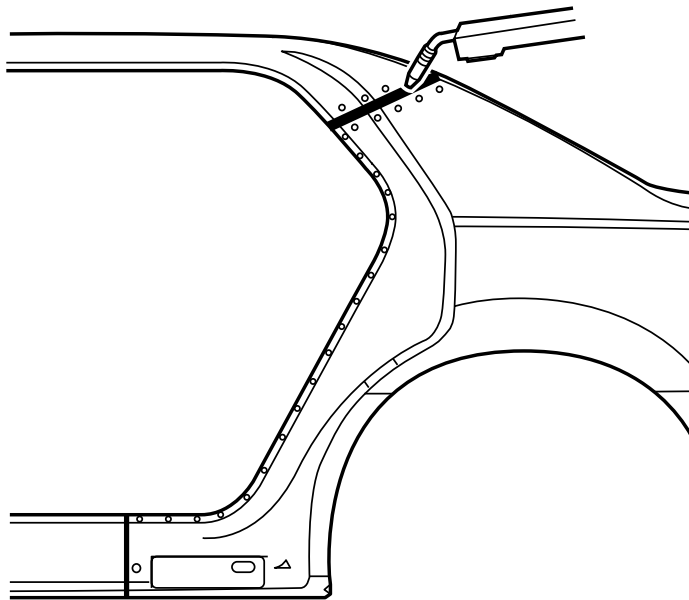


Fig. 1-10 — Outer Rear Pillar Installation

Preparation Of Service Part

1. Cut service part in corresponding locations to fit original cut lines. Leave a gap of one-and-one-half times the metal thickness of sectioning joint (Fig. 1-9).
2. Create 100 mm (4 in) backing plate on rocker panel from unused portion of service part.
3. Create a 50 mm (2 in) backing plate on quarter panel from unused portion of old quarter panel.
4. Drill 8 mm (5/16 in) plug weld holes as noted from original locations. At backing plates, drill 8 mm plug weld holes 13 mm (1/2 in) from seam spaced 40 mm (1 1/2 in) apart.

Installation Procedure

1. Position service part on vehicle. Check fit using body dimensions.
2. Temporarily remove service part.
3. Prepare mating surfaces.

IMPORTANT: Prior to refinishing, refer to the publication GM4901M-D-2000 "GM Approved Refinish Materials" for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.
4. Apply weld through primer to mating surfaces.
5. Install GM P/N 12399117 Sealing Strip between outer wheelhouse and gas door pocket.
6. Weld backing plates into position on body.
7. Position service part and clamp in place. Spot blast plug weld areas. Plug weld as necessary in original locations and along backing plates.
8. Stitch weld along entire sectioning joint. Make 25 mm (1 in) welds along the seam with 25 mm (1 in) gaps between them (Fig. 1-10).
9. Go back and complete the stitch weld. This will create a solid joint with minimal heat distortion.
10. Clean and prepare welded surfaces, as necessary.
11. Install all sealers, sound deadeners and anti-corrosion materials as necessary. Install acoustic foam baffles as noted from original part.
12. Apply two-part catalyzed primer.
13. Refinish as necessary.
14. Install all related panels and components.