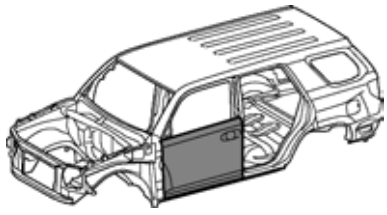
FRONT DOOR OUTER PANEL (ASSY)



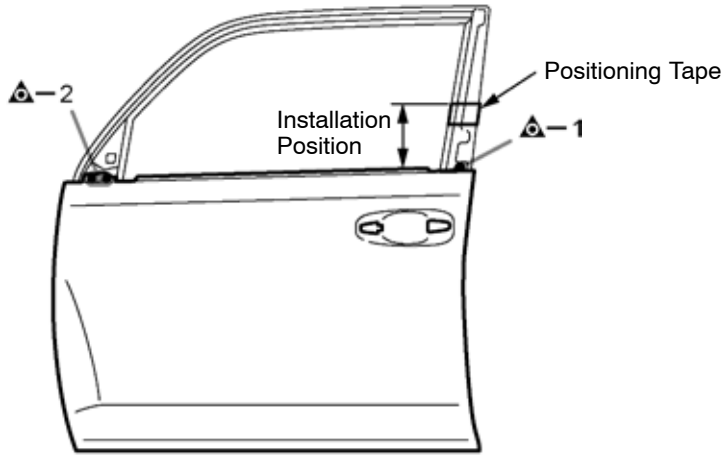
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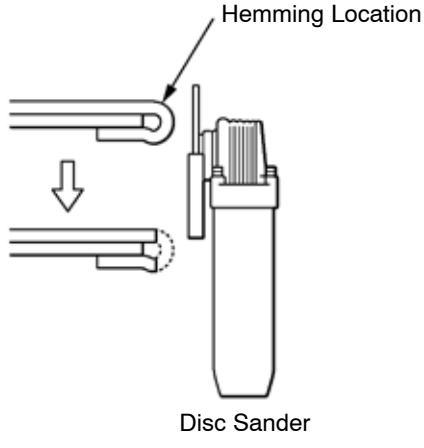
Symbol meaning

: Remove Weld Points

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REMOVAL





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REMOVAL POINT

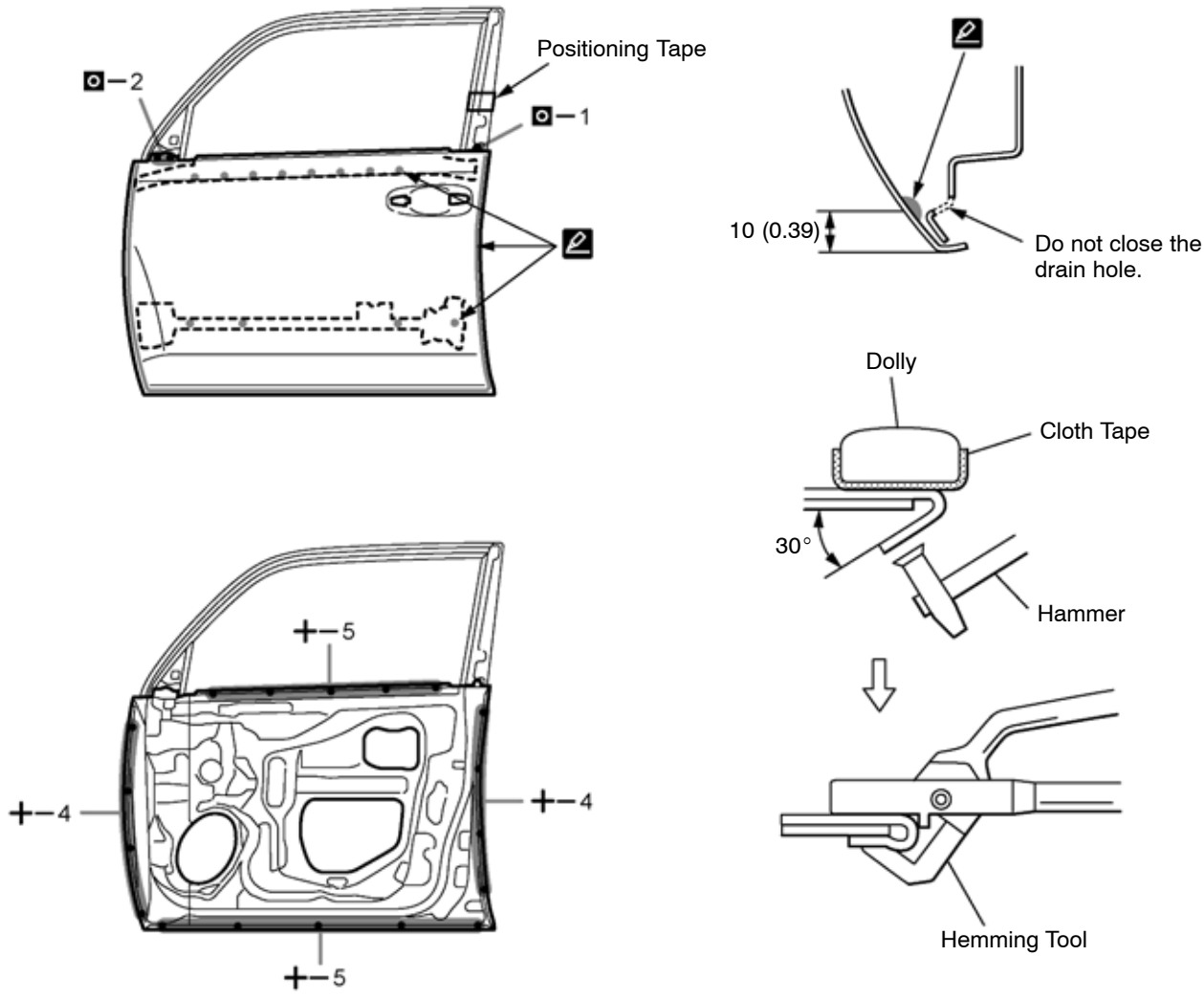
1 Before removing the outer panel, mark the installation position with tape.
2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
3 After grinding off the hemming location, remove the outer panel.

Symbol meaning

: Plug Weld : Spot MIG Weld : Body Sealer

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INSTALLATION



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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:
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:
- *Perform hemming in three steps, being careful not to warp the panel.*
- *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.