

Front Side Door Opening Assembly

The Sheet Moulded Compound (SMC) Side Door Opening assembly is a two panel assembly that bonds along the frame rail and up the front body hinge pillar. The service assembly (Fig. 3.31) can be disassembled at the riveted and bonded joint (Fig. 3.32) for individual panel replacement. If sectioning the side door opening assembly, use backing plates. (Refer to SMC Repair Procedures.)

— REMOVE OR DISCONNECT —

- 1 Visually inspect, if any damage to the frame rails or wheelhouse mounting areas exist, then restore as much of the damage as possible to specifications using three-dimensional measuring procedures.

Notice: Use Kent Moore Tools Frame Adapter Clamp (P/N J42058) to secure the vehicle if pulling and straightening is required (Fig. 3.33).

Notice: The frame rails and bumper impact bars must be serviced as required, and returned to three-dimensional coordinates before any SMC repairs are attempted.

- 2 Remove all panels and components to gain access to door side frame. This may include the following components: quarter panel and quarter inner splash shield (NOTE: The door side frame can be removed if the quarter panel is loosened from it).

Notice: Use caution when removing the side door opening assembly in the area of the instrument panel. Overlapping interior trim components must be removed first to prevent damage.

- 3 Remove latch striker closeout cover and striker. Also, remove the trim screws that attach the side door frame panel to the rail. (NOTE: These screws must be re-installed to secure the service panel in place until the adhesive cures.)

Notice: Make sure the fuel inlet is sealed before proceeding with repair procedure.

- 4 Apply heat and pry to break bond along area indicated in Fig. 3.34. (NOTE: Use caution along the underside of the vehicle when applying heat not to de-bond the floor panels from the frame rail.)

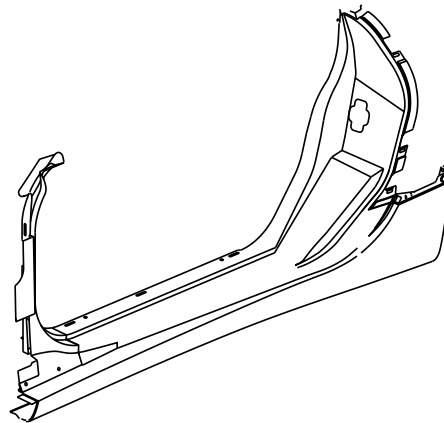


Fig. 3.31 — Side Door Opening Service Part

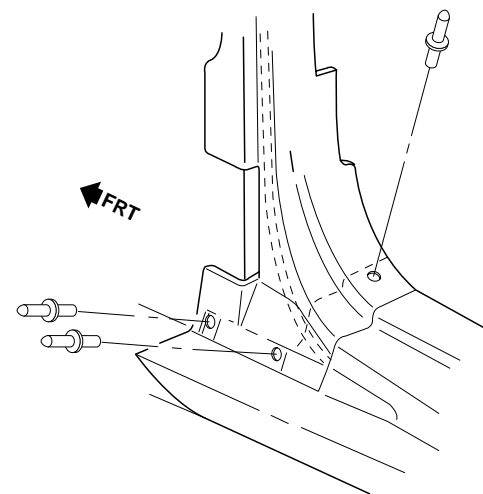


Fig. 3.32 — Service Part Can Be Separated at the Bonded and Riveted Joint

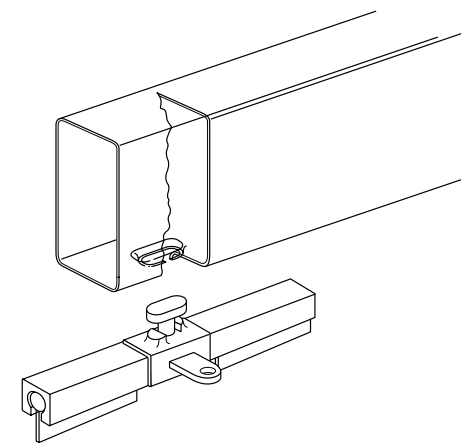


Fig. 3.33 — Adapter Clamp for Conventional Anchoring System

Front Side Door Opening Assembly

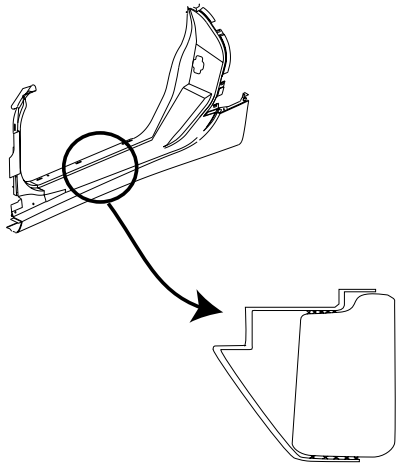


Fig. 3.34—

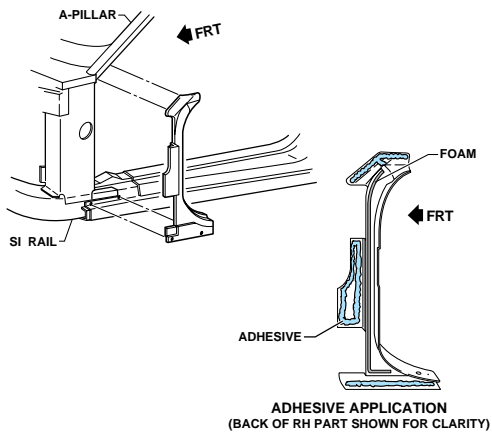


Fig. 3.35 —

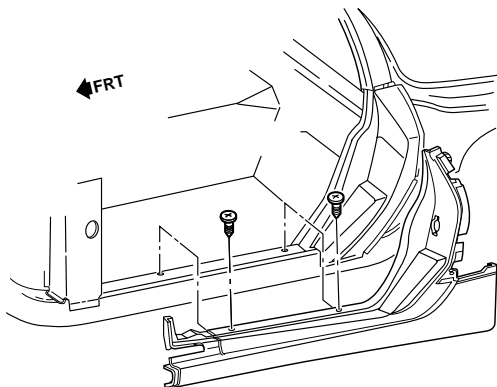


Fig. 3.36 — Install Screws to Secure Panel While Adhesive Cures. Also Apply Adhesive to the Lower Edge of Rocker to Bond at Bottom Side of Rail.

— INSTALL OR CONNECT —

- 1 Remove all remaining adhesive, and scuff all bonding surfaces to ensure proper adhesion. (Refer to SMC Repair Procedures.)
- 2 Clean and prepare all bonding surfaces as necessary. (Refer to SMC Repair Procedures.)
Important: Prior to refinishing, refer to GM P/N 4901 Refinish Manual for recommended products.
- 3 Apply approved anti-corrosion primer.
Notice: DO NOT top-coat any bonding surface.
- 4 Temporarily fit the side door opening assembly to ensure proper fit and alignment with adjacent panels.
- 5 The front body hinge pillar portion of the side door opening panel has a foam seal that must make contact with the front hinge pillar (Fig. 3.35).
- 6 Remove panel assembly and apply a consistent bead of adhesive, 10mm in diameter to the front body hinge pillar and top surface of rail and to all areas originally bonded, except for bottom side of rail. (This area is bonded after the side door opening assembly is installed.)
Important: Use US Chemical and Plastics 82007B System 2000 Structural Adhesive, a PLIOGRIP® adhesive manufactured by Ashland Chemical Company, or equivalent. Note the 30 minute working time and 2.5 to 3 hour cure time.
- 7 Install assembly using original screws in factory locations. The screws are necessary to secure the service part until the adhesive cures (Fig. 3.36).
- 8 Apply adhesive to inner edge of rocker and clamp in place until adhesive cures. (NOTE: Standoffs in part must fit flush against bottom surface of rail). See Fig. 3.34.
- 9 Remove excess adhesive squeeze-out and allow to cure.
Important: Prior to refinishing, refer to GM P/N 4901 Refinish Manual for recommended products.
- 10 Apply approved anti-corrosion primer. Do not combine paint systems. Always refer to paint manufacturer's recommendations.
- 11 Install all related panels and components.