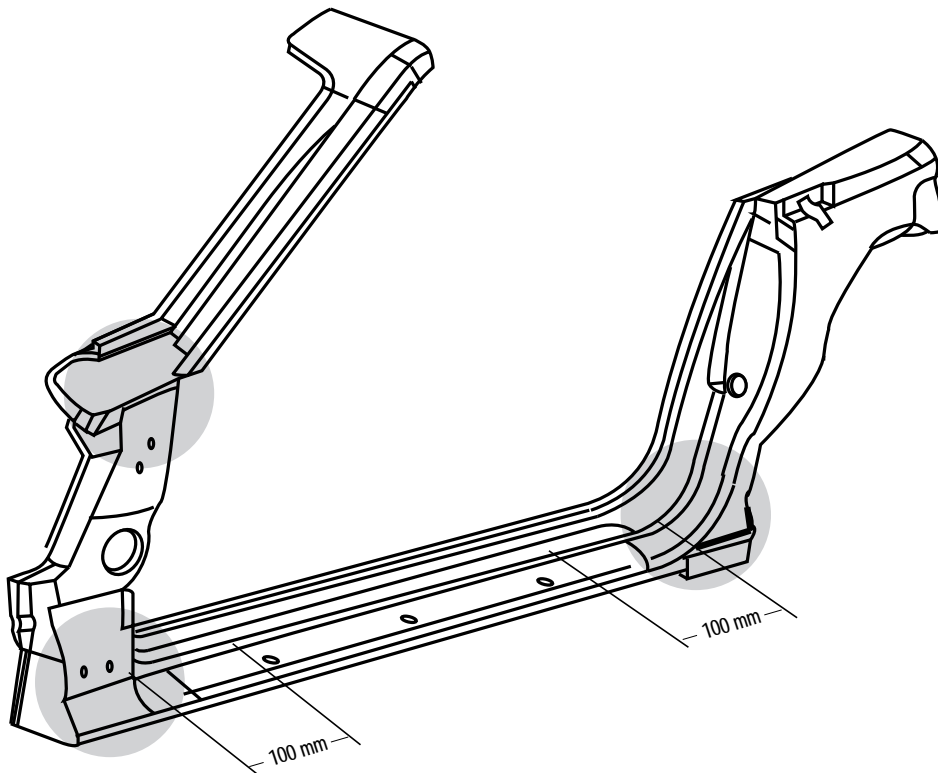


SIDE DOOR OPENING FRAME

When sectioning the door opening frame on the Camaro/Firebird convertible, there are three locations where sectioning should not take place (figure 1). Sectioning in these areas could jeopardize the structural integrity of the vehicle. The door ring service panel is unique for convertibles. The panel can be installed as a complete assembly or modified for sectioning. When sectioning in an area with no reinforcement, a backing plate or sleeve must be used.

REMOVE OR DISCONNECT

1. Remove all related panels and components.
2. Visually inspect and restore as much damage as possible to factory specifications.
3. Remove sealers, sound deadeners and corrosion materials, as necessary.
4. Locate, mark and drill out factory welds, as necessary. Note the number of welds for installation of the new assembly.
5. Measure, mark, cut and remove the damaged section of the frame, being careful in areas where there are multiple layers of steel.



■ FIGURE 1 ■
AREAS WHERE SECTIONING
SHOULD NOT TAKE PLACE

SIDE DOOR OPENING FRAME

INSTALL OR CONNECT

1. Prepare the new door opening frame by measuring and cutting to match the removed section. Check for proper fit.

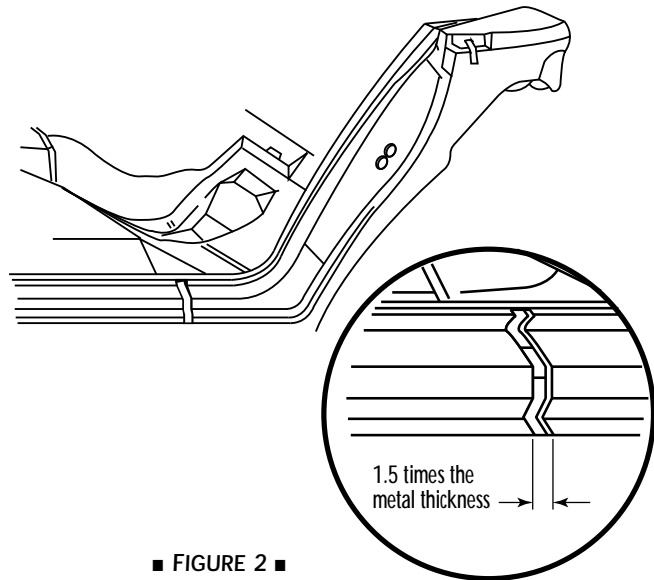
— NOTICE —

Do not section within 4 inches (100 mm) of either inner lower curve of the door opening frame or outer rocker panel sectioning (see figure 1).

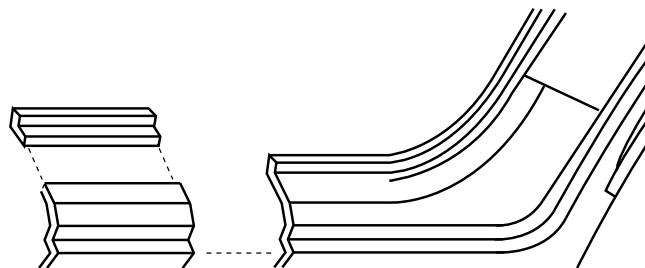
— NOTICE —

A gap 1 1/2 times the thickness of the metal must be maintained at the joint between the old frame and replacement frame (figure 2). Trim the replacement frame, as required, to achieve this fit.

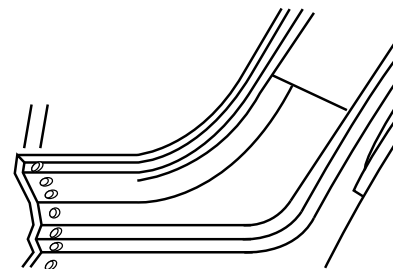
2. In areas having no inner reinforcements, cut pieces to serve as backing plates of the same configuration from the areas where sectioning is to be done. These should be approximately 3 inches (75 mm) in length. Use the damaged frame or the excess portions of the replacement frame (figure 3).
3. Modify the pieces so they fit snugly to the backside of the section joints.
4. Pre-drill 5/16-inch plug weld holes for installation of the new frame (figure 4).



■ FIGURE 2 ■
FITTING THE NEW PANEL

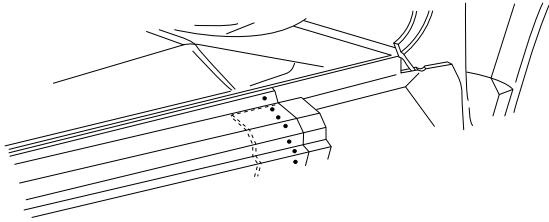


■ FIGURE 3 ■
FITTING THE BACKING PLATE

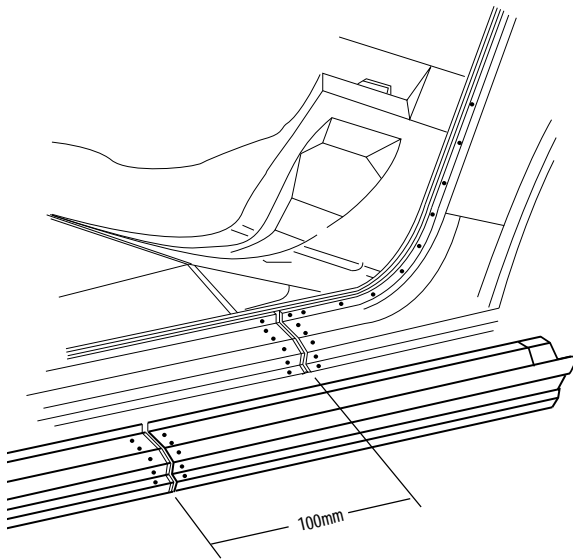


■ FIGURE 4 ■
PRE-DRILLING PLUG WELD HOLES

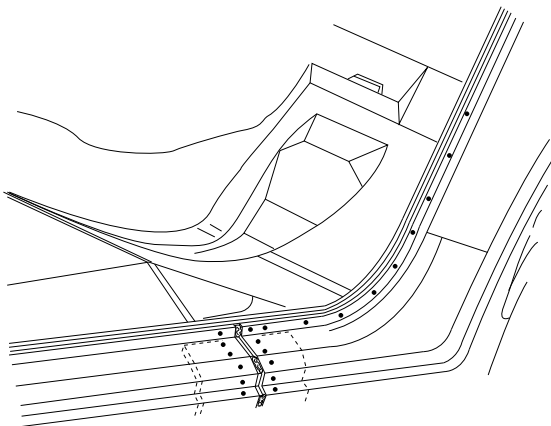
SIDE DOOR OPENING FRAME



■ FIGURE 5 ■
FITTING THE BACKING PLATE FOR WELDING



■ FIGURE 6 ■
WELDING THE JOINT GAP



■ FIGURE 7 ■
WELDING THE REMAINING HOLES

5. Fit the backing plate halfway into the section joint on the vehicle. Clamp and MIG weld the backing plate to the vehicle (figure 5).
6. When all the backing plates are welded in place, reinstall the new part and check the fit using body dimensions.
7. When the replacement frame is properly fitted and aligned, clamp and MIG weld it to the backing plates (figure 6). An alternating weld sequence is recommended to reduce heat and metal distortion.
8. MIG weld the remaining weld holes to attach the panel permanently (figure 7).
9. Clean and prepare welded surfaces. Prime with two-part catalyzed primer. Apply sealers and corrosion protection materials, as necessary. Do not combine paint systems. Refer to paint manufacturer's recommendations. Reinstall all related components.