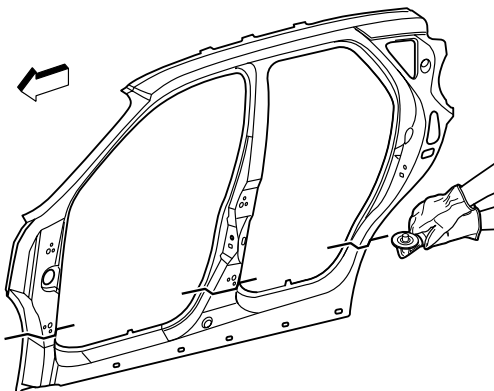
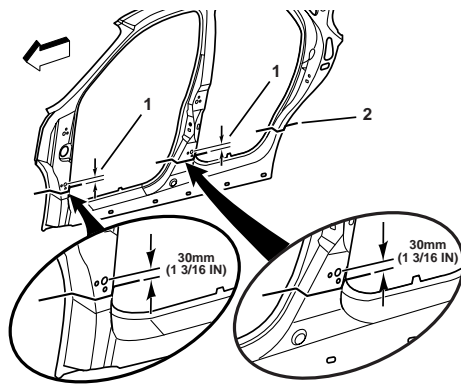
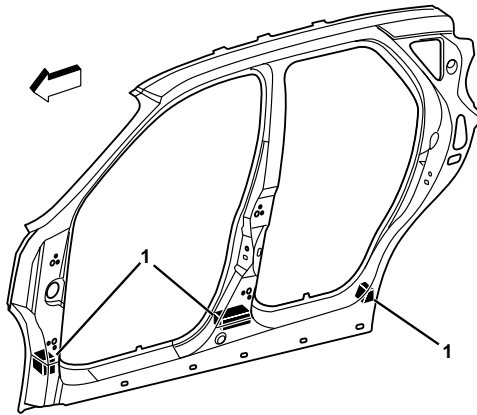


Door Frame Sectioning—Outer (Rocker Sectioning)

Removal Procedure

1. Remove all related panels and components.
2. Restore as much of the damage as possible to factory specifications.
3. Note the location and remove the following as necessary:
 - Anti-corrosion materials
 - Sound deadeners (1)
 - Sealers
4. By measuring from the lower edge of the guide hole (1) downward 30 mm (1-3/16 in.), locate and mark for sectioning of the Front Hinge Pillar and the Center Pillar.
5. With quarter panel removed (2), locate and mark for sectioning of the Rear Lock Pillar.
6. Scribe a line horizontally to the rocker.
7. Cut the panel where sectioning is to be performed.

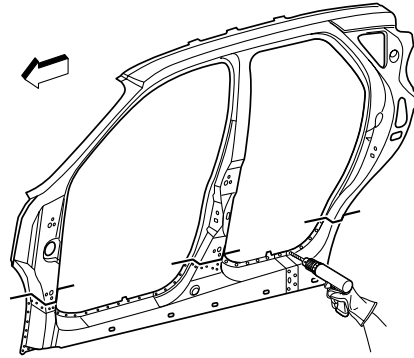
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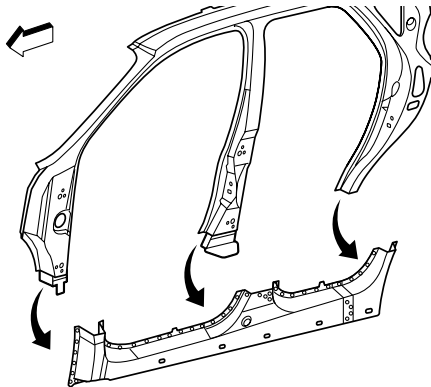
IMPORTANT: Do not damage any inner panels or reinforcements.

**Door Frame Sectioning—Outer
(Rocker Sectioning)
Removal Procedure con't**

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



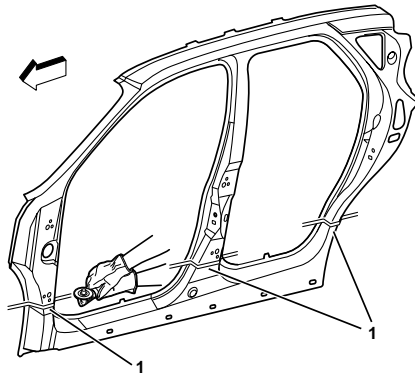
9. Remove the damaged Rocker Panel.



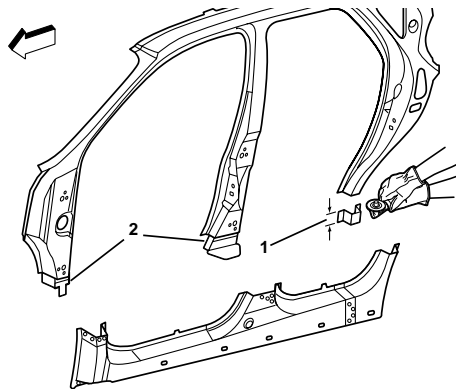
Door Frame Sectioning—Outer (Rocker Sectioning)

Installation Procedure

1. Cut the replacement service part in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half times the metal (1) thickness at the sectioning joint.



2. In the Rear Lock Pillar, create a 50 mm (2 in.) backing plate (1) from the unused portion of the Door Frame Opening. Trim the backing plate as necessary to fit behind the sectioning joint.
3. Use the lower hinge reinforcement (2) as the backing plate in the front Hinge Pillar and the Center Hinge Pillar.

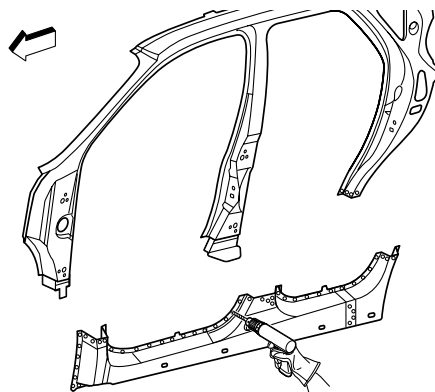


4. Drill 8 mm (5/16 in.) plug weld holes along the sectioning cut on the remaining original part.

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

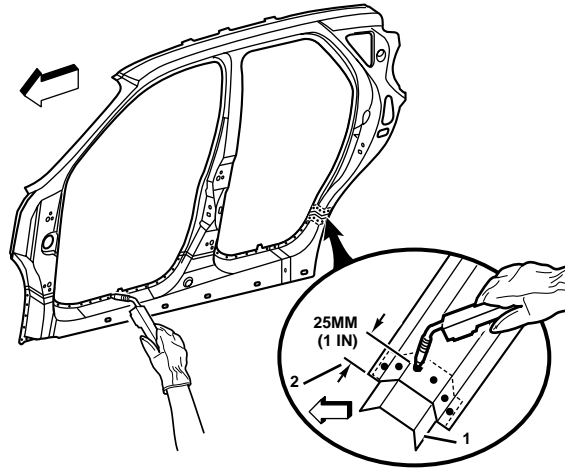
5. Drill 8 mm (5/16 in.) plug weld holes as necessary in locations noted from the original panel and along the sectioning cut.

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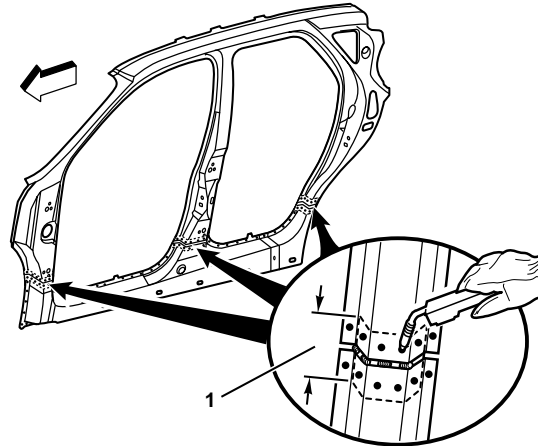


Door Frame Sectioning—Outer (Rocker Sectioning) Installation Procedure con't

6. Prepare all attachment surfaces as necessary.
7. Apply weld-thru primer to all bare-metal surfaces.
8. Fit the backing plate (1) halfway into the sectioning joint (2). Clamp and plug weld to the vehicle.



9. Align the Rocker Panel using three-dimensional measuring equipment.
10. Plug weld accordingly.
11. To create a solid weld with minimum heat distortion, make 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.



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

12. Clean and prepare all welded surfaces.
13. Apply the following as necessary:
 - Anti-corrosion materials
 - Sound deadeners (1)
 - Sealers
14. Refinish as necessary.
15. Install all related panels and components.

