

Rocker Outer Panel Sectioning

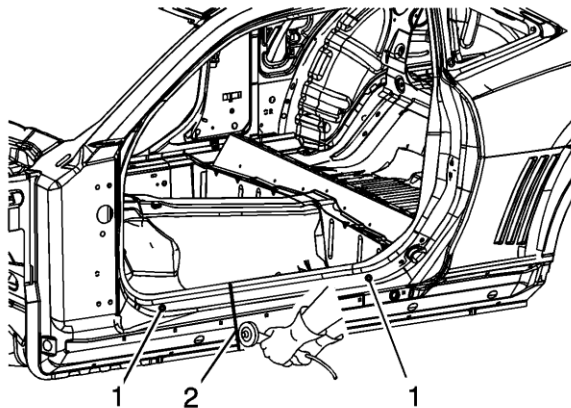
Removal Procedure

Warning: Refer to [Collision Sectioning Warning](#) in the Preface section.

Warning: Refer to [Approved Equipment for Collision Repair Warning](#) in the Preface section.

Warning: Refer to [Glass and Sheet Metal Handling Warning](#) in the Preface section.

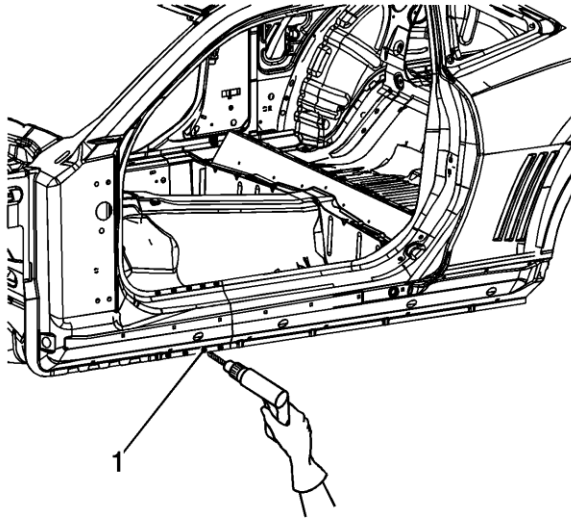
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#).
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
3. Remove all related panels and components.
4. Restore as much of the damage as possible to factory specifications.
5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Foam Sound Deadeners Warning](#).



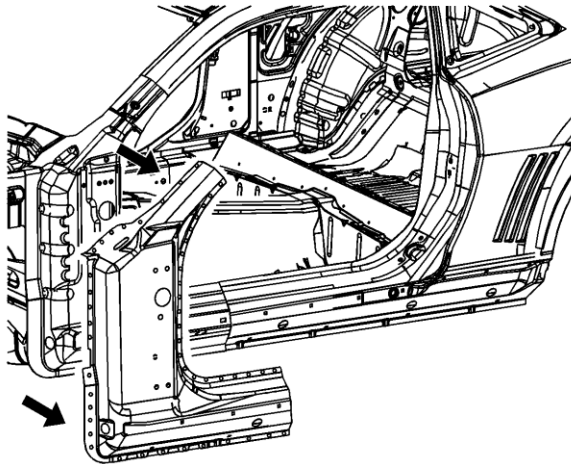
Note: Do not damage any inner panels or reinforcements. The Rocker panel may be sectioned at any location between the radius (1) of the hinge pillar and lock pillar, using a 100 mm sleeve.

6. Cut the Rocker Panel where sectioning is to be performed (2).

7. Perform additional sectioning procedures as necessary. Refer to [Quarter Outer Panel Sectioning](#) and [Front Hinge Pillar Body Sectioning](#).

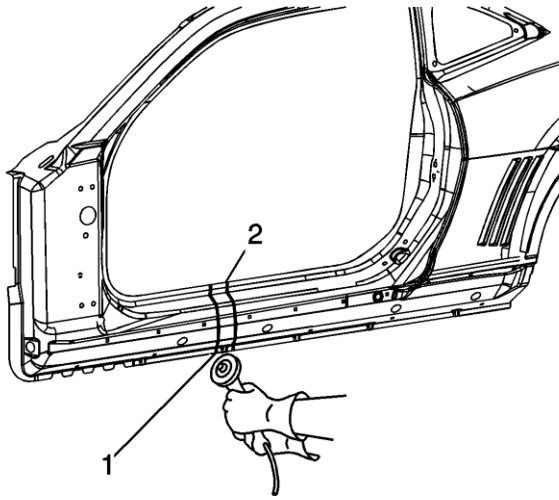


8. Locate and drill out all factory welds (1). Note the number and location of the welds for installation of the service part.

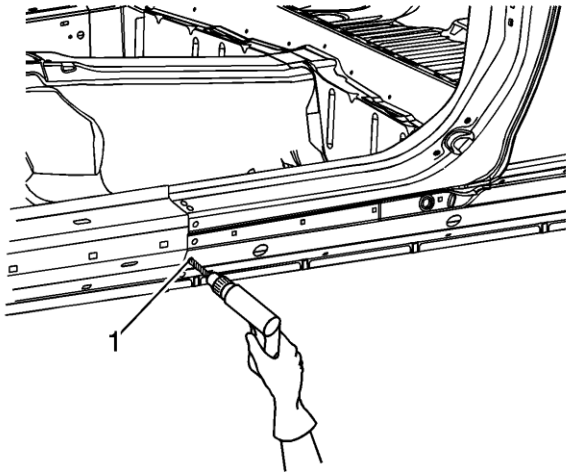


9. Remove the damaged Rocker Panel (1).

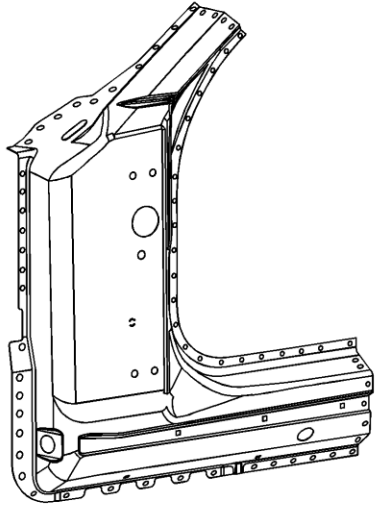
Installation Procedure



1. Cut the replacement Rocker Panel in corresponding locations to fit the original panel (1). The sectioning joint should be trimmed to allow 1.5 times the metal thickness at the sectioning joint.
2. Create a 100 mm (4 in) backing plate from the unused portion of the service part (1). Trim the backing plate as necessary to fit behind the sectioning joint where there is no reinforcement.

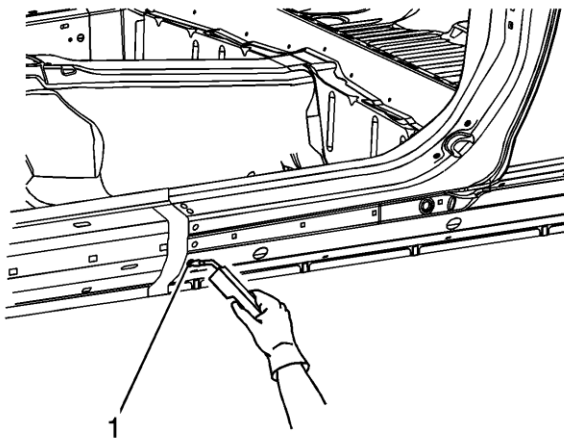


3. Drill 8 mm (5/16 in) plug weld holes along the sectioning cut on the remaining original part (1). Locate these holes 25 mm (1 in) from the edge and spaced 40 mm (1 1/2 in) apart.

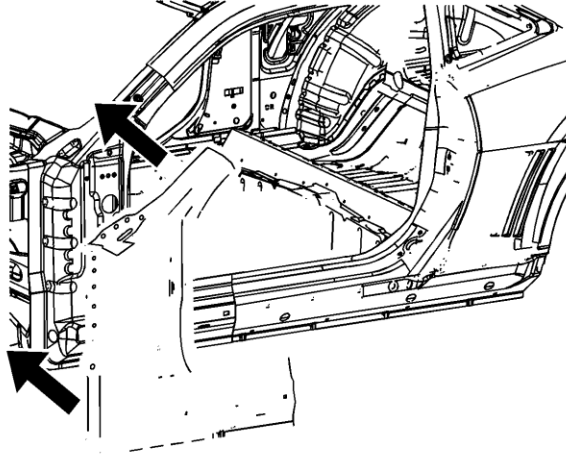


Note: In any area damaged beyond recognition, or Structural weld thru adhesive was present space plug weld holes every 40 mm (1 1/2 in) apart.

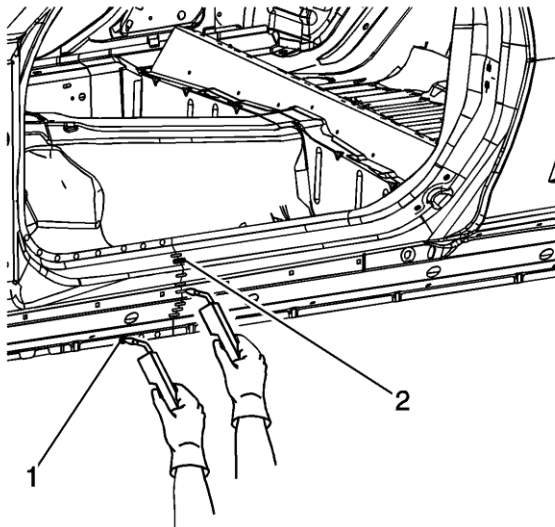
4. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel and along the sectioning cut (1).
5. Prepare all attachment surfaces as necessary.
6. Apply GM approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).



7. Fit the backing plate halfway into the sectioning joint, clamp and plug weld (1) to the vehicle



8. Position the service panel to the vehicle (1).
9. Clamp service part in place.
10. Inspect the vehicle for proper dimensions using 3-dimensional measuring equipment.



11. Plug weld accordingly (1).

Note: To create a solid weld with minimum heat distortion make 25 mm (1 in) stitch welds along the seam with 25 mm (1 in) gaps between them. Then go back and complete the stitch weld.

12. Stitch weld sectioning joint (2).
13. Clean and prepare all welded surfaces.
14. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).
15. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#).

16. Install all related panels and components.
17. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
18. Enable the SIR system. Refer to [SIR Disabling and Enabling](#).

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