

Rear Side Door Outer Panel Replacement (MIG-Brazing)

Special Tools

- BO-6396 Bonding Pliers
- BO-6392 Flanging Tool Kit

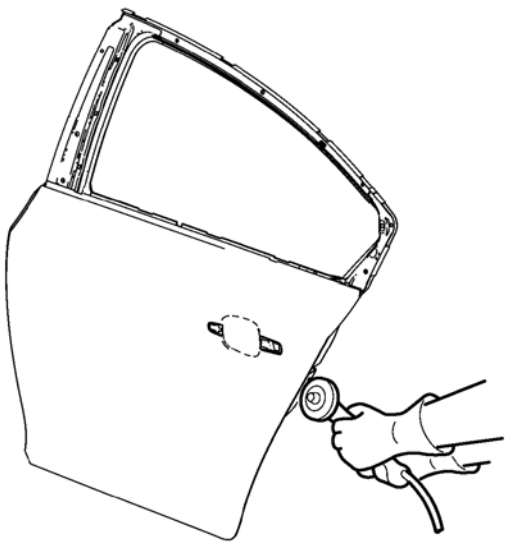
For equivalent regional tools, refer to [Special Tools](#).

Note: According to different corrosion warranties, only the regional mandatory joining methods are allowed.

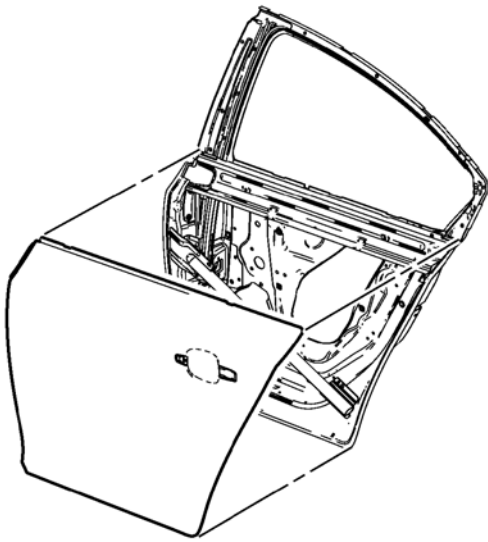
Removal Procedure

Warning: Refer to [Glass and Sheet Metal Handling Warning](#) in the Preface section.

1. Disable the SIR System. Refer to [SIR Disabling and Enabling](#).
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
3. Remove the rear side door. Refer to [Rear Side Door Replacement](#).
4. Remove the rear side door outside handle. Refer to [Rear Side Door Outside Handle Replacement](#).
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).



6. Grind the edges of the rear side door outer panel to separate the outer door panel from the door shell.



7. Remove the rear side door outer door panel.
8. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).
9. Straighten the edges of the door shell.

Installation Procedure

1. Apply structural adhesive on the flanges of the rear side door inner panel where the rear side door outer panel bears on.
2. Align the rear side door outer panel.
3. Verify the fit of the rear side door outer panel.