

Rocker Outer Panel Sectioning (Sedan)

Removal Procedure

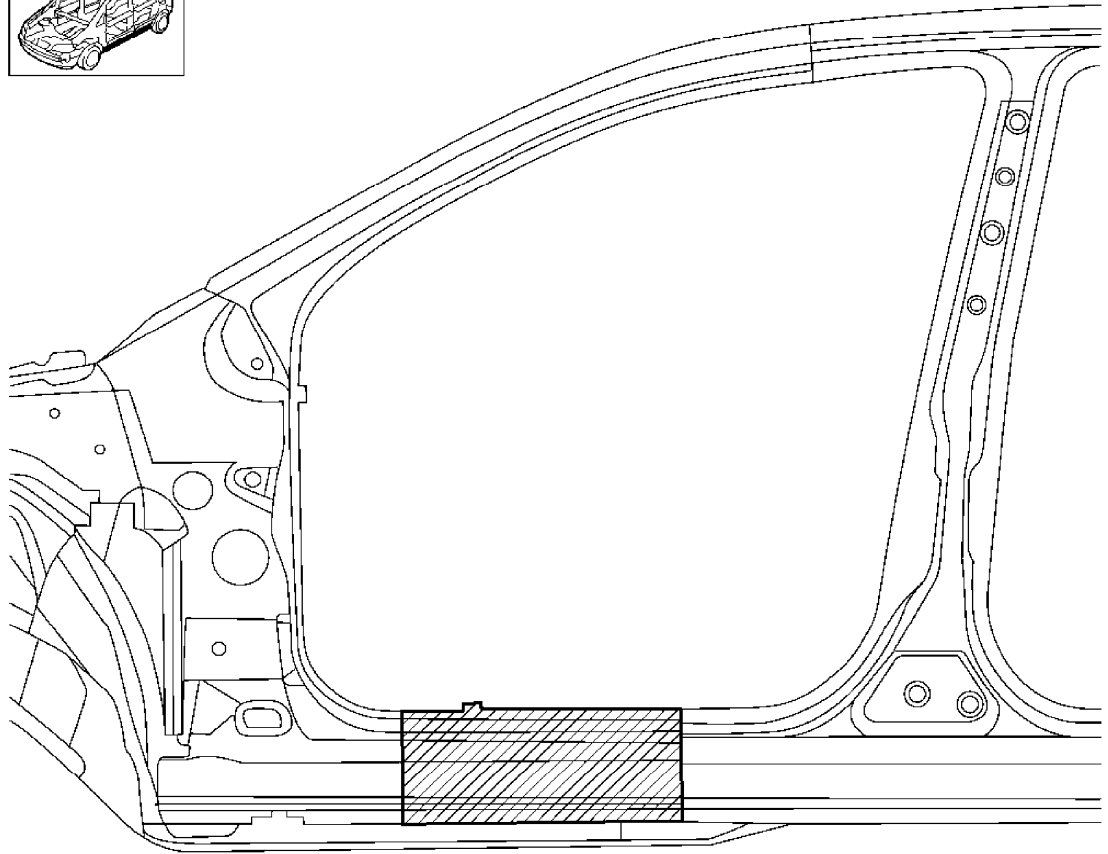
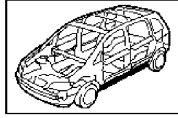
Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in the Preface section.

Important: Section in specific specified areas only. Sectioning outside of these areas may compromise the structural integrity of the vehicle.

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.

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

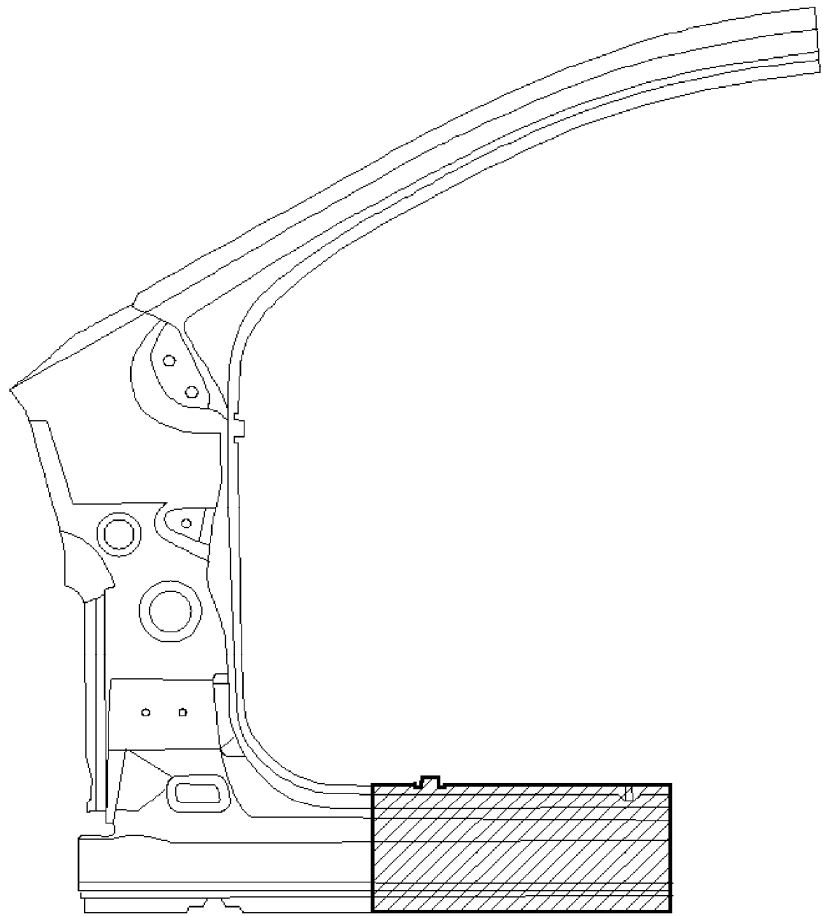
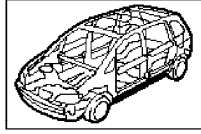
5. Note the locations and remove the sealers and anti-corrosion materials from repair area as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .



Important: Do not damage any inner panels or reinforcements.

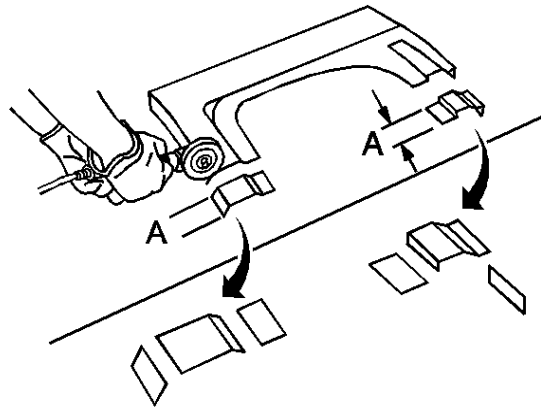
6. Cut the panel where sectioning is to be performed.
7. Locate and drill out factory welds along the rocker panel flanges. Note the number and location of the welds for installation of the service part.
8. Remove the damaged rocker panel.

[Installation Procedure](#)

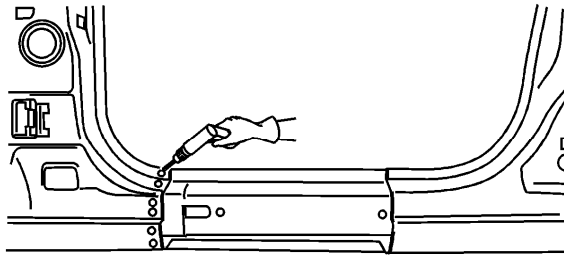


Important: The replacement rocker panel must be sectioned from the front hinge pillar replacement part.

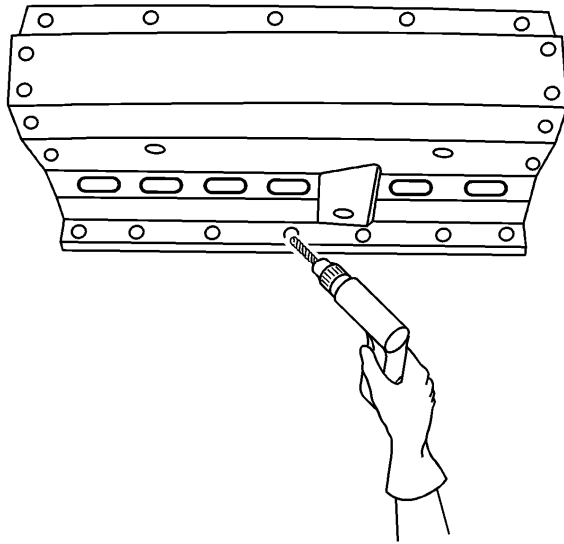
1. Cut the replacement rocker panel in corresponding locations to fit the original panel. The sectioning joint(s) should be trimmed to allow 1 and ½ times the metal thickness at the sectioning joint.



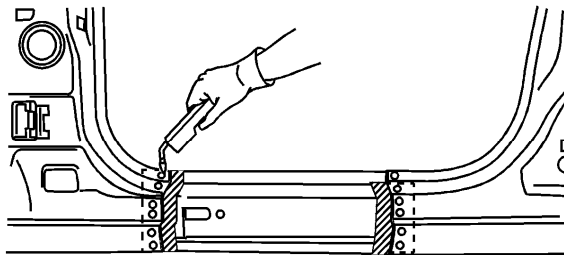
2. Create a 50 mm (2 in) backing plate (A) from the unused portion of the service parts. Trim the backing plate as necessary to fit behind the sectioning joint where there are no reinforcements.



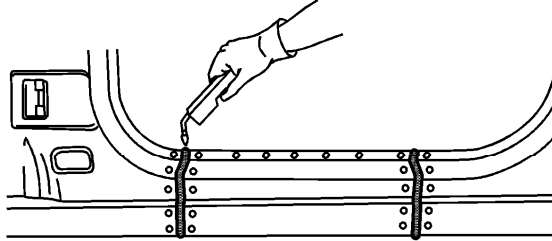
3. Drill 8 mm plug weld holes along the remaining original panel. Locate these holes 13 mm (1/2 in) from the edge and spaced 40 mm (1 1/2 in) apart.



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



7. Fit the backing plate halfway into the sectioning joint, clamp and weld in place.



8. Position front service rocker section to the vehicle using 3-dimensional measuring equipment. Clamp and weld in place.

Important: To create a solid weld with minimal heat distortion, make a 25 mm (1 in) stitch welds along the seam with 25 mm (1 in) gaps between them. Then go back and complete the stitch weld joint.

9. Stitch weld the sectioning joint.
 10. Clean and prepare all welded joints.
 11. Apply the sealers and anti-corrosion materials to the repair area as necessary.
Refer to [Anti-Corrosion Treatment and Repair](#) .
 12. Install all related panels and components.
 13. Connect the negative battery cable.
 14. Enable the SIR system.
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