

Pillar Lock Front Door Reinforcement Sectioning - Outer

Removal Procedure

Caution: To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

Caution: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

Caution: Refer to SIR Caution on page 1-1 in General Information.

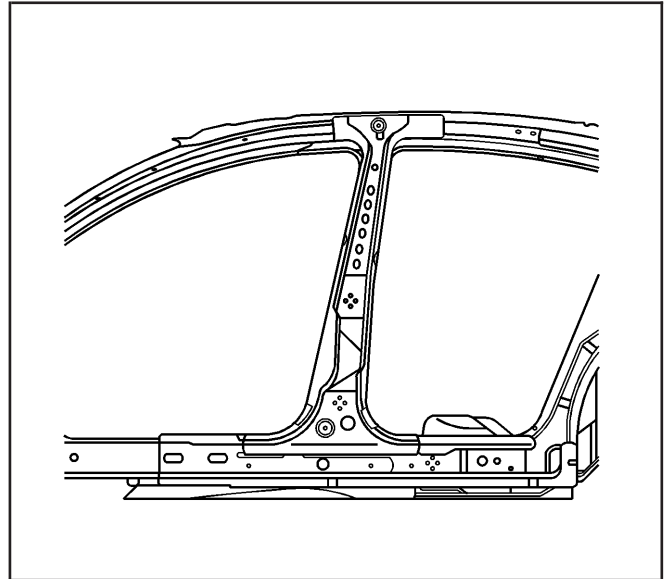
1. Disable the SIR system.

Caution: Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect the negative battery cable. Failure to follow these precautions may cause personal injury and/or damage to the vehicle or its components.

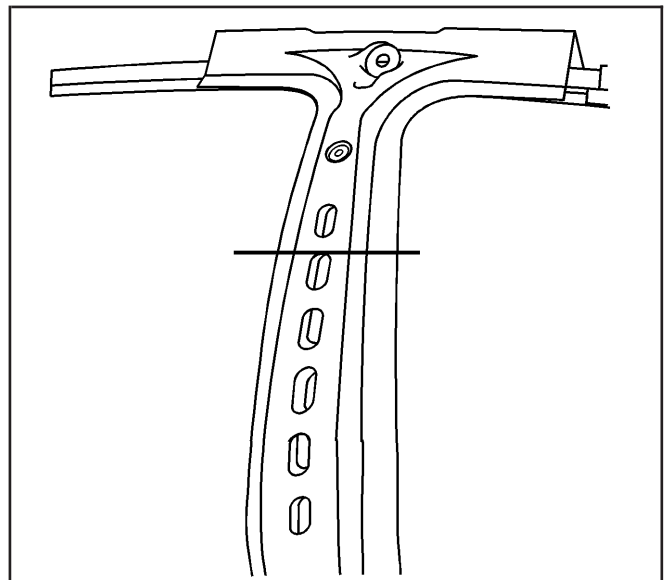
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damaged area as possible. Refer to *Dimensions - Body* on page 3-7.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary.
6. On the center pillar reinforcement, locate and mark the top of the fifth oval hole up from the bottom.

Important: Do not damage any inner reinforcements.

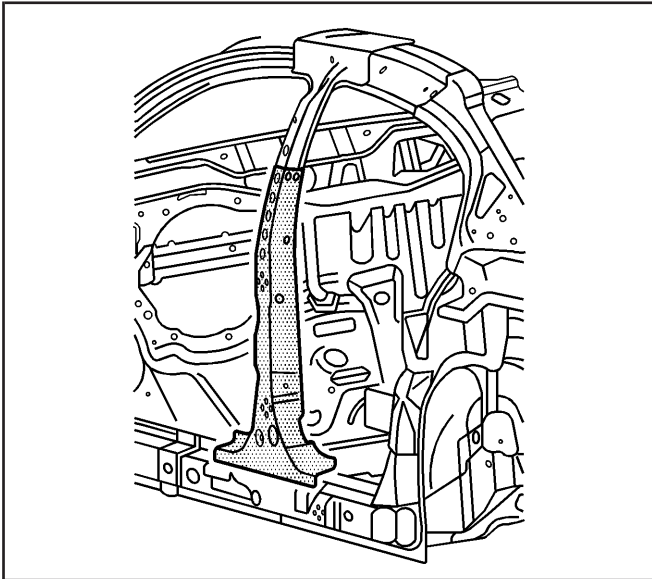
7. Cut the panel at the mark made previously.



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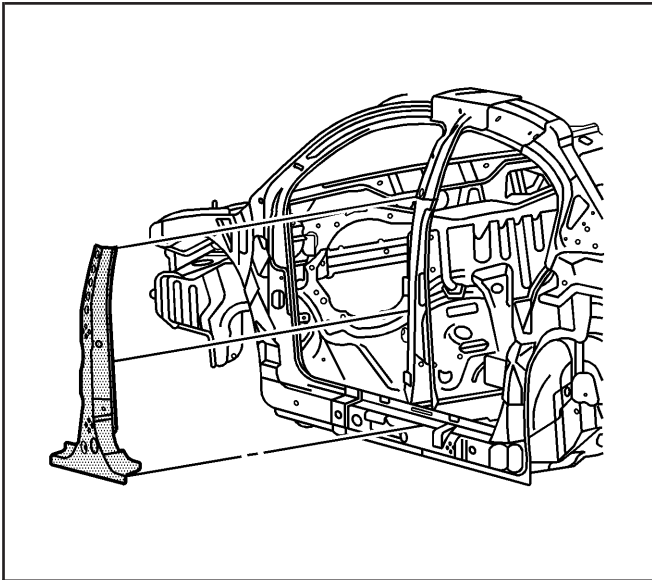


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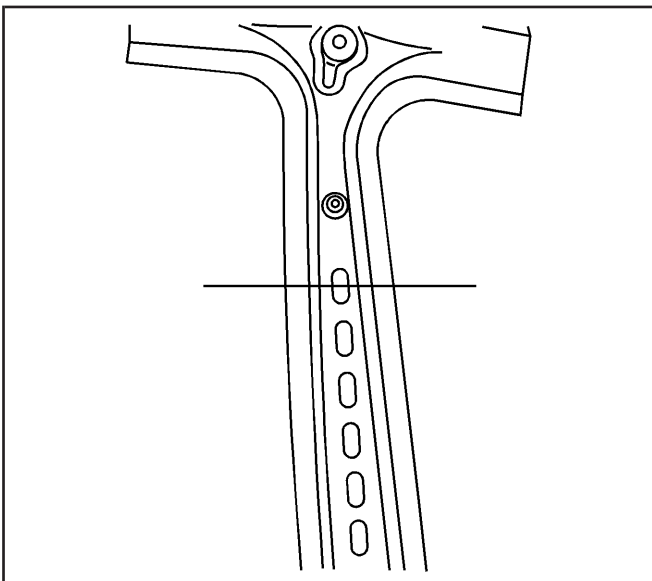
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8. Locate and drill out all factory welds. Note the number and location of the welds for installation of the service part.



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9. Remove the damaged center pillar.

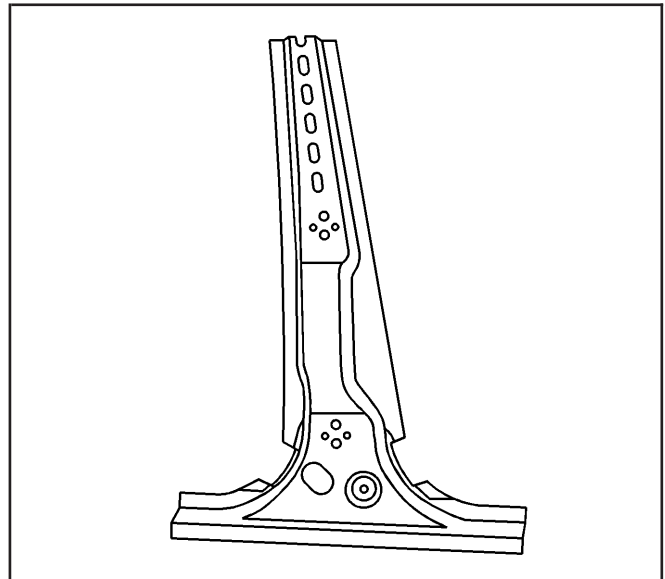


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Installation Procedure

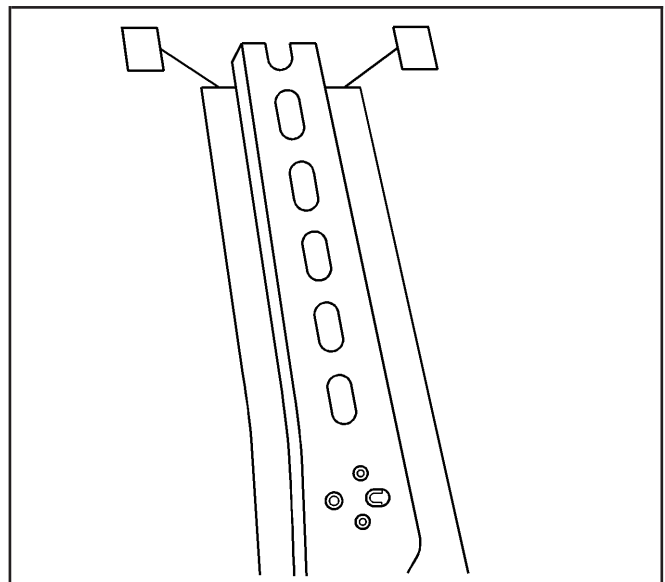
1. Mark a line through the center of the sixth oval hole from the bottom on the center pillar reinforcement service part.

- Cut the replacement service part at the marked line.



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- At the cut area of the service part, notch the weld flange areas down to the top of the fifth hole from the bottom.
- Drill 8 mm (5/16 in) plug weld holes, 2 holes on each side, along the sectioning cut on the original reinforcement. Locate these holes 10 mm (1/2 in) from the edge.
- Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the corresponding locations noted on the original panel.
- Prepare all mating surfaces for welding as necessary.
- Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.
- Slide the top sectioning joint together by sliding the service part under the original part at the sectioning area.
- Position the service part on the vehicle using 3-dimensional measuring equipment. Clamp the part in place.
- Plug weld accordingly.
- To create a solid weld with minimum heat distortion, make 25 mm (1 in) stitch welds along the sectioning joint seam with gaps of 25 mm (1 in). Go back and complete the stitch weld.
- Clean and prepare all of the welded surfaces.
- Apply the sealers and anti-corrosion materials to the repair area, as necessary.
- Paint the repaired area.
- Install all of the related panels and components.
- Connect the negative battery cable.
- Enable the SIR system.



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