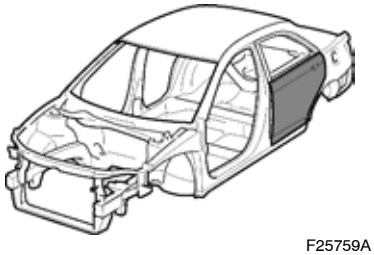
REAR DOOR OUTER PANEL (ASSY)



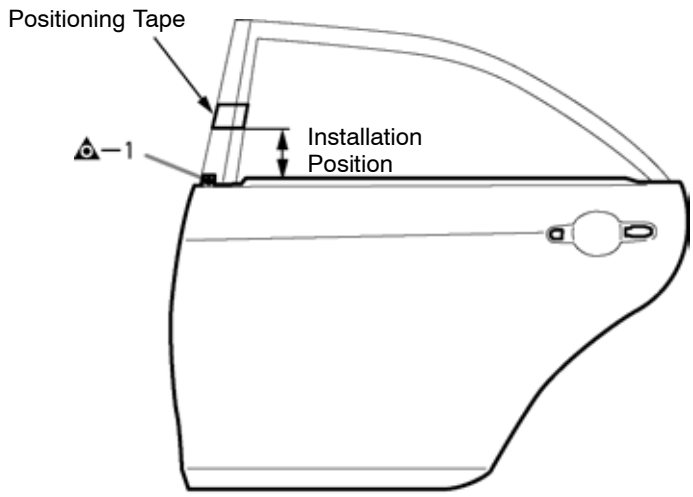
F25759A

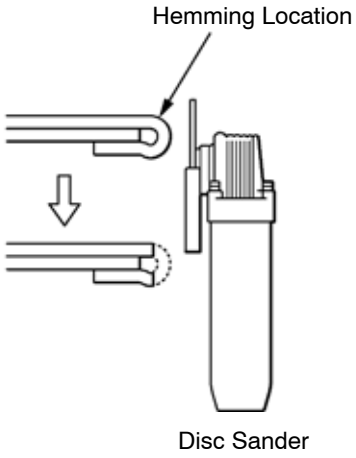
Symbol meaning

: Remove Weld Points

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REMOVAL





F25759

REMOVAL POINT

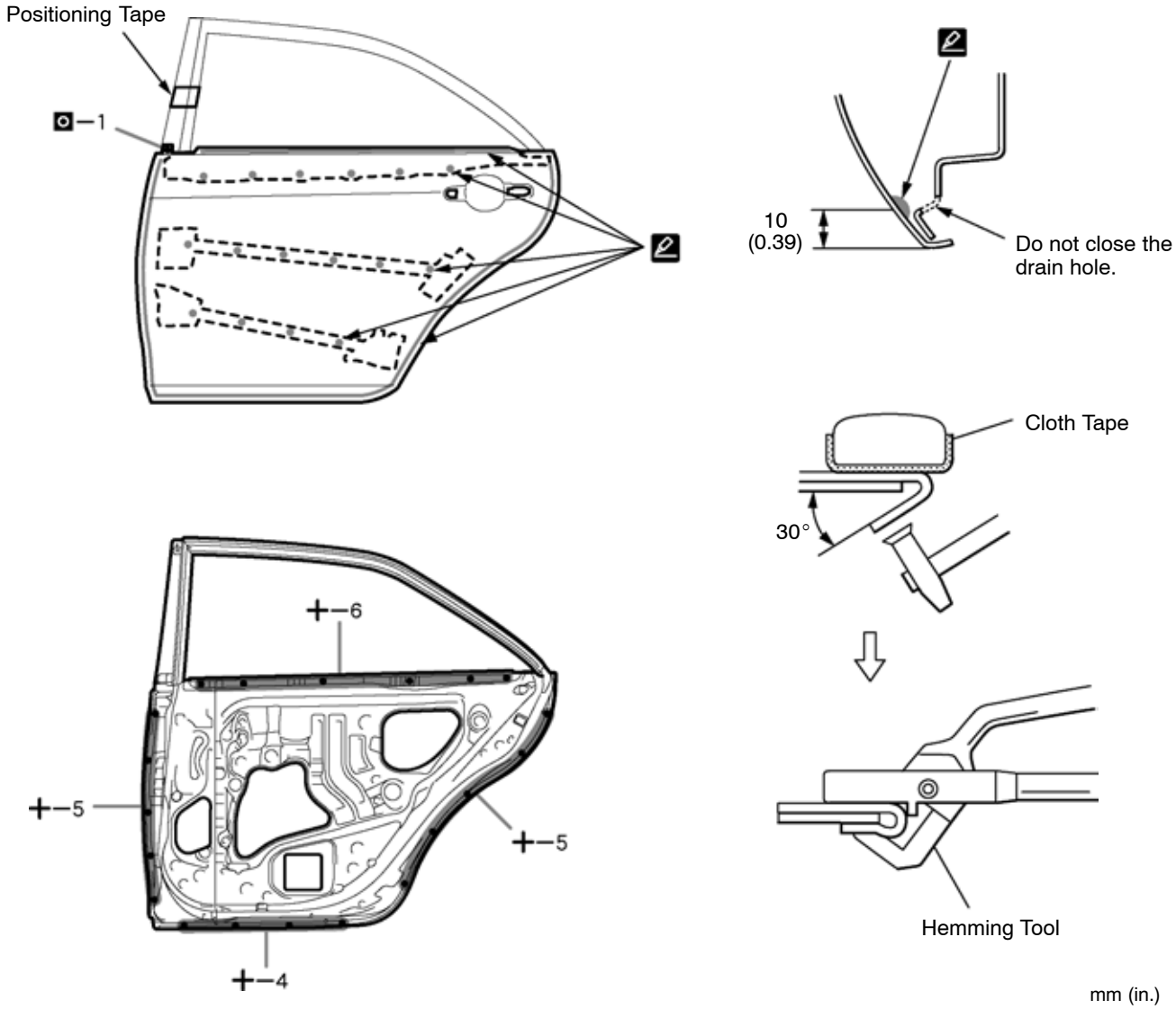
1 Before removing the outer panel, mark the installation position with tape.
2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
3 After grinding off the hemming location, remove the outer panel.

Symbol meaning

: MIG Plug Weld : Spot MIG Weld : Body Sealer

F25760B

INSTALLATION



F25760

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.