

Inner Front Pillar, Center Pillar and Rear Wheelhouse Sectioning

CAUTION: When performing service on or near the 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 bodyside inner panel comes as a one piece assembly and can be replaced at factory seams after removal of outer panel, roof and glass. Any one of these procedures can be performed separately, or in any combination dependent upon the extent of damage to the vehicle.

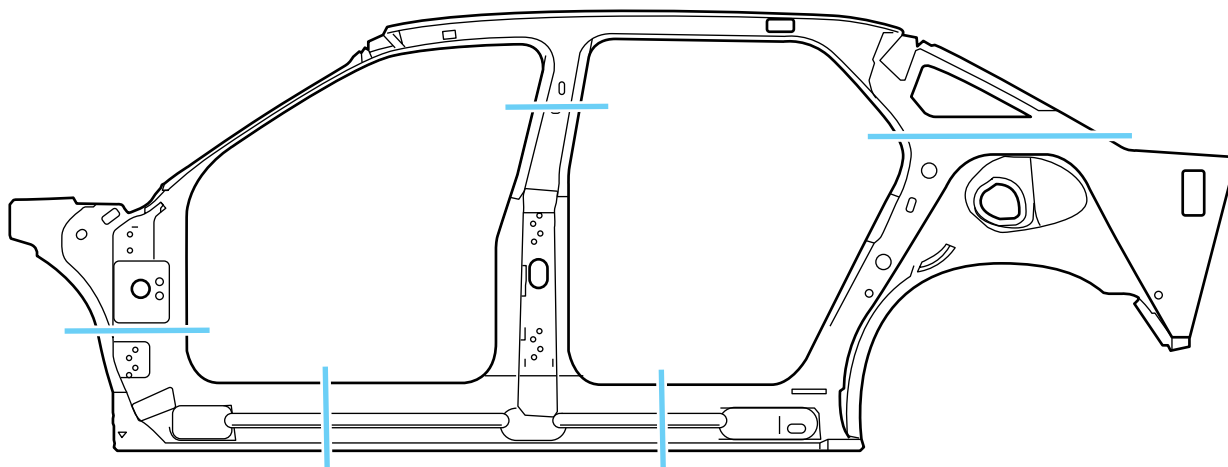


Fig. 1-11 — 2000 DeVille Inner Frame Sectioning Locations

Inner 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 outer panel according to specified directions in Outer Panel Removal procedure.
3. Remove all necessary components to allow access to repair area.
4. Locate and mark a horizontal line 50 mm (2 in) down from the raised, square portion of the hinge pillar (Fig. 1-12). This will be your cut location (1).
5. At rocker panel, locate and mark a vertical cut line in the approved sectioning location (Fig. 1-12).
6. Cut at the two marked locations. Use caution to cut through one layer of metal only.
7. Locate and drill out factory welds noting the number and location of welds.
8. Remove damaged section from vehicle.

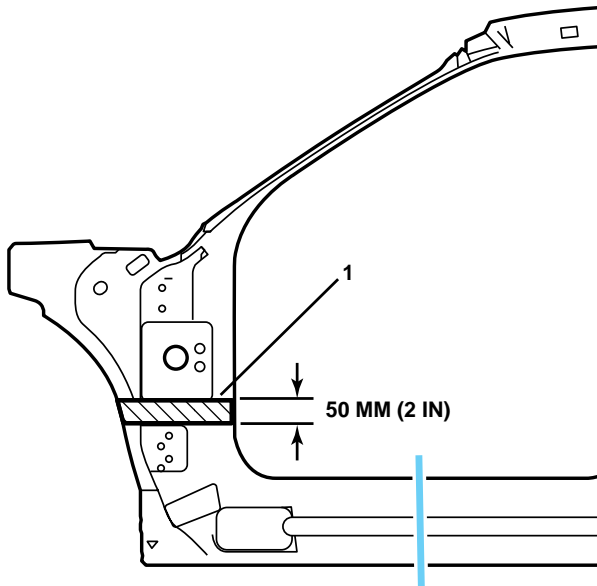


Fig. 1-12 — 2000 DeVille Inner Front Pillar Sectioning Locations

Preparation of Service Part

1. On hinge pillar, scribe a cut line 25 mm (1 in) below the raised, square portion of the hinge pillar. This will create a 25 mm (1 in) overlap on the service part.
2. Notch the panel on the door weather-strip flange (1) to prevent excessive metal thickness in this area (Fig. 1-13).
3. In rocker area, locate and mark a cut line in the recommended sectioning area. Allow for a 50 mm (2 in) overlap to the vehicle sectioning areas (Fig. 1-13).
4. Cut along marked sectioning lines to create service part.
5. Notch upper and lower edges of service part (2) to prevent excessive metal thickness in this area (Fig. 1-13).
6. Drill plug weld holes spaced 40 mm (1-5/8 in) apart along overlap flanges. Place holes 25 mm (1 in) from edge on rocker panel and 13 mm (1/2 in) from edge on hinge pillar.

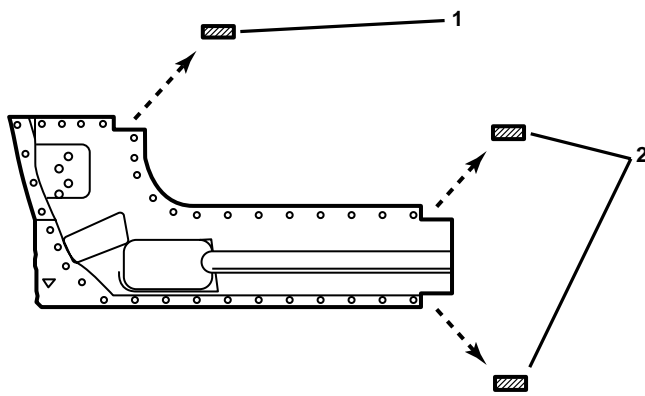


Fig. 1-13 — 2000 DeVille Inner Front Pillar Service Part

Installation Procedure

1. 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.
2. Prime with two-part catalyzed primer.
3. Position part on vehicle and clamp in place. Measure and check for fit (Fig.1-14).
4. Spot blast plug weld areas.
5. Plug weld accordingly.
6. Stitch weld at hinge pillar and rocker panel.
7. Dress and finish weld seam as necessary.
8. Refinish as necessary.
9. Install related panels and components as necessary.

Inner Center Pillar Sectioning

Removal Procedure

1. Remove necessary trim and outer panels.
2. Secure wiring harness away from repair area.
3. Locate the laser weld in the center pillar upper area (Fig. 1-15).
4. Measure down 25 mm (1 in) from the laser weld line and scribe a horizontal line. This is the cut location.
5. At the front door rocker area, scribe a vertical cut line within the preferred sectioning area.
6. At the rear door rocker area, scribe a vertical cut line within the preferred sectioning area.
7. Cut on the three scribed lines.
8. Drill out factory spot welds noting their location for installation of the service part.
9. Remove the damaged panel.

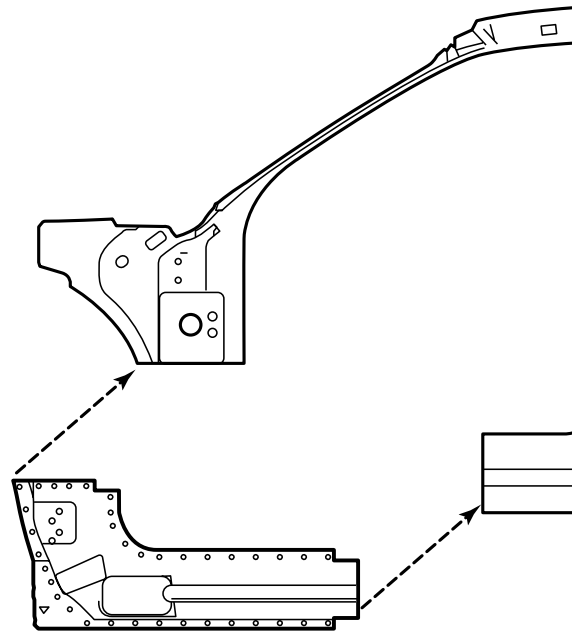


Fig. 1-14 — 2000 DeVille Inner Center Pillar Detail

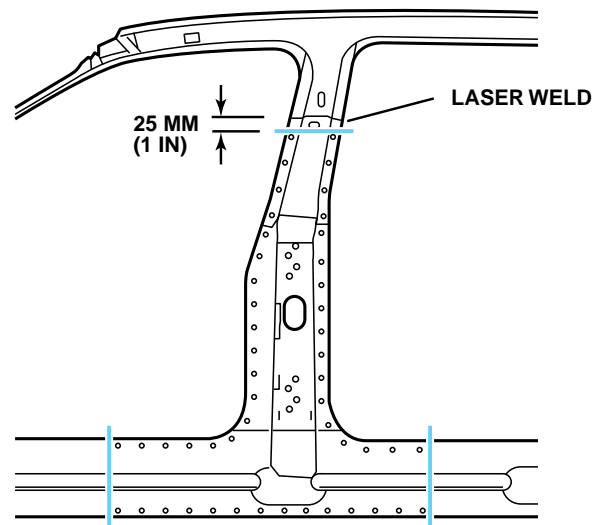


Fig. 1-15 — 2000 DeVille Inner Center Pillar

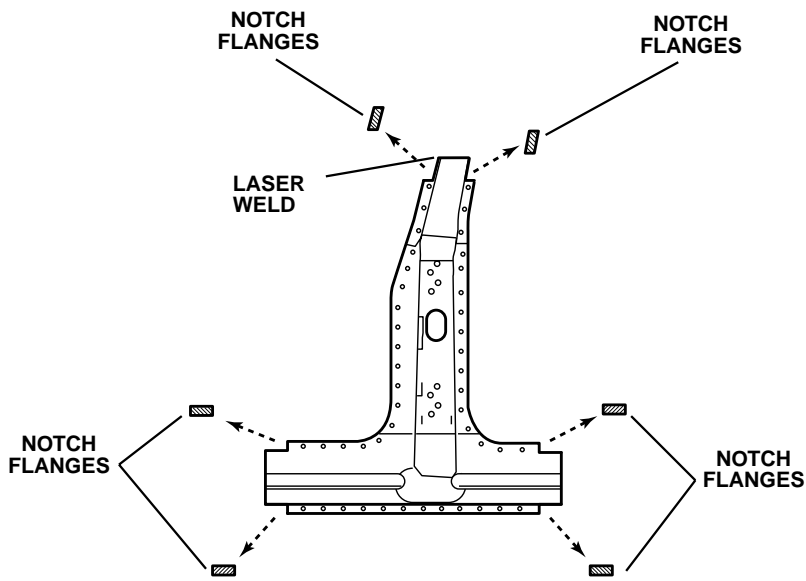


Fig. 1-16 — 2000 DeVille Inner Center Pillar – Preparation

Preparation of Service Part

1. Cut center pillar at laser weld location. This will allow a 25 mm (1 in) overlap to the vehicle for welding (Fig. 1-16).
2. Notch the weather strip flange to prevent excessive metal thickness in these areas.
3. In front and rear door rocker areas of service part, scribe vertical cut lines to allow a 50 mm (2 in) overlap of original cut lines on vehicle.
4. Cut on the scribed lines. Notch the weatherstrip and lower flanges to prevent excessive metal thickness in these areas.
5. Drill 8 mm (5/16 in) plug weld holes every 40 mm (1-5/8 in) along rocker overlaps, 25 mm (1 in) from edge of overlap. On center pillar, drill weld holes 13 mm (1/2 in) from edge.
6. Drill 8 mm (5/16 in) plug weld holes on weld flanges as noted from original panel.

Installation Procedure

1. 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.
2. Prime repair areas with two-part catalyzed primer.
3. Clamp part in position. Check for proper fit (Fig. 1-17).
4. Spot blast plug weld areas.
5. Plug weld as necessary.
6. Stitch weld along sectioned areas.
7. Finish seams as necessary.
8. Refinish as necessary.
9. Install all related panels and components.

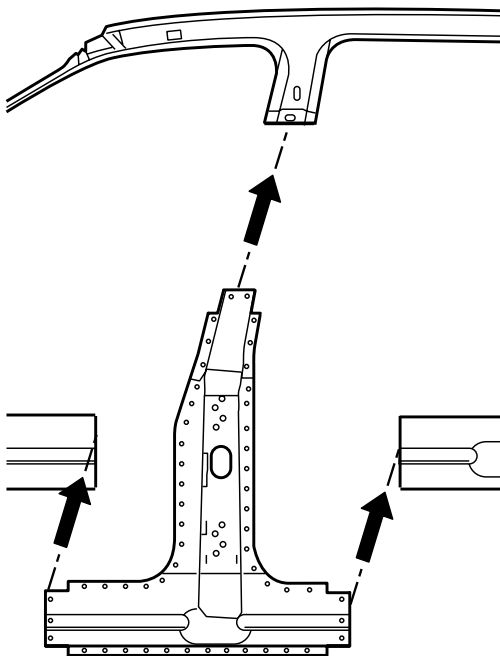


Fig. 1-17 — 2000 DeVille Inner Center Pillar – Installation

Outer Wheelhouse Sectioning

Removal Procedure

1. Locate horizontal laser-weld line in upper quarter area (Fig. 1-18).
2. Measure down 25 mm (1 in) and scribe a cut line.
3. On the vehicle rocker area, locate and scribe a vertical cut line in the recommended section area.
4. Cut panel at scribed locations.
5. Drill out factory welds. Note the number and location of welds.
6. Remove the damaged panel.

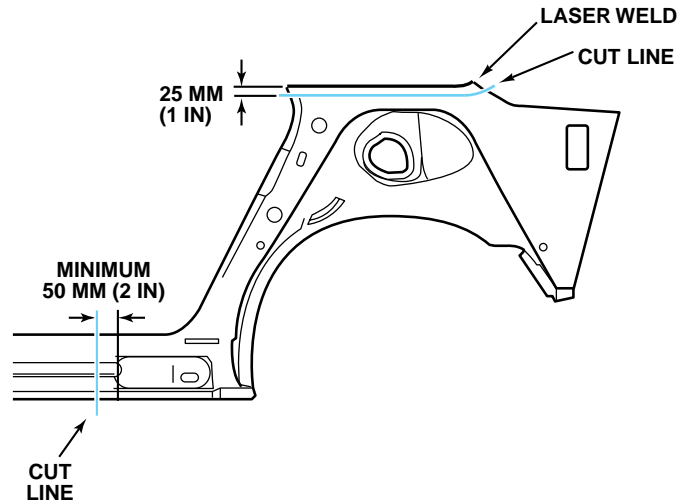


Fig. 1-18 — 2000 DeVille Outer Wheelhouse Removal

Preparation Of Service Part

1. Locate laser weld line on service part (Fig. 1-19).
2. Cut along laser weld line.
3. In specified sectioning location of rocker area, create a vertical cut line. Allow for a 50 mm (2 in) overlap of service part to rocker area on the vehicle.
4. Cut service part along marked locations.
5. Trim a 20 mm x 50 mm (7/8 in x 2 in) tab at top and bottom of section area of service part to allow for a flush fit at pinch welds.
6. Drill plug weld holes in service part as noted from original panel.
7. Drill 8 mm (5/16 in) plug weld holes along section areas 25 mm (1 in) from edge on rocker and 13 mm (1/2 in) from edge in upper quarter area.

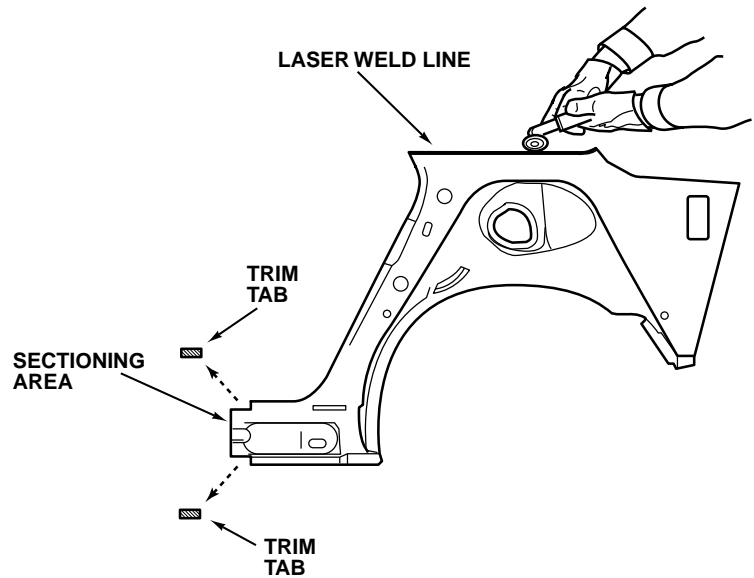


Fig. 1-19 — 2000 DeVille Outer Wheelhouse Preparation

Installation Procedure

1. Install new part and clamp in place. Check for fit.

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 manufacturer's recommendations.
2. Apply two-part catalyzed primer.
3. Spot blast weld areas.
4. Perform stitch weld, plug weld, grind and finish as necessary.
5. Use a brushable seam sealer on inside seam.
6. Install all related panels and components.