

# Panel Replacement – Door Outer

## Removal Procedure

**CAUTION:** Refer to Glass and Sheet Metal Handling in Cautions and Notices.

1. Remove the door from the vehicle.
2. The outer door panel is folded over the inner door shell. Grind off the edges so that the outer door panel can be separated from the door shell.
3. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Cautions and Notices.
4. Straighten the edges of the door shell and grind it clean.

## Installation Procedure

1. Prepare all attachment surfaces as necessary.
2. Prime with 2- part catalyzed primer.
3. Position the door outer panel to the door shell, and ensure that alignment is correct.
4. Apply 2-3 mm (0.08-0.12 in.) bead of Lord 6449G metal bonding specification, or equivalent to the outer panel at hem flanges.
5. Install the door outer panel to the door shell.
6. Fold the front, rear and bottom edges of the door panel around the door shell using a plastic mallet and dolly. Continue to hammer in stages along each edge, before the adhesive cures.
7. Install the door to the vehicle and check for proper alignment, and adjust as necessary.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair in Cautions and Notices.
9. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems in Cautions and Notices.

