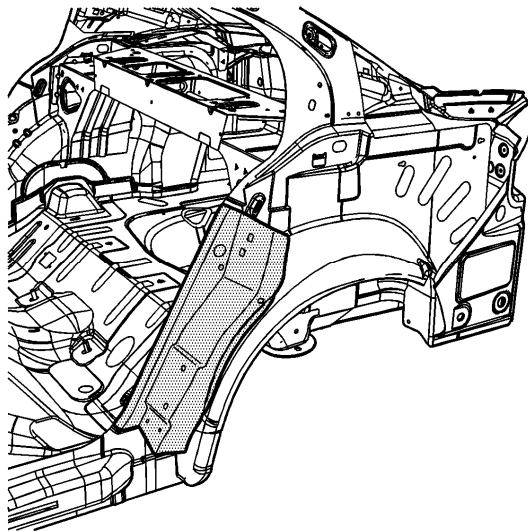


Rear Door Inner Lock Pillar Replacement

Removal Procedure

Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

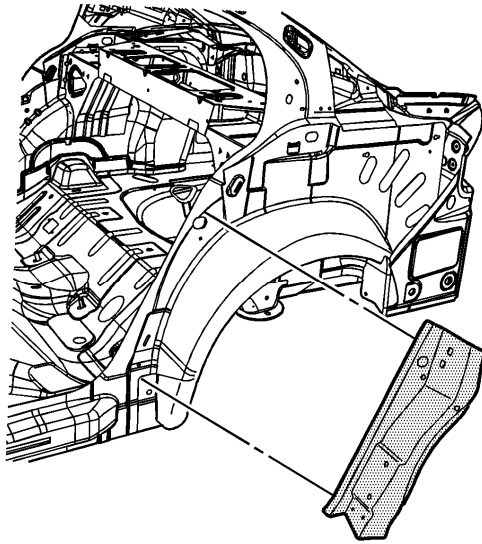
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.



3. Remove all related panels and components.
4. Repair as much of the damaged area as possible. Refer to [Dimensions - Body](#) .
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.

Important: Note the number and location of the factory welds for installation of the inner pillar lock rear door.

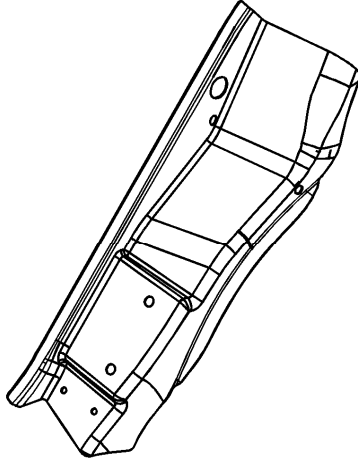
6. Locate and drill out all the necessary factory welds.



Important: Structural adhesive is present on the rear striker inner reinforcement panel. Use a small flame from an oxy-acetylene torch to aid in releasing the wheelhouse bond to the structural adhesive.

7. Remove the inner pillar lock rear door.

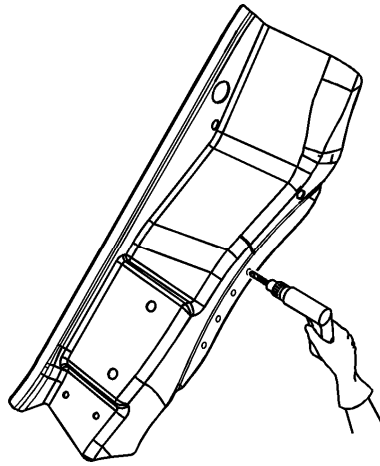
Installation Procedure



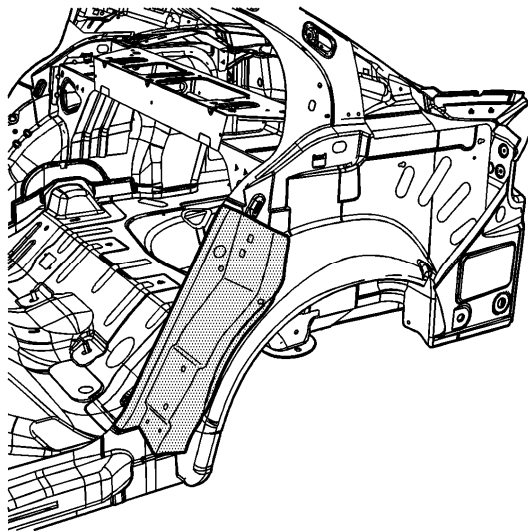
Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

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.

Important: Use plug welds in place of the structural adhesive. Plug weld at the flange from the rear door lock pillar inner reinforcement to the rear wheelhouse outer.



2. Drill 8-mm (5/16-in) plug weld holes in the service part on the attachment flange to the rear wheelhouse outer. Space the holes every 20 mm (13/16 in) apart.
3. Prepare all mating surfaces for welding as necessary.
4. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).



5. Position the inner pillar lock rear door. Clamp the part in place.
6. Plug weld accordingly.
7. Clean and prepare all of the welded surfaces.
8. Install all of the related panels and components.

9. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
10. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
11. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
12. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.