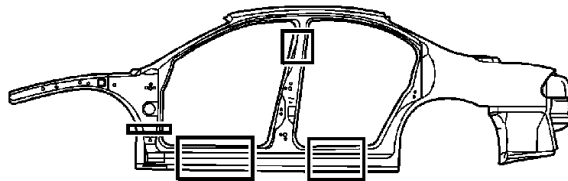


# Outer Door Frame Sectioning

## Removal Procedure

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

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](#).

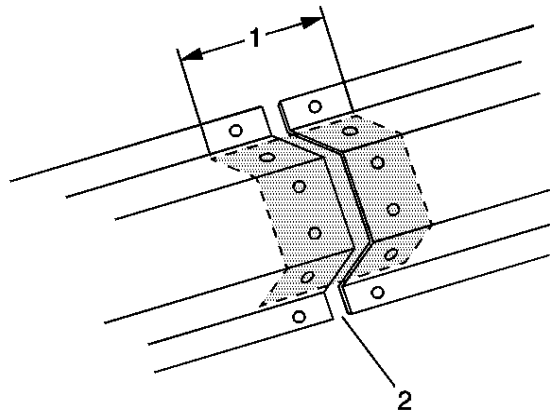
**Caution:** Refer to [Foam Sound Deadeners Caution](#) in Cautions and Notices.

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/Coatings.
6. Remove the radiator support. Refer to [Radiator Support Replacement](#).
7. Cut the panel in the areas where the sectioning is to take place. Sectioning should be performed in recommended areas only.

**Important:** Use care not to cut the inner reinforcement when cutting the outer door frame.

8. Locate, mark and drill out all factory welds. Note the number and location of welds for installation of the service assembly.
9. Remove the damaged outer door frame opening.

## Installation Procedure



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

1. On service part, mark a horizontal 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 (94 in) piece from the unused portion of the service part for a backing plate (1).
4. Remove the flange on each side of the backing plate so that it will fit behind the sectioning joint.
5. Drill 8 mm (5/16 in) holes for plug welding in the service part in the locations noted from the original panel.
6. Drill holes for plug welding along the sectioning cuts on both the service part and the original panel.
7. Locate 3 holes approximately 25 mm (1 in) from the edge of the sectioning cuts.

8. Prepare all mating surfaces as necessary.
9. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces.  
Refer to [Anti-Corrosion Treatment and Repair](#) .
10. Position the service part to overlap the exposed 50 mm (2 in) of the backing plate.
11. Inspect for proper fit. Use 3-dimensional measuring equipment.
12. Plug weld accordingly.
13. Stitch weld along the sectioning joint.
14. Make 25-mm (1-in) welds along the seam with 25 mm (1 in) gaps between.
15. Go back and complete the stitch weld. This will create a solid joint with minimal heat distortion.
16. Complete all other welds and sectioning procedures as necessary.
17. Clean and prepare welded surfaces.
18. Apply the sealers and anti-corrosion materials to the repair area, as necessary.  
Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
19. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint/Coatings.
20. Install all related panels and components.
21. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
22. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.