

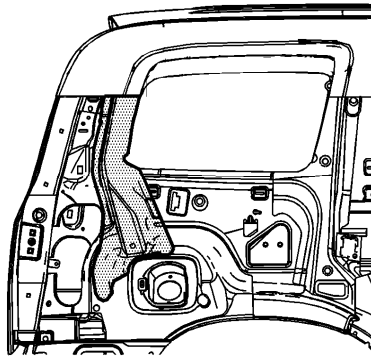
Back Body Opening Upper Frame Replacement

Removal Procedure

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

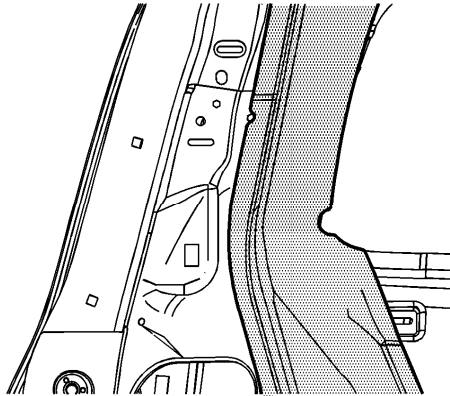
Caution: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

1. Disable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) .
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) .

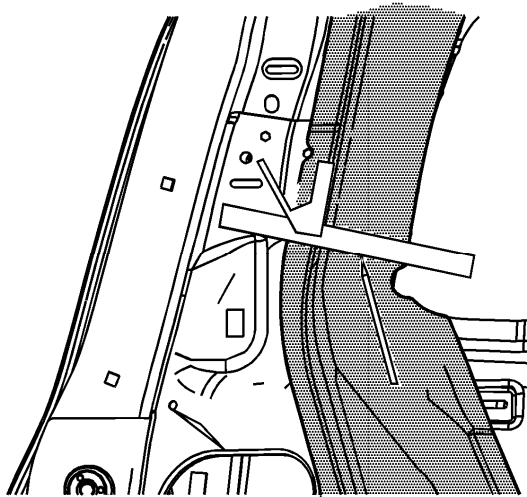


3. Remove all of the related panels and the components.
4. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .

5. Repair as much of the damage as possible. Refer to [Dimensions - Body](#) .

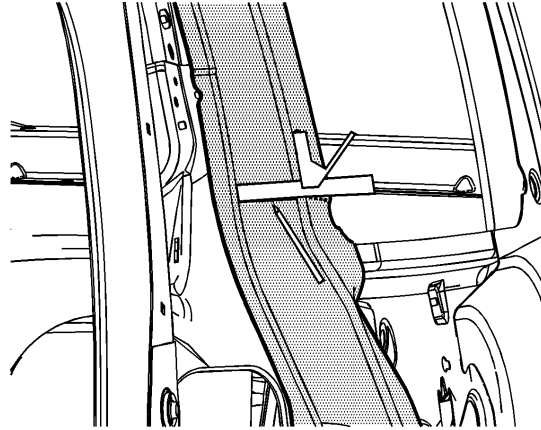


6. Locate the notch in the window opening pinchweld flange.

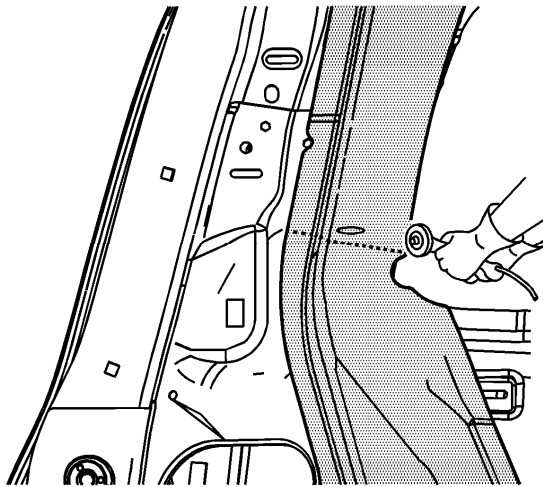


Important: Do not section the rail in any area other than location given.

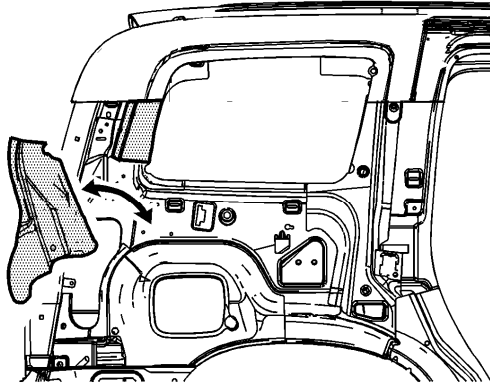
7. Align a sliding square or similar tool to the top portion of the notch and scribe a line across the reinforcement.



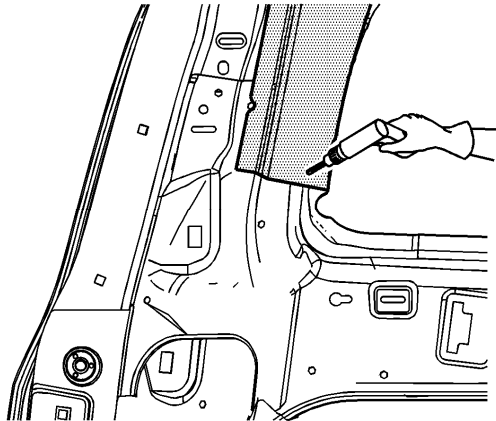
8. Use the same tool to transfer this scribed line onto the back side of the reinforcement.



9. Cut at the marked location.



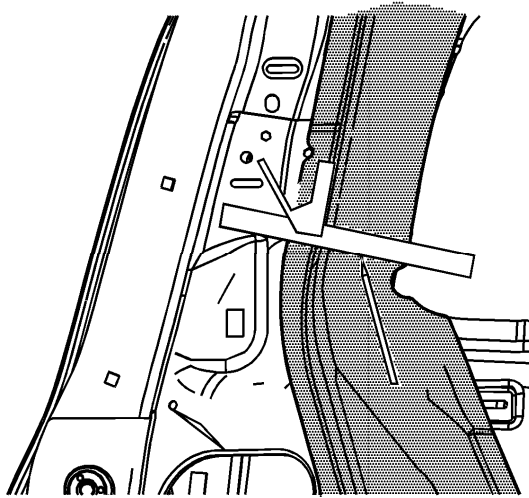
10. Remove the damaged component from the vehicle.



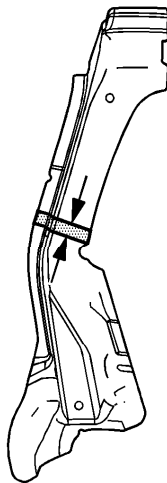
11. Drill 2 8 mm (5/16 in) plug weld holes on each of the 2 sides of the reinforcement.
Position the center of the holes 10 mm (3/8 in) from the cut edge.

[Installation Procedure](#)

1. Locate the notch on the service part.

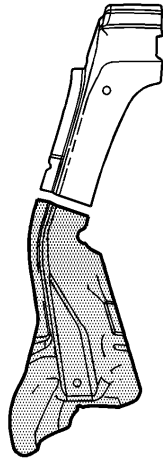


2. Align a sliding square or similar tool to the top of the notch in the window opening pinchweld flange. Scribe a line across the service part.
3. Use the same tool to transfer this scribed line onto the back side of the service part.

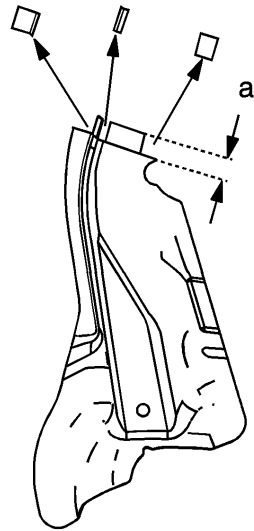


4. Place a mark 25 mm (1 in) above the scribed line on all 2 sides of the service part.
5. Use the tool to scribe a line on all sides of the service part.

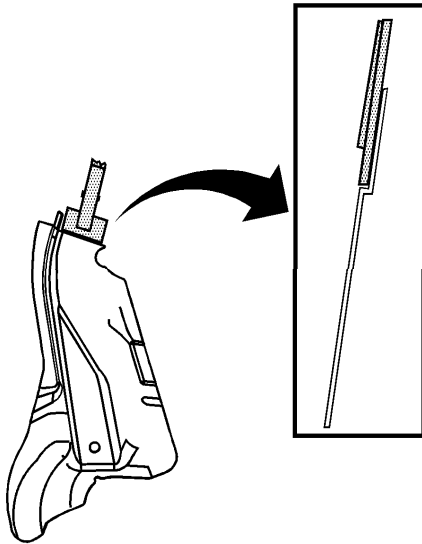
- Cut at the top scribed line created on the service part.



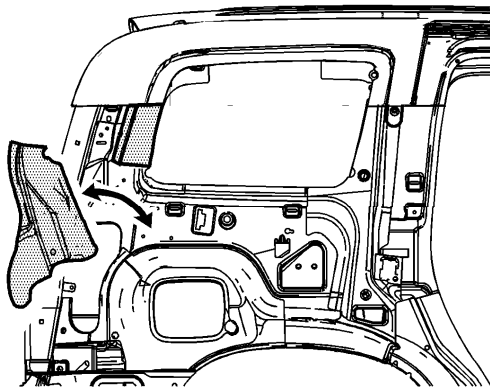
- Remove the service part portion of the reinforcement.



- Cut the upper outer flanges of the reinforcement at the section joint on the service part. Cut the flanges (a) down 25 mm (1 in) and remove the tabs.
- Cut the radius corner (b) of the service part down 25 mm (1 in) also and remove the small corner piece.



10. Bend the bottom side of the service part at the sectioning location inward slightly by aligning a vice grip flanging tool or similar tool at the lower scribed line at the top of the notch.
11. Prepare the service part for welding.
12. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



Important: The service part sectioning joint is to go inside the original reinforcement with a 25 mm (1 in) overlap.

13. Position the rear rail section using 3-dimensional measuring equipment. Clamp the service part in place.

14. Tack weld the part into position.
15. Inspect the service part for proper dimensions, using 3-dimensional measuring equipment.
16. Plug weld at each 8 mm plug weld hole location.
17. Stitch weld along the entire sectioning joint. Make welds along the seam with 25 mm (1 in) gaps between. Weld the gaps.
18. Clean and prepare the welded surfaces.
19. Install all of the related panels and components.
20. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
21. Paint the repaired area. Refer to [Anti-Corrosion Treatment and Repair](#) .
22. Enable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) .
23. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) .