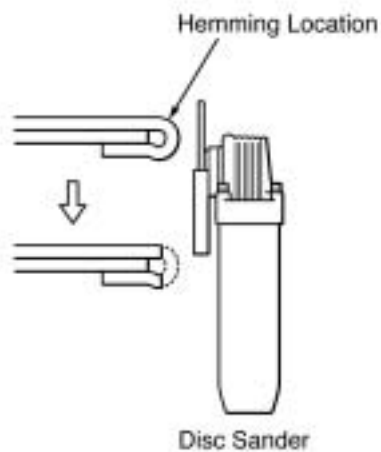
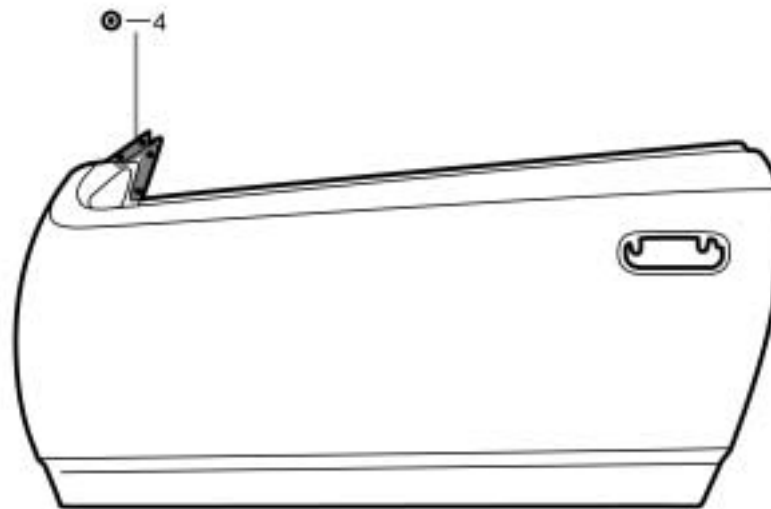


FRONT DOOR OUTER PANEL (ASSY) REPLACEMENT

1. REMOVE FRONT DOOR OUTER PANEL

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



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.

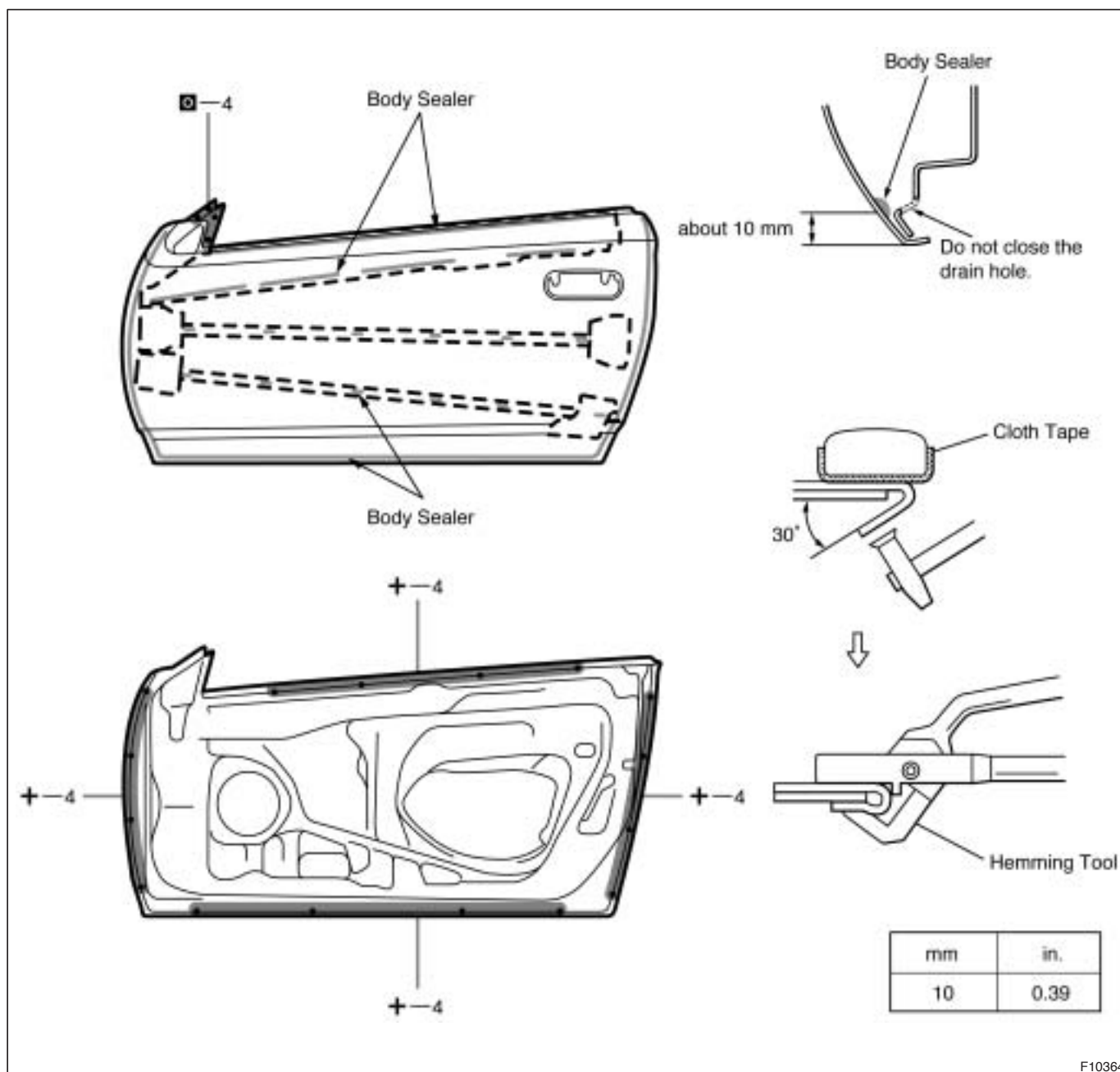
HINT:

- Apply sealer evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter to the outer panel and apply just enough sealer for the side impact protection beam to make contact.
- 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.



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.