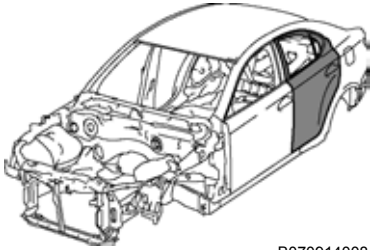


REAR DOOR OUTER PANEL (ASSY)

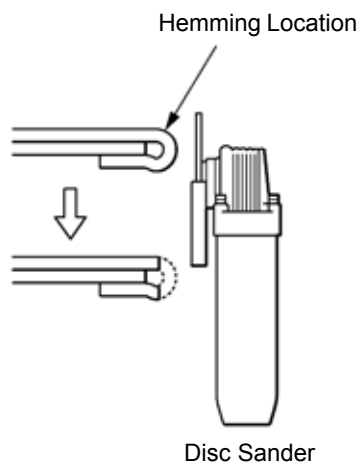
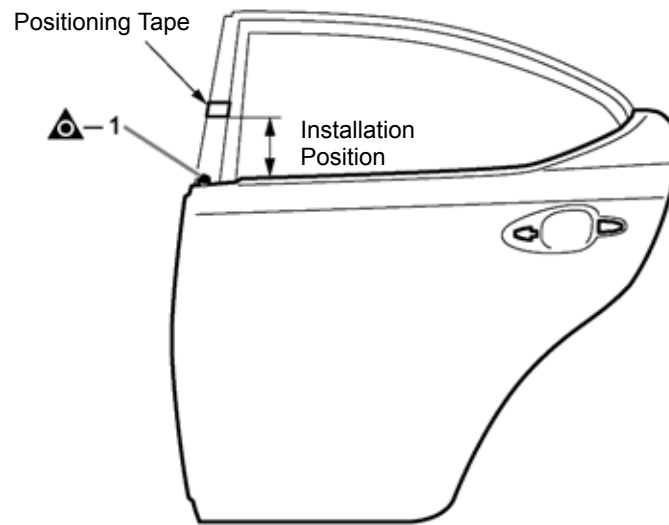


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Symbol meaning

⚠ : Remove Weld Points

REMOVAL



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REMOVAL POINT

- 1 Before removing the outer panel, mark the installation position with tape.
- 2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
- 3 After grinding off the hemming location, remove the outer panel.

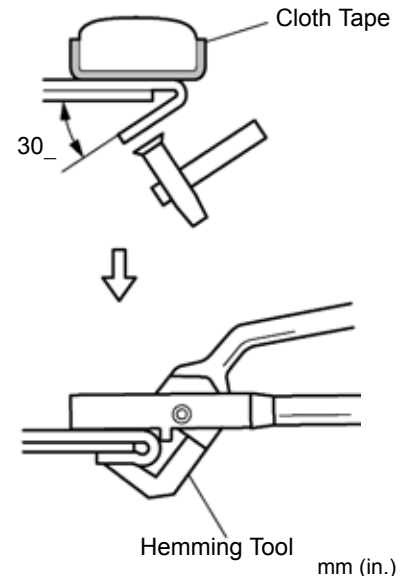
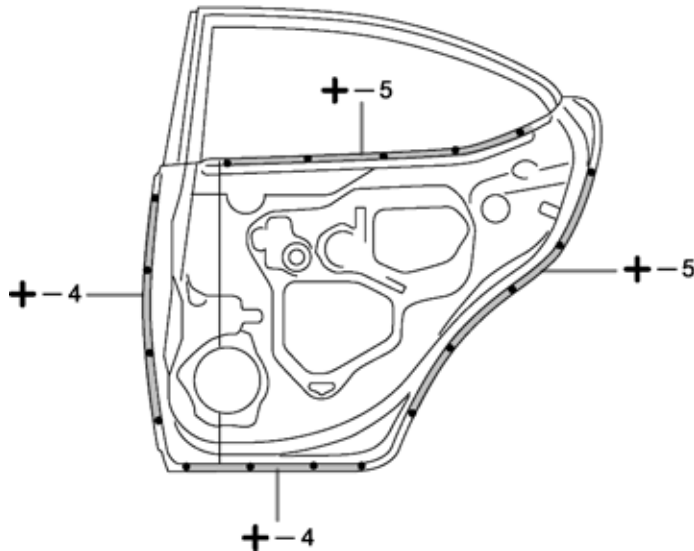
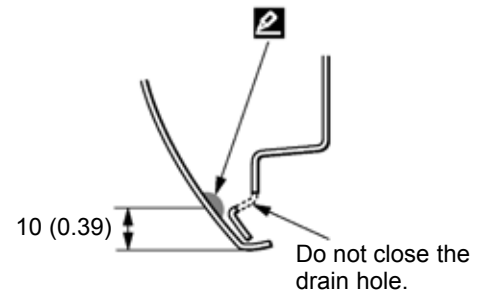
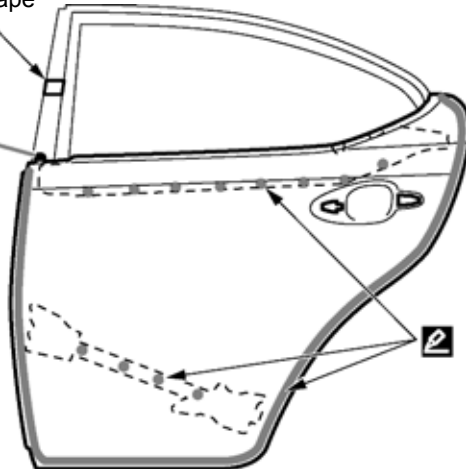
Symbol meaning

◻ : MIG Plug Weld + : Spot MIG Weld  : Braze  : Body Sealer

INSTALLATION

Positioning Tape

◻ - 1



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INSTALLATION POINT

- 1 Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and backside of the new parts.
HINT:
 - 1) Apply sealer evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter on the outer panel and apply just enough sealer for the reinforcement and side impact protection beam to make contact.
- 2 Bend the flange hem about 30_ with a hammer and dolly. Then, fasten tightly with a hemming tool.
HINT:
 - 1) Perform hemming in three steps, being careful not to warp the panel.
 - 2) If a hemming tool cannot be used, hem with a hammer and dolly.
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.