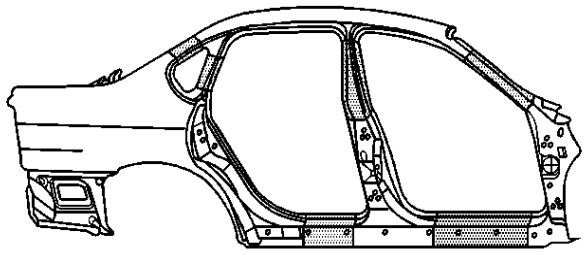
General Door Frame Opening Sectioning

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.
2. Remove all related panels and components.
3. Remove sealers and anti-corrosion materials as necessary.
4. Cut the panel in the areas where the sectioning is to take place. Sectioning should take place in shaded areas only.

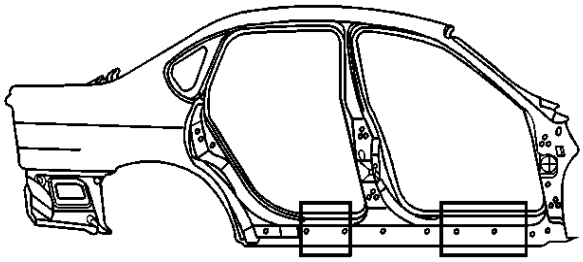
   Important: Use care not to cut the inner reinforcements when cutting the outer door opening frame.

5. Locate and mark all factory welds. Note the number and location of welds for installation of the service assembly.
6. Drill out all factory welds.

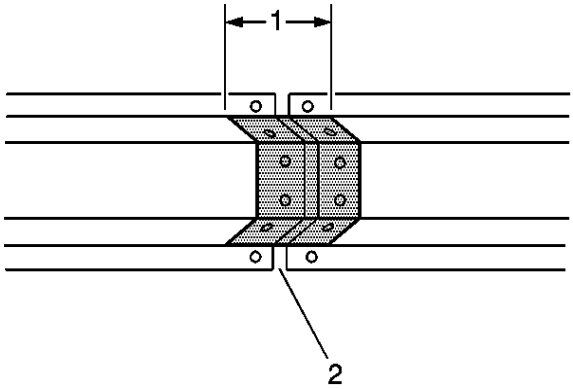
   Important: Note the location of the sound deadening foam for installation.

7. Remove the damaged outer door opening frame.

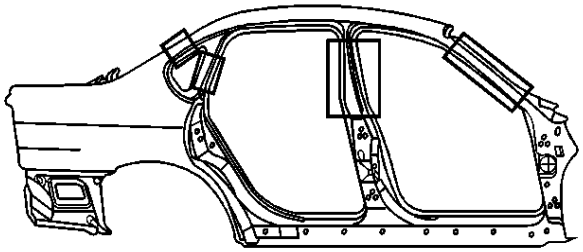
Installation Procedure



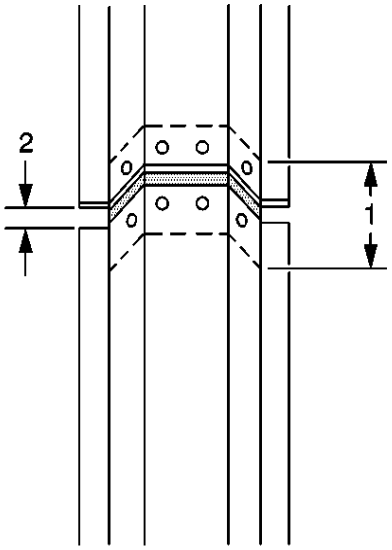
Important: Sectioning in the rocker locations requires the use of a 100 mm (4 in) backing plate.



1. On the service part, mark a line to leave a gap of one and one-half times the thickness of the metal at the sectioning joint (2).
2. Cut the outer door frame opening service part along this line.
3. Cut a 100 mm (4 in) piece (1) from the unused portion of the service part for a backing plate when sectioning in the rocker areas of the door frame opening.



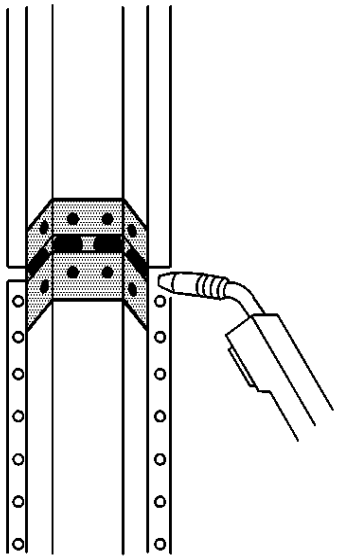
4. Sectioning in the A, B, or C pillars of the outer door frame opening requires the use of a 50 mm (2 in) backing plate.



5. Cut a 50 mm (2 in) piece (1) from the unused portion of the service part for a backing plate, leaving a gap of 1½ times the thickness of the metal (2).

Important: When sectioning the outer door frame at the lower front hinge pillar of at the center lock pillar, the inner reinforcement panel can be used as a backing plate.

6. Drill 8 mm (5/16 in) holes for plug welding in the service part in the locations noted from the original panel.
7. Drill holes for plug welding along the sectioning cuts on both the service part and the original panel.
8. Prepare the mating surfaces as necessary. Position the backing plates on the body with 50 percent of the backing plate exposed.
9. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.
10. Plug weld accordingly.
11. Position the service part to overlap the exposed 50 percent of the backing plate.
12. Check the fit using 3-dimensional measuring equipment.
13. Plug weld accordingly.



14. Stitch weld along the entire sectioning joint.
15. Make 25 mm (1 in) welds along the seam with 25 mm (1 in) gaps between.
16. Go back and complete the stitch weld. This will create a solid joint with minimal heat distortion.
17. Complete all other welds and sectioning procedures as necessary.
18. 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.

Important: Apply the sound deadening foam in the locations noted from the removal process.

19. Prime with 2-part catalyzed primer.
20. Apply sealers and anti-corrosion materials as necessary.
21. Install all related panels and components.