

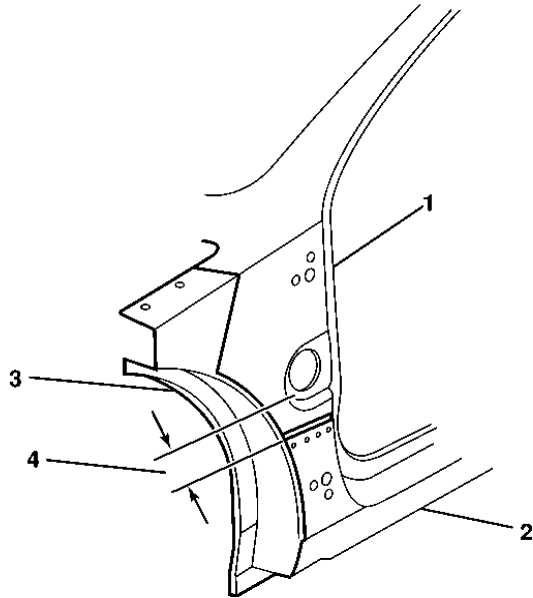
Front Hinge Pillar Sectioning

Removal Procedure

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

Important: Do not cut adjacent panels.

Important: Follow general sectioning for the outer rocker panel. Sectioning should take place in shaded areas only. There are key structural areas on the outer rocker panel where sectioning should not be performed. Sectioning in these areas may compromise the structural integrity of the vehicle.



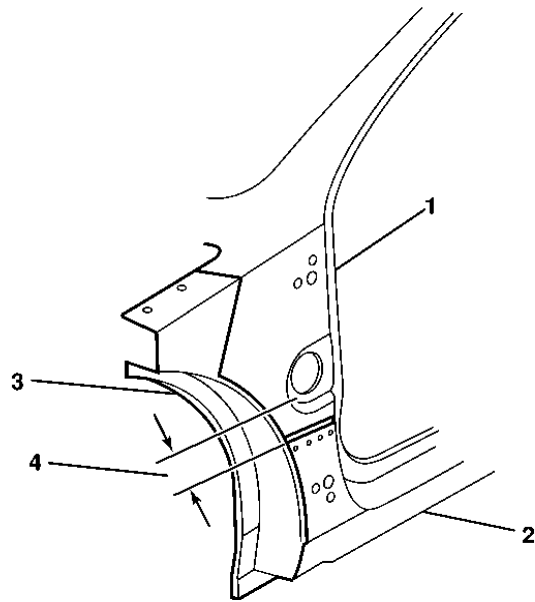
1. Visually inspect and restore as much of the damage as possible to factory specifications.
2. Remove all related panels and components.
3. Position all wiring out of the way to prevent damage and for best access to vehicle.
4. Remove all sealers and anti-corrosion materials as necessary.

5. On the original outer door frame (1) measure down 50 mm (2 in) from the large wiring harness hole in the pillar and mark a horizontal line (4).
6. Cut the outer door frame along this line for sectioning.
7. Perform additional sectioning procedures as necessary to remove damaged areas of the door frame opening.
8. Locate and mark all factory welds. Note the number and location of welds for installation of the service part.
9. Drill out all factory welds as necessary.

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

10. Remove the damaged section of the outer door frame opening (2).

Installation Procedure



1. On the service part (2), mark a horizontal line to leave a gap of 1 ½ times the thickness of the metal at the section joint.
2. Cut the service panel along this line.
3. Drill 8 mm (5/16 mm) holes for plug welding in the service part in the locations noted from the original panel.
4. Drill holes for plug welding along the sectioning cut on the service part. Locate these holes approximately 13 mm (½ in) from the edge of the sectioning cut.
5. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
6. Use the inner reinforcement (3) as a backing plate.

7. Stitch weld along the entire joint with 25 mm (1 in) welds along the seams with 25 mm (1 in) gaps between.
8. Go back and complete the stitch weld. This will create a solid joint with minimal heat distortion.
9. Complete all other welds and sectioning procedures as necessary.
10. 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.

11. Prime with 2-part catalyzed primer.

Important: It is necessary to apply the sound-deadening foam in the locations as noted from removal.

12. Apply sealers and anti-corrosion materials as necessary.
13. Install all related panels and components.