

# Front Hinge Pillar Body Replacement (Sedan)

## Removal Procedure

**Caution:** Refer to [Approved Equipment for Collision Repair Caution](#) in the Preface section.

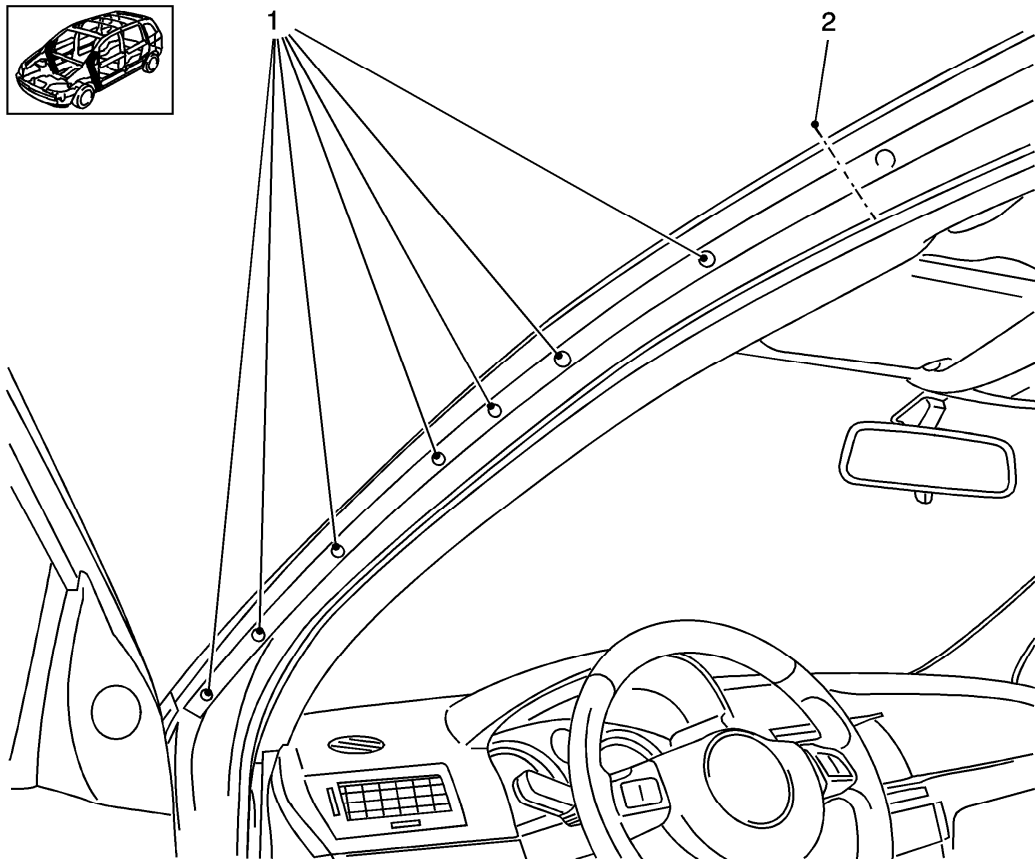
**Caution:** Refer to [Glass and Sheet Metal Handling Caution](#) in the Preface section.

**Caution:** Refer to [Collision Sectioning Caution](#) in the Preface section.

1. Disable the SIR system.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#)

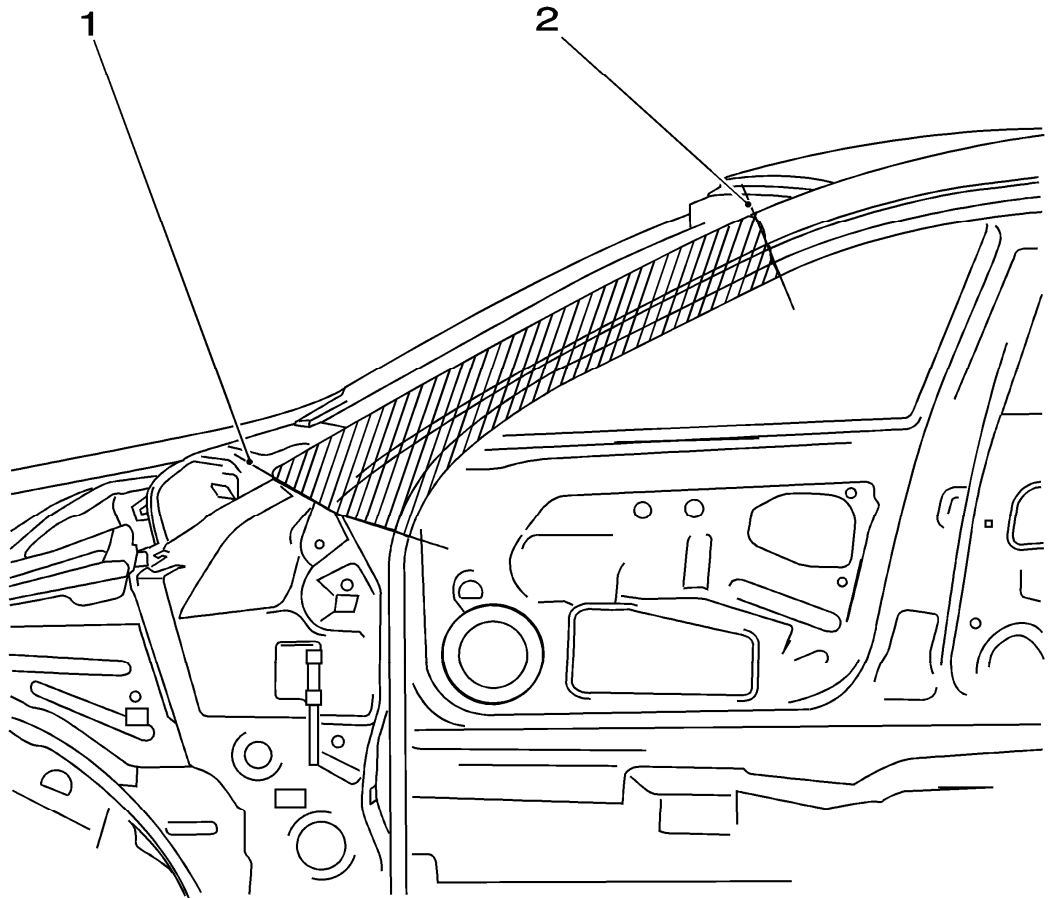
**Caution:** Refer to [Foam Sound Deadeners Caution](#) in the Preface section.

5. Note the locations and remove the sealers and anti-corrosion materials from the repair area as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .

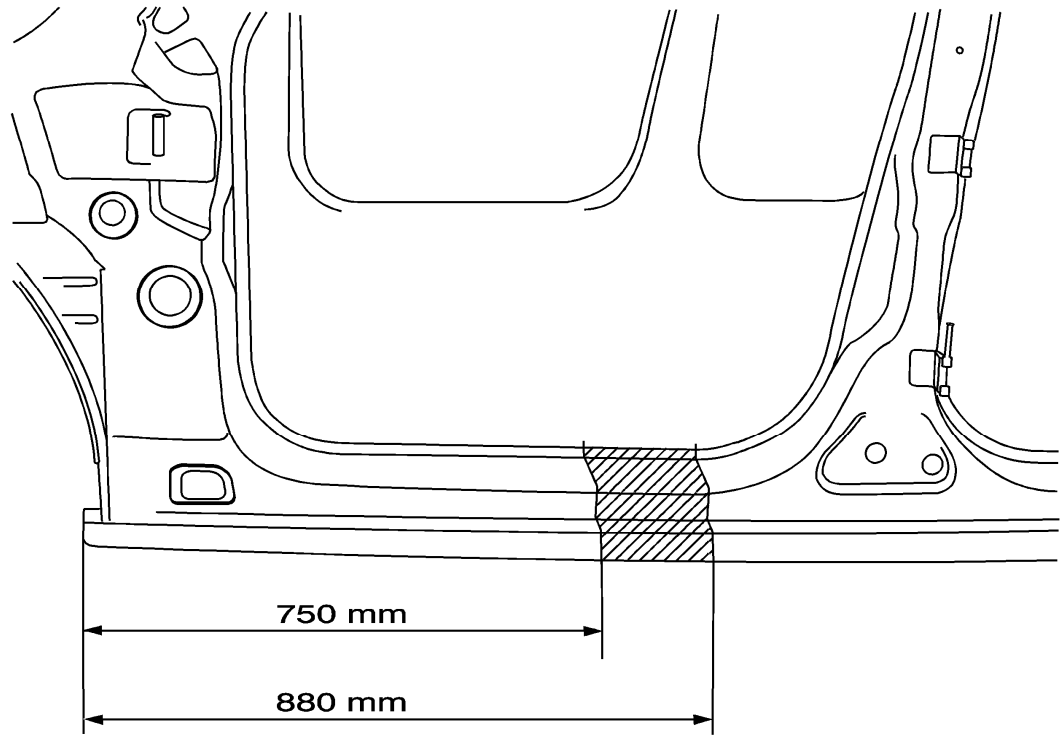


6. Locate and drill out welds (1) securing mounting strip to roof rail.

7. Section mounting strip approximately 100 mm (5 in) from the 7th spot weld (2).



8. Section roof rail in locations (1) and (2) as shown.
9. Locate and drill out factory welds along roof rail section. Note the number and location for installation.

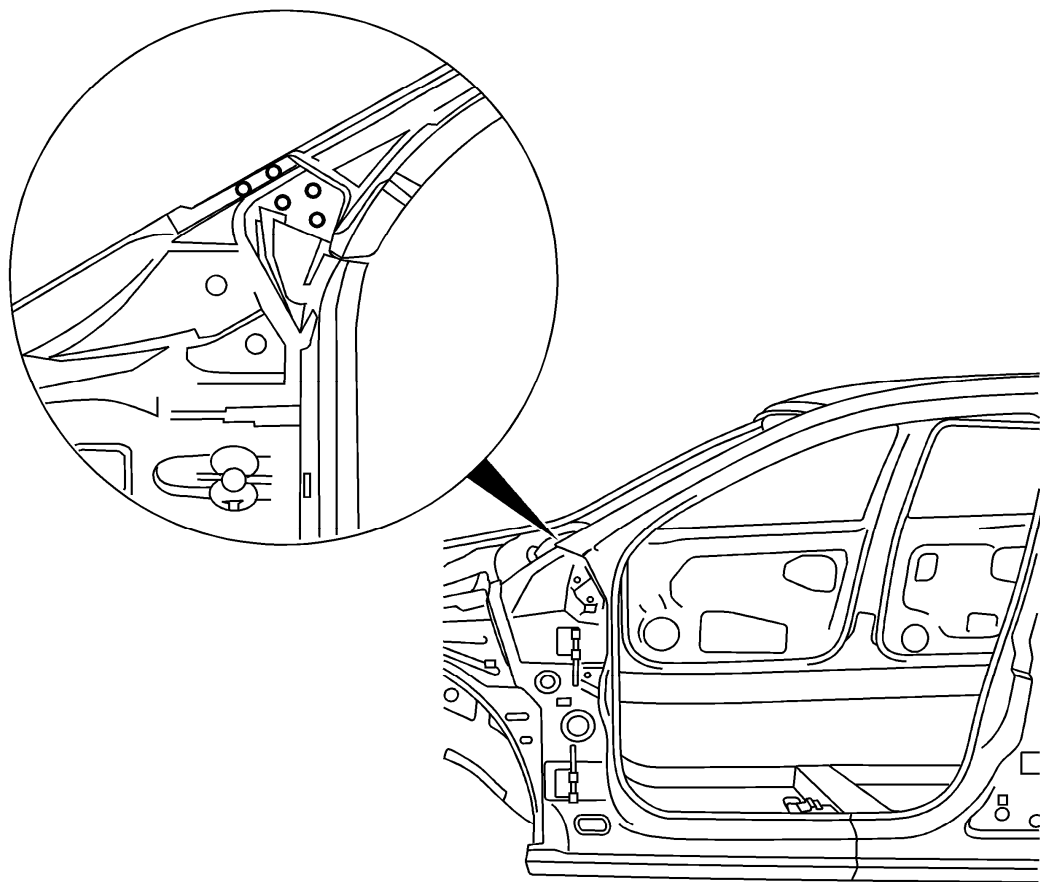


**Important:** Do not damage any inner panels or reinforcements.

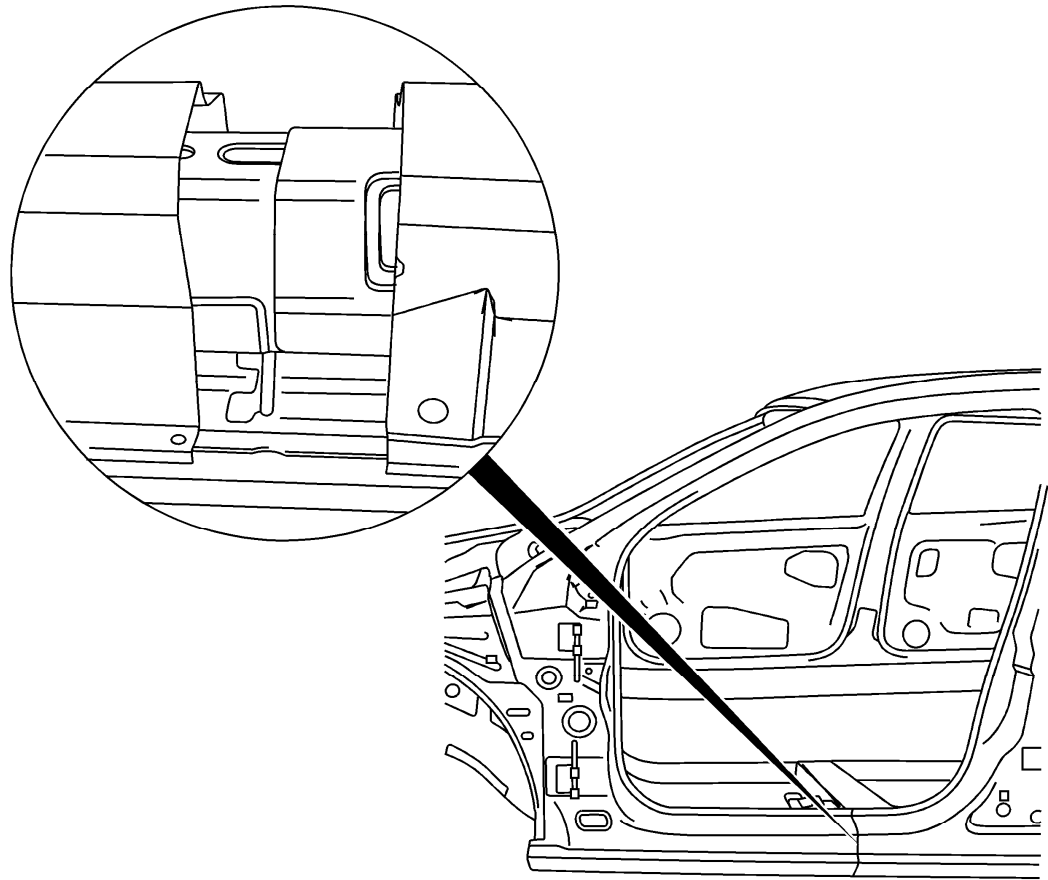
**Important:** A window must be cut into the rocker outer panel to gain access to the pillar reinforcement welds. This panel must be reused, do not damage.

10. Cut access window in locations shown.

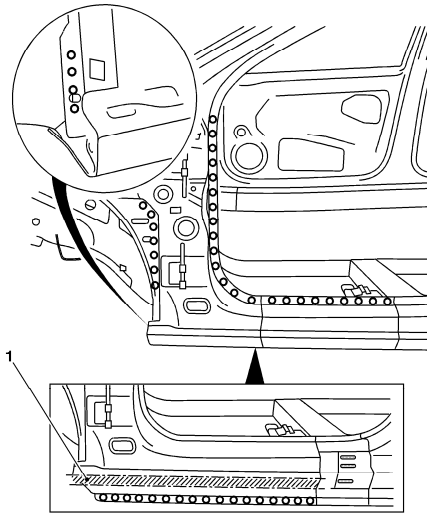
11. Locate and drill out welds and remove panel.



12. Locate and drill out welds at top of hinge pillar.



13. Locate and drill out welds at rear pillar reinforcement.

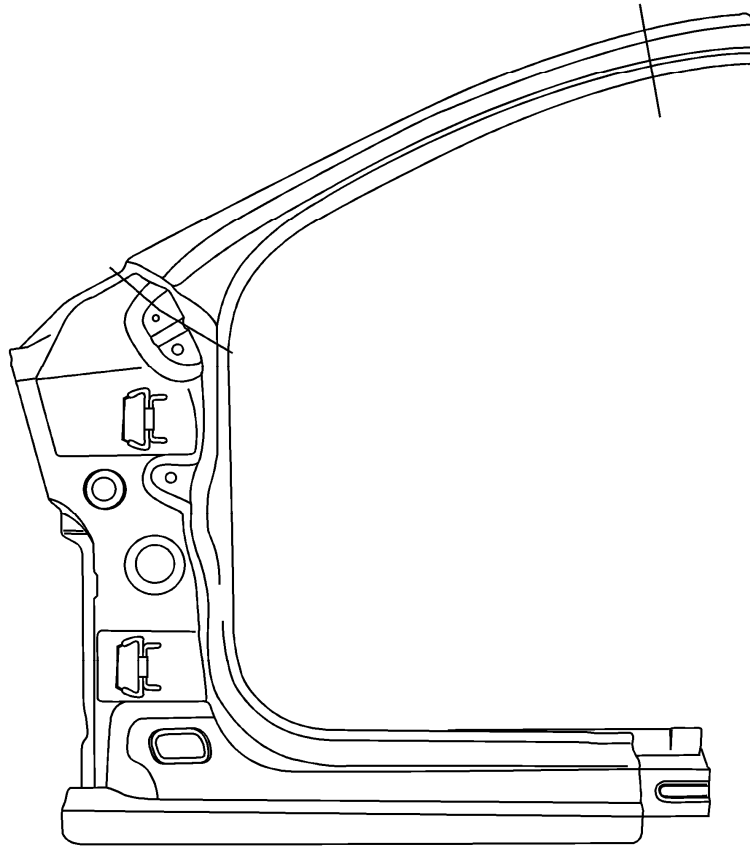


**Important:** For easier access to the row of spot welds on the lower sill, an area of the rocker panel (1) can be removed.

14. Locate and drill out all factory welds. Note the number and location for installation of the service part.

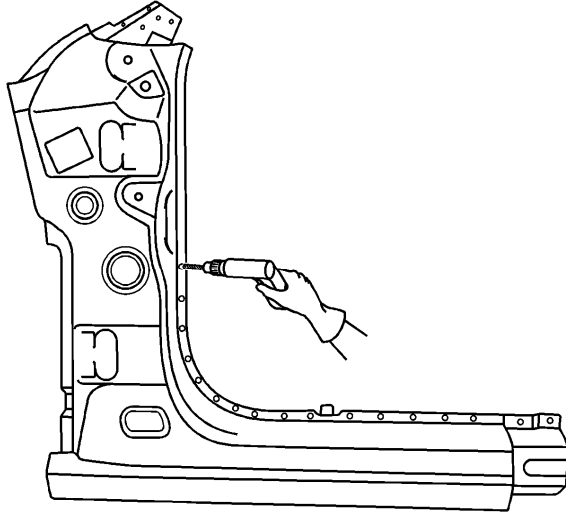
15. Remove the hinge pillar.

## [Installation Procedure](#)



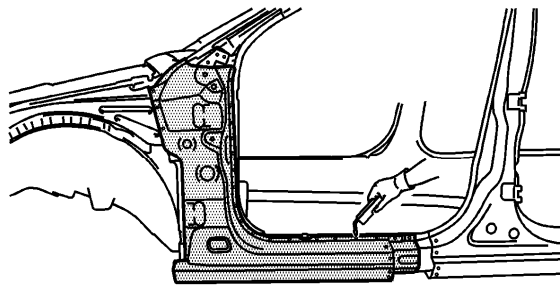
**Important:** The door hinges on the service part are only tack welded. Once the hinge pillar is welded in place, the welds on the hinges need to be completed. Refer to [Front Side Door Hinge Replacement](#) for proper hinge welding when hinge pillar repair procedure is complete.

1. On the service part, cut and remove the roof rail in the areas noted.

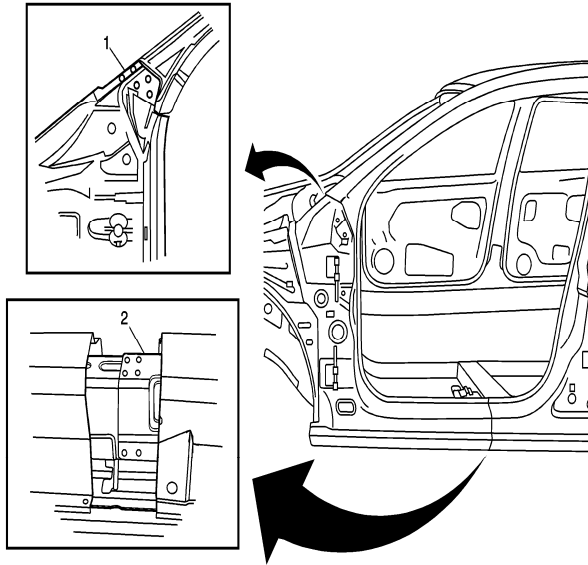


**Important:** If the location of the original welds cannot be determined or if structural adhesive was present, space the plug weld holes every 40 mm (1 ½ in) apart.

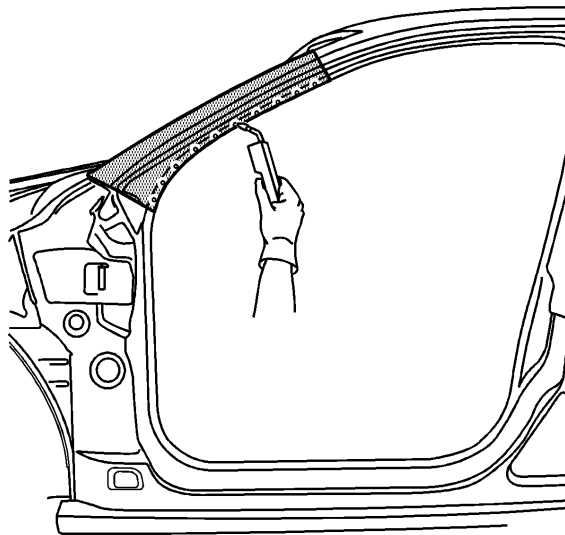
2. Drill 8 mm (5/16 in) plug weld holes in the service hinge pillar (1) in the locations noted from the original panel and along the section cut.
3. Prepare all attachment surfaces as necessary.
4. Apply GM approved Weld-Thru coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



5. Position hinge pillar (1) to the vehicle using 3-dimensional measuring equipment. Clamp in place.
6. Plug weld accordingly.



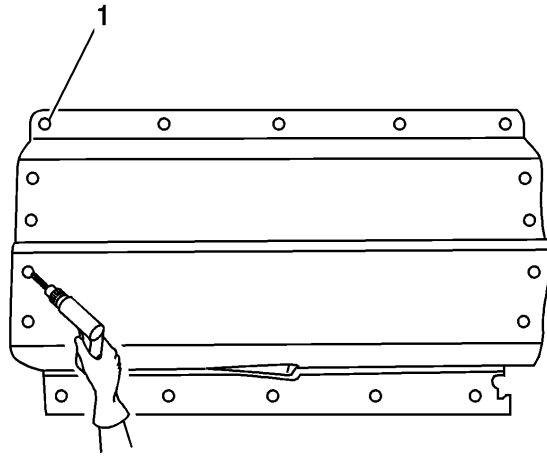
7. Clean and prepare welded surfaces where roof rail (1) and access panel (2) will cover hinge pillar.



8. Position roof rail (1) to vehicle using 3 dimensional measuring equipment. Clamp in place.
9. Plug weld accordingly.

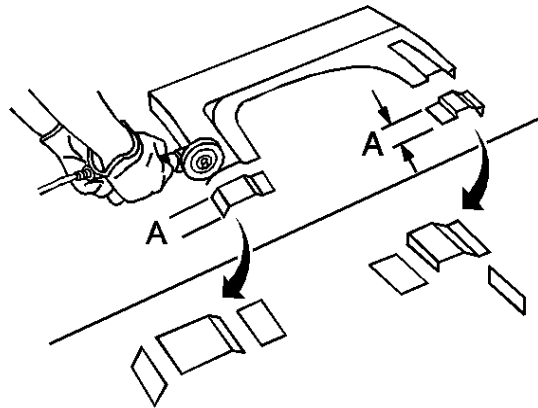
**Important:** To create a solid weld with minimum heat distortion, make 25 mm stitch welds along the seam with 25 mm gaps between them.

10. Complete the stitch weld.

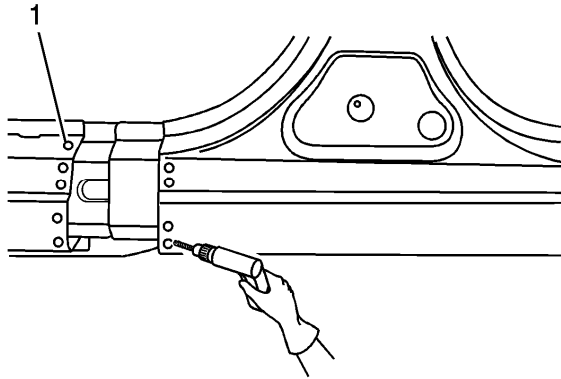


11. Locate the window access panel that was previously removed from the rocker panel.

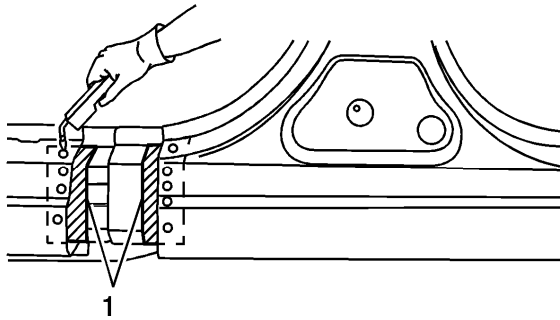
12. Drill 8 mm (5/16 in) plug weld holes (1) along the section joint. Locate holes 13 mm from the edge and spaced every 40 mm apart.



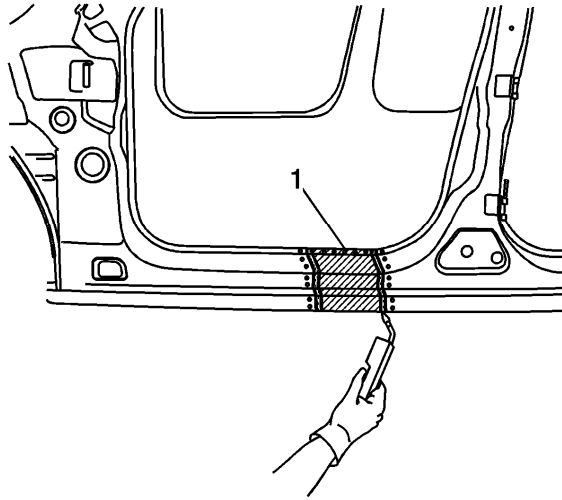
13. Create a 50 mm backing plate (A) from a similar gauge scrap panel. Trim the backing plate as necessary to fit behind the sectioning joint where there is no reinforcements.



14. Drill 8 mm plug weld holes (1) along the sectioning joint. Locate these holes 13 mm from the edge and spaced 40 mm apart.
15. Prepare all attachment surfaces as necessary.
16. Apply GM approved weld-thru coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



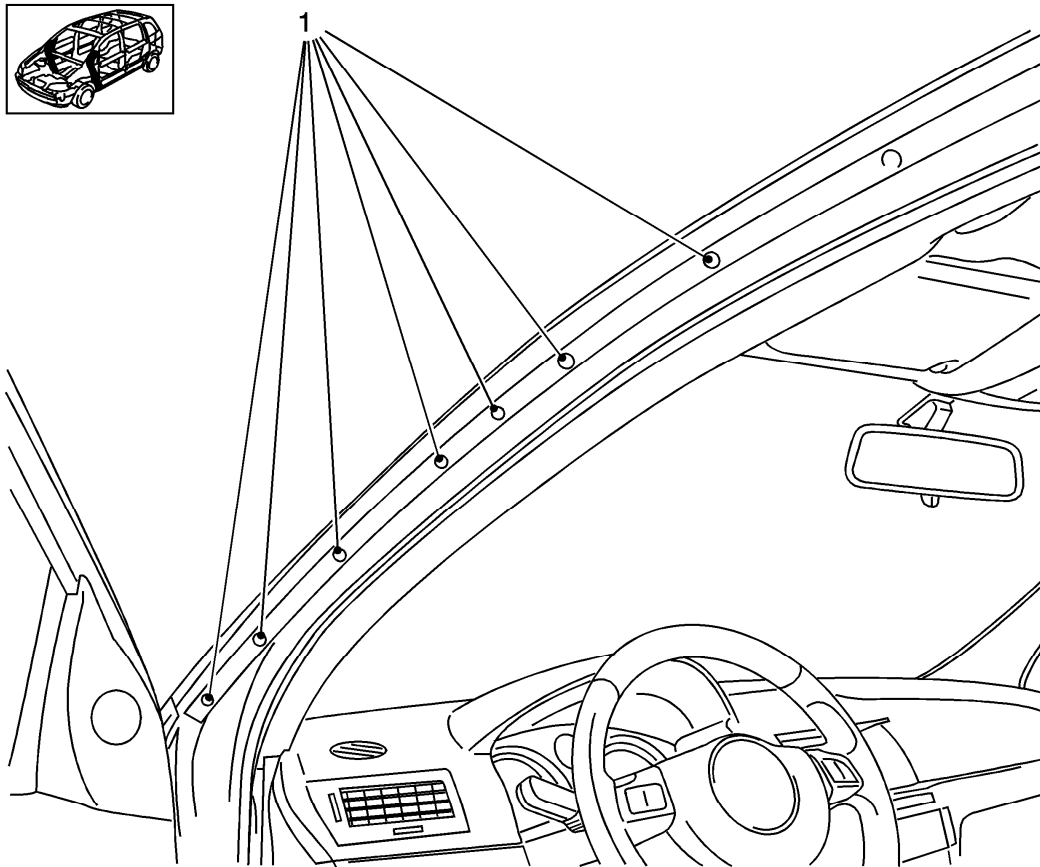
17. Fit the backing plates (1) halfway into the sectioning joint, clamp and plug weld into place.



18. Position the window access panel (1) in place, clamp, and weld accordingly.

**Important:** To create a solid weld with minimum heat distortion, make 25 mm stitch welds along the seam with 25 mm gaps between them. Then go back and complete the weld.

19. Stitch weld the joint.



20. Position door seal mounting strip and clamp in place.
  21. Plug weld accordingly.
  22. MIG weld sectioning joint.
  23. Adjust doors and weld hinges in place. Refer to [Front Side Door Hinge Replacement](#) .
  24. Clean and prepare all welded surfaces.
  25. Apply the sealers and anti-corrosion materials to the repair area as necessary.  
Refer to [Anti-Corrosion Treatment and Repair](#) .
  26. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
  27. Install all related panels and components.
  28. Connect the negative battery cable.
  29. Enable the SIR system.
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