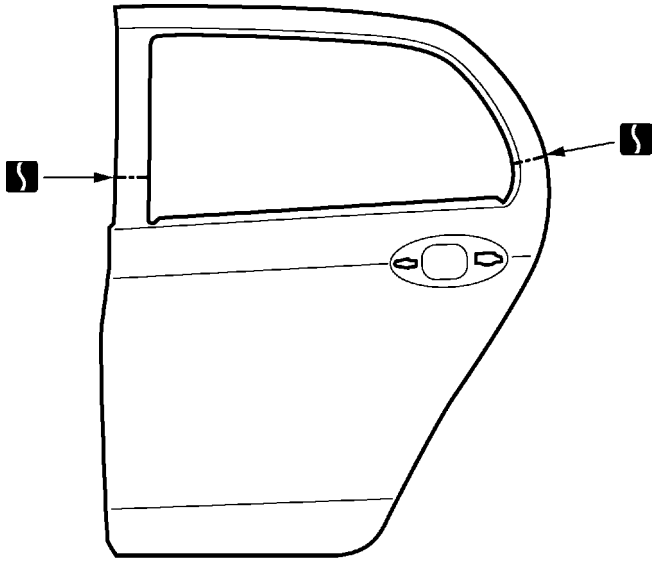
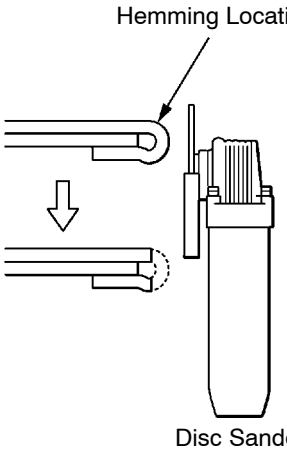
REAR DOOR OUTER PANEL (CUT): Hatchback 5 Door


F23309A

REPLACEMENT

REMOVAL





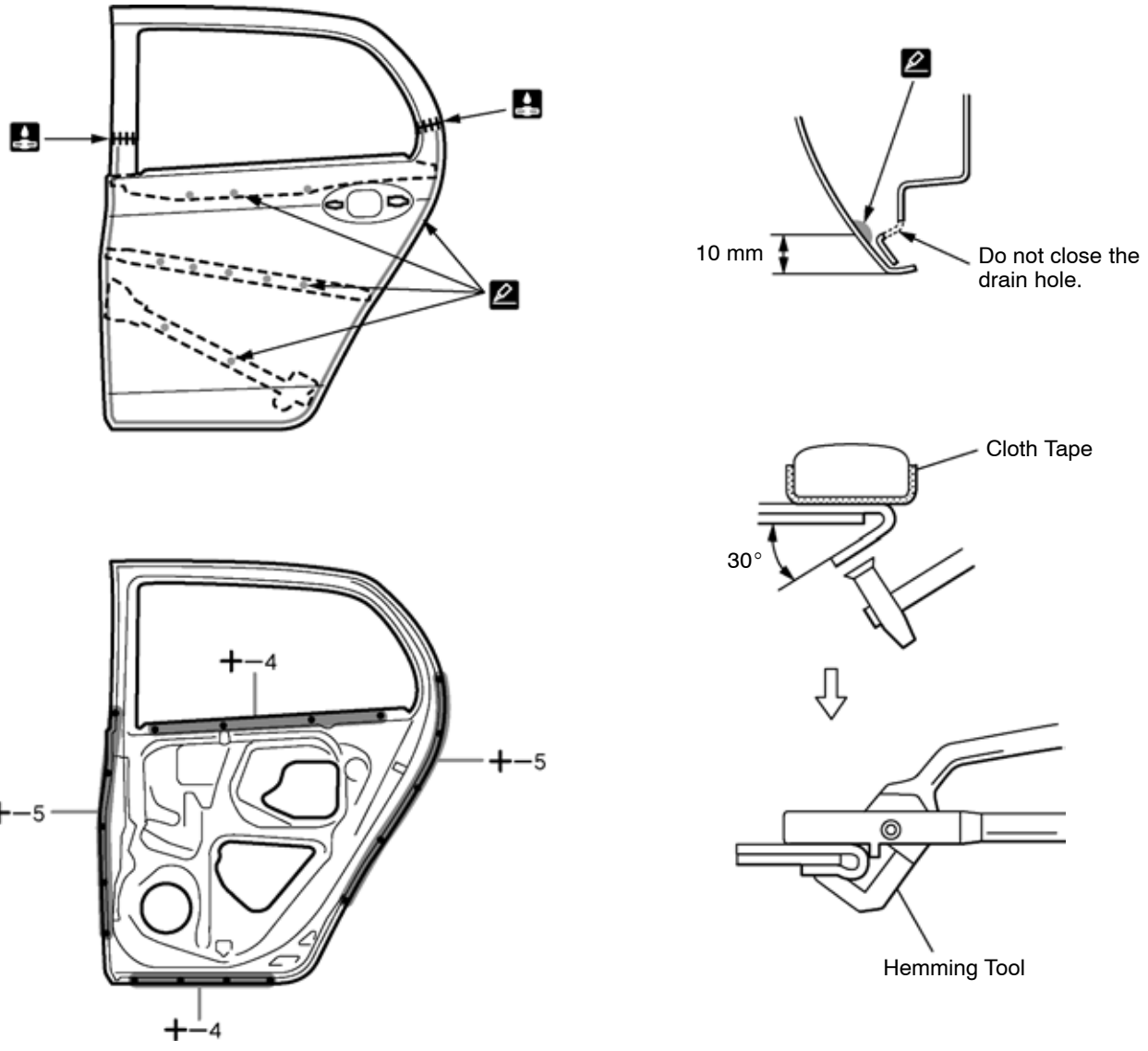
F23309

POINT

1 After grinding off the hemming location, remove the outer panel.

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

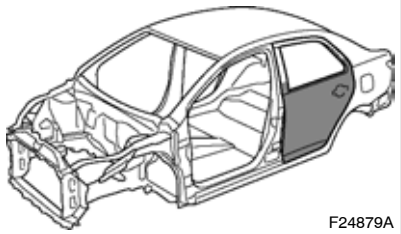


POINT

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 of 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.

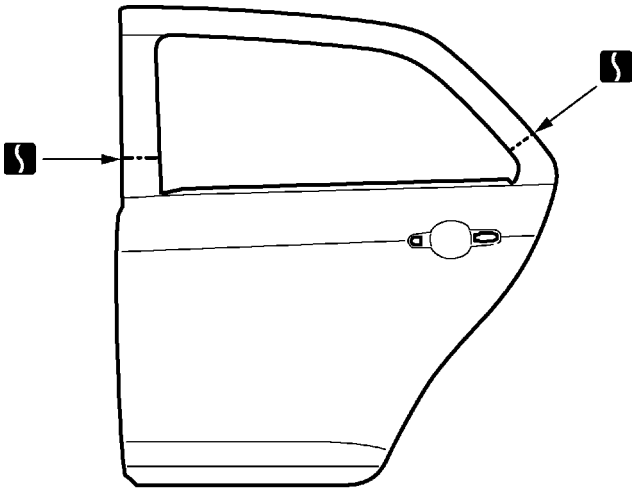
2 Bend the flange hem about 30° with a hammer and dolly. Then, fasten tightly with a hemming tool.
HINT:
1) Perform hemming in three steps, being careful not to warp the panel.
2) If a hemming tool cannot be used, hem with a hammer and dolly.

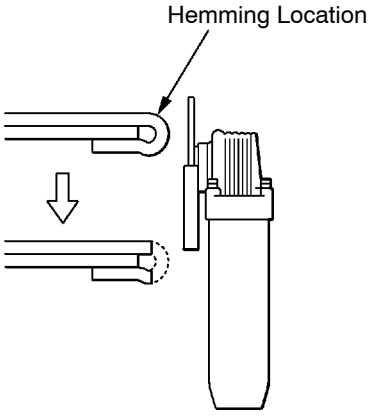
REAR DOOR OUTER PANEL (CUT): Sedan Ex. U.S.A., CANADA


F24879A

REPLACEMENT

REMOVAL





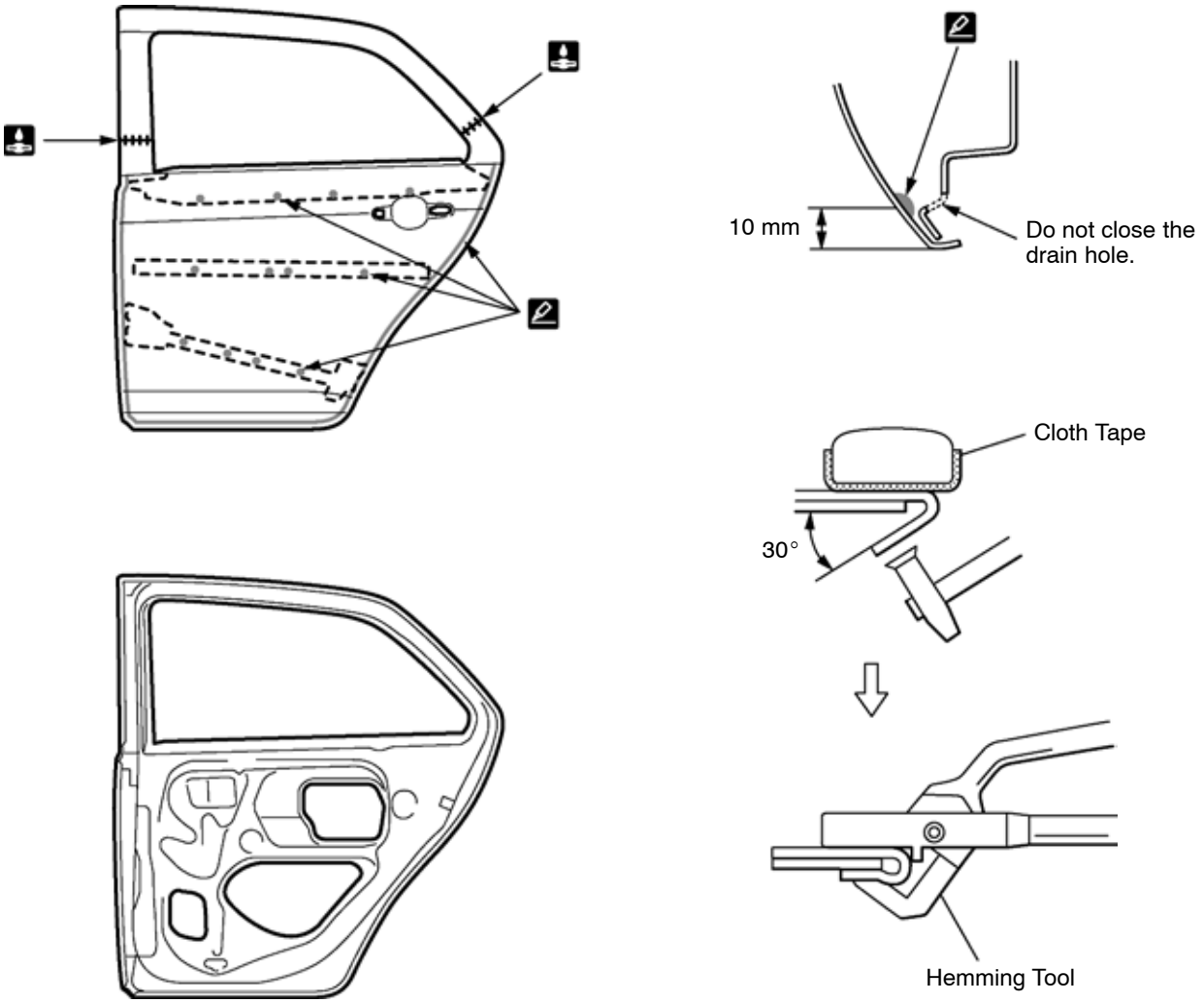
F24879

POINT

1 After grinding off the hemming location, remove the outer panel.

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply polyurethane foam to the corresponding parts.
- After welding, apply body sealer and undercoating to the corresponding parts.
- After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

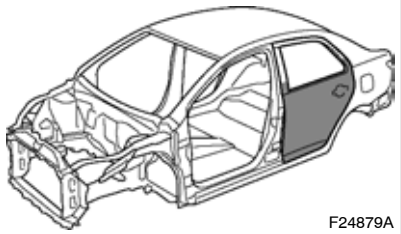


POINT

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 of 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.

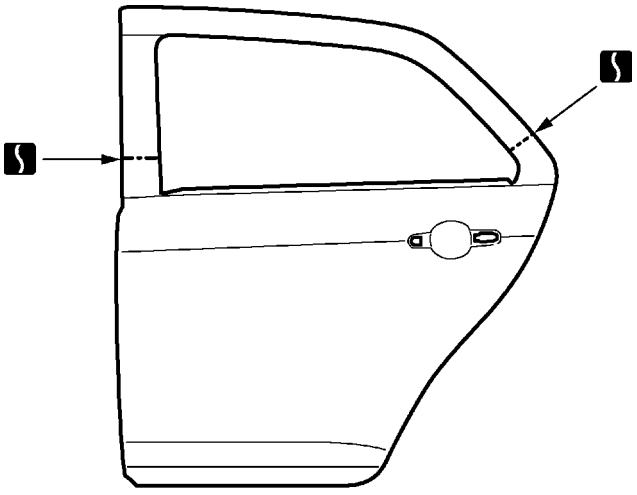
2 Bend the flange hem about 30° with a hammer and dolly. Then, fasten tightly with a hemming tool.
HINT:
1) Perform hemming in three steps, being careful not to warp the panel.
2) If a hemming tool cannot be used, hem with a hammer and dolly.

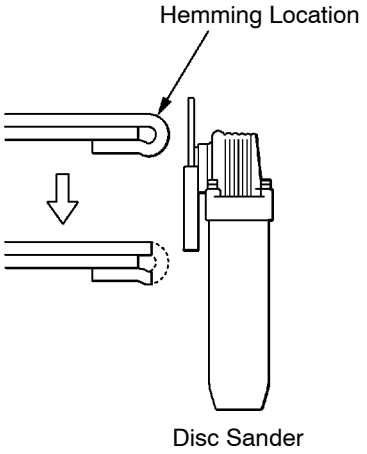
REAR DOOR OUTER PANEL (CUT): Sedan U.S.A., CANADA


F24879A

REPLACEMENT

REMOVAL





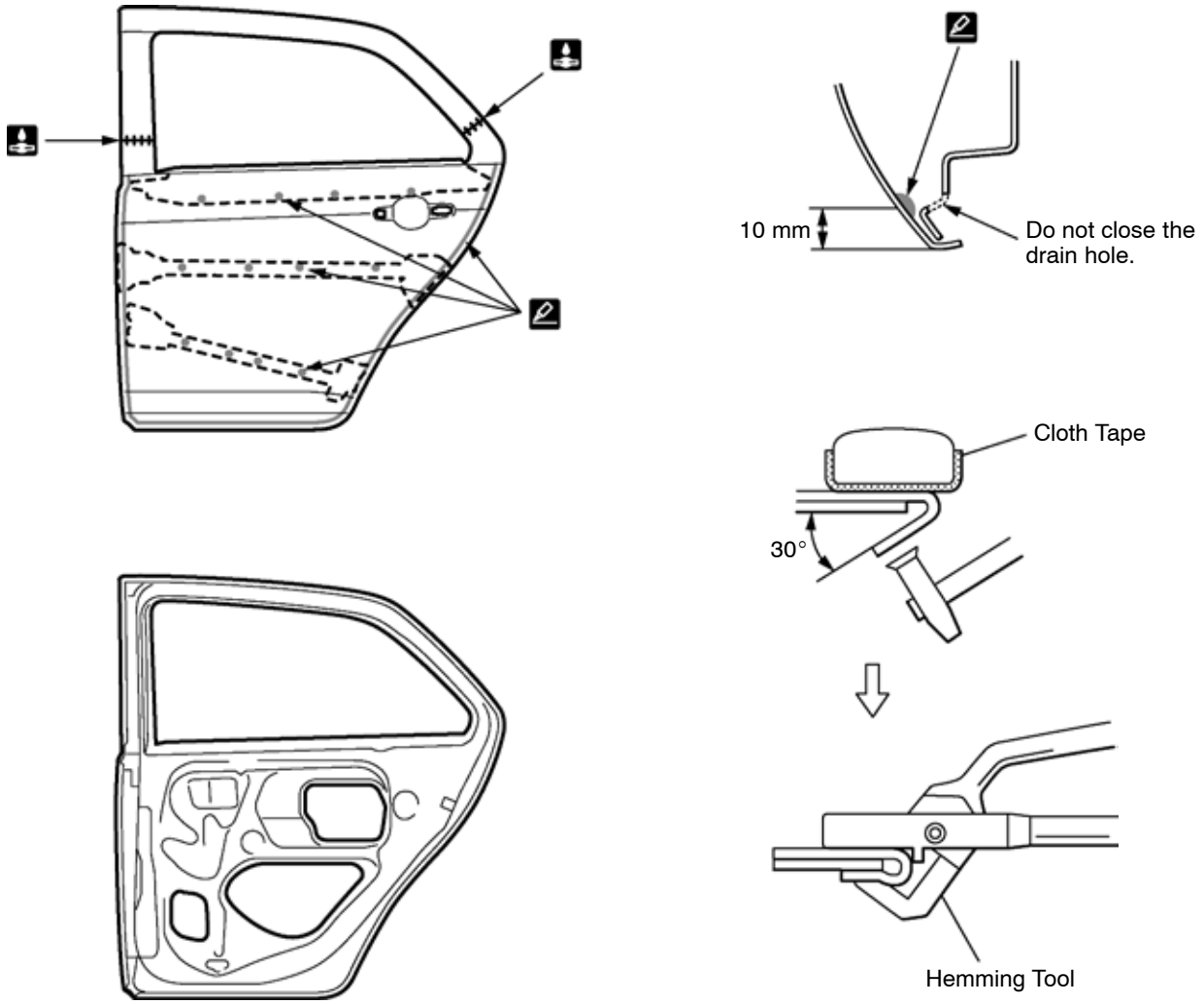
F24881

POINT

1 After grinding off the hemming location, remove the outer panel.

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply polyurethane foam to the corresponding parts.
- After welding, apply body sealer and undercoating to the corresponding parts.
- After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



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 of 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.