

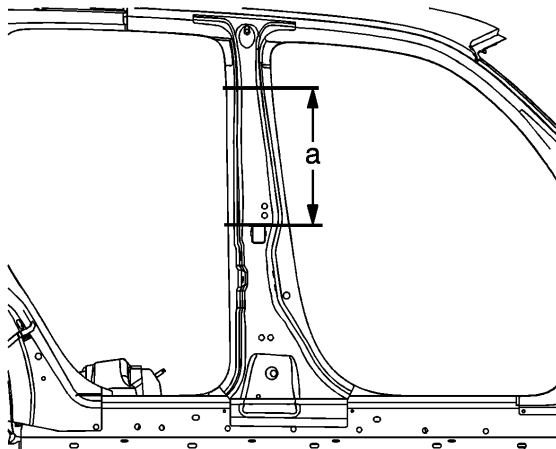
Body Lock Pillar Outer Panel Reinforcement Sectioning

Removal Procedure

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

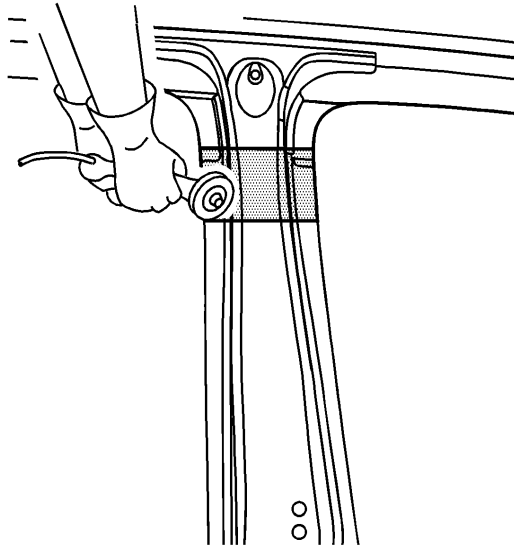
Caution: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) .
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 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](#) .



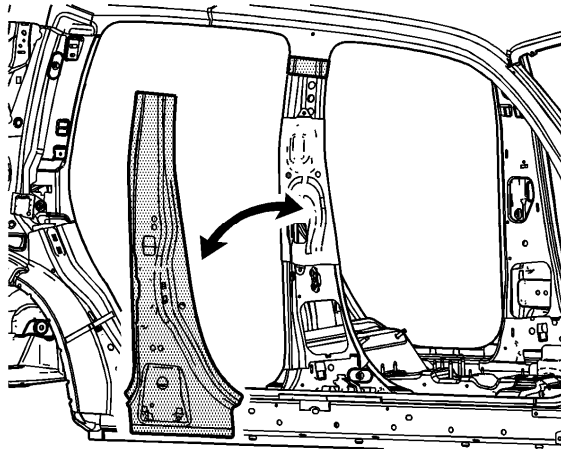
6. Measure up from the top of the square hole 395 mm (15.75 in) and mark location.

7. At the marked location, transfer a line across the reinforcement.



Important: Do not damage any inner reinforcements.

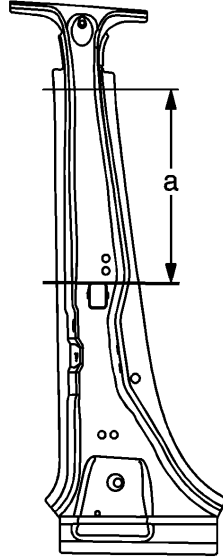
8. Cut the panel at the mark made previously.
9. Locate and drill out all factory welds. Note the number and location of the welds for installation of the service part.



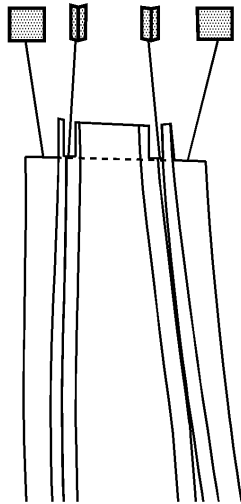
10. Remove the damaged center pillar.

[Installation Procedure](#)

1. On the service part, measure up from the top of the square hole 420 mm (16.75 in) and mark the location.
2. At the marked location, transfer a line across the reinforcement.



3. Cut the replacement service part at the marked line 420 mm (19.75 in) (a).



4. At the cut area of the service part (a), notch the weld flange areas down 25 mm (1 in).
5. Step flange all 3 sides that will extend up inside the original panel by 25 mm (1 in).
6. Drill 8-mm (5/16-in) plug weld holes along the sectioning cut on the original reinforcement. Locate these holes 10 mm (1/2 in) from the edge.

7. Drill 8-mm (5/16-in) plug weld holes in the service part as necessary in the corresponding locations noted on the original panel.
8. Prepare all mating surfaces for welding as necessary.
9. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .
10. Slide the top sectioning joint together by sliding the service part under the original part at the sectioning area.
11. Position the service part on the vehicle using 3-dimensional measuring equipment. Clamp the part in place.
12. Plug weld accordingly.
13. To create a solid weld with minimum heat distortion, make 25 mm (1 in) stitch welds along the sectioning joint seam with gaps of 25 mm (1 in). Go back and complete the stitch weld.
14. Clean and prepare all of the welded surfaces.
15. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
16. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
17. Install all of the related panels and components.
18. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
19. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .