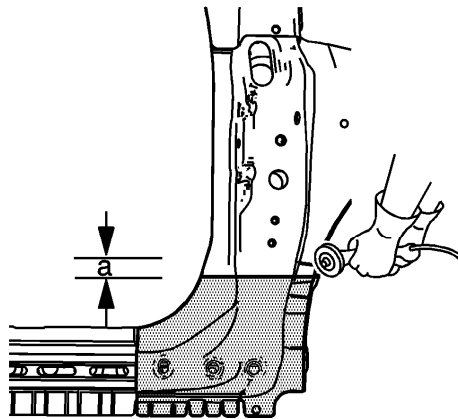


Front Inner Hinge Pillar Reinforcement Sectioning

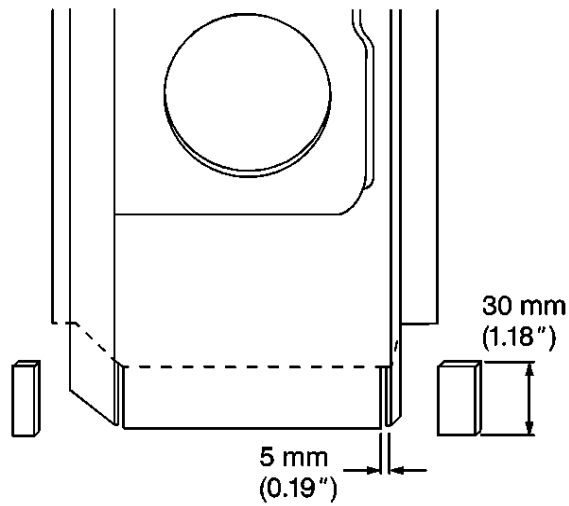
Removal Procedure

1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .
5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
6. Remove the front outer hinge pillar. Refer to [Front Hinge Pillar Sectioning](#) .

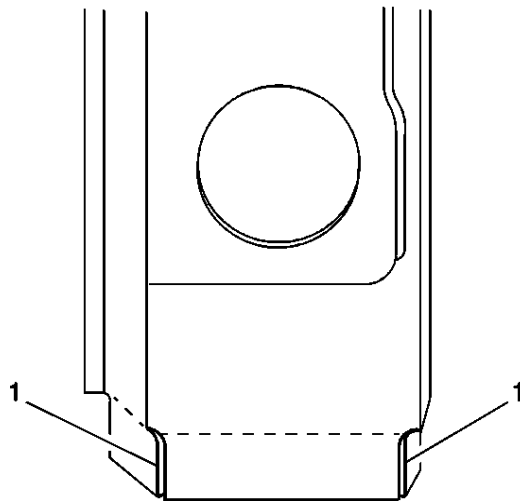


7. On the original reinforcement panel, measure 50 mm (2 in) down from the body line and mark a horizontal line (a).
8. Cut the inner reinforcement along this line.
9. Locate, mark, and drill out all factory welds, as necessary. Note the number and location of welds for installation of the service part.
10. Remove the damaged section of the inner reinforcement.

Installation Procedure

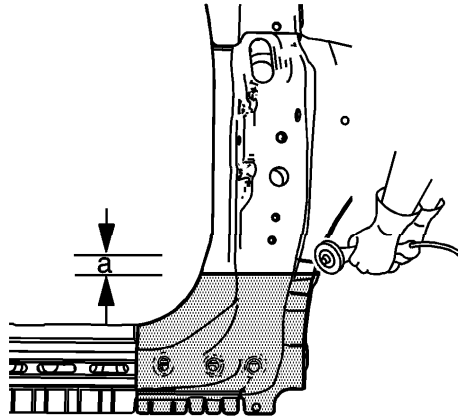


1. Cut and remove 30 mm (1 3/16 in) from the flanges on either side of the remaining section of the original hinge pillar to create a 30-mm (1 3/16-in) flange.
2. Cut 5-mm (3/16-in) wide gaps in the bottom corners.

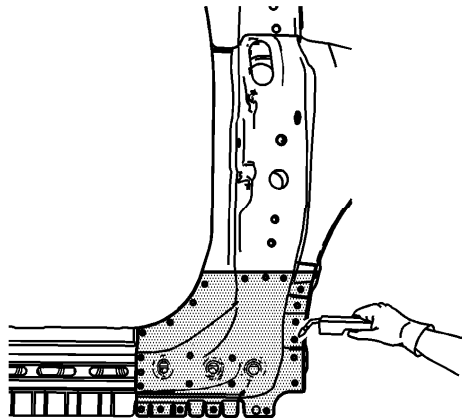


3. Step the tabs inward to allow the door frame inner reinforcement service section to fit over the original inner reinforcement.

4. Weld the tabs together along the edges (1).

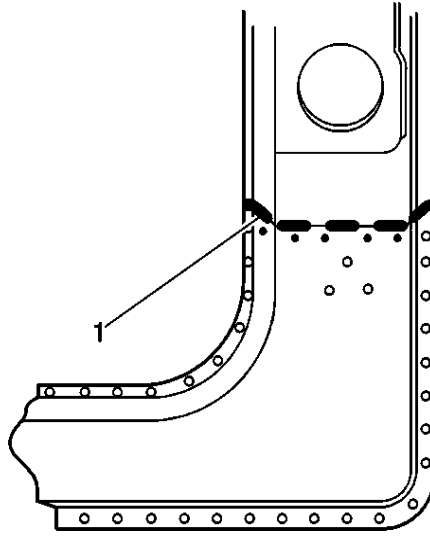


5. On the service part measure 20 mm (1 in) down from the body line and mark a horizontal line (a).
6. Cut the hinge pillar reinforcement along this line.



7. Drill 8-mm (5/16-in) plug weld holes as necessary in the locations noted from the original panel.
8. Drill plug weld holes along the sectioning cut of the service part. These holes should be located approximately 15 mm (9/16 in) from the edge of the cut.
9. Prepare mating surfaces and position the service section over the stepped tab on the original inner reinforcement allowing 30 mm (1 3/16 in) of overlap.

10. Plug weld accordingly.



11. Stitch weld along the entire joint with 25 mm (1 in) gaps between the welds (1).
12. Go back and complete the stitch weld. This will create a solid joint with minimal heat distortion.
13. Install the front outer hinge panel. Refer to [Front Hinge Pillar Sectioning](#) .
14. Clean and prepare all welded surfaces.
15. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
16. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
17. Install all related panels and components.
18. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
19. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.