

Front Lower Hinge Pillar Sectioning

Removal Procedure

1. Visually inspect and restore as much of the damage as possible to factory specifications.
2. Remove all related panels and components.
3. Note the location and remove the following as necessary:
 - Sealers
 - Sound deadeners
 - Anti-corrosion materials
4. Measure 80 mm (3-1/8 inches) down from the large wiring harness hole in the hinge pillar and mark a horizontal line.
5. Cut the pillar in the locations where sectioning is to be performed.

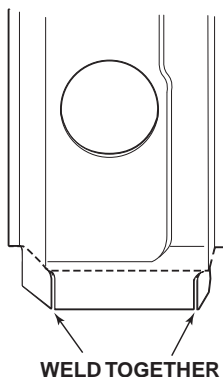
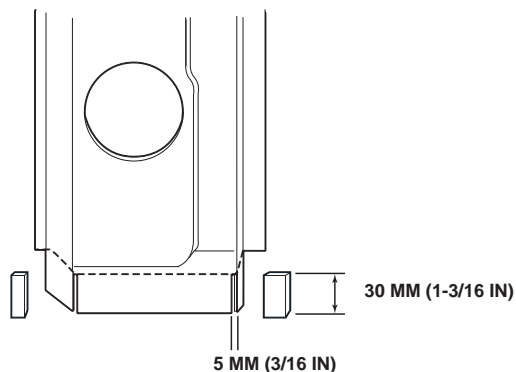
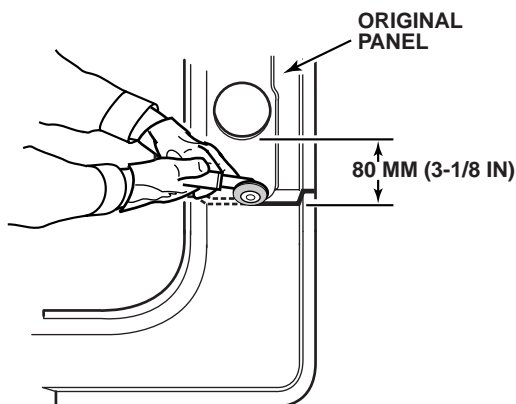
IMPORTANT: Take care not to damage the inner panel.

6. Locate, mark and drill out all necessary factory welds. Note the number of welds for the installation of the service section.
7. Remove the damaged section of the door frame opening.

IMPORTANT: The metal of the hinge pillar is of a heavy gauge. However, the tabs can be created using the appropriate tools.

8. Cut and remove 30 mm (1-3/16 inches) from the flanges on either side of the remaining section of the original hinge pillar to create 30 mm (1-3/16 in.) tabs. Cut 5 mm (3/16 in.) wide gaps in the bottom corners.

9. Step the tabs inward to allow the door frame opening service section to fit over the original hinge pillar. Weld the tabs together along the edges.



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Installation Procedure

1. On the service part, measure 50 mm (2 in.) down from the large wiring harness hole in the hinge pillar and mark a horizontal line. Cut the hinge pillar along this line.
2. Perform additional sectioning procedures as necessary to remove the unused areas of the service part. Refer to Windshield Sectioning; Center Pillar, Rear Lock Pillar, and Rocker Sectioning.

NOTICE: In any area damaged beyond recognition, space plug weld holes every 40 mm (1-1/2 in.) apart.

3. Drill 8 mm (5/16 in.) plug weld holes as necessary in the locations noted from the original section. Also drill plug weld holes along the hinge pillar sectioning cut of the service part. These should be located approximately 15 mm (9/16 in.) from the edge of the cut.

CAUTION: FOAM SEALERS ARE FLAMMABLE AND SHOULD BE REMOVED FROM ALL WELD LOCATIONS.

4. Prepare mating surfaces as necessary.
5. Apply weld-thru primer to all bare-metal surfaces.
6. Position the service section over the stepped tab on the original hinge pillar, allowing 30 mm (1-3/16 inches) of overlap. Check fit using three-dimensional measuring.
7. Plug weld service part in position.

8. Make 25 mm (1 in.) welds along the seam with 25 mm (1 in.) gaps between. Then go back and complete the stitch weld. This will create a solid joint with minimal heat distortion.

9. Clean and prepare all welded surfaces.

IMPORTANT: Prior to refinishing, refer to the publication GM4901M-D-01 GM Approved Refinish Materials for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

10. Apply an approved anti-corrosion primer.
11. Apply sealers and refinish as necessary.
12. Install all related panels and components.

