

FIVE-HUNDRED AND MONTEGO DOOR OUTER PANEL REPLACEMENT INSTRUCTION SHEET

KIT - 7G13-5420182-AA (FRONT RIGHT HAND SIDE)		
Part Number	Description	Quantity
7G13-5420204	Door Outer Panel	1
5G13-5421124	Outer Belt Reinforcement	1
Motorcraft TA-1	Adhesive	1
PM-24-A or PM-24-B	Motorcraft Rust Inhibitor	1
SK 7G13-5420182-AA	Instruction Sheet	1

KIT - 7G13-5420183-AA (FRONT LEFT HAND SIDE)		
Part Number	Description	Quantity
7G13-5420205	Door Outer Panel	1
5G13-5421125	Outer Belt Reinforcement	1
Motorcraft TA-1	Adhesive	1
PM-24-A or PM-24-B	Motorcraft Rust Inhibitor	1
SK 7G13-5420182-AA	Instruction Sheet	1

KIT - 7G13-5420184-AA (REAR RIGHT HAND SIDE)		
Part Number	Description	Quantity
7G13-5424704	Door Outer Panel	1
5G13-5426086	Outer Belt Reinforcement	1
Motorcraft TA-1	Adhesive	1
PM-24-A or PM-24-B	Motorcraft Rust Inhibitor	1
SK 7G13-5420182-AA	Instruction Sheet	1

KIT -7G13-5420185-AA (REAR LEFT HAND SIDE)		
Part Number	Description	Quantity
7G13-5424705	Door Outer Panel	1
5G13-5426087	Outer Belt Reinforcement	1
Motorcraft TA-1	Adhesive	1
PM-24-A or PM-24-B	Motorcraft Rust Inhibitor	1
SK 7G13-5420182-AA	Instruction Sheet	1



SERVICE PROCEDURE- DOOR SKIN REPLACEMENT

Overview: The replacement of this door skin is similar to other vehicles; however, the upper window frame area will be left intact and joined to the new lower skin as described in the procedure

1. Remove interior door trim panel, and all internal door components, including the window glass and mechanisms, following the appropriate workshop manual section.
2. Remove all exterior door trim, including mirror, moldings, weatherstrips, and handle assembly.
3. Remove the door shell and place on a work stand.
4. Using a high speed cut off wheel, make the cuts to the beltline area of the door skin following Figure 1.
5. Using a grinder, grind the perimeter of the door hem to separate the hem edges, following Figure 1.
6. Before removal of the skin, use a sharp knife to cut the adhesive between the door outer skin and the flutter, beltline reinforcement, and intrusion beams.
7. Remove the original skin, using a flat bladed air chisel as required.
8. Trial fit the new door skin to the door frame, and carefully mark the cut lines on the skin to match the cuts on the original skin.
9. Cut the new door skin, and trial fit again to ensure proper alignment.
10. Prepare the skin and door frame joint areas by grinding clean all mating surfaces, including the inner hem, outer belt reinforcement, intrusion beam, and flutter beam areas (refer to Figures 2 and 3).
11. Apply Motorcraft TA-1 adhesive to the following areas: new door skin hem, intrusion beam to door skin, flutter beam to door skin, and the outer belt reinforcement to door skin (refer to Figures 2 and 3).
12. Spot weld the outer belt reinforcement to the doorskin as shown in Figure 2.
13. Position and align the new door skin to the frame, and carefully turn the assembly over to begin hemming process.
14. Using door skin installation tool or the hammer and dolly method, close the perimeter door hem and smooth any residual adhesive in the joints.
15. Turn the door over, then MIG weld the upper beltline joint. Finish grind and trial fit the upper beltline molding and mirror (refer to Figure 4).
16. Prime and paint door using Ford approved paint system.
17. Apply Motorcraft PM-24 Anti-Corrosion treatment to all hem areas and especially the upper beltline area.
18. Reassemble and realign door to vehicle.



CPR © 2007 FORD MOTOR COMPANY
DEARBORN, MICHIGAN 48121
3-07

SK 7G13-5420182-AA

SHEET 2 OF 4

**FIVE-HUNDRED AND MONTEGO DOOR OUTER PANEL
REPLACEMENT INSTRUCTION SHEET**

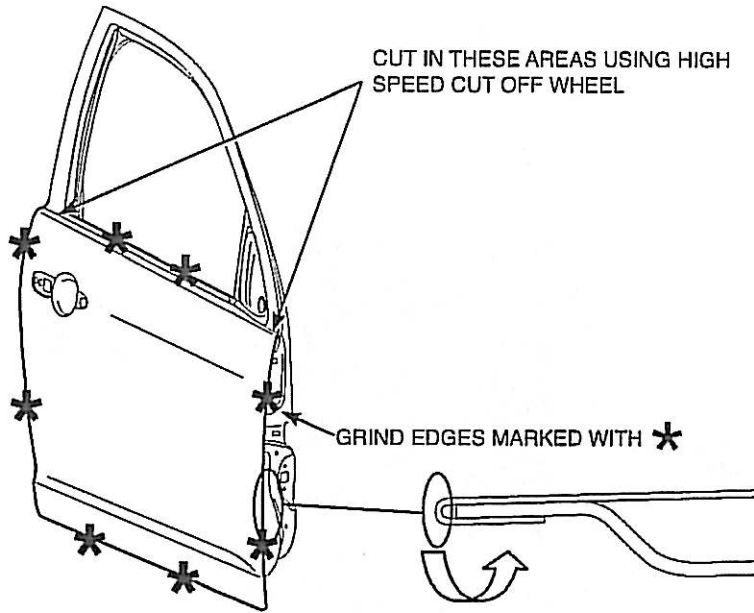


FIGURE 1

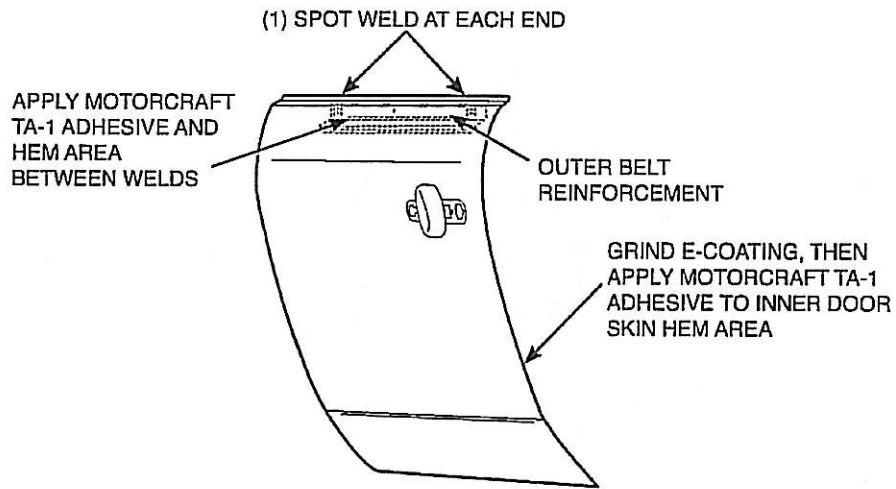


FIGURE 2



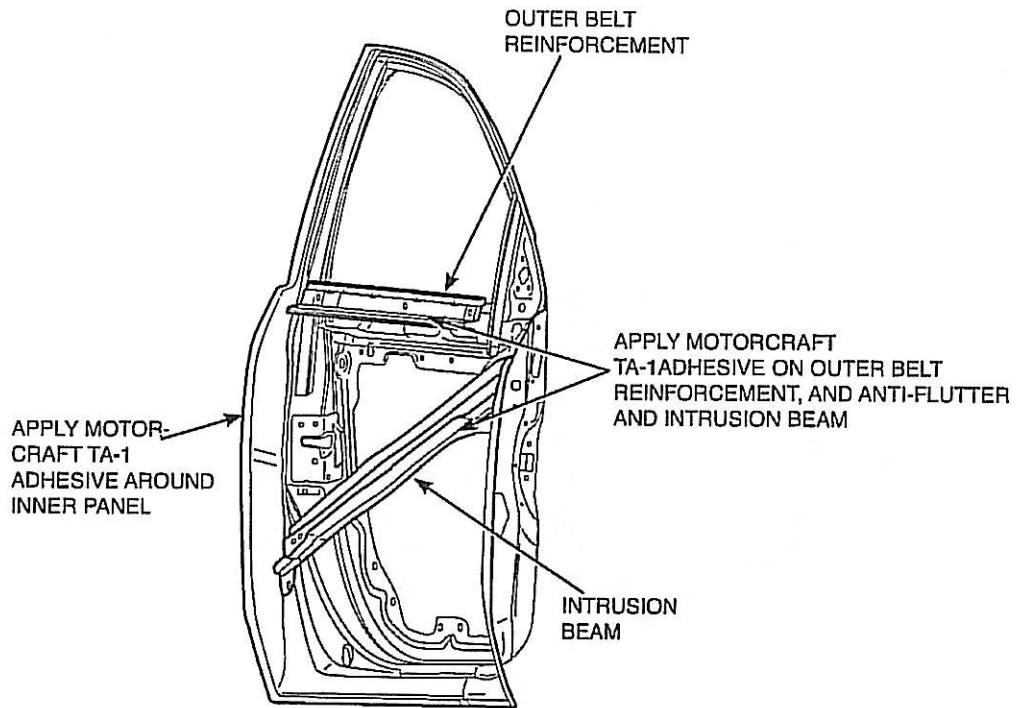


FIGURE 3

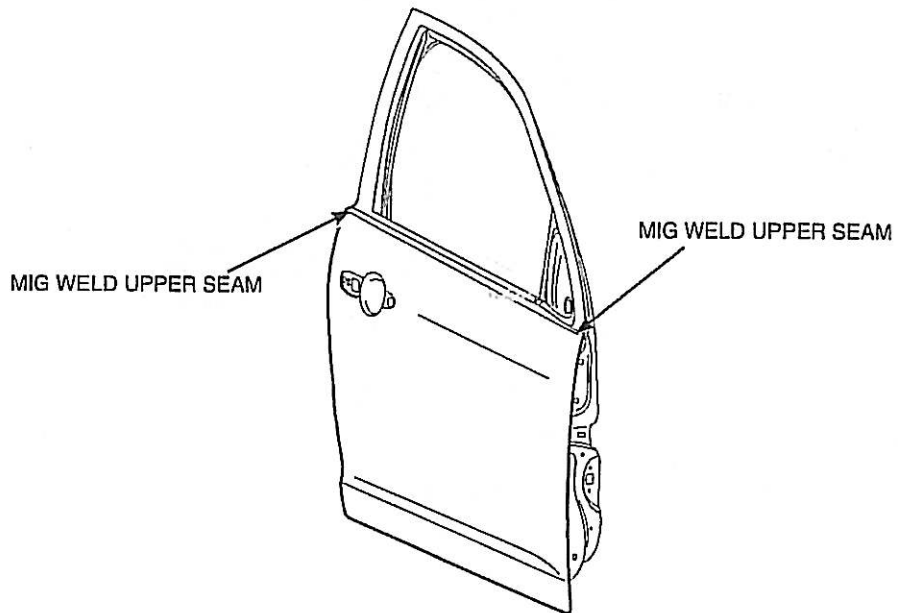


FIGURE 4

