

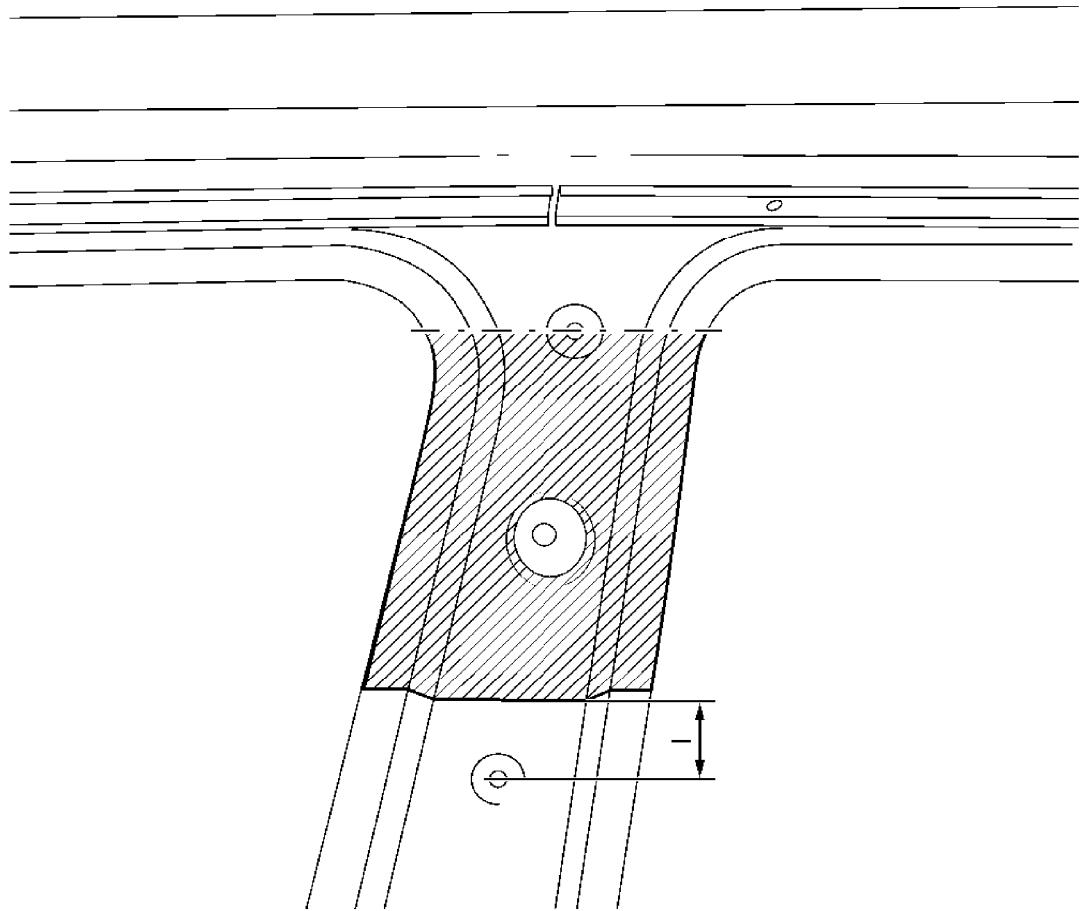
Center Pillar Sectioning - Inner (Sedan)

Removal Procedure

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

Important: Section in specified area only. Sectioning outside of these areas may compromise the structural integrity of the vehicle. The sectioning procedures have been developed as a more cost-effective alternative to complete panel replacement.

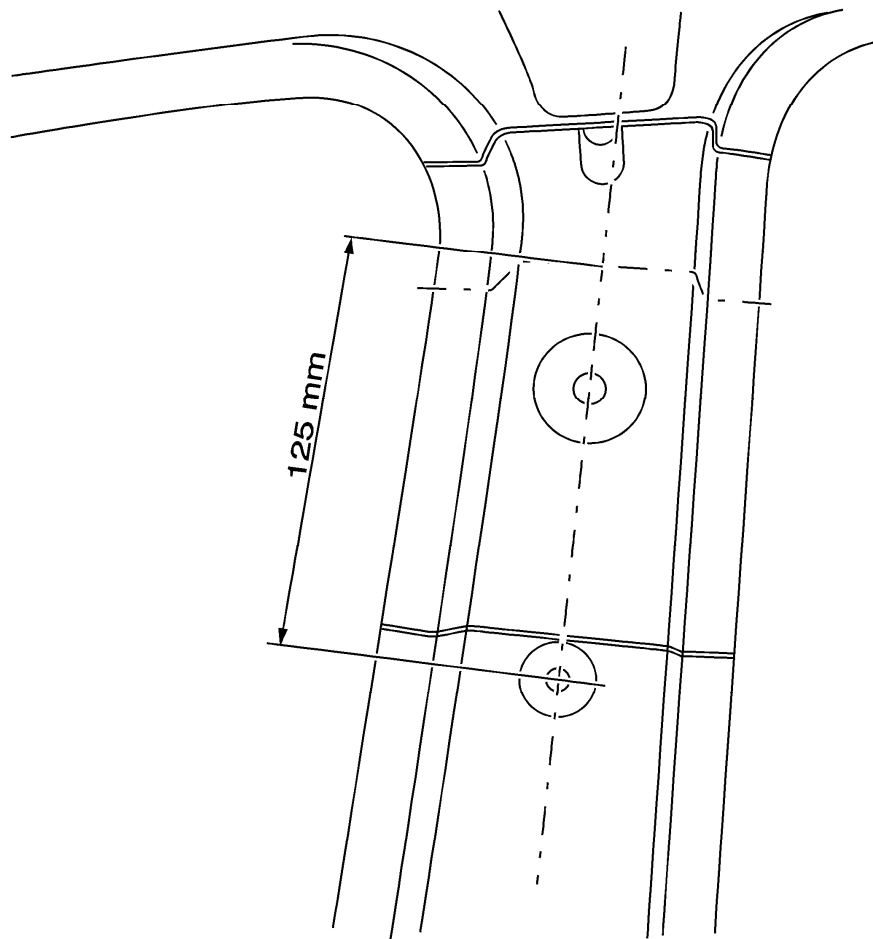
1. Disable the supplemental inflatable restraint (SIR) system.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .
5. Note the location and remove the sealers and anti-corrosion materials from the repair area as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .



Important: A window will need to be cut into the center pillar outer panel to gain access to the inner reinforcement.

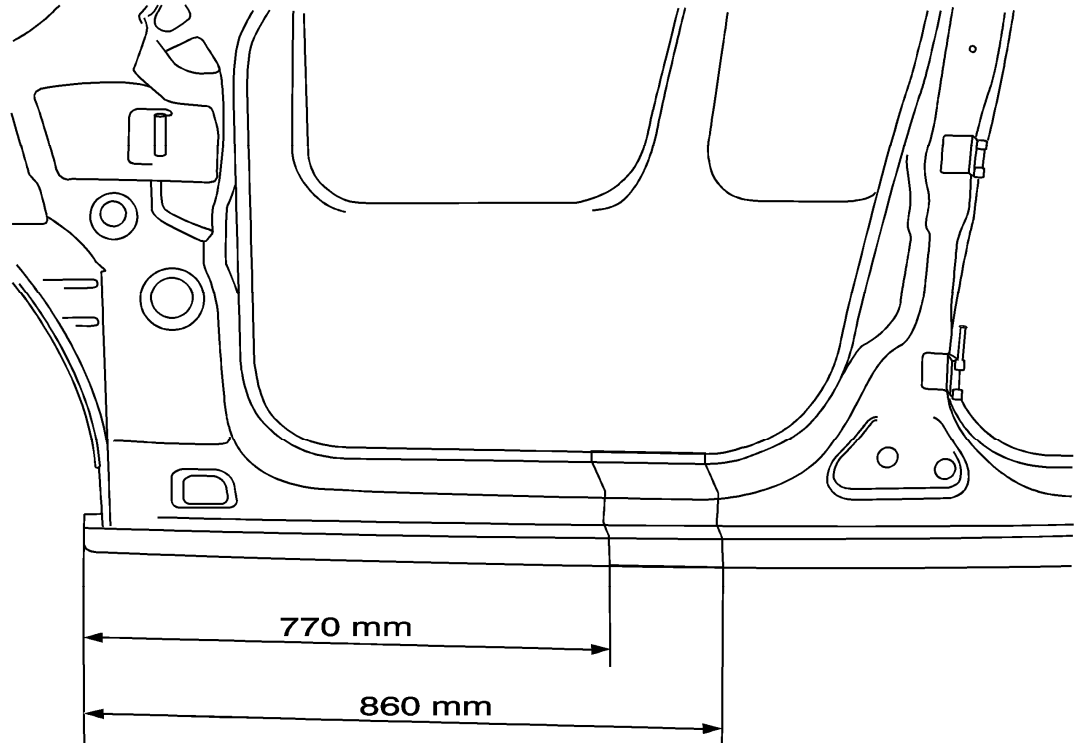
6. Measure and mark horizontal lines on the center pillar outer panel as shown.
 - 6.1. Approximately 30 mm between lower hole and sectioning joint.
 - 6.2. Upper sectioning cut is located through mounting hole.
8. Cut the panel where sectioning is to be performed.
9. Locate and drill out factory welds securing center pillar outer section.

10. Remove the damaged center pillar outer panel.



11. Measure and mark horizontal lines on the center pillar reinforcement as shown.

12. Cut the reinforcement where sectioning is to be performed.



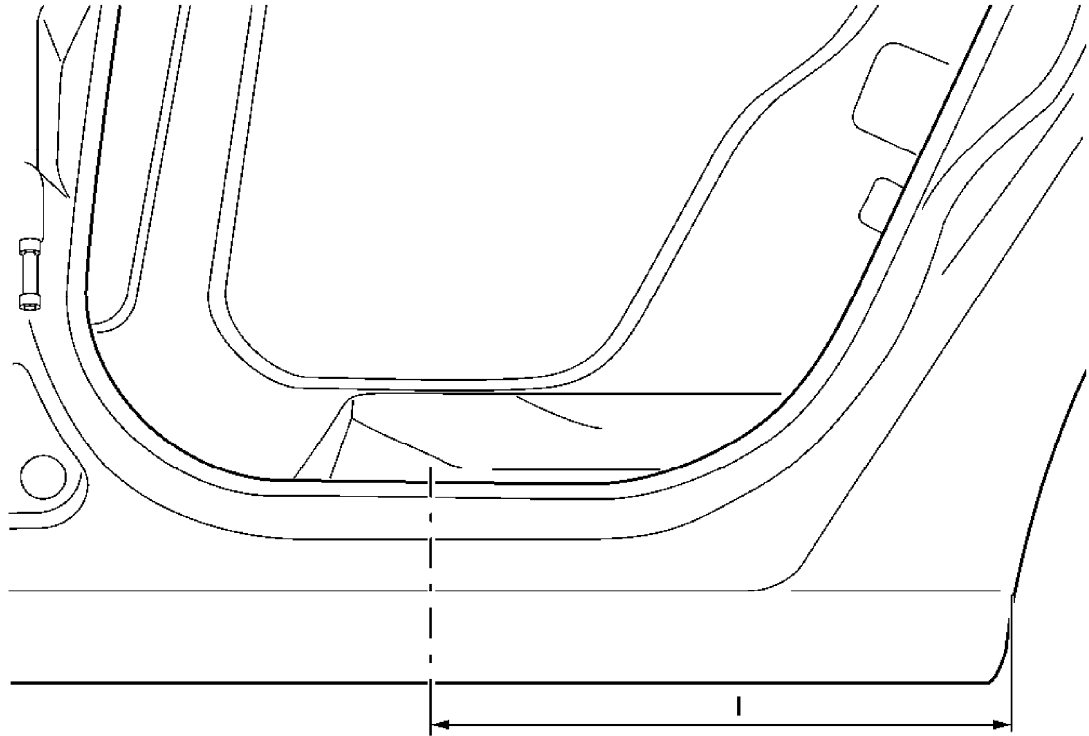
Important: A window must be cut in the rocker outer panel to gain access to the center pillar reinforcement welds. Note size of new part. Do not damage any inner panels or reinforcements.

13. Measure and mark vertical lines on the rocker panel as shown.

14. Cut the panel when indicated.

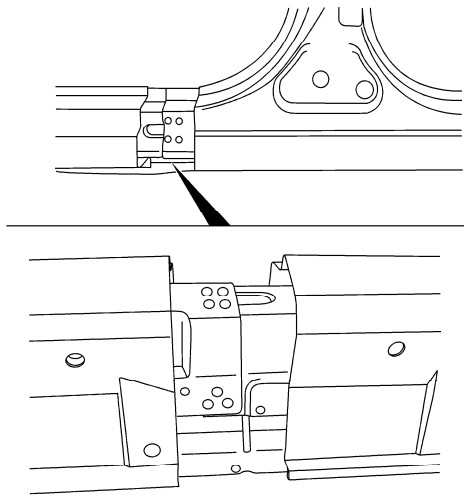
15. Locate and drill out factory welds in area of window.

16. Remove the rocker panel window section.

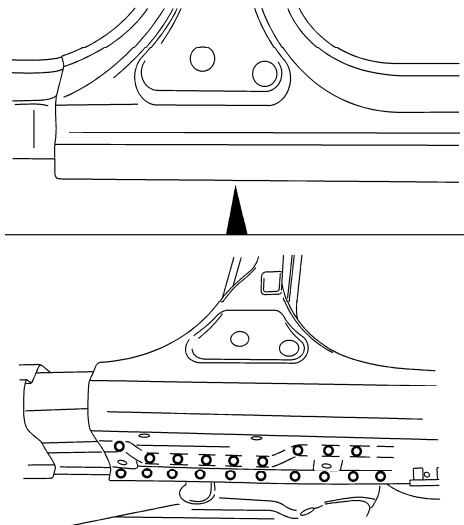


17. Measure and mark a vertical line as shown.

Sectioning cut (1) is approximately 430 mm from wheel opening flange.

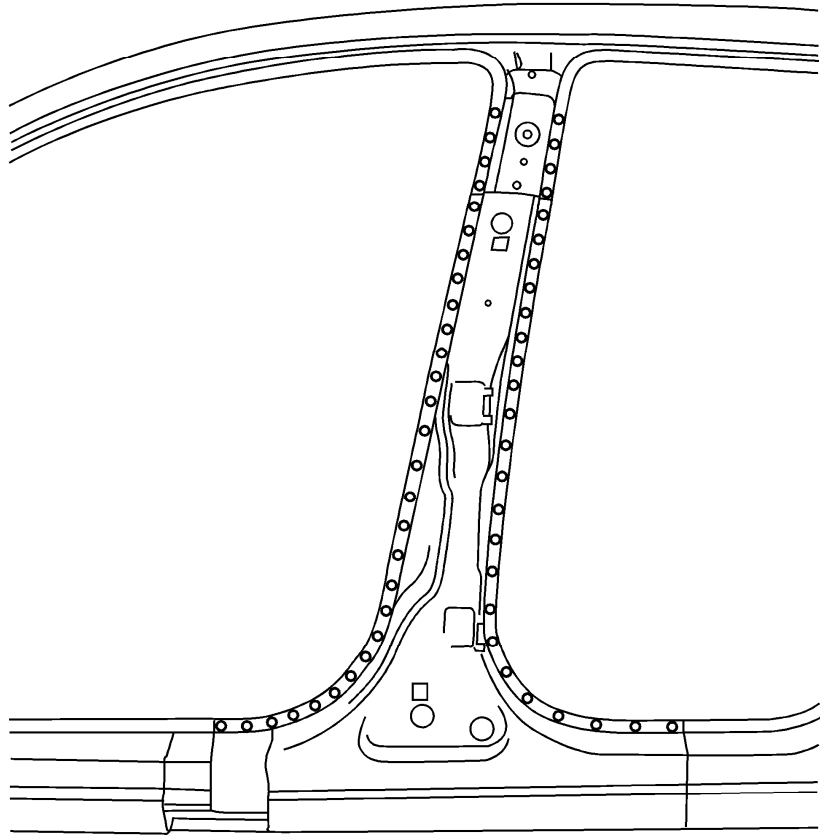


18. Locate and drill out factory welds at the front of the center pillar reinforcement.



Important: Do not drill into reinforcement for the rocker panel on the inside.

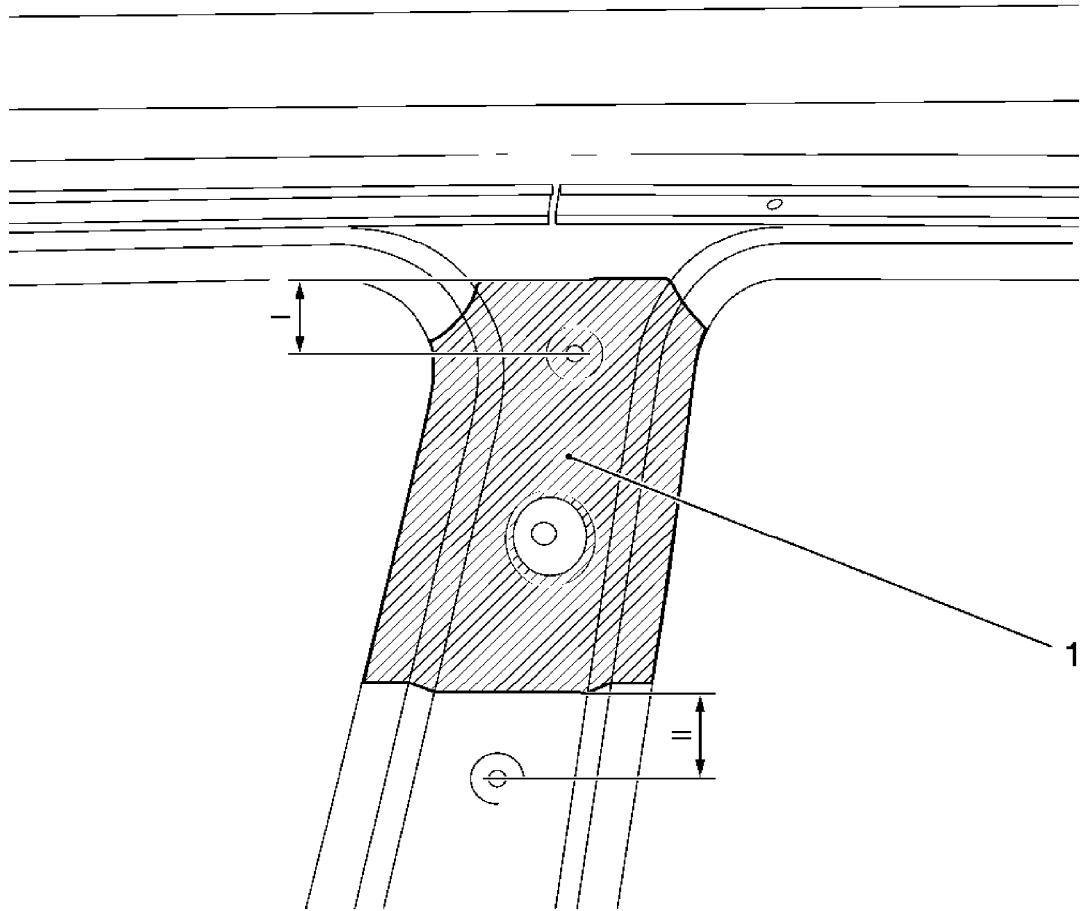
19. Locate and drill out factory welds from the lower center pillar.



20. Locate and drill out factory welds securing the center pillar reinforcement.

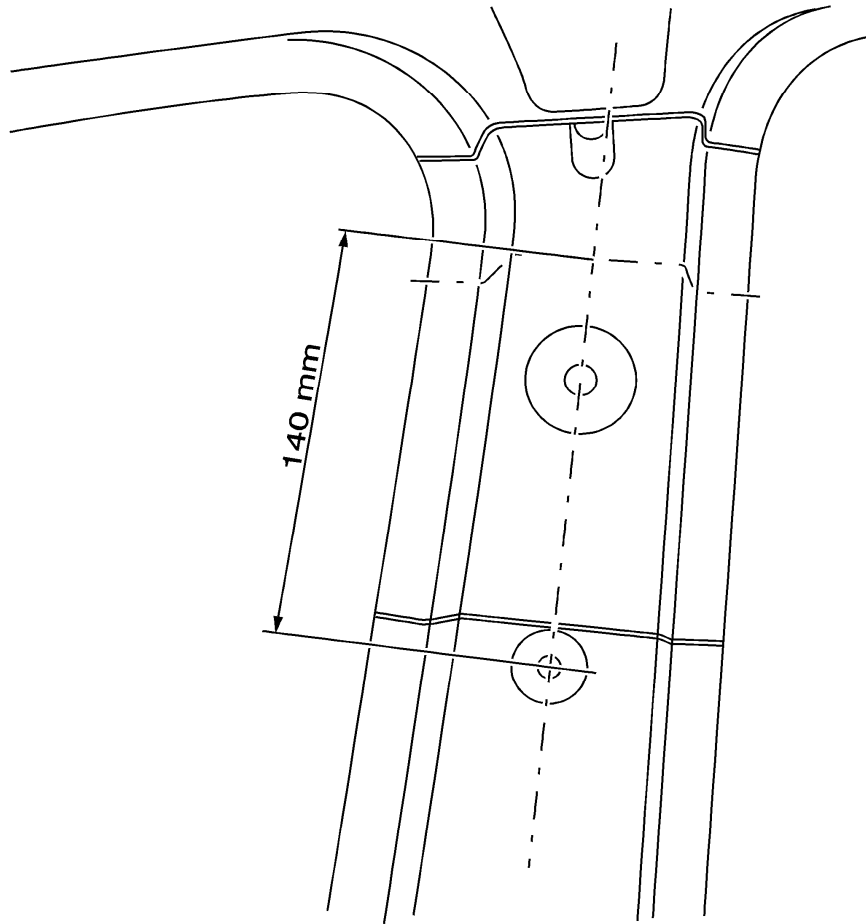
21. Remove damaged center pillar.

[Installation Procedure](#)

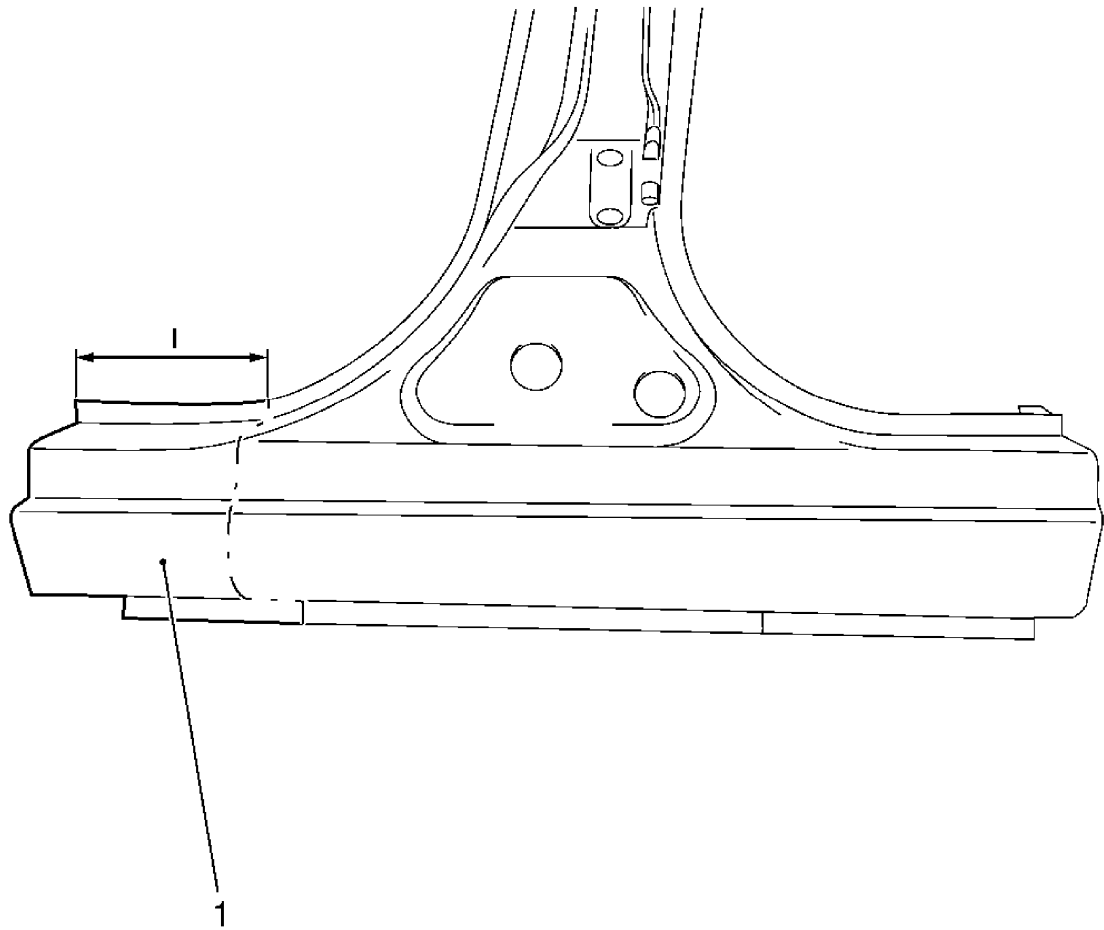


Important: Do not damage any inner panels or reinforcements.

1. On the service part, measure and mark horizontal lines on the center pillar outer panel as noted (-, =) from the original panel. The center pillar outer panel window (1) must be reused.
2. Cut the panel. The sectioning joint should be trimmed to allow 1½ times the metal thickness at the sectioning joint.
3. Locate and drill out factory welds to separate center pillar outer panel from assembly.

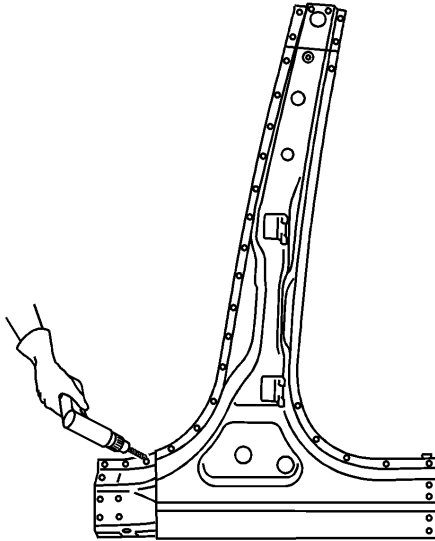


4. On the service part, measure and mark a horizontal line on the center pillar reinforcement as noted from the original panel. The sectioning joint should be trimmed to allow $1\frac{1}{2}$ times the metal thickness at the sectioning joint.
5. Cut the center pillar reinforcement and make the section cut at the rear rocker panel in locations noted from original panel.



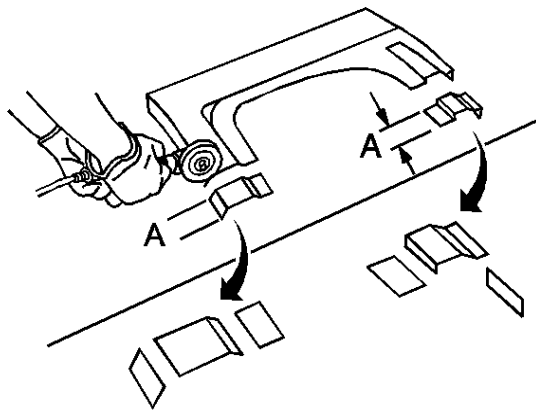
Important: Joint on front rocker panel is not cut to size until after the assembly window has been adjusted to fit. The assembly window (1) must be re-used.

6. Measure and mark a vertical line on the service part rocker panel as shown. The measurement (I) will be approximately 120 mm from edge of part.

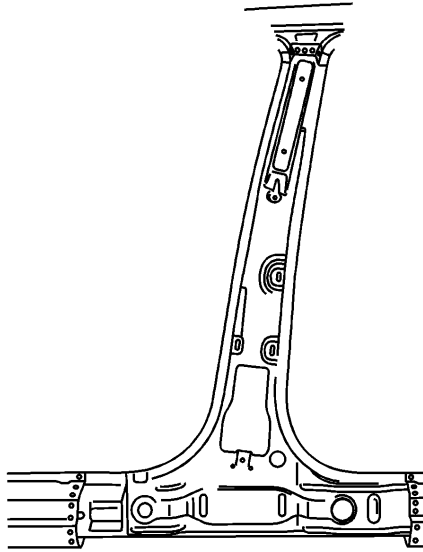


Important: If the location of the original plug weld holes can not be determined, space the plug weld holes every 40 mm (1½ in) apart.

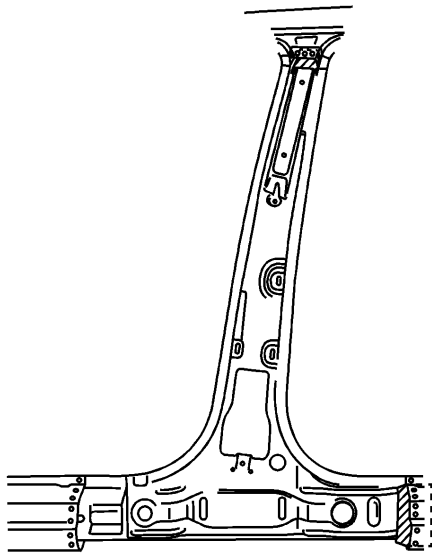
7. Drill 8 mm (5/16 in) plug weld holes in the replacement part as necessary in locations noted from the original panel.



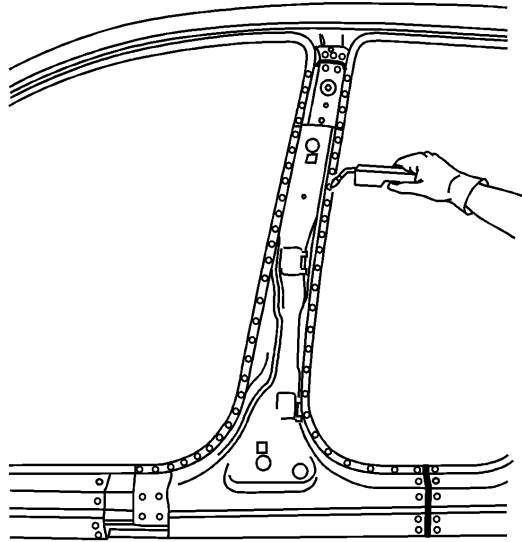
8. Create a 50 mm (2 in) backing plate from the unused portion of the replacement part or from same gauge scrap panels. Trim the backing plate as necessary to fit behind the sectioning joint where there are no reinforcements.



9. Drill 8 mm (5/16 in) plug weld holes along the sectioning joint on the original panel. Locate these holes 13 mm (1/2 in) from the edge and spaced 40 mm (1 1/2 in) apart.
10. Prepare all mating surfaces as necessary.
11. Apply GM approved Weld-Thru coating or equivalent to all mating surfaces.
Refer to [Anti-Corrosion Treatment and Repair](#) .



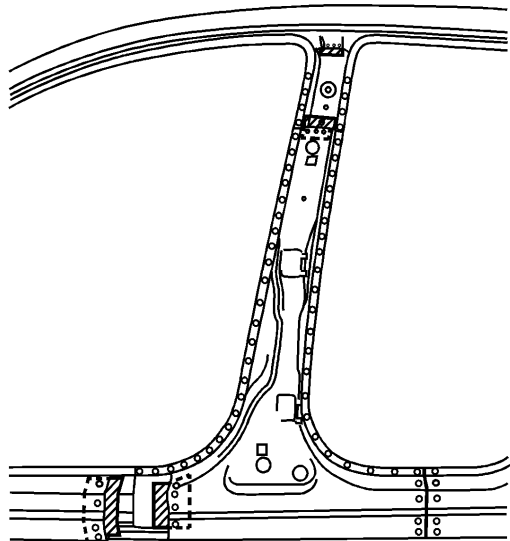
12. Fit the backing plate halfway into the sectioning joint at the top and rear of the center pillar reinforcement. Clamp and weld in place.



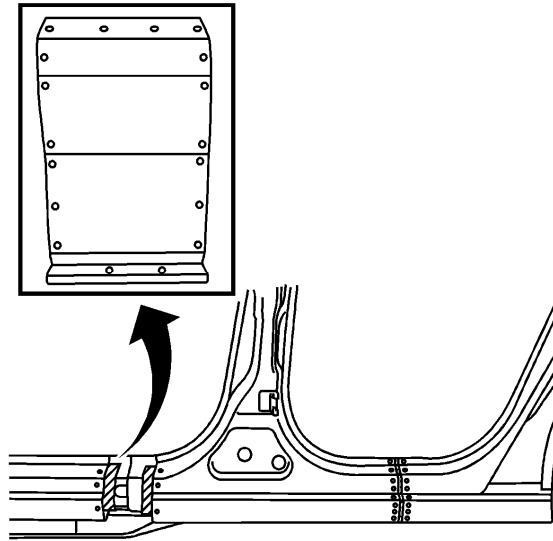
13. Position the replacement center reinforcement to the vehicle using 3-dimensional measuring equipment. Clamp in place.
14. Plug weld accordingly.

Important: 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.

15. Stitch weld the sectioning joint at top and rear portions of center reinforcement.



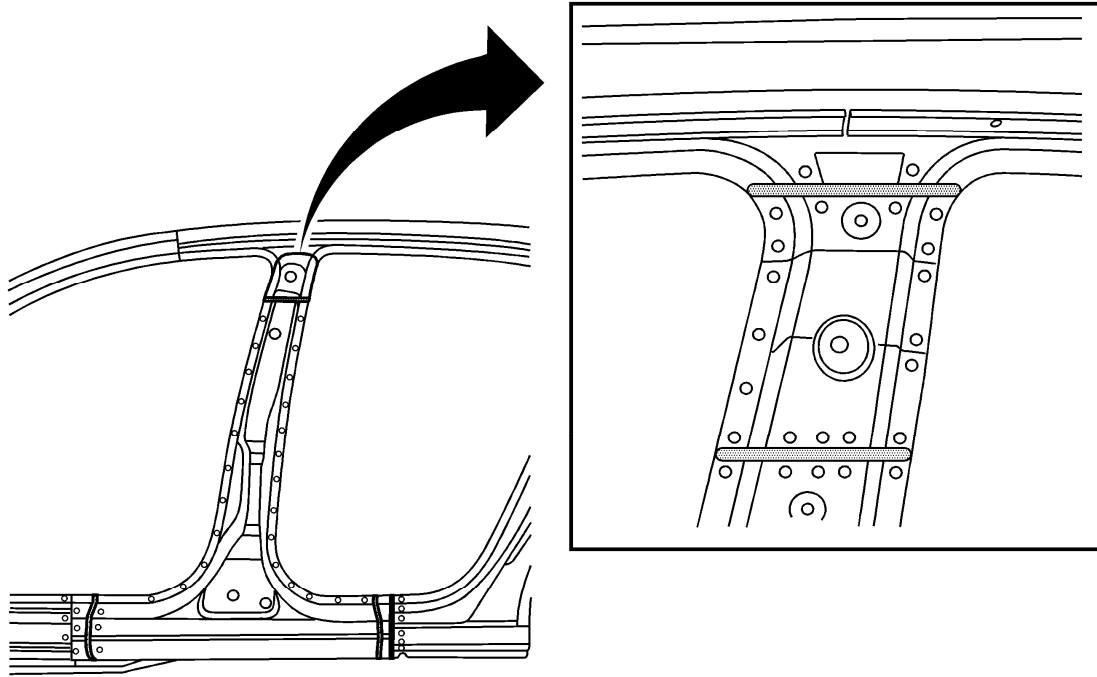
16. Fit the backing plates halfway into the remaining sectioning joints. Clamp and weld into place.



17. Locate and position the rocker panel window.
18. Clamp and plug weld accordingly.

Important: 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.

19. Stitch weld the sectioning joint.



20. Locate and position the upper center pillar panel.
21. Clamp and plug weld accordingly.

Important: 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.

22. Stitch weld the sectioning joint.
 23. Prepare all welded surfaces as necessary.
 24. Apply the sealer and anti-corrosive materials to the repair area as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
 25. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
 26. Install all the related panels and components.
 27. Connect the negative battery cable.
 28. Enable the SIR system.
-