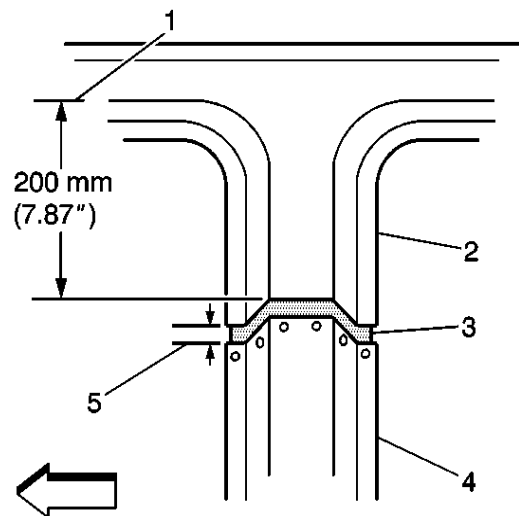


Center Pillar Replacement

Removal Procedure

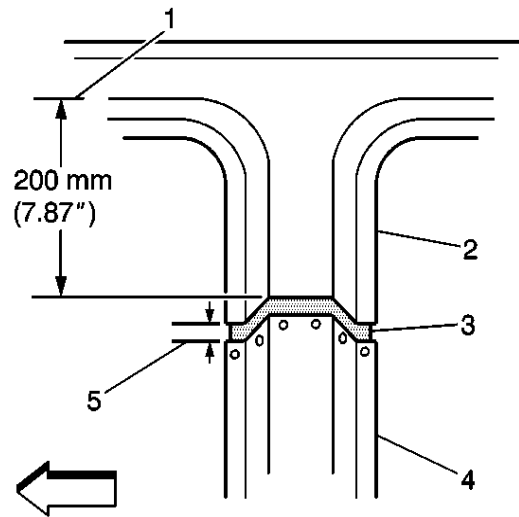
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.



1. Visually inspect and restore as much of the damage as possible to factory specifications.
2. Remove all related panels and components.
3. Position all wiring out of the way to prevent damage.
4. Remove sealers and anti-corrosion materials as necessary.
5. On the original outer door frame (2) measure down from the lower edge (1) of the door opening 200 mm (8 in) and mark a horizontal line.
6. Cut the outer door frame along this line for sectioning. Do not cut into the inner reinforcement.
7. Locate and mark all factory welds. Note the number and location of welds for installation of the service section.
8. Drill out all factory welds as necessary.

9. Perform additional sectioning procedures as necessary to remove the center lock pillar.
10. Remove the damaged section of the door frame opening (4).

Installation Procedure



1. On the service part (4), mark a horizontal line to leave a gap of $1\frac{1}{2}$ times the thickness of the metal (5) at the sectioning joint.
2. Cut the service panel along this line.
3. Drill 8 mm (5/16 in) holes for plug welding in the service part (4) in the locations noted from the original panel.
4. Drill holes for plug welding long the sectioning cuts on the services part.
5. Locate these holes approximately 13 mm (17/32 in) from the edge of the sectioning cuts.
6. Prepare the mating surfaces as necessary. Position the service part using three-dimensional measuring equipment.
7. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
8. Plug weld accordingly.
9. Use the inner reinforcement (3) as a backing plate and stitch weld along the entire sectioning joint.
10. Make 25 mm (1 in) welds along the seam with 25 mm (1 in) gaps between.
11. Go back and complete the stitch weld. This will create a solid joint with minimal heat distortion.
12. Complete all other welds and sectioning procedures as necessary.

13. Clean and prepare welded surfaces.

Important: Prior to refinishing, refer to GM 4901MD-99 Refinish Manual for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

14. Prime with 2-part catalyzed primer.

15. Apply sealers and anti-corrosion materials as necessary.

16. Install all related panels and components.