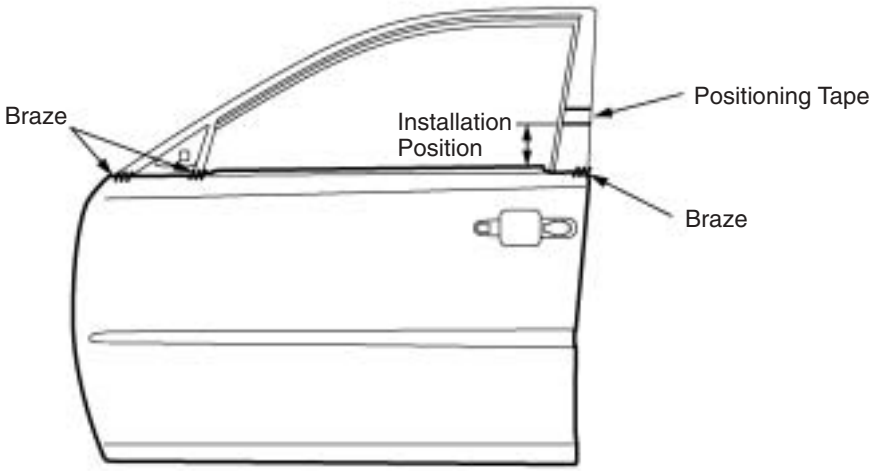
FRONT DOOR OUTER PANEL (ASSY)

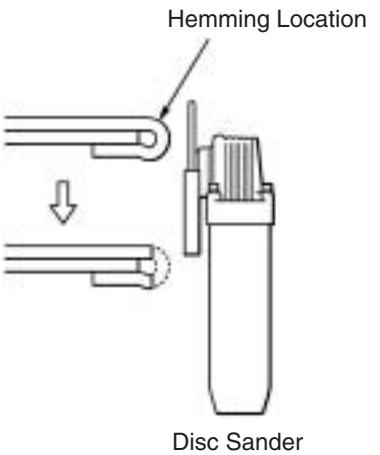
REPLACEMENT

1. REMOVE FRONT DOOR OUTER PANEL

(a) Before removing the outer panel, make the installation position with a tape.

(b) After grinding off the hemming location, remove the outer panel.





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2. INSTALL FRONT DOOR OUTER PANEL

(a) Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and back side of the new parts.

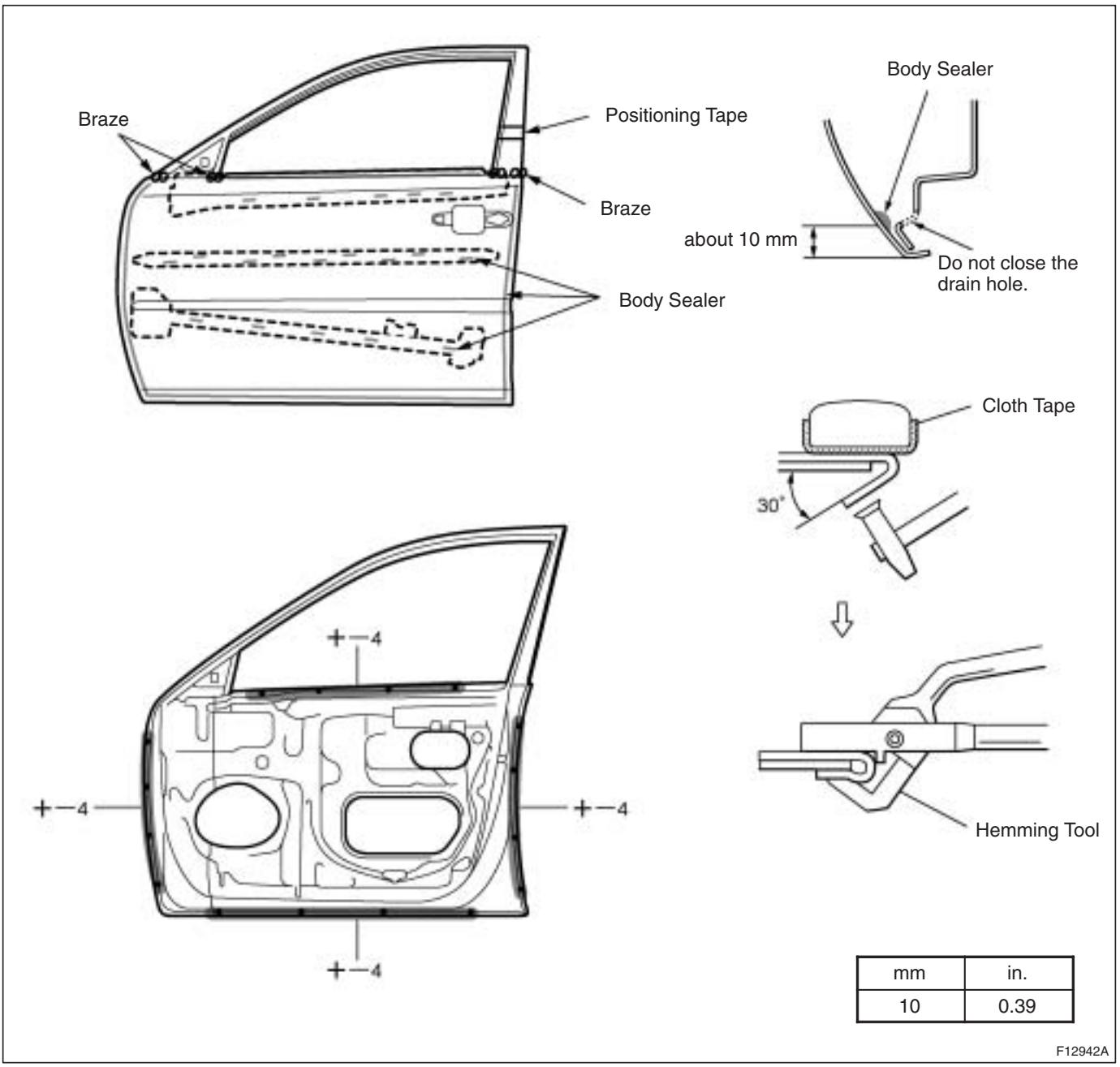
HINT:

- Apply just enough sealer for the reinforcement and side impact beam to touch the new panel. Apply sealer evenly around the flange area, about 10 mm (0.39 in.) from the edge, as shown.
- For other sealing points, refer to section PC.

(b) 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.



mm	in.
10	0.39

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3. APPLYING SEALER TO THE DOOR PARTS (See page PC-1)

4. APPLYING ANTI-RUST AGENT

(a) After applying the top coat layer, apply the anti-rust agent to the inside of the necked section structural weld spots.