

## E. Door Frame Repair

### (1) Bent Door Frame Extrusions

**WARNING:** Remove or separate/insulate body panel from aluminum prior to heating or welding to prevent melting of panel.

(a) If the extrusion cannot be straightened, replace it as follows:

- (i) Remove Lock Pins from corner brackets using the Lock Pin removal tool.
- (ii) Remove all remaining Lock Pins attaching damaged component.
- (iii) Remove component.
- (iv) Install replacement extrusion per assembly instructions in this manual.

### (2) Cracked or Broken Door Frame Components

(a) Weld any cracked or broken extrusion using MIG or TIG welding equipment with welding wire of alloy AA5356 (AlMg5).

**WARNING:** Remove or separate/insulate body panel from aluminum prior to heating or welding to prevent melting of panel.

## F. Loose or Missing Fastener Replacement

Replace fasteners as follows:

Remove loose Lock Pins with a Lock Pin removal tool and install using an appropriate Lock Pin installation tool.

Note: For removal of Lock Pin and Collar, ACS recommends placing a piece of masking tape over the head of the pin to prevent it from flying off when the Collar is removed. (Drilling pins out from Collar with 9/32 inch drill bit is permissible for pins that are not accessible to the pin removal tool or just difficult to remove.)

## G. Panel Replacement (Major Damage)

- (1) Remove all Lock Pins securing panel in place
- (2) Remove the damaged panel
- (3) Install the new panel