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## Door Opening Frame Replacement - Side

### Tools Required

J 42058 Frame Adapter Clamp

### Removal Procedure

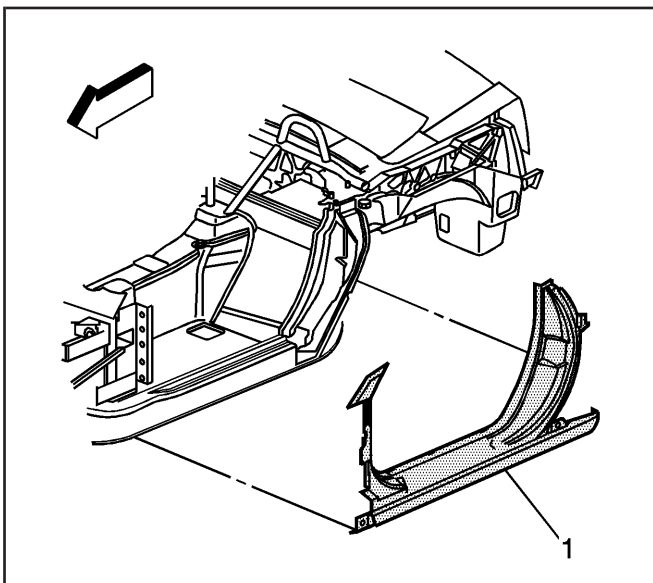
**Caution:** To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

The side door opening frame is made of sheet molded compound (SMC), and is bonded to the side structure and frame rail with structural adhesive.

1. Disable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-66.
2. Disconnect the negative battery cable.
3. Remove all related panels and components.

**Caution:** Fuel Vapors can collect while servicing fuel system parts in enclosed areas such as a trunk. To reduce the risk of fire and increased exposure to vapors: Use forced air ventilation such as a fan set outside of the trunk, plug or cap any fuel system openings in order to reduce fuel vapor formation, clean up any spilled fuel immediately, avoid sparks and any source of ignition, use signs to alert others in the work area that fuel system work is in process.

4. Make sure the fuel inlet is sealed before proceeding with repair procedure.
5. Remove the door frame by applying heat and pry to detach the adhesive (1) along the bonding surface.
6. Remove the door frame (1) from the vehicle.
7. Note the location of the adhesive and remove all remaining loose adhesive.
8. Inspect the side structure and frame rails for damage.
9. Restore as much of the damage as possible to the factory specifications. Refer to *Dimensions - Body* on page 2-2 and *Measurements - Underbody* on page 2-4.
10. Use J 42058 to secure the vehicle if pulling and straightening is required.



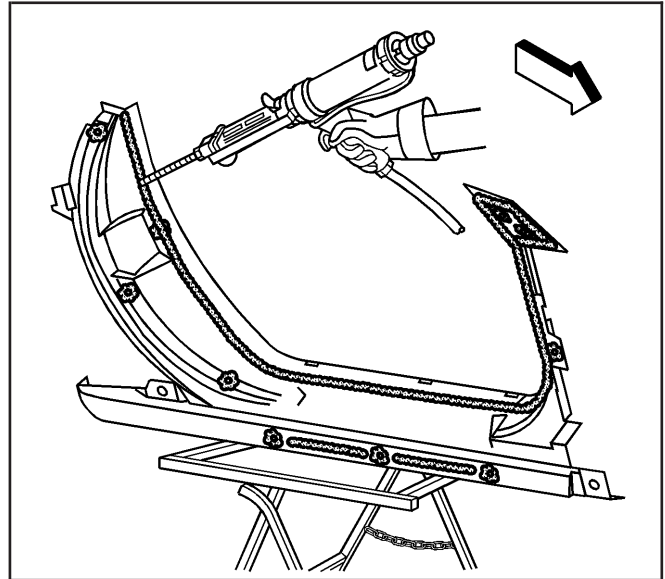
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## Installation Procedure

1. Before applying adhesive dry fit the door frame for proper fit and alignment.

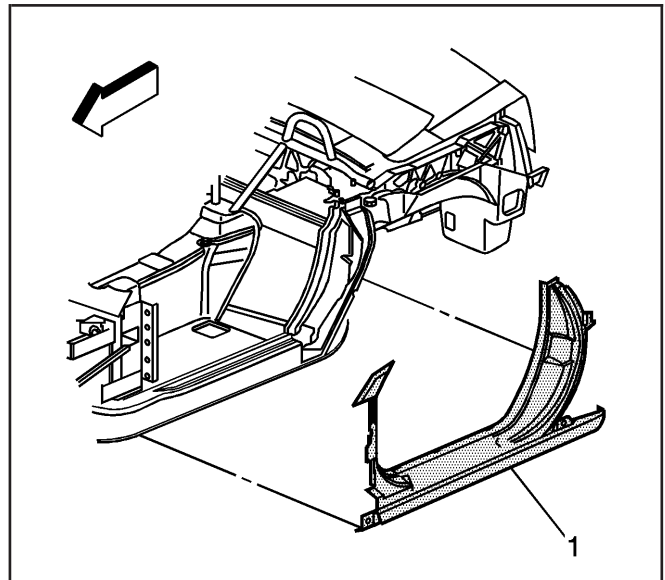
**Important:** DO NOT top coat any bonding surface. Use primer only on bonding surfaces. Refer to adhesive manufacturer's recommendations.

2. Clean and prepare all bonding mating surfaces according to adhesive manufacturer's recommendations.
3. Apply a consistent bead of structural adhesive (1) 10 mm (3/8 in) in diameter to the inner surface of the door frame to mate with the side structure and frame rail and to all areas originally bonded. Refer to *Sheet Molded Compound (SMC) Panel Bonding* on page 2-56.



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4. Position the door frame (1) to the vehicle.
5. Apply pressure to the door frame to set the adhesive.
6. Clamp or tape the door frame in place as necessary.
7. Remove any excess adhesive.
8. Install all related panels and components.
9. Connect the negative battery cable.
10. Enable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 2-66.



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