

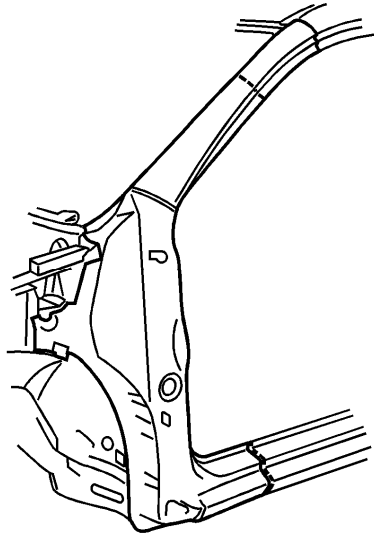
# Hinge Pillar Replacement - Front

## Removal Procedure

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

**Important:** When replacing panels that involve servicing of stationary glass, refer to [Urethane Adhesive Installation of Stationary Windows](#) before performing any priming or refinishing.

1. Disable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.

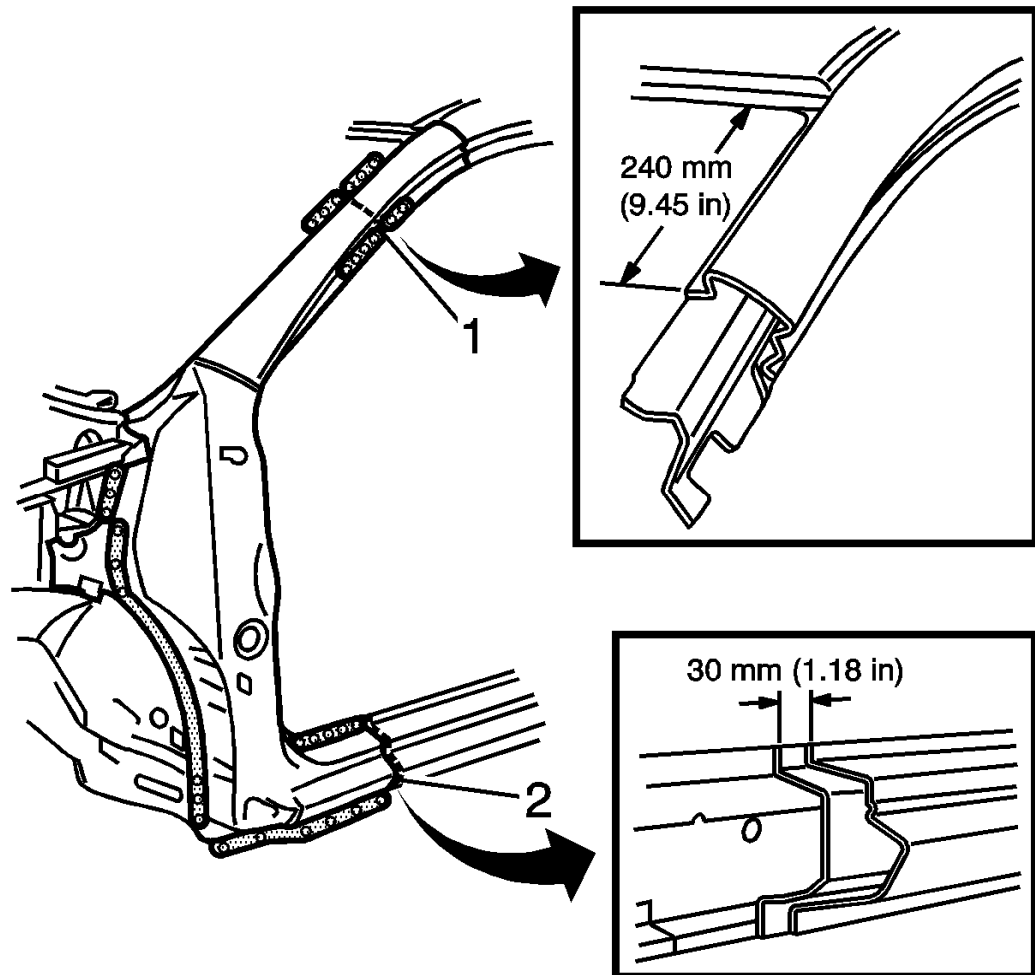


3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#).

**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 and Coatings.

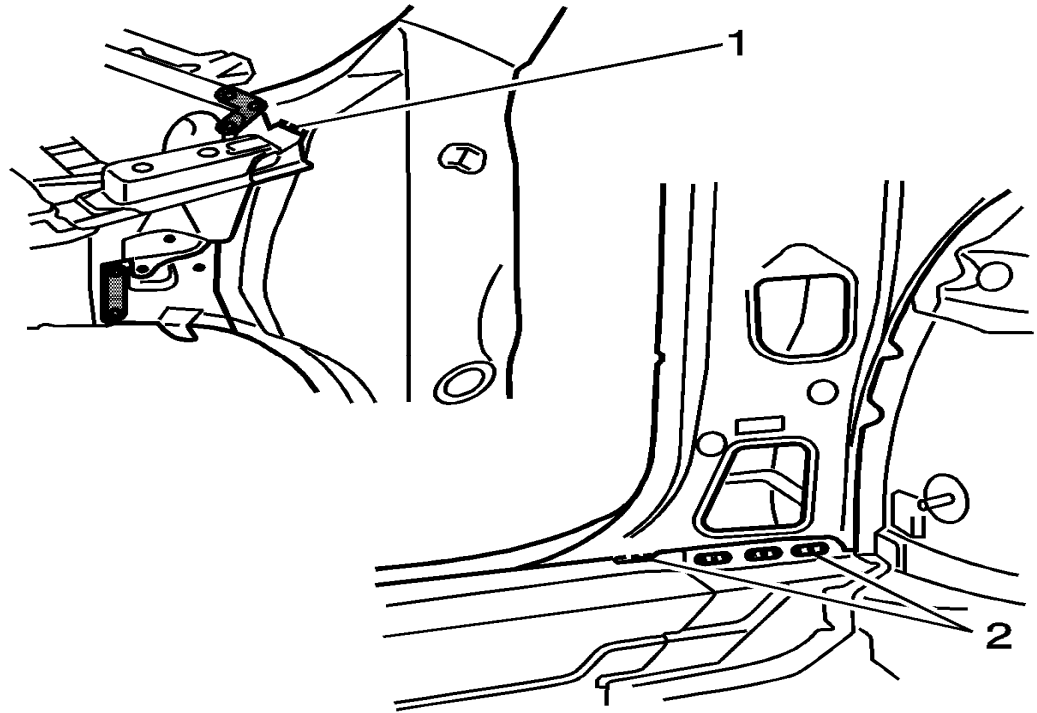
6. Perform the necessary procedures to gain access to repair. Refer to [Rail Replacement - Upper](#) .
7. Position all wiring out of the way to prevent damage and for best access to vehicle.



8. Select a cutting point (1) on the hinge pillar approximately 200 mm (9.45 in) from the bottom of the windshield flange.
9. At the selected point, cut through the outer panel, leaving the inner panel intact.
10. Cut through the rocker panel section of the door opening frame assembly. The cut point (2) should be referenced with the service part.

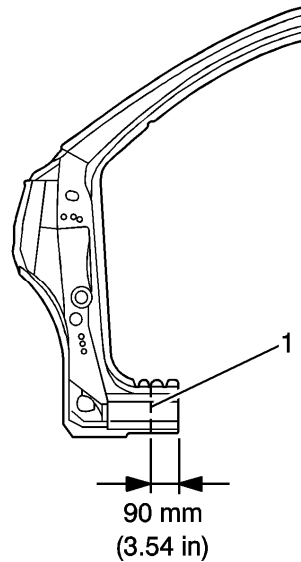
**Important:** Note the location of the sound deadening foam for installation.

11. Locate and drill out all factory welds. Note the number and location of welds for installation of the front hinge pillar.

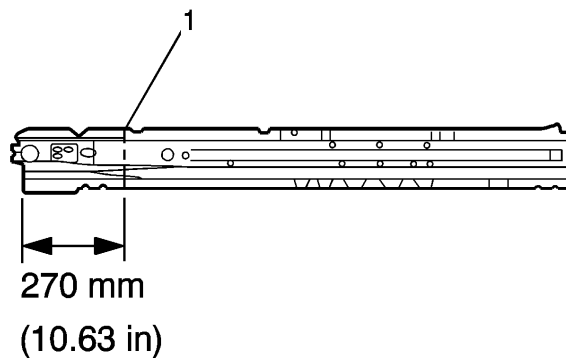


12. Make a cut to the upper pillar as shown (1).
13. Make a cut to the lower part of the pillar as shown (2).
14. Drill out all remaining factory welds as necessary.
15. Remove the damaged section of the outer hinge pillar.

## Installation Procedure



1. On the service part, make a cut (1) 90 mm (3.54 in) from the edge, save this piece, it will be needed later in repair procedure.

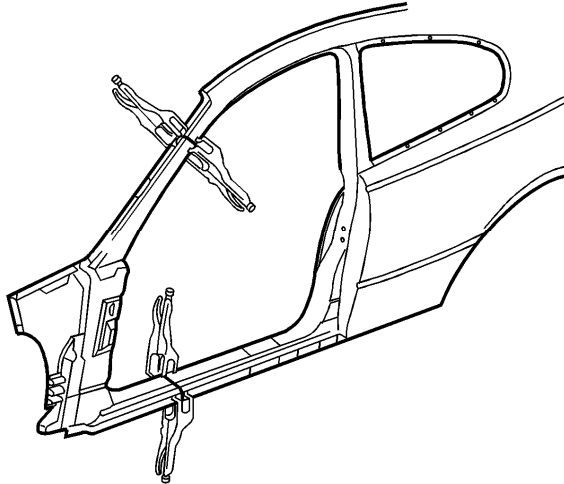


2. Remove a section of inner rocker panel (2). Cut 270 mm (10.63 in) from the area as shown.

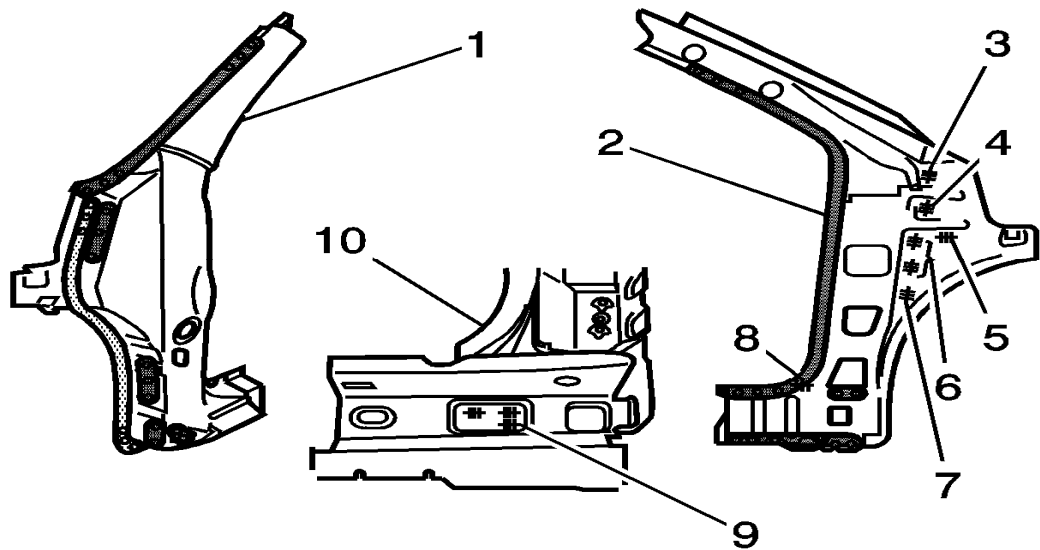
**Important:** If the location of the original plug weld holes can not be determined, or if structural weld-thru adhesive is present, space the plug weld holes every 40 mm (1½ in) apart.

3. Drill 8 mm (5/16 in) plug weld holes as necessary in locations noted from the original panel.

4. Prepare all mating surfaces as necessary.
5. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces.  
Refer to [Anti-Corrosion Treatment and Repair](#).

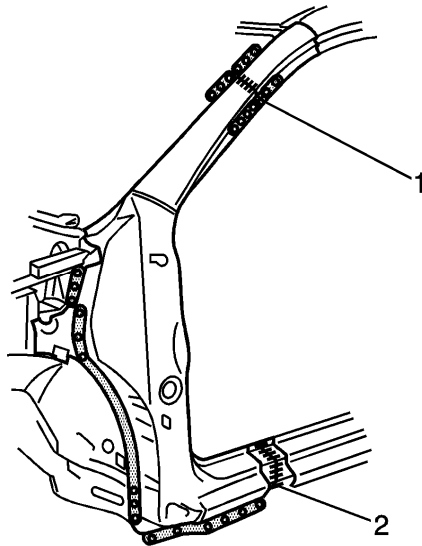


6. Clamp the replacement panel in position on the vehicle and check the door opening dimensions. Refer to [Dimensions - Body](#).

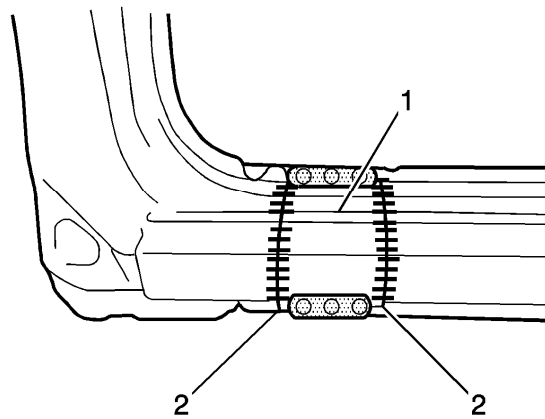


7. Tack weld the inner pillar upper (2), and lower (10) areas (3), (4), (5), (6), (7), (8), and (9) accordingly.

8. Plug weld accordingly.

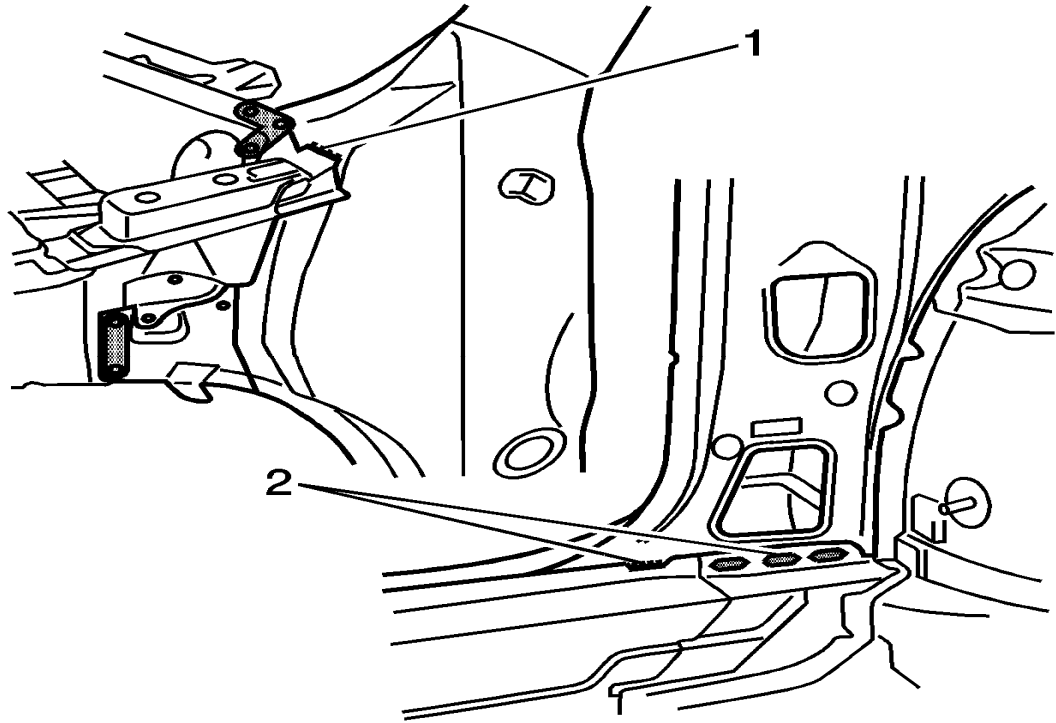


9. Stitch weld along the upper pillar (1) and the rocker panel reinforcement (2).
10. Make 25 mm (1 in) welds along the seams with 25 mm (1 in) gaps between.
11. Go back and complete the stitch weld to create a solid weld joint with minimal heat distortion.



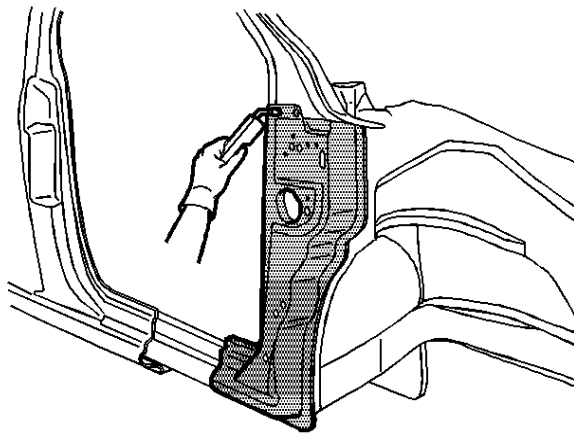
12. Position the cut-out (1) from the service part, to the rocker panel.
13. Stitch weld along the seams (2).
14. Make 25 mm (1 in) welds along the seams with 25 mm (1 in) gaps between.
15. Go back and complete the stitch weld to create a solid weld joint with minimal heat distortion.

16. Plug weld the upper and lower area accordingly.



17. Complete the remaining tack welds.

18. Complete the remaining plug welds.



19. Plug weld accordingly.

20. Complete the necessary procedures. Refer to [Rail Replacement - Upper](#) .

21. Clean and prepare all welded surfaces.

22. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
23. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
24. Install all related panels and components.
25. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.
26. Enable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.