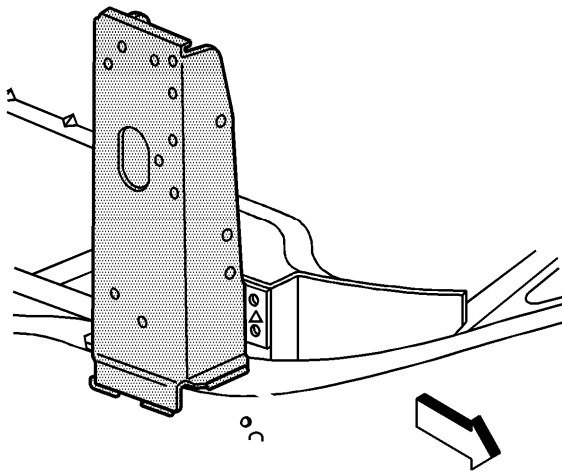


Front Hinge Pillar Body Replacement

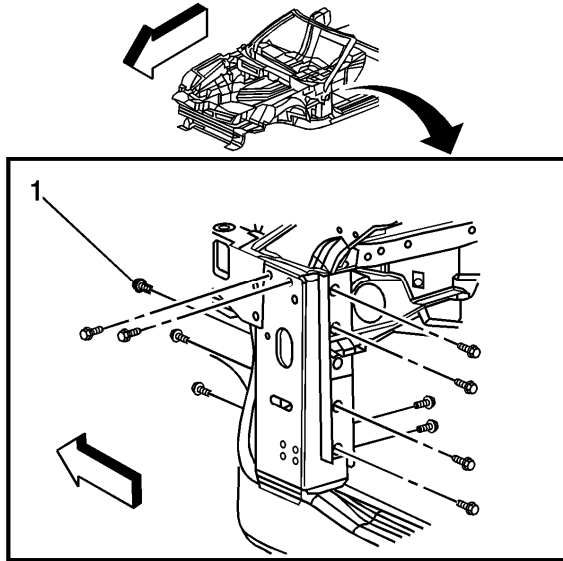
Removal Procedure



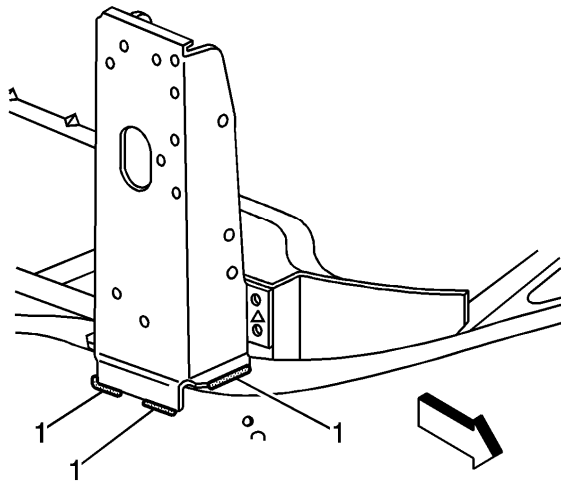
The front hinge pillar panel is bolted, welded and bonded with structural adhesive to the side structure and frame rail. The replacement front hinge pillar panel is serviced as an assembly. You must remove and replace the side door opening panel in order to replace the front hinge pillar.

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

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. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#).
5. Note the location of the sealers and the anti-corrosion materials and remove these components from the repair area as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).

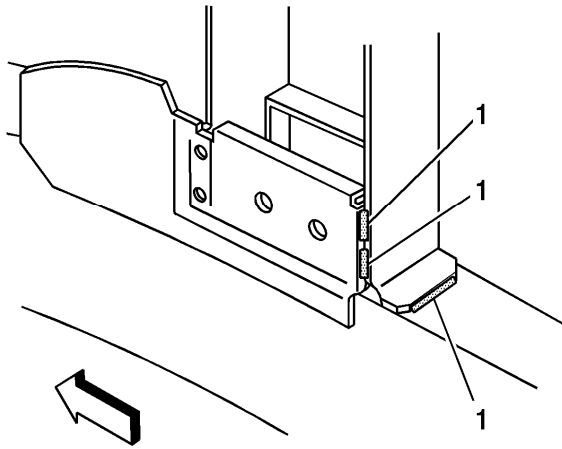


6. Remove the bolts (1) attaching the front hinge pillar to the windshield frame.

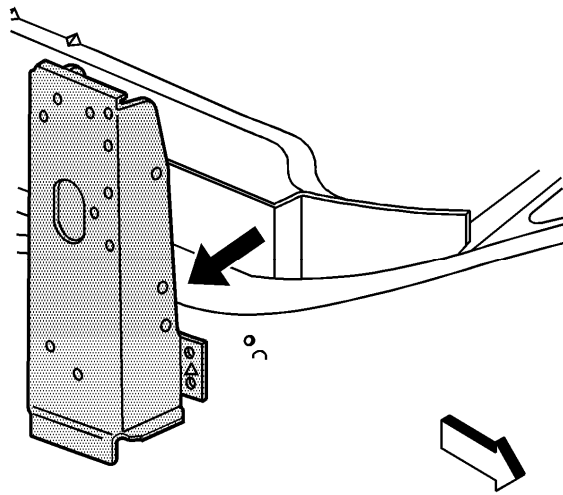


Important: Do NOT damage the inner panels or the reinforcements.

7. Locate and remove all factory welds (1) from the outer hinge pillar. Note the number and location of the welds for installation of the new hinge pillar.



8. Locate and remove all factory welds (1) from the inner hinge pillar. Note the number and location of the welds for installation of the new hinge pillar.



9. Remove the damaged hinge pillar.
10. Note the location of the adhesive and remove all remaining loose adhesive.

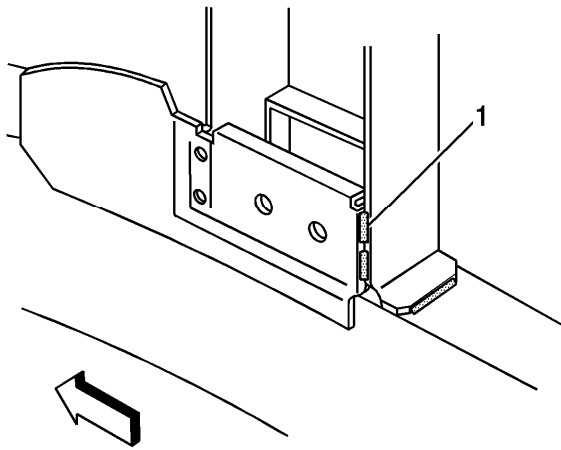
Installation Procedure

1. Before applying the adhesive, dry fit the hinge pillar for proper fit and alignment.

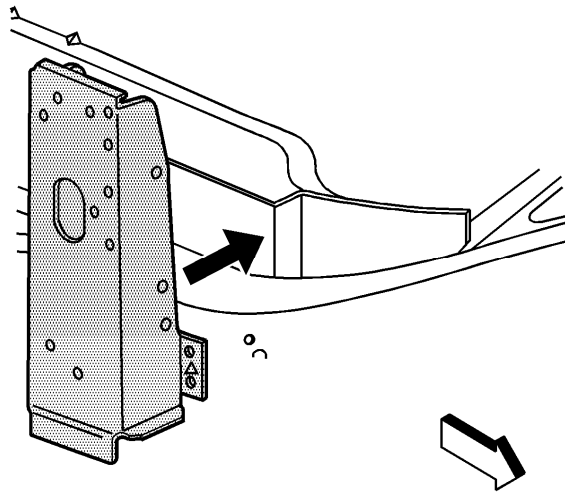
2. Prepare all welding attachment surfaces as necessary.

Important: Use primer only on bonding surfaces. Do NOT top coat any bonding surfaces. Refer to the adhesive manufacture's recommendation.

3. Clean and prepare all bonding mating surfaces according to the adhesive manufacturer's recommendations.
4. Apply a consistent bead of structural adhesive 10 mm (3/8 in) in diameter to mate with the bonding surfaces. Refer to [Sheet Molded Compound \(SMC\) Panel Bonding](#).



5. If the weld (1) is not accessible, replace the weld with structural adhesive.
6. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).



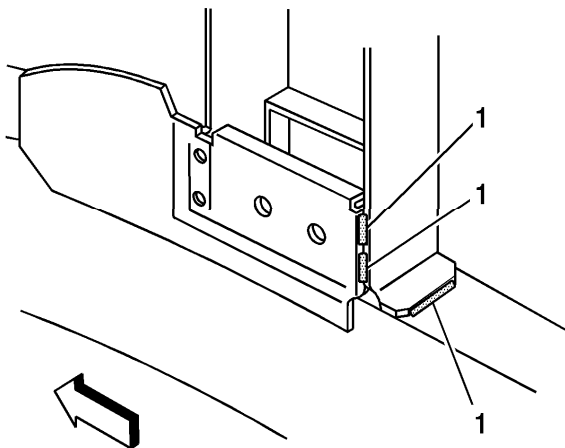
7. Position the hinge pillar to the vehicle using 3-dimensional measuring equipment.

Notice: Refer to [Fastener Notice](#) in Cautions and Notices.

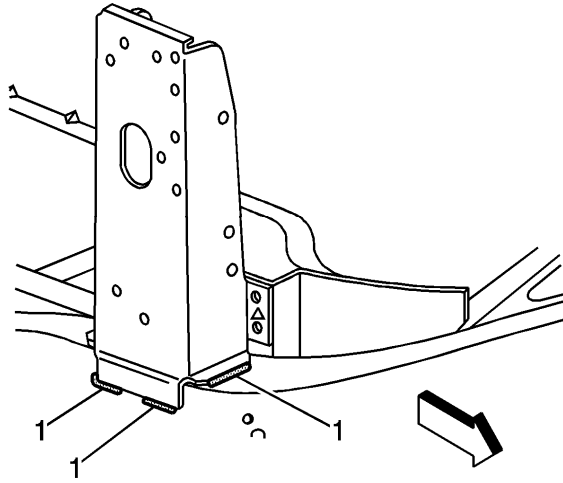
8. Install the bolts (1) that attach the windshield frame to the front hinge pillar.

Tighten

Tighten the bolts to 25 N·m (18 lb ft).



- Using a metal inert gas (MIG) welder, stitch weld the inner hinge pillar to the vehicle in the locations (1) noted on the original panel.



- Using a MIG welder, stitch weld the outer hinge pillar to the vehicle in the locations (1) noted on the original panel.
 - Apply the sealers and the anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).
 - Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#).
 - Install all related panels and components.
 - Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
 - Enable the SIR system. Refer to [SIR Disabling and Enabling](#).
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