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31 - Collision Information

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Warning

SAFETY NOTICE

CAUTION: All service and rebuilding instructions contained herein are applicable to, and for the convenience of, the automotive trade only. All test and repair procedures on components or assemblies in non-automotive applications should be repaired in accordance with instructions supplied by the manufacturer of the total product.

Proper service and repair is important to the safe, reliable operation of all motor vehicles. The service produces recommended and described in this publication were developed for professional service personnel, and are effective methods for performing vehicle repair. Following these procedures will help ensure efficient economical vehicle performance and service reliability. Some service procedures require the use of special tools designed for specific procedures. These special tools should be used as recommended throughout this publication.

Special attention should be exercised when working with spring-or tension-loaded fasteners and devices such as E-Clips, Circlips, Snap rings, etc., since careless removal may cause personal injury. Always wear safety goggles when working on vehicles or vehicle components.

It is important to note that this publication contains various Cautions and Warnings. These should be read carefully in order to minimize risk of personal injury or the possibility that improper service methods may damage the vehicle or render it unsafe. It is important to note that these Cautions and Warnings cover only the situations and procedures Chrysler Group LLC has encountered and recommended. Chrysler Group LLC cannot possibly know, evaluate, and advise the service trade of all conceivable ways in which service may be performed, or of the possible hazards of each. Consequently, Chrysler Group LLC has not undertaken any such broad service review. Accordingly, anyone uses a service procedure or tool that is not recommended in this publication must be certain that neither personal safety, nor vehicle safety, will be jeopardized by the service methods they select.

USE OF HEAT DURING REPAIR

WARNING: Chrysler Group LLC engineering's position on the use of heat during collision repair is as follows:

- Any body panel or frame component damaged which is to be repaired and reused, must be repaired using the "cold straightening" method. No heat may be used during the straightening process.
- During rough straightening prior to panel replacement, damaged panels or frame components may be heated to assist in body/frame realignment. The application of heat must be constrained to the parts which will be replaced and not allowed to affect any other components.

This "no heat" recommendation is due to the extensive use of high strength and advanced high strength steels in Chrysler Group LLC products. High-strength materials can be substantially and negatively affected from heat input which will not be obviously known to the repairer or consumer.

Ignoring these recommendations may lead to serious compromises in the ability to protect occupants in a future collision event, reduce the engineered qualities and attributes, or decrease the durability and reliability of the vehicle.

This statement supersedes any previously released information by the Chrysler Group LLC.

Failure to follow these instructions may result in serious or fatal injury.

Standard Procedure

SERVICE AFTER A SUPPLEMENTAL RESTRAINT SYSTEM DEPLOYMENT

Any vehicle which is to be returned to use following a Supplemental Restraint System (SRS) component deployment must have the deployed restraints replaced. In addition, the following guidelines **MUST** be observed.

- **Following ANY major vehicle impact damage in the vicinity of an impact sensor or the ORC** - It is critical that the mounting surfaces and mounting brackets for the Occupant Restraint Controller (ORC), front impact sensors and side impact sensors located within the proximity of the impact damage be closely inspected and restored to their original conditions. Because the ORC and each impact sensor are used by the SRS to monitor or confirm the direction and severity of a vehicle impact, improper orientation or insecure fastening of these components may cause airbags not to deploy when required, or to deploy when not required.
- **Following ANY airbag deployment event** - The Lower Anchors and Tethers for CHildren (LATCH) provisions, the upper tether anchors (if equipped) and all interior trim panels must also be inspected.
- **If an active head restraint is deployed** - An inertia-based Active Head Restraint (AHR) unit that is undamaged following a deployment automatically resets itself. These units are designed with the intention of reuse.
- **If the driver airbag is deployed** - If the Driver AirBag (DAB) has been deployed, the DAB, the clockspring, the steering wheel, the steering column assembly including the intermediate shaft and coupler, both front seat belt retractor and tensioner assemblies, and all other seat belt retractors and buckles in use must be replaced. The front impact sensors must be inspected.
- **If the passenger airbag is deployed** - If the Passenger AirBag (PAB) has been deployed, the PAB, the instrument panel and the PAB wire harness or connector must be replaced.
- **If a seat airbag is deployed** - If a Seat AirBag (SAB) (also known as the pelvic and thoracic airbag) has been deployed, the SAB, the SAB jumper wire harness, the thermoplastic SAB chute, the seat back frame, the seat back foam, the seat back trim cover and the side impact sensors on the same side of the vehicle as the deployed airbag must be replaced. Both front seat belt retractor and tensioner assemblies, and all other seat belt retractors and buckles in use must be replaced.
- **If a seat belt tensioner is deployed** - The seat belt tensioners are deployed in conjunction with the front airbags, but can also be deployed with a Seat AirBag (SAB) (also known as the pelvic and thoracic airbag) or side curtain airbags (also known as Side AirBag Inflatable Curtains/SABIC). All seat belt tensioners must be replaced if any airbag in the vehicle has been deployed.
- **If a side curtain airbag is deployed** - If a side curtain airbag (also known as Side AirBag Inflatable Curtain/SABIC) has been deployed, the SABIC, the upper A and C-pillar trim, the upper quarter trim and the side impact sensors on the same side of the vehicle as the deployed airbag must be replaced. The headliner, both front seat belt retractor and tensioner assemblies, and all other seat belt retractors and buckles in use must be replaced. For vehicles with an optional sunroof, the sunroof and the sunroof drain tubes and hoses must be inspected.

The components identified with the deployed SRS components in the preceding list are not intended for reuse and will be damaged or weakened as a result of an airbag deployment, which may or may not be obvious during a visual inspection. All other vehicle components should be closely inspected following any SRS component deployment, but are to be replaced only as required by the extent of the visible damage incurred.

SQUIB CIRCUIT DAMAGE

In addition to the preceding guidelines, be aware that the heat created by the initiator during an airbag or tensioner deployment will cause collateral damage to the connected wiring (squib circuits) and connector insulators. There are two methods by which an airbag or seat belt tensioner may be connected to the vehicle electrical system. The first method involves a short pigtail harness and connector insulator that are integral to the airbag or tensioner unit and are replaced as a unit with the service replacement airbag or seat belt tensioner. This connection method typically requires no additional wiring repair following a deployment.

However, the second connection method involves a wire harness takeout and connector insulator that are connected directly to the airbag or tensioner initiator or squib. These direct-connect type take outs and connector insulators **MUST** be repaired following an airbag or seat belt tensioner deployment using the approved Supplemental Restraint System Wiring Repairs procedure. ([Refer to 10 - Restraints - Standard Procedure](#)).

AIRBAG SQUIB STATUS

Multistage airbags with multiple initiators (squibs) must be checked to determine that all squibs were used during the deployment event. The Driver AirBag (DAB) and Passenger AirBag (PAB) in this vehicle are deployed by electrical signals generated by the Occupant Restraint Controller (ORC) through the driver or passenger squib 1 and

squib 2 circuits to the two initiators in the airbag inflators. Typically, both initiators are used and all potentially hazardous chemicals are burned during an airbag deployment event. However, it is possible for only one initiator to be used; therefore, it is always necessary to confirm that both initiators have been used in order to avoid the improper handling or disposal of potentially live pyrotechnic or hazardous materials. The following procedure should be performed using a diagnostic scan tool to verify the status of both airbag squibs before either deployed airbag is removed from the vehicle for disposal.

CAUTION: Deployed front airbags having two initiators (squibs) in the airbag inflator may or may not have live pyrotechnic material within the inflator. Do not dispose of these airbags unless you are certain of complete deployment. Refer to the Hazardous Substance Control System for information regarding the potentially hazardous properties of the subject component and the proper safe handling procedures. Then dispose of all non-deployed and deployed airbags and seat belt tensioners in a manner consistent with state, provincial, local and federal regulations.

1. Be certain that the diagnostic scan tool contains the latest version of the proper diagnostic software. Connect the scan tool to the 16-way Data Link Connector (DLC). The DLC is located on the driver side lower edge of the instrument panel, outboard of the steering column.
2. Transition the status of the ignition switch to On.
3. Using the scan tool, read and record the active (current) Diagnostic Trouble Code (DTC) data.

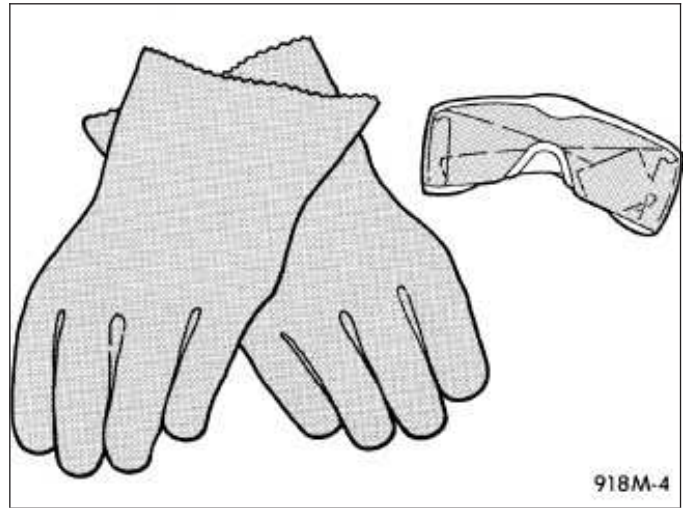
Using the active DTC information, refer to the **Airbag Squib Status** table to determine the status of both DAB squibs and both PAB squibs.

AIRBAG SQUIB STATUS		
IF THE ACTIVE DTC IS:	CONDITIONS	SQUIB STATUS
Driver or Passenger Squib 1 open	AND the stored DTC minutes for both Driver or Passenger squibs are within 15 minutes of each other	Both Squib 1 and 2 were used.
Driver or Passenger Squib 2 open		
Driver or Passenger Squib 1 open	AND the stored DTC minutes for Driver or Passenger Squib 2 open is GREATER than the stored DTC minutes for Driver or Passenger Squib 1 by 15 minutes or more	Squib 1 was used; Squib 2 is live.
Driver or Passenger Squib 2 open		
Driver or Passenger Squib 1 open	AND the stored DTC minutes for Driver or Passenger Squib 1 open is GREATER than the stored DTC minutes for Driver or Passenger Squib 2 by 15 minutes or more	Squib 1 is live; Squib 2 was used.
Driver or Passenger Squib 2 open		
Driver or Passenger Squib 1 open	AND Driver or Passenger Squib 2 open is NOT an active code	Squib 1 was used; Squib 2 is live.
Driver or Passenger Squib 2 open	AND Driver or Passenger Squib 1 open is NOT an active code	Squib 1 is live; Squib 2 was used.

NOTE: If none of the Driver or Passenger Squib 1 or 2 open are active codes, the status of the airbag squibs is unknown. In this case the airbag should be handled and disposed of as if the squibs were both live.

CLEANUP PROCEDURE

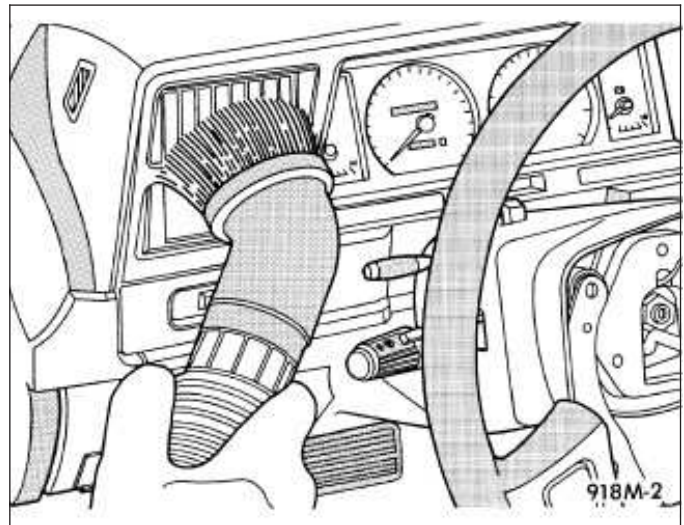
Following a Supplemental Restraint System (SRS) component deployment, the vehicle interior will contain a powdery residue. This residue consists primarily of harmless particulate by-products of the small pyrotechnic charge that initiates the propellant used to deploy a SRS component. However, this residue may also contain traces of sodium hydroxide powder, a chemical by-product of the propellant material that is used to generate the inert gas that inflates the airbag. Since sodium hydroxide powder can irritate the skin, eyes, nose, or throat, be certain to wear safety glasses, rubber gloves, and a long-sleeved shirt during cleanup.



WARNING: To avoid serious or fatal injury, if you experience skin irritation during cleanup, run cool water over the affected area. Also, if you experience irritation of the nose or throat, exit the vehicle for fresh air until the irritation ceases. If irritation continues, see a physician.

1. Begin the cleanup by using a vacuum cleaner to remove any residual powder from the vehicle interior. Clean from outside the vehicle and work your way inside, so that you avoid kneeling or sitting on a non-cleaned area.
2. Be certain to vacuum the heater and air conditioning outlets as well. Run the heater and air conditioner blower on the lowest speed setting and vacuum any powder expelled from the outlets.

CAUTION: Deployed front airbags having two initiators (squibs) in the airbag inflator may or may not have live pyrotechnic material within the inflator. Do not dispose of these airbags unless you are certain of complete deployment. Refer to the AIRBAG SQUIB STATUS heading within this information. All damaged, ineffective, or non-deployed Supplemental Restraint System (SRS) components which are replaced on vehicles are to be handled and disposed of properly. If an airbag or seat belt tensioner unit is ineffective or damaged and non-deployed, refer to the Hazardous Substance Control System for information regarding the potentially hazardous properties of the subject component and the proper safe handling procedures. Then dispose of all non-deployed and deployed airbags and seat belt tensioners in a manner consistent with state, provincial, local and federal regulations.



3. Next, remove the deployed SRS components from the vehicle. Refer to the appropriate service removal procedures.
4. You may need to vacuum the interior of the vehicle a second time to recover all of the powder.

BASE COAT/CLEARCOAT FINISH

The original equipment paint finish is a multi step process that involves cleaning, applying electro de-position (E-coat), anti-chip primer, basecoat, and clearcoat steps.

CAUTION: Do not use abrasive chemicals, abrasive compounds or harsh alkaline based cleaning solvents on the painted surfaces of a vehicle. Failure to follow this caution can result in damage to vehicle finish.

On most vehicles a two-part paint application (basecoat/clearcoat) is used. Color paint that is applied to primer is called basecoat. A clear coat paint is then applied to protect the basecoat from ultraviolet light and to provide a durable high-gloss finish.

FINESSE SANDING, BUFFING, AND POLISHING

CAUTION: Do not remove more than 0.5 mils of clearcoat finish when sanding, hand buffing or polishing. Basecoat paint must retain clearcoat for durability.

CAUTION: If the finish has been finesse sanded in the past, it cannot be repeated. Failure to follow this caution can result in damage to vehicle finish.

NOTE: Finesse sanding should only be performed by a trained automotive paint technician.

Minor acid etching, orange peel, or smudging in a clearcoat or single-stage finish can be reduced with light finesse sanding, hand buffing and polishing. Use a Paint Thickness Gauge #PR-ETG-2X or equivalent to determine clearcoat or single-stage paint thickness before and after the repair.

PAINT TOUCH-UP

If the painted metal surface of a vehicle becomes scratched or chipped, it should be touched-up as soon as possible to avoid corrosion.

WARNING: Use an OSHA approved respirator and safety glasses when spraying paint or solvents. Failure to follow this warning may result in possible personal injury or death.

When repairing painted metal surfaces, for best results, use MOPAR® Scratch Filler/Primer, Touch-Up Paints and Clear Top Coat.

1. Scrape any loose paint and corrosion from inside the scratch or chip.

WARNING: Avoid prolonged skin contact with petroleum or alcohol-based cleaning solvents. Failure to follow this warning can result in possible personal injury or death.

2. Clean affected area with MOPAR® Tar/Road Oil Remover or equivalent, and allow to dry.
3. Fill the inside of the scratch or chip with a coat of filler/primer. Do not overlap primer onto good surface finish. The applicator brush should be wet enough to puddle-fill the scratch or chip without running. Do not stroke brush applicator on body surface. Allow the filler/primer to dry hard.
4. Cover the filler/primer with color touch-up paint. Do not overlap touch-up color onto the original color coat around the scratch or chip. Butt the new color to the original color, if possible. Do not stroke applicator brush on body surface. Allow touch-up paint to dry hard.
5. On vehicles with clearcoat, apply clear top coat to touch-up paint with the same technique as described in step 4. Allow clear top coat to dry hard. If desired, the clearcoat can be lightly finesse sanded (1500 grit) and polished with rubbing compound.

NET, FORM AND PIERCE REPAIR

CAUTION: Failure to follow these recommendations could result in damage or failure to the part and the related parts.

Net, form and pierce is a manufacturing process which takes place during the original build of the vehicle. The original part will have a beveled platform that will decrease toward the fastener location mounting hole. Replacement parts in these areas may not include bevel (form) or fastener hole (pierce) and will need to be adapted for proper fit and finish.

The primary locations which may utilize net, form and pierce are:

- fender reinforcement (at front end module mount)
- fender tower mounts
- hood hinge (lower half)
- rear body header (liftgate hinge mounts)
- strut tower (at upper control arm mount)

NOTE: Shock tower is net, pierce only.

NOTE: The thickness of shims is not to exceed the original thickness of the factory bevel. If more shims are needed damage is still present and must be repaired properly.

If the replacement part did not come with a fastener hole, one of equal size and location will have to be drilled. Body shims should be used in the fender reinforcement to front end module. The hood hinge area, fender tower mounts, and rear body header will utilize washers as spacers where a specific spacer does not exist. The shims and spacers should be sealed between each other and to the stationary surface. Care should be taken when smoothing sealer around washers to give an undetectable repair. Refinish the repair area per the paint manufacturer's recommendations for corrosion resistance and appearance purposes.

NON-STRUCTURAL SHEET METAL REPAIR

Safety Notice

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It is important to note this publication contains various **Cautions** and **Warnings**. These should be read carefully in order to minimize risk of personal injury or the possibility that improper service may damage the vehicle or render it unsafe. It is important to note that these cautions and warnings cover only the situations and procedures Chrysler Group LLC. has encountered and recommended. Chrysler Group LLC. cannot possibly know, evaluate, and advise the service trade of all conceivable ways in which service may be performed, or the possible hazards of each. Consequently, Chrysler has not undertaken any broad service review. Accordingly, anyone that uses a service procedure or tool that is not recommended in this publication must be certain that neither personal safety, nor vehicle safety will be jeopardized by the service methods they select.

Safety Precautions

WARNING: Always wear an approved respirator, as well as skin and eye protection per adhesive manufacturer recommendations as stated in the product Safety Data Sheets (SDS).

Adhesives:

- Safety Data Sheets (SDS) must be available and understood before adhesives are handled.
- All personnel should be instructed on the proper procedures to prevent skin contact with solvents, curing agents, and uncured base adhesives, which could cause allergic reactions or sensitization.

Types of Structural Adhesives

Overview: There are three basic chemistries used in the collision repair industry. The types of adhesives used include Acrylic, Epoxy and Urethane. To achieve optimal results, it is best to use the chemistry that bonds best to the substrate being repaired, is easiest to use and offers the most permanent, non-detectable repair at the most economical repair cost. All three chemistries have their strengths and weaknesses.

NOTE: Structural adhesives that meet Chrysler Group LLC's approved replacement materials specifications include - Fusor 112B and 3M 08116

Adhesive Types:

- **Acrylic Adhesives** - Bond all types of bare metals and are excellent for cross bonding aluminum to steel. They have good NVH (Noise Vibration Harshness) properties and some offer anti-corrosion properties, so primers on bare metals are not necessary. Most acrylics have a fast room temperature cure, and are stable with regards to temperature and moisture during cure. However, both of these can effect shelf life. Mix ratio is modestly important although the performance properties can vary with a change in mix ratio. Acrylics are the most forgiving of the three chemistries with regards to mix ratio accuracy.
- **Epoxy Adhesives** - Bond well to ridged and semi ridged plastics and are generally easy to sand and feather edge. Some may be too ridged for flexible substrates and they often require primers on bare metal applications. Epoxies can be heat cured to increase strength and accelerate the curing process. They have a long and stable shelf life. The mix ratio can vary by $\pm 50\%$ and still cure. However, the performance properties will vary when the mix ratio is incorrect. Epoxies are more forgiving than urethanes with regards to mix ratio accuracy.
- **Urethane Adhesive** - Typically flexible and bond well to plastics. However, they usually require primers on metal surfaces to protect against corrosion. Urethanes have good seam sealing and NVH qualities and are frequently the optimal choice for seam sealers. They are sensitive to moisture during cure, packaging and storage. Single component urethanes usually have a much shorter shelf life than two component urethanes. Mix ratios are critical for urethanes. In most cases it cannot vary more than $\pm 5\%$. Therefore, hand mixing is not recommended. Urethanes are the most unforgiving of the three chemistries with regards to mix ratio accuracy.

Non-Structural Repair Table

JOINT AND REPAIR TYPES	REFERENCE
Backer Panel Joint	Backer Panel Joint
Door Skin	Door Skin Replacement
Body Side Aperture/Quarter Panel	Side Aperture/Quarter Panel
Metal Fatigue/Stress Cracks	Metal Fatigue Stress Crack

Backer Panel Joint

Overview: Backer panel procedures may be used to achieve a smooth joint between panel sections. The backer panel works well in areas where there is not enough room to smooth or feather in an overlap joint. The backer panel joint is a common repair for rocker panels, quarter panels and body side apertures.

NOTE: OEM panel replacement such as a quarter panel, side aperture and rocker panel will always require the weld bonding procedure at the pinch weld flange area(s).

Preparation:

NOTE: Be certain vehicle is evenly supported at normal suspension points.

1. Restore structural dimensions as well as all related mating flanges.

NOTE: It will be difficult to abrade the underside mating surface of the original panel, however this is an important step and should be done effectively.

2. Create a 50mm. (2in.) backer panel out of an unused portion of original or new sheetmetal panel, whichever contains the appropriate shape. Be certain it has a precise fit to the back of the panels it will join.
3. All paint, primer, adhesive and any other corrosion protective coatings must be removed from the mating surfaces as well as the backer panels themselves, prior to application of adhesive. Grind a 25mm. (1in.) contact area on all panels where backer panel bonding will take place. The metal should be completely bare and shiny in appearance, if the metal appears pewter in color all of the galvanized coating has not been removed.
4. Pre-fit the backer panel to the panel(s) being joined, to ensure proper fit. If screws will be used to hold the panels in place during curing, dry fit them now to be certain of proper fit later. There should be a 0.8 - 1.6mm. (1/32 - 1/16in.) gap between the two outer panels, no gap on backer panels.
5. Without a mixing tip attached, purge a small amount of structural adhesive from the cartridge. This will ensure an even flow of both components.
6. Attach a mixing tip and dispense a mixing tube's length of adhesive from the cartridge.

Application:

NOTE: Refer to the structural adhesives manufacturer for information on work, handling and curing times.

7. Apply a 10 - 13mm. (3/8 - 1/2in.) bead of structural adhesive to the bare metal mating surfaces of the backer panels. Evenly apply the adhesive over the complete bonding surface. Apply a 10 - 13mm. (3/8 - 1/2 in.) bead of structural adhesive to bare metal mating surfaces. Use a body filler applicator to level the adhesive, making sure to cover all bare metal to protect against corrosion.
8. Position the new backer panel(s), making sure not to separate after contact. Lifting will create air bubbles and weaken the bond. **Adjustments must be made by sliding, not lifting the panel(s).**
9. Clamp tightly and evenly. Adhesive has glass beads that will prevent complete squeeze out. Install screws to the "hard to clamp areas".
10. Remove excess adhesive from all joints prior to adhesive cure.
11. Allow adhesive to cure, per manufacturer recommendations. When fully cured, expect the adhesive to be a little tacky, as this is a normal characteristic of the adhesive.
12. Remove clamps and screws.
13. Repeat procedure for installation of new panel.
14. Remove any remaining adhesive with a grinder or abrasive disc. All adhesive must be removed from the cosmetic repair area to ensure proper adhesion of further repair and refinish materials.
15. Bevel the center of the screw holes and apply fiber-reinforced waterproof body filler to the screw holes and section seam. When cured, sand and apply conventional body filler and block sand as necessary. Prime and

paint per paint manufacturer recommendations.

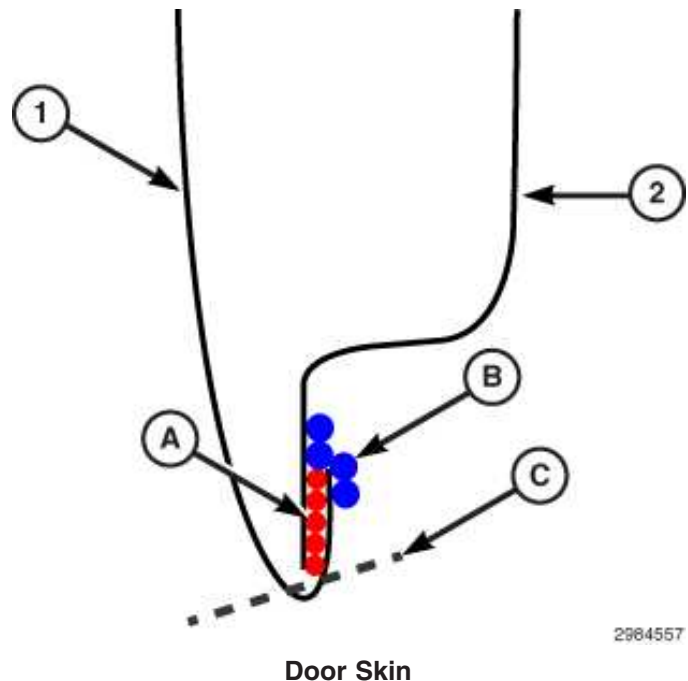
16. Apply inner panel corrosion inhibiting materials (Mopar Cavity Wax part #6804292970 or equivalent).

Door Skin Replacement

Overview: Depending on the type of door to be repaired, a full skin or a belt cut will be required. Belt cut replacement is necessary when a door with a full skin, around the window opening, has an angle that makes it to difficult to get tools into to do a quality hem flange installation. A butt-joint is used at this seam.

Preparation:

1. Belt cut skins will require determining and cutting of the sectioning locations on the original panel and on the replacement panel.
2. Remove the door skin by grinding the outer edge (C) until the seam is perforated.
3. Cut around weld nuggets and spot welds with a spot weld cutting bit or similar weld removal tool.
4. If panel is attached with adhesive you may use heat, from a **non-flame** heat source, up to 204°C. (400F°). This will aid in loosening the bond.
5. With an air chisel and a flat bladed bit, remove outer skin and any remaining hem flange.
6. Grind any remaining weld nuggets flush with door frame, and remove all adhesive, paint, E-coating and corrosion protective coatings from the area where the **structural adhesive** will be applied, and where the 'butt-joint' is to take place. The metal should be completely bare and shiny in appearance, if the metal appears pewter in color all of the galvanized coating has not been removed.
7. Straighten door flange and any remaining damage on door shell using the hammer and dolly method.
8. The area of the new door skin that will make contact with the door shell will need to be scuffed with a course abrasive pad or ground with a 50 grit grinding disc. This will vary upon adhesive manufacturers, be certain to check adhesive manufacturer recommendations.
9. Dry fit the new panel. Determine where to place clamps to hold the panel in place, as necessary.



NOTE: Drain holes must remain clear of obstructions from adhesives and sealers.

- 1 - DOOR SKIN (OUTER)
- 2 - DOOR SHELL (INNER)
- A - STRUCTURAL ADHESIVE
- B - SEAM SEALER
- C - HEM FLANGE CUT LINE (BOTTOM EDGE SHOWN, SURROUNDING EDGES TYPICAL)

CAUTION: Be certain the fit is good from the skin to door and door to door opening. Cured adhesive is extremely strong and will not allow for "adjustments".

10. Without a mixing tip attached, purge a small amount of structural adhesive from the cartridge. This will ensure an even flow of both components.
11. Attach a mixing tip and dispense a mixing tube's length of adhesive from the cartridge.

NOTE: Refer to the structural adhesives manufacturer for information on work, handling and curing times.

Installation:

NOTE: Do not apply adhesive within 25mm. (1in.) of the belt cut location.

12. Apply a 10 - 13mm. (3/8 - 1/2 in.) bead of structural adhesive to bare metal mating surfaces. Use a body filler applicator to level the adhesive, making sure to cover all bare metal to protect against corrosion.

NOTE: When applying adhesives be certain any and all drain holes remain open and clear of obstructions.

13. Apply a second bead of adhesive to ensure proper bead thickness.
14. Position the new panel. If repositioning is necessary slide the panel, do not lift or separate panels.

Adjustments must be made by sliding, not lifting the panel(s). Apply clamps to hold panel in position, as necessary.

NOTE: There are many tools readily available to aid in the hem flange folding process.

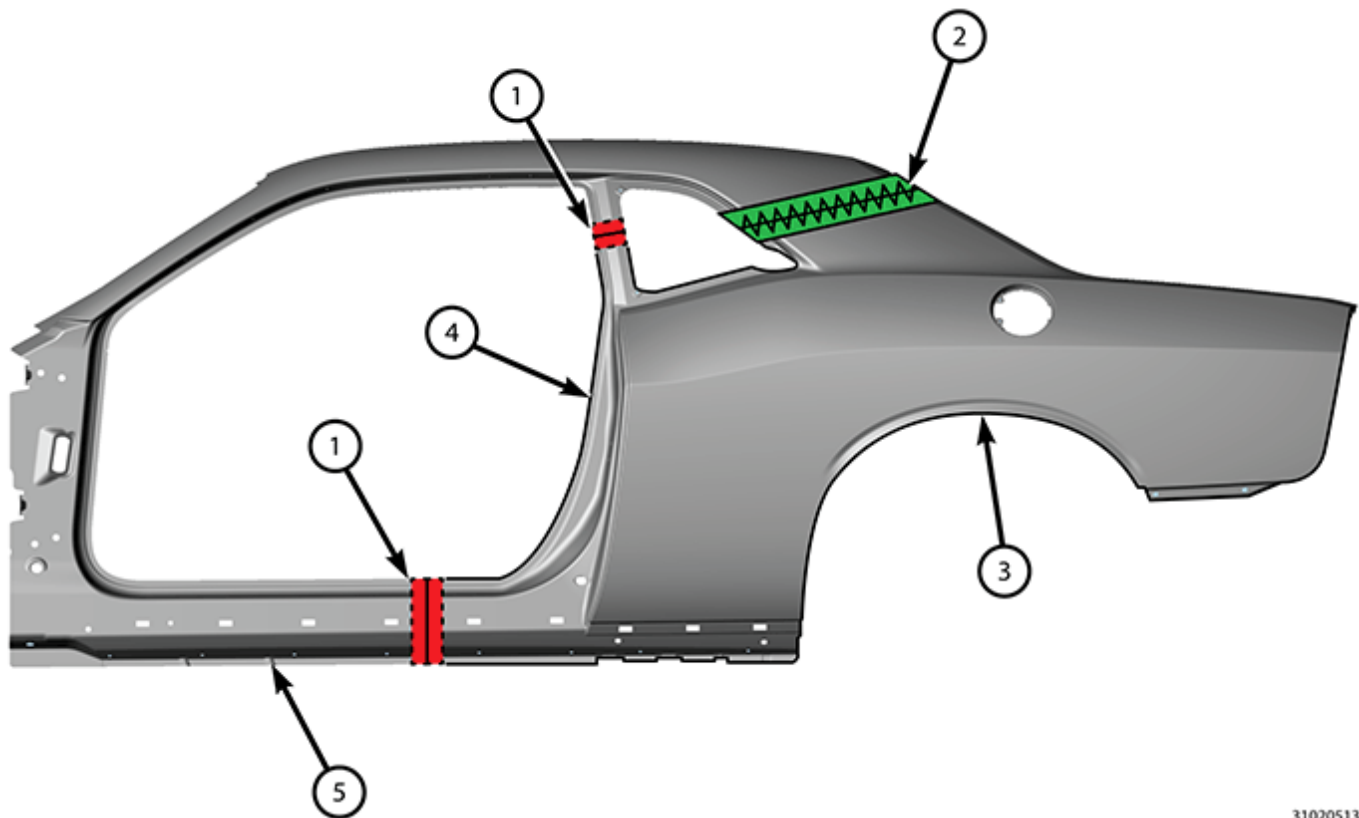
15. Roll the hem flange over. Remove excess adhesive. This will save time, as compared to waiting until cured.
16. Re-check door gap and flushness to the vehicle opening and adjust as necessary.
17. Allow the adhesive to cure per manufacturer recommendations. When fully cured, expect the adhesive to be a little tacky, as this is a normal characteristic of the adhesive. Remove clamps, if used.
18. Remove any excess cured adhesive with a grinder or abrasive disc. All adhesive must be removed from the cosmetic repair area to ensure proper adhesion of repair and refinish materials.
19. Weld the butt-joint with GMAW (Gas Metal Arc Welding), if a belt cut was used. Clean and dress welds accordingly.
20. Apply fiber-reinforced waterproof body filler to the section seam, as necessary. When cured sand and apply conventional body filler and block sand.
21. Apply an epoxy or anti-corrosion primer. When cured, lightly scuff.
22. Seam seal the entire door. Duplicate the factory seam sealer. Apply a discrete bead around the rest of the door to seal and protect, maintaining the original appearance.
23. Prime and paint per paint manufacturer recommendations.
24. Apply inner panel corrosion inhibiting materials (Mopar Cavity Wax part #68042970AA , or equivalent).

Side Aperture / Quarter Panel

Overview: Chrysler's recommended repair procedure for body side aperture / quarter panel replacement include butt joints using backer panels with structural adhesive at the sectioning joint, or a welded backer panel with a welded butt joint using GMAW (Gas Metal Arc Welding). Resistance spot welding with structural adhesive, referred to as weld bonding, should be used at all pinch welds and may be used at the drain trough and tail panel areas as well. With the exception of the sectioning joint, the rule to follow is "Re-assemble as it was built from the OEM". For further information on Weld / Weld Bonding, (Refer to Collision Information - Standard Procedure). GMAW (plug or puddle) welds may be used in place of STRSW (Squeeze Type Resistance Spot Welding) only in areas that specifically use spot welds and in areas that access limitations will not allow STRSW. GMAW cannot be used in the weld bonding process. Never weld with GMAW within 25mm. (1in.) of any area where structural adhesive is used. The weld "heat zone" will destroy the properties of the adhesive.

Vehicle design will determine if the sectioning location is to be in the pillar or the roof line area . For locations and warnings that may apply to body side aperture / quarter panel sectioning locations reference Sectioning Procedures,

(Refer to Collision Information - Standard Procedure).



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Body Side Aperture

- 1 - ADHESIVE SECTION JOINTS WITH BACKER PANEL
- 2 - WELDED SECTION JOINT WITH BACKER PANEL
- 3- WHEELHOUSE HEM FLANGE
- 4 - WELD BONDING (AREAS WHERE ACCESSIBLE)
- 5 - BODY SIDE APERTURE

Preparation:

NOTE: Be certain vehicle is evenly supported at normal suspension points.

1. Restore structural dimensions as well as all related mating flanges.
2. Once sectioning locations have been established, cut original and replacement panels at the pre-determined locations. Remove spot welds within sectioned parameter.

NOTE: Be careful not to destroy any areas that may be able to be used as backer panels.

3. If panel is attached with adhesive, you may use heat, from a **non-flame** heat source, up to 204°C. (400F°). This will aid in loosening the bond.
4. Use an air chisel with a flat bladed bit to remove original panel.
5. Using a hammer and dolly, restore any and all damage to mating surfaces.
6. Create backer panels to be used at the adhesive butt joints (1). Refer to [Backer Panel Joint](#).

NOTE: It will be difficult to abrade the underside mating surface of the original panel, where backer panel is to be used, however this is important step and should be done effectively.

NOTE: Due to the length of the butt joint along the C-pillar a welded section joint (2) with a 13 mm (0.5 in) welded backer panel is required.

7. Grind all mating surfaces with a 50 grit grinding disk. Remove all adhesive, sealers, paint, E-coating and corrosion protective coatings from the area where the structural adhesive and welds will be applied. The metal should be completely bare and shiny in appearance, if the metal appears pewter in color all of the galvanized coating has not been removed.
8. Pre- drill any GMAW plug / puddle weld holes that may be necessary, with a 8mm. (5/16in.) hole.
9. With the aid of an assistant, dry fit the panel. Apply clamps to hold panel in place, making note of locations. Install screws where accessibility prohibits the use of clamps. This will aid in proper alignment during installation.

10. Without a mixing tip installed, purge a small amount of structural adhesive from the cartridge. This will ensure an even flow of both components.
11. Attach a mixing tip and dispense a mixing tube's length of adhesive from the cartridge.

NOTE: Using scrap metal and adhesive, make test coupon samples and perform peel test to ensure your STRSW equipment is ready to apply welds as required. The Weld/Weld Bonding section will provide further information on peel testing and equipment set-up, (Refer to Collision Information - Standard Procedure).

NOTE: Refer to the structural adhesives manufacturer for information on work, handling and curing times.

Installation:

12. Install backer panels, refer to [Backer Panel Joint](#).
13. Apply 10 - 13mm. (3/8 - 1/2in.) bead of structural adhesive to the area where the two panels are to be bonded and weld bonded. **Do not apply to areas that will only be STRSW or GMAW welded.**
14. Smooth the adhesive with a body filler spreader or equivalent, to cover all bare metal surfaces. Apply a second bead of adhesive to ensure proper adhesive thickness.
15. With the aid of an assistant place the panel to the vehicle. If the panel needs to be adjusted, slide the panel.

NOTE: Adjustments must be made by sliding, not lifting the panel(s). Lifting will cause air bubbles and weaken the bond.

16. Install clamps and screws to locations determined during the dry fit process.

NOTE: There are many tools readily available to aid in the hem flange folding

17. Roll the wheelhouse hem flange (3) over 180 degrees.
18. Remove all squeeze out of adhesive, prior to curing.

NOTE: Structural adhesive manufacturers will vary on time allowed for completion of STRSW in weld bond zones. Check and follow adhesive manufacturer recommendations.

19. Apply STRSW to weld bond areas immediately.
20. Once fully cured, remove clamps and screws. When fully cured, expect adhesive to remain a little tacky, as this is a normal characteristic of the adhesive.
21. Complete STRSW and / or GMAW (plug / puddle) welds.
22. Finish / Dress the welds as necessary. If screws were necessary bevel the screw holes. Prepare the joint and screw holes by grinding the area with 50 grit grinding disc. Get in seams as best as possible without thinning the metal.
23. Remove any excess cured adhesive with a grinder or abrasive disc. All adhesive must be removed from the cosmetic repair area to ensure proper adhesion of repair and refinish materials.
24. Apply fiber-reinforced waterproof body filler to screw holes and joint. Complete the repair using conventional body filler, and block sanding.
25. Apply an epoxy or anti-corrosion primer. When cured, lightly scuff and then apply seam sealer as necessary.
26. Prime and paint per paint manufacturer recommendations.
27. Apply inner panel corrosion inhibiting materials (Mopar Cavity Wax part #68042970AA, or equivalent).

Metal Fatigue/Stress Crack

Overview: On rare occasions you may encounter metal fatigue, also referred to as stress cracks. This will appear as a crack starting at an edge and trailing away. Follow these steps for a proper repair:

1. Locate the trailing end of the crack and drill a 3mm. (1/8in.) hole at the very point at which it stops. This is referred to as "Stop Drilling".
2. Remove all contaminants and coatings including primer, paint and anti-corrosion, from the repair area. Surface should be clean and shiny (if pewter in color then anti-corrosion has not been removed).
3. Stitch weld the seam/crack closed using GMAW. Follow welding guidelines as found in Weld/Weld Bonding section, (Refer to 31 - Collision Information - Standard Procedure).
4. Dress the welds as necessary. **Careful not to thin the base metal.**
5. Depending on the location and visibility of the repair surface refinishing will vary from body filler, finishing and painting to simply applying an epoxy or anticorrosion primer and rubberized undercoating, Mopar part #05093417AA or equivalent.
6. Apply inner panel corrosion inhibiting materials (Mopar Cavity Wax part #68042970AA , or equivalent).

WELDING AND WELD BONDING

Safety Notice

CAUTION: All Service and rebuilding instructions contained herein are applicable to, and for the convenience of, the automotive repair industry only

The service procedures recommended and described in this publication were developed for professional service personnel, and are effective methods for performing vehicle repair.

It is important to note this publication contains various **Cautions** and **Warnings**. These should be read carefully in order to minimize risk of personal injury or the possibility that improper service may damage the vehicle or render it unsafe. Chrysler Group LLC. cannot possibly know, evaluate, and advise the service trade of all conceivable ways in which service may be performed, or the possible hazards of each. Consequently, Chrysler has not undertaken any broad service review. Accordingly, anyone that uses a service procedure or tool that is not recommended in this publication must be certain that neither personal safety, nor vehicle safety will be jeopardized by the service methods they select.

Safety Precautions

WARNING:

- When Welding and/or working with Adhesives always wear safety goggles and gloves to prevent contact with chemicals and to prevent weld spatter, sparks, and sharp metal from causing bodily injury.
- Wear an approved respirator while welding and during the application of adhesives to prevent inhalation of harmful vapors.
- Always remove NVH (Noise Vibration and Harshness) foam from welding repair area, as material is flammable.

WARNING: Failure to follow these instructions may result in possible serious or fatal injury

Welding

- Comply with all federal, state and local regulations to avoid any injuries due to shock, fires, fumes, sparks and liquids.
- All flammable materials or liquid should be stored in tightly sealed and labeled containers, and used only in well ventilated areas.
- No spark producing equipment should be permitted in any area where flammable materials are being handled or stored.

Adhesives:

- Safety Data Sheets (SDS) must be available and understood before adhesives are handled.
- All personnel should be instructed on the proper procedures to prevent skin contact with solvents, curing agents, and uncured base adhesives, which could cause allergic reactions or sensitization.

Introduction

Gas Metal Arc Welding

The purpose of this document is to clearly explain the welding options available to the collision repair technician and how to determine that welding repairs are made properly. The primary types of welding covered in this section are Squeeze Type Resistant Spot Welding (STRSW), Gas Metal Arc Welding (GMAW) and Weld Bonding (a combination of STRSW and structural adhesive). Proper training and weld testing are required to ensure that a safe, high quality, vehicle repair is made.

INDEX	REFERENCE
Panel Removal	Panel Removal
Key Points of a Welding Repair	Key Points of a Welding Repair
Requirements of a Welding Repair	Requirements of a Welding Repair
Modified Lap Joint	Modified Lap Joint

INDEX	REFERENCE
Types of Welding (STRSW, GMAW and Weld Bonding)	Types of Welding
Weld Processes (STRSW, GMAW and Weld Bonding)	Weld Processes
Minimum Weld Nugget Requirement Chart	Minimum Weld Nugget Chart
Training and Qualification	Training and Qualification

Panel Removal

WARNING: Always Wear Safety Goggles, Work Gloves, Hearing Protection and a Dust Mask when removing welded panels this way. Failure to follow these instructions could result in serious or fatal injury.

When removing panels and components for replacement, care must be taken not to damage the underlying component. On welded and "Weld Bonded" panels spot welds must be removed using a spot weld cutting type tool, or equivalent. On panels that are adhesive bonded or weld bonded it is acceptable to use heat up to **204°C. (400°F.)**, from a **Non-Open Flame** heat source. This will loosen the bond, so less damage is inflicted to the mating surface. After panel is removed, any remaining weld nugget should be ground smooth. Cut-off wheels should not be used, as there is potential to remove material from the base material which would weaken the final repair. Place an air hammer with a flat bladed chisel bit (or equivalent) in between panels and remove the panel. Care should be taken as to not damage mating flanges and the surrounding components.

Key Points of a Welding Repair

- Poor fit up will adversely affect weld quality and may result in a weld failure due to excessive metal stretching around the nugget.
- Clamps should be used to bring parts together and hold them in position.
- Clamps should be insulated when using STRSW to control weld current shunting (This can be accomplished with specialized clamps or by placing a insulating material such as cardboard between the clamp jaws and the panels.)
- Number, size and location of welds should closely duplicate the original assembly. Do not place the new spot weld directly on the original spot weld location. Placement of a new weld over an original weld location may lead to metal fatigue or poor weld quality.
- Surface of the steel parts should be clean and free of scale, rust, paint, cured adhesives/sealers and any other contaminants that could adversely affect the quality of the weld joint. This includes the removal of any E-coat applied to the service part within 25mm. (1in.) of any welds.
- Proper corrosion protection must be installed when repairs are complete, (Refer to 31 - Collision Information/ Standard Procedure/Corrosion Protection).
- If the joint originally had adhesive, all E-coat must be removed where the adhesive is to be reapplied.
- "Weld-thru" primers are not recommended anywhere STRSW or GMAW are used.
- Do not remove base material from the base panel when releasing welds.

NOTE: Chrysler Group LLC recommends the same quantity of welds as the original panel, but placement of the new weld should NOT be put directly on the original spot weld location. Placement of a new weld over an original weld location may lead to metal fatigue or poor weld quality.

Requirements of a Welding Repair

The number one requirement of any welding repair is to restore the vehicle to its OEM condition. Materials and technologies should duplicate original OEM conditions as much as possible. To meet this requirement, the technician must ensure the following:

- Panel layering (shingling) is the same as original
- Part fit up is correct
- Equivalent sealers and/or adhesives are utilized
- Welds are replaced in the same size, quantity and location
- "Weld-thru" primers are NOT recommended
- Structural adhesives and sealers must be replaced where they were located

A significant amount of structural adhesive is used at the OEM to improve joint strength. It may be difficult to determine if the material between the panels is an adhesive or a sealer, and for this reason, the following guideline should be used: **If in doubt, use a two-component, corrosion inhibiting, structural adhesive.** GMAW welding

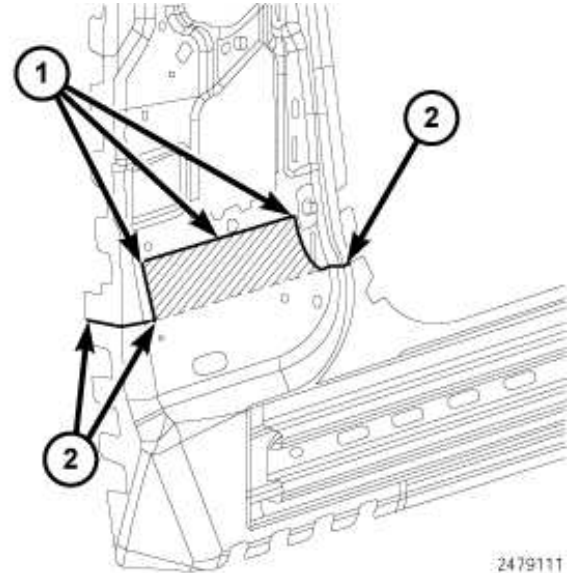
is not recommended within 25mm. (1in.) of the adhesive as it creates heat that will destroy the adhesive. STRSW on the other hand, can weld through the adhesive and will not destroy its properties.

NOTE: Structural adhesives that meet Chrysler materials recommendations for adhesive strength and corrosion protection qualities include Lord Fusor #112B and 3M #08816

Modified Lap Joint

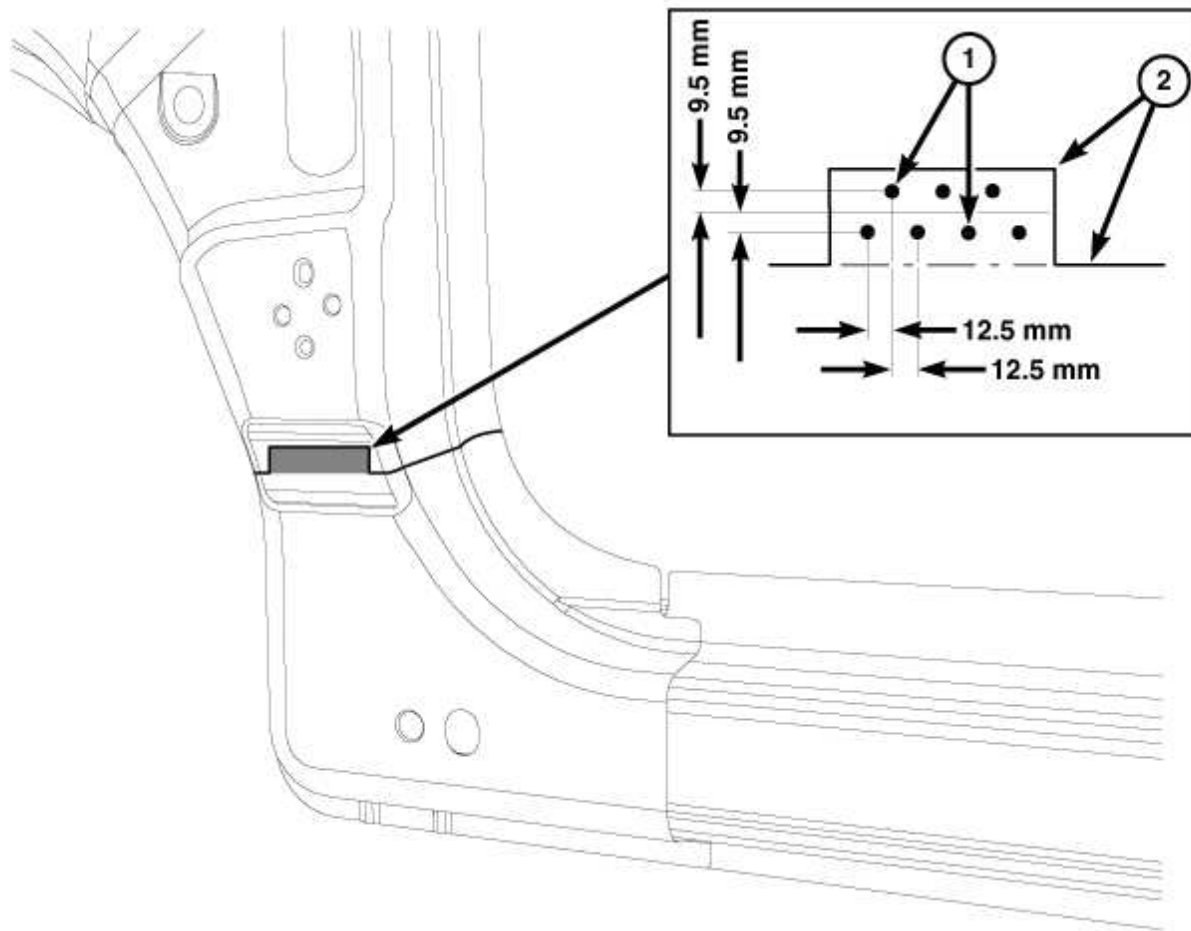
NOTE: Parts shown for example purposes only. Emphasis is on joint design and proper plug weld placement

The repair joint is a combination lap-joint (1) and butt-joints (2) – the panels are lapped in the flat areas and butted in contoured locations and at weld flanges. The graphic better illustrates this process.



Modified Lap Joint

- 1 - LAP-JOINT WELDS
- 2 - BUTT-JOINT WELDS



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Plug Weld Layout

- 1 - MIG PLUG WELDS
2 - MIG SEAM WELD

The MIG plug welds, or "puddle welds" should be made after drilling 8 mm (5/16 in) holes and should be staggered 12.5 mm (0.5 in) apart following the centerline of the lap and should be alternating above and below the centerline 9.5 mm (3/8 in.).

In the lap-jointed area, staggered MIG plug welds (1) are used to augment the joint and **all edges** of the lapped panel seam (2) should be **completely** welded.

Types of Welding

STRSW (Squeeze Type Resistant Spot Welding)

- STRSW relies on the resistance of the material being welded to create heat as a current is passed through. The materials being welded are squeezed together, and as current passes through, resistance causes heat buildup. The force of the tips and the heat from the current allow the materials to fuse together. The current is removed and the force from the welding tips is held during a cool down cycle. When the cool down cycle is complete, the pressure is released and the next weld is positioned.
- Learning how to create weld coupons, refer to [Test Weld Coupon](#) and then performing a destructive test using these coupons, is the key to successfully using STRSW. Chrysler Group LLC requires a physical test using test coupons and the methods outlined in this document to test welds prior to making repairs.
- Tip condition is very important for producing proper welds. Inspect tips often and either dress or change per equipment manufacturer recommendations.
- High-quality welding equipment must be used or welds may be inadequate. Also, the equipment must be able to produce repeatable welds from the beginning of the repair to the end.

GMAW (Gas Metal Arc Welding or "MIG")

- GMAW is an arc welding process where the electrode wire is fed through a weld gun and is surrounded by a shielding gas. The term MIG comes from early uses on aluminum where argon was used as shielding gas and

the process was referred to as Metal Inert Gas welding. The GMAW process is currently the most common in the uni-body repair environment.

Weld Bonding

- A method of joining metals using STRSW in conjunction/combination with a structural adhesive.
- Weld bonding provides the customer with a superior repair as compared to the traditional plug/puddle welding process using GMAW. Structural adhesive should not be used in a joint that did not originally contain it.
- The repair joint or seam should duplicate the OE build as closely as possible, unless otherwise stated in the collision information.

NOTE: Chrysler Group LLC. DOES NOT approve or endorse the use of structural adhesives alone in the replacement of body panels.

Weld Processes

Squeeze Type Resistance Spot Welding (STRSW)

Applications

- With advancements in equipment technologies, STRSW is not restricted to light gauge sheet metal any longer. Heavier gauges of high strength and coated steel, currently used in vehicle structures, can now be welded in the field, providing destructive testing is performed on each combination. This is to ensure quality welds are being maintained.

Equipment Requirements

- Equipment must produce two sided welds
- Equipment must have been tested to SAE J2667 with satisfactory results obtained
- Equipment must have the capability to create welds that comply with the Minimum Weld Nugget Requirement Chart
- Technician must have the appropriate sheet metal measuring equipment to ensure their welds meet the minimum weld nugget size for the actual panels being welded

Gas Metal Arc Welding (GMAW or "MIG")

Applications

- Sheet metal repairs where STRSW is not available or practical, and truck frame repairs.
- The most common usage of GMAW on uncoated or galvaneal coated steel will utilize a 75% Argon - 25% CO2 shielding gas mix, and AWS specification ER70S6 wire. When welding galvanized material, Flux Core Arc Welding (FCAW) using AWS specification E71T-GS wire should be used to avoid weld porosity from the zinc in the galvanizing.

Weld Process

COMPONENT PARTS	TRUCK FRAME		BODYSHELL EXTERIOR & UNDERBODY PANELS			
	Zinc and Zinc Iron Alloy coated sheet steels					
WELDING PROCESS	GAS METAL ARC (Note: 1)	FLUX CORED ARC	GAS METAL ARC (Note: 1)	MIG BRAZE (Note: 2)	GAS METAL ARC (Note: 1)	FLUX CORED ARC
Material Type	High Strength and Structural Quality Steels which includes HSLA, Martensitic, and Dual Phase materials					
Material Thickness Range	2 mm - 4 mm		0.6 mm - 1.02 mm		>1.02 mm - 3.0 mm	
ELECTRODE TYPE (AWS SPEC. A5.18)	AWS CLASS. ER70S-6	AWS CLASS. E71T-11 (Note 3)	AWS CLASS. ER70S-6	AWS CLASS. ERCuSi - A Silicon Bronze	AWS CLASS. ER70S-6	AWS CLASS. E71T-11 (Note 3)
ELECTRODE SIZE	0.035	0.045	0.023 - 0.025	0.035	0.035	0.045
ELECTRODE MAKER	Lincoln®	Lincoln® NR-211-MP	Lincoln®		Lincoln®	Lincoln® NR-211-MP

COMPONENT PARTS	TRUCK FRAME		BODYSHELL EXTERIOR & UNDERBODY PANELS			
WIRE FEED SPEED (in/min)	245-250 Vertical Down 70-90 Flat & Horizontal	110 Vertical Down 70-90 Flat & Horizontal	95-115 All Welds	150-155 Flat & Horizontal	245-250 Vertical Down 70-90 Flat & Horizontal	110 Vertical Down 70-90 Flat & Horizontal
TRAVEL SPEED (in/min)			10			
VOLTAGE	19-20	15-18	16-19	18-19	19-20	15-18
POLARITY	DCEP	DCEN	DCEP	DCEP	DCEP	DCEN
GAS FLOW (cfh)	25-35	N/A	25-35	25-35	25-35	N/A
ELECTRICAL STICKOUT (in)	1/2 - 5/8	3/8 - 1/2	1/2 - 5/8	5/8 - 3/4	1/2 - 5/8	3/8 - 1/2
GAS TYPE	75% Ar 25% CO2	N/A	75% Ar 25% CO2	100% Ar	75% Ar 25% CO2	N/A
TYPE OF ARC TRANSFER	Short Circuit		Short Circuit	Pulse	Short Circuit	

These Procedure Specifications are appropriate as of this publication. Procedures may be superseded with new spec's at a later date.

Always process to the thinner material thickness (TMT)

All persons performing welding must be qualified to weld in all positions.

NOTE:

1. Must remove Zinc Coating on both sides of metal at the weld zone.
2. MIG Braze welding process requires use of Pulse Arc® or STT® welding machine.

Equipment Requirements

- The preferred GMAW welder will be a 220V. unit with minimum output capacity of 150 amps (250 amps suggested to avoid equipment limitations).

Limitations

- Welds must be "dressed", or ground down before applying topcoats.
- GMAW cannot weld through paints, sealers, or adhesives. Additionally, the zinc used in coated steels can lead to reduced weld strength due to porosity. This porosity problem on materials with heavy coatings can be dealt with by using FCAW.
- Due to the heat affected zone, structural adhesives cannot be applied within 25mm. (1in.) of GMAW welds.

Testing

- Weld coupons identical to the repair situation need to be created to help set up the welding equipment and weld process. These coupons then should be destructively tested to ensure proper quality welds are being made

Post Weld Procedures

- When welding has been completed, welds in cosmetic locations must be dressed.
- Welds will need to be smoothed down to the height of the surrounding panel without any thinning of the sheet metal. This can be accomplished using one of many sanding or grinding products available in the aftermarket.
- Slag must always be removed prior to refinishing to restore corrosion protection and appearance.
- Corrosion inhibiting materials must be applied to seal the weld zone from future corrosion.

Minimum Weld Nugget Requirement Chart

*Governing Metal Thickness (GMT)	**Minimum Weld Nugget Diameter
0.64mm. - 0.79mm.	3.5mm.
0.8mm. - 0.99mm.	4.0mm.
1.0mm. - 1.29mm.	4.5mm.

*Governing Metal Thickness (GMT)	**Minimum Weld Nugget Diameter
1.3mm. - 1.59mm.	5.0mm.
1.6mm. - 1.89mm.	5.5mm.
1.9mm. - 2.29mm.	6.0mm.
2.3mm. - 2.69mm.	6.5mm.
2.7mm. - 3.04mm.	7.0mm.

*Governing Metal Thickness (GMT) = The minimum weld nugget for two thickness welds shall be based on the thinner of the two sheets being welded. The minimum weld nugget diameter for three thickness welds shall be based on the middle gauge of the three panels being welded (not necessarily the middle panel).

**Minimum nugget diameter should be measured with a venire caliper. If the weld is not round, measure the major and minor diameter and average.

Equipment Limitations

- Each brand/model is limited to material capacity that can be welded
- The facility power supply can also impact equipment performance

Access Limitations

- Due to the existing structure of the vehicle being repaired, each weld must be evaluated for feasibility. Due to power limitations of the equipment, tongs that are long and deep enough for certain welds may not be available, and the weld will need to be made by another method.

CAUTION: All NVH foam must be removed from the repair area of the vehicle, as material is flammable.

Preparation

- Prior to making repairs with STRSW, weld coupons must be created for testing. The test joint must be an exact duplicate of the original joint, including layering and adhesive application. The testing is required to ensure the repair restores the vehicle to its originally produced condition using the minimum weld nugget requirement chart.
- To correctly identify the material being welded or tested, the technician must possess an accurate material thickness gauge
- No "improvements" to the vehicle design are allowed as this could have a negative impact on the vehicle as a whole. The repair should mirror what was used on the vehicle at the assembly plant.
- Note, the weld is affected by more than just the thickness or number of panels being welded, but also material coatings. Zinc based anti-corrosion coatings (i.e., galvannealing, galvanizing), sealers, adhesives, and E-coat will affect welder performance. Any sandwich type coatings will increase weld time (and current in some types of STRSW welders) required to accomplish an acceptable weld nugget.
- When preparing an E-coated panel for STRSW the E-coat must be removed from both of the mating flanges within 25mm. (1in.) of any flange. Corrosion protection is required anytime you remove E-coat. A scuffing disc should be used to remove the E-coat without damaging other sheet metal coatings
- If the panel originally had structural adhesives it should be reapplied prior to welding. The adhesive should have a corrosion inhibitor and cover all bare metal.
- Prior to creating weld coupons and the final body repairs, all coatings and dirt/road debris must be removed.

Testing

- Weld coupons identical to the repair situation need to be made prior to performing any repair. These coupons must be tested (peel test) to determine if the weld nugget meets the minimum size outlined above in the Minimum Weld Nugget Requirement Chart. Keep in mind that different material coatings, coating thickness, material thickness, and joint configurations have a direct impact on nugget size.

Weld Bonding

NOTE: Structural adhesive manufacturers will vary on time allowed for completion of STRSW in weld bond zones. Check and follow adhesive manufacturer recommendations.

Application

- Weld bonding is the STRSW welding process utilizing structural adhesive between the panels that are resistance welded together. The adhesive creates a very stiff structure, while the welding eliminates concerns of the adhesives' peel strength.
- Additionally, the adhesive acts as a sealer and provides a high level of corrosion protection.

Sealers and Adhesives

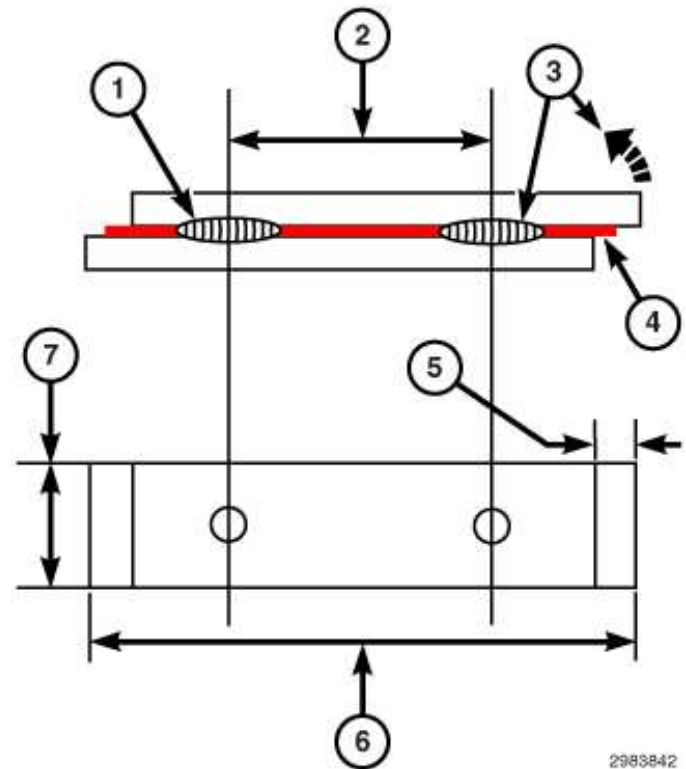
- Sealers are materials placed on top of a seam to control water and air intrusion.
- Adhesives, providing structural improvements, are found between panels welded together. Adhesives also

provide the qualities of sealers when applied correctly.

- The Chrysler Group LLC. recommendation is to replace any suspected adhesive with a two-component, corrosion inhibiting structural adhesive when any repairs are made, providing the STRSW process is applicable.

Test Weld Coupon

NOTE: Periodically check the electrodes tips to determine whether the faces have been contaminated, damaged or increased in size. If any of these conditions have occurred, replace or re-face the electrode tips per equipment manufacturer recommendations.

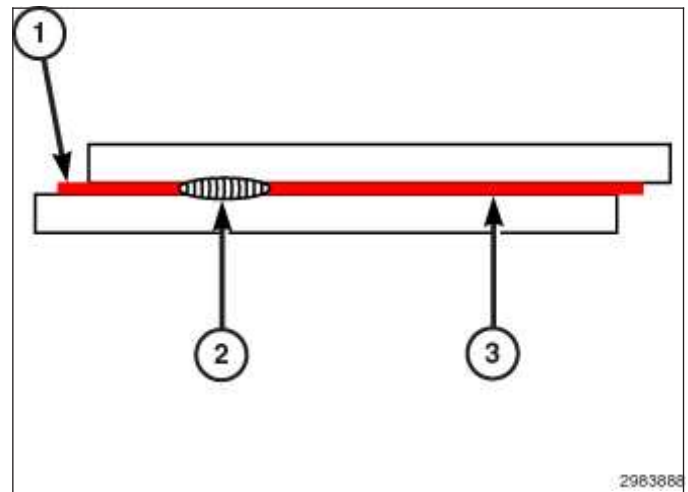


Weld Coupon

- 1 - FIRST WELD TOWARD END OF COUPON, AT LEAST 12.5mm. (0.5in.) FROM ANY EDGE
- 2 - DISTANCE MUST EQUAL THE SPACING FROM THE REPAIR WELD TO THE CLOSEST EXISTING WELD ON THE VEHICLE
- 3 - TEST THE SECOND WELD BY PEELING APART IN DIRECTION SHOWN (USING PLIERS OR EQUIVALENT)
- 4 - STRUCTURAL ADHESIVE
- 5 - APPROXIMATELY 13mm. (0.5in.)
- 6 - APPROXIMATELY 100mm. (4in.)
- 7 - APPROXIMATELY 25mm. (1in.)

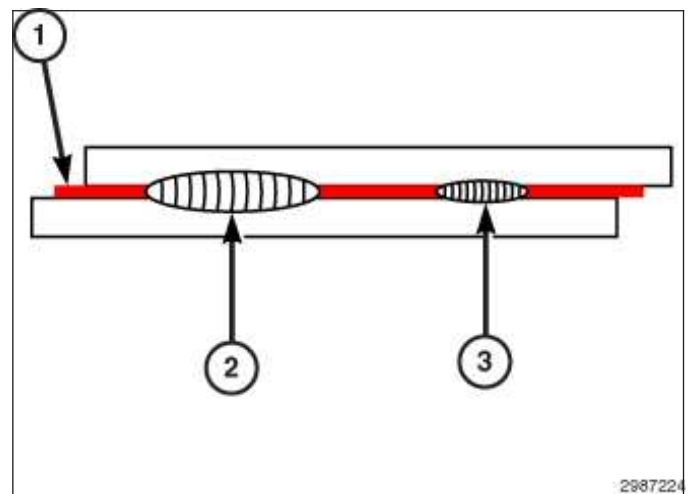
Weld Examples

Current Level Low for Both Welds



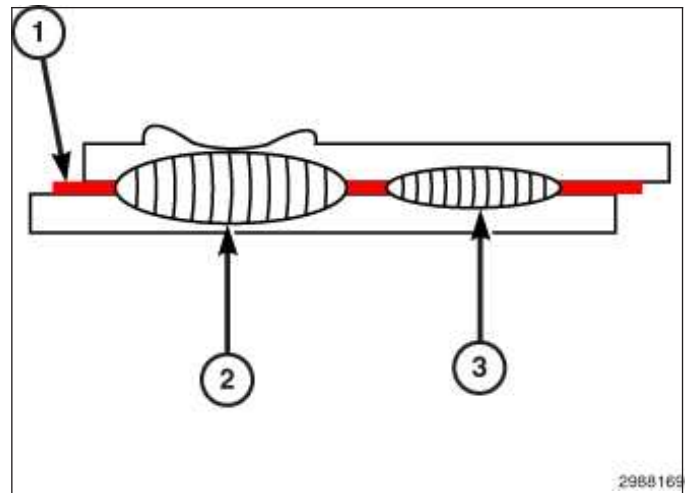
- 1 - STRUCTURAL ADHESIVE
- 2 - WELD TOO SMALL
- 3 - WELD NON-EXISTENT

Current Level Medium for Both Welds



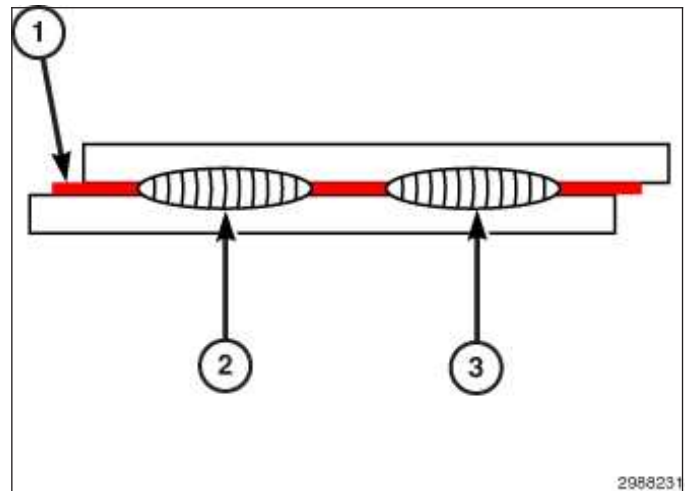
- 1 - STRUCTURAL ADHESIVE
- 2 - WELD CORRECT SIZE
- 3 - WELD TOO SMALL

Current Level High for Both Welds



- 1 - STRUCTURAL ADHESIVE
- 2 - WELD HAS HEAVY EXPULSION OF METAL AND SURFACE MARKINGS
- 3 - WELD CORRECT SIZE

Current Level Adjusted to Provide Acceptable Welds



- 1 - STRUCTURAL ADHESIVE
- 2 - WELD CORRECT SIZE
- 3 - WELD CORRECT SIZE

1. Select the proper spot welding "arm" which provides the best access to the areas of the vehicles where the spot welds are to be made.
2. Obtain metal of the same thickness and coating (i.e., bare, galvanized, or galvanized) to be welded. This metal will be used for spot welder set up. Damaged sheet metal taken from the vehicle being repaired may be used if it is from the area from which the work is to take place. The sheet metal must be flat, free of cracks, wrinkles and scored metal.
3. Using the procedure outlined in [Test Weld Coupon](#), prepare the test coupons.
4. Clean and prepare both mating coupons. If using adhesives, verify the recommendations of the adhesive manufacturer. All contaminants such as rust scale, dirt, paint, and existing sealers and adhesives must be removed. Remove any E-coat within 25mm. (1in.) of where the welds are to be placed.
5. If the panel joint originally contained structural adhesive, it should be applied to the coupon at this time.
6. Install the equipment manufacturers recommended electrode tips.
7. Adjust the welding electrode tip force, and clamp time per manufacturer recommendations.

NOTE: Galvanneal and galvanized coated steel will require more force

8. As shown in [Test Weld Coupon](#), place first weld at a position at least 12.5mm. (0.5 in.) away from end weld coupons. Then make the second weld. The weld spacing should be the same distance as the original welds or the closest existing weld, whichever is the least on the vehicle being repaired.
9. Destructively test the **second** weld to determine the size of the resistance spot weld produced (see examples

in [Test Weld Coupon](#). If the weld is insufficient, adjust the welder per the welder manufacturer recommendations and repeat steps 7,8 and 9 until the proper weld size is achieved.

NOTE: If the first weld becomes too "hot" before the second weld reaches the correct size, reduce the current settings for the first weld and continue increasing the current setting for the second weld until the proper size for the second has been reached.

Final Weld Preparation

CAUTION: NVH foam should be removed from the weld area, as material may be flammable.

1. Visually verify that mating flanges are free of scale, rust, dirt, paint and cured adhesives/sealers, as well as wrinkles. If cracked, wrinkled or scored metal exists the condition needs to be corrected at this time.
2. E-coat within 25mm. (1in.) needs to be removed for STRSW. If Weld Bonding, E-coat should be ground off completely along seam.

NOTE: Corrosion resistance coating (i.e., galvanized, galvalume) should not be removed during cleanup of components.

3. If adhesive is to be used, apply it at this time. Clamp the component to the vehicle.

NOTE: Insulated clamps should be used, as not to shunt the weld current.

4. Visually verify that the welds to be made **will not** be placed directly over an existing weld.
5. After verifying that the welder control settings are the same required to produce the second weld on the test coupons, make the welds on the vehicle.

NOTE: Structural adhesive manufacturers will vary on time allowed for completion of STRSW in weld bond zones. Check and follow adhesive manufacturer recommendations.

6. If adhesive was used, clean up any excessive squeezeout prior to adhesive curing.

Training and Qualification

Training

As with any equipment, proper training is required, and in the case of welding equipment this is no exception. The goal of automobile facilities and technicians is to restore the vehicle to its OEM condition.

Training must be considered a two-fold process:

- The technician must be well versed in how the equipment operates, how adjustments are made and what effects those adjustments have on the weld. The technician must also clearly understand the maintenance of the equipment and the impact of poor maintenance on welds and equipment longevity.
- The second and most important, aspect of the training, is weld quality confirmation. Destructive testing of weld coupons must be performed to ensure the minimum weld size is created. Physical appearance of the weld is not enough to determine the quality of the weld. Additionally, poor welds may also reduce the durability, or quality, of the repaired vehicle in time.

It is required that technicians have received training regardless of the welding equipment or method they utilize. Both training in the specific field of welding, and the particular equipment, are necessary to ensure safe, durable, quality welds are obtained.

Qualification

To demonstrate welding skill, it is highly important that technicians obtain certification from an organization such as the American Welding Society (AWS) or a certificate from the Inter-Industry Conference on Auto Collision Repair (ICAR).

SECTIONING PROCEDURES

WARNING: Sectioning of components may only be performed in the described areas if damage to component does not extend past sectioning location. Should damage extend past sectioning location entire component replacement is the only acceptable repair

WARNING: Chrysler engineering's position on the use of heat during collision repair is as follows:

- Any body panel or frame component damaged which is to be repaired and reused, must be repaired using the "cold straightening" method. No heat may be used during the straightening process.
- During rough straightening prior to panel replacement, damaged panels or frame components may be heated to assist in body/frame realignment. The application of heat must be constrained to the parts which will be replaced and not allowed to affect any other components.

This "no heat" recommendation is due to the extensive use of advanced high strength steels in Chrysler Group LLC products. High-strength materials can be substantially and negatively affected from heat input which will not be obviously known to the repairer or consumer.

Ignoring these recommendations may lead to serious compromises in the ability to protect occupants in a future collision event, reduce the engineered qualities and attributes, or decrease the durability and reliability of the vehicle.

This statement supersedes any previously released information by the Chrysler Group LLC.

Failure to follow these instructions may result in serious or fatal injury.

CAUTION:

- All restraint systems should be disabled before beginning repairs.
- Electronic modules located within 305 mm (12 in.) of any welding should be isolated.
- Protect vehicle from weld spatter damage.
- Vehicle service manual should be referenced for guidelines and warnings.

Service assemblies for body components may be disassembled if utilization of the subcomponents is more appropriate to the repair or to reduce vehicle disruption. The structural and non-structural metal on the Challenger (LA) may be sectioned in several areas providing the prescribed methods below are adhered to.

The joint should whenever possible be performed in as "flat" an area as possible to simplify the repair. While the joint may include "holes" and formations, it is suggested they be avoided but where this is not possible, the technician must ensure that the additional material thickness does not impede installation of fasteners, etc. that the hole exists for.

All dimensions are to be restored to factory specifications prior to full or partial component replacement.

CAUTION: NVH foam should be removed from the weld area, as material may be flammable.

CAUTION: Do not apply any corrosion protection or NVH foam prior to completion of welding, as materials are flammable.

The described sectioning locations only explain joint location and type. All other welds along the sectioned portion of the component must be replaced. Squeeze Type Resistance Spot Welding (STRSW) is the method to be used. If accessibility prevents application of spot welds MIG plug welds are to be used. Welding of structural panels through 3 or more tiers of panel stack ups will require 9.5 mm. plug welds. Exterior panels should be installed using 8 mm. plug welds. For further information reference Weld / Weld Bonding, (Refer to Collision Information - Standard Procedure).

When welding is completed apply inner panel rust proofing, such as Mopar Cavity Wax Kit (part #68042969AA), Mopar Wax Refill (part #68042970AA), or equivalent. Apply to the inner cavity areas in two applications with a 30-minute flash period between the applications. Pay particular attention to areas which have been welded. Corrosion protection should always be restored to manufacturer specifications. For further information on Corrosion Protection, (Refer to Collision Information - Standard Procedure).

Finish, sealers, adhesives and silencers should be reapplied or replaced to OEM locations and specifications, (Refer to Collision Information - Locations).

DESCRIPTION	FIGURE
UPPER LOAD PATH BEAM	Upper Load Path Beam

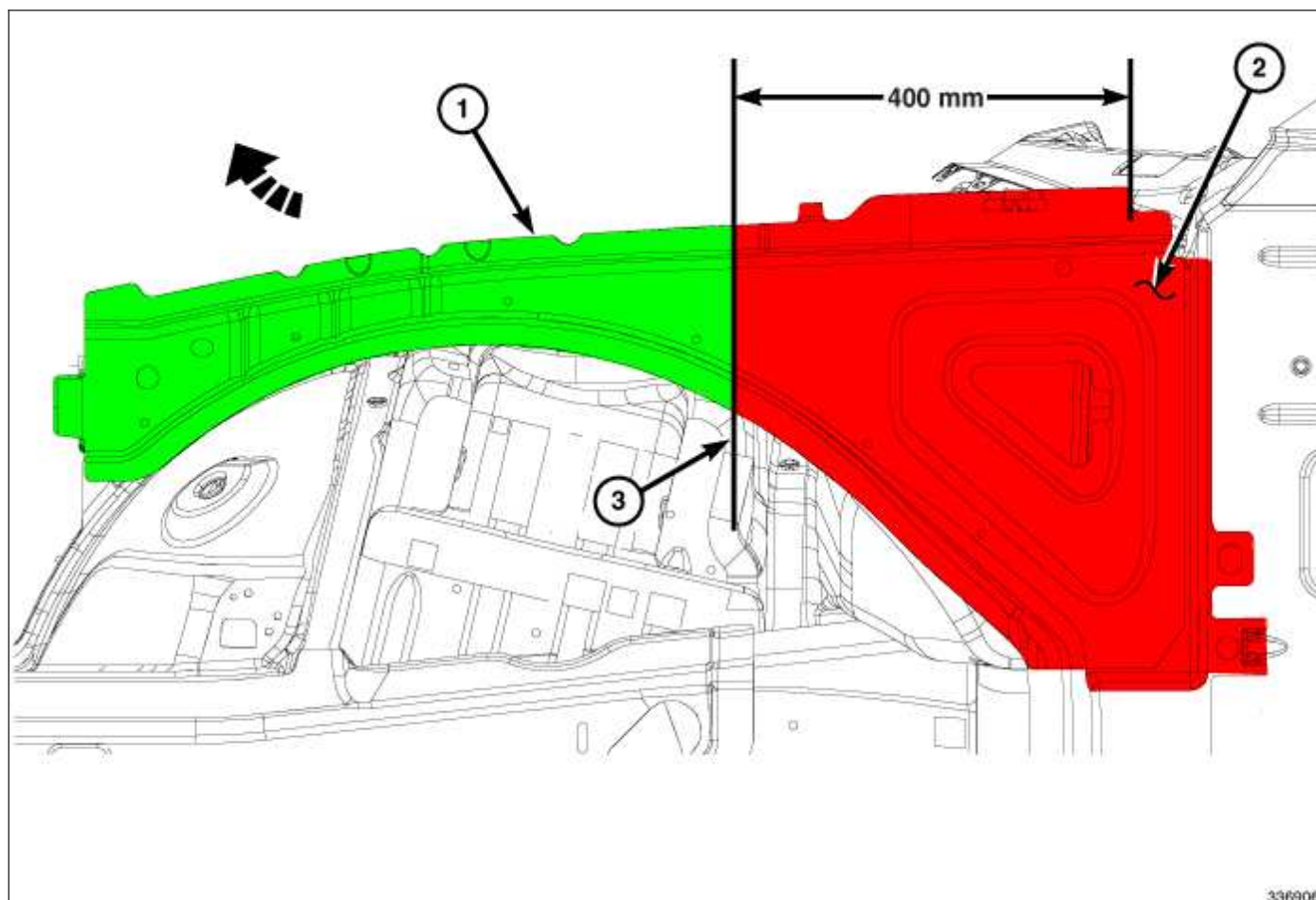
DESCRIPTION	FIGURE
LOWER FRONT RAIL ASSEMBLY	Front Rail Assembly
OUTER BODY SIDE APERTURE	Outer Body Side Aperture
INNER BODY SIDE COMPONENT DO NOT SECTION	Inner Body Side Components-Do Not Section
A-PILLAR AND ROOF RAIL COMPOSITE INSERTS	Composite Inserts
INNER BODY SIDE ASSEMBLY	Inner Body Side Assembly
INNER BODY SIDE REINFORCEMENT	Inner Body Side Reinforcement
SILL PANEL AND SILL REINFORCEMENT	Sill Panel and Sill Reinforcement Sectioning
REAR RAIL (Right and Left)	Rear Rail

Upper Load Path Beam

1. Verify that structural dimensions have been restored to vehicle specifications.
2. Remove all components necessary to access the upper load path beam.

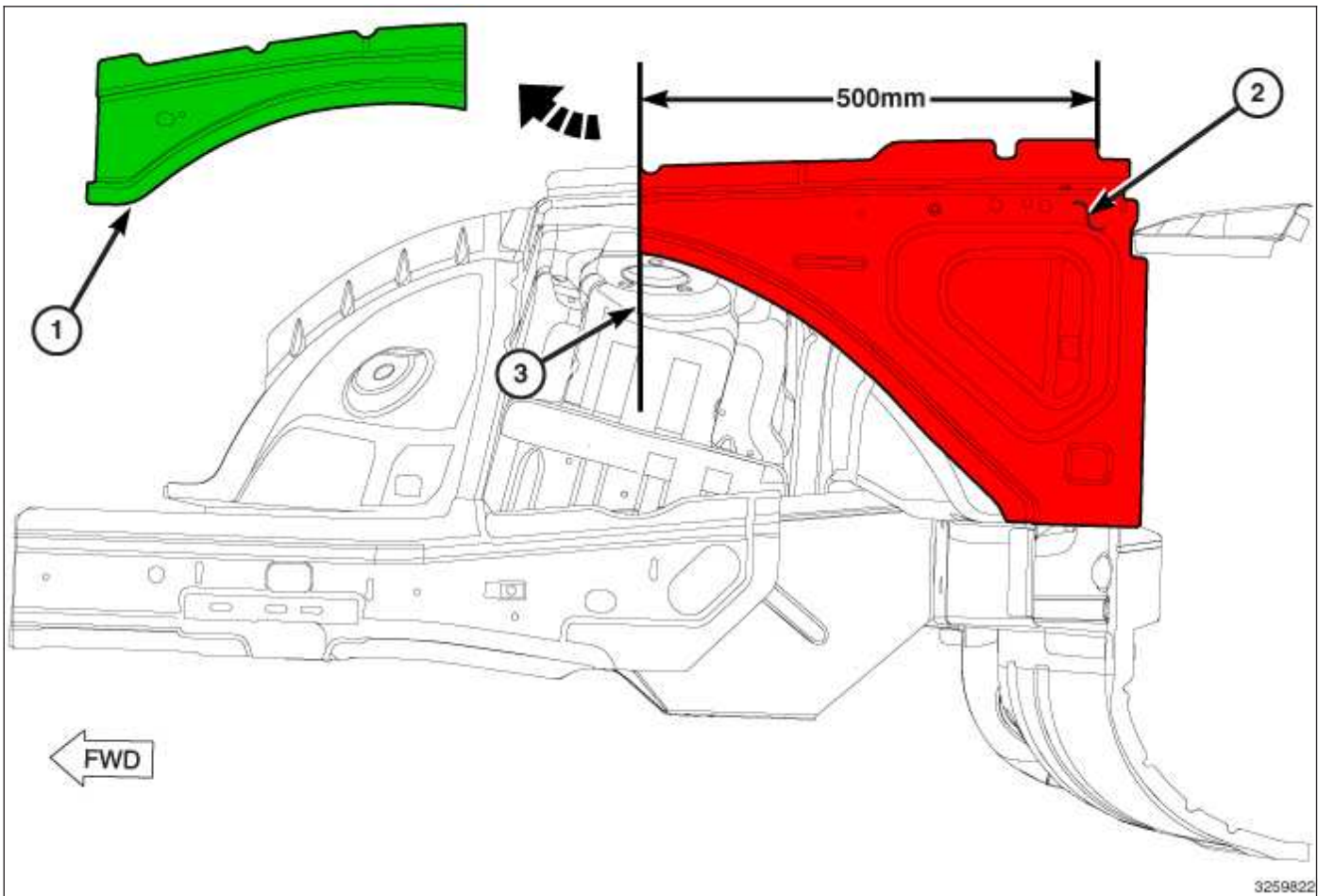
NOTE: Sectioning of the outer load path beam is recommended due to the use of net, form and pierce in the hood hinge area.

NOTE: Should full replacement of outer load path beam be necessary, hood hinge mount area will require hammer and dolly method to re-create.

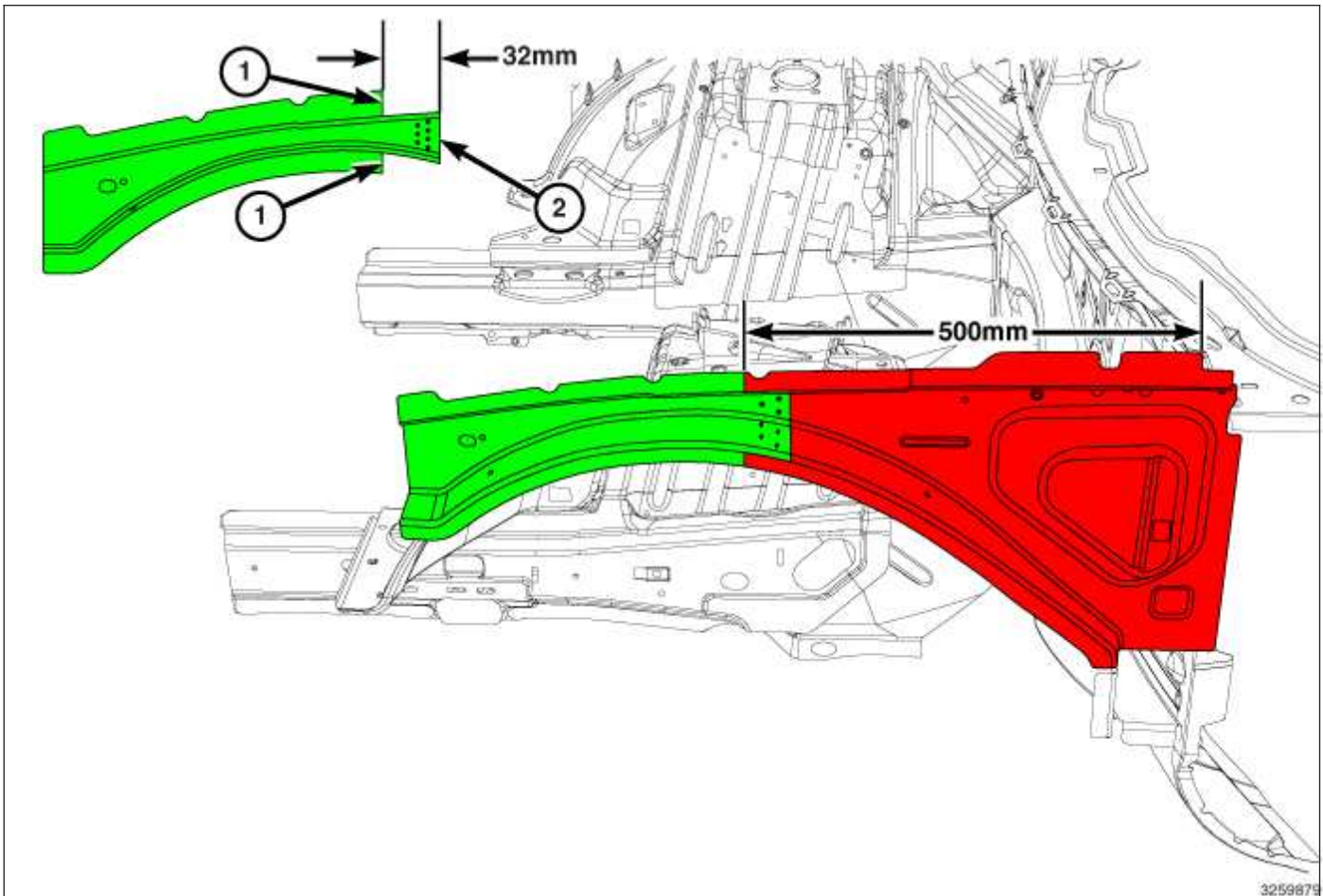


3. On the existing (original) outer load path beam (2), measure 400 mm (15.75 in) from the rear edge shown forward, and scribe top edge.
4. With the use of a "square", scribe the center section. With a straight edge, scribe the upper and lower flange. This will be the cut line (3).
5. Cut through the outer load path beam using a reciprocating saw or similar tool, while being careful not to cut the inner load path beam.

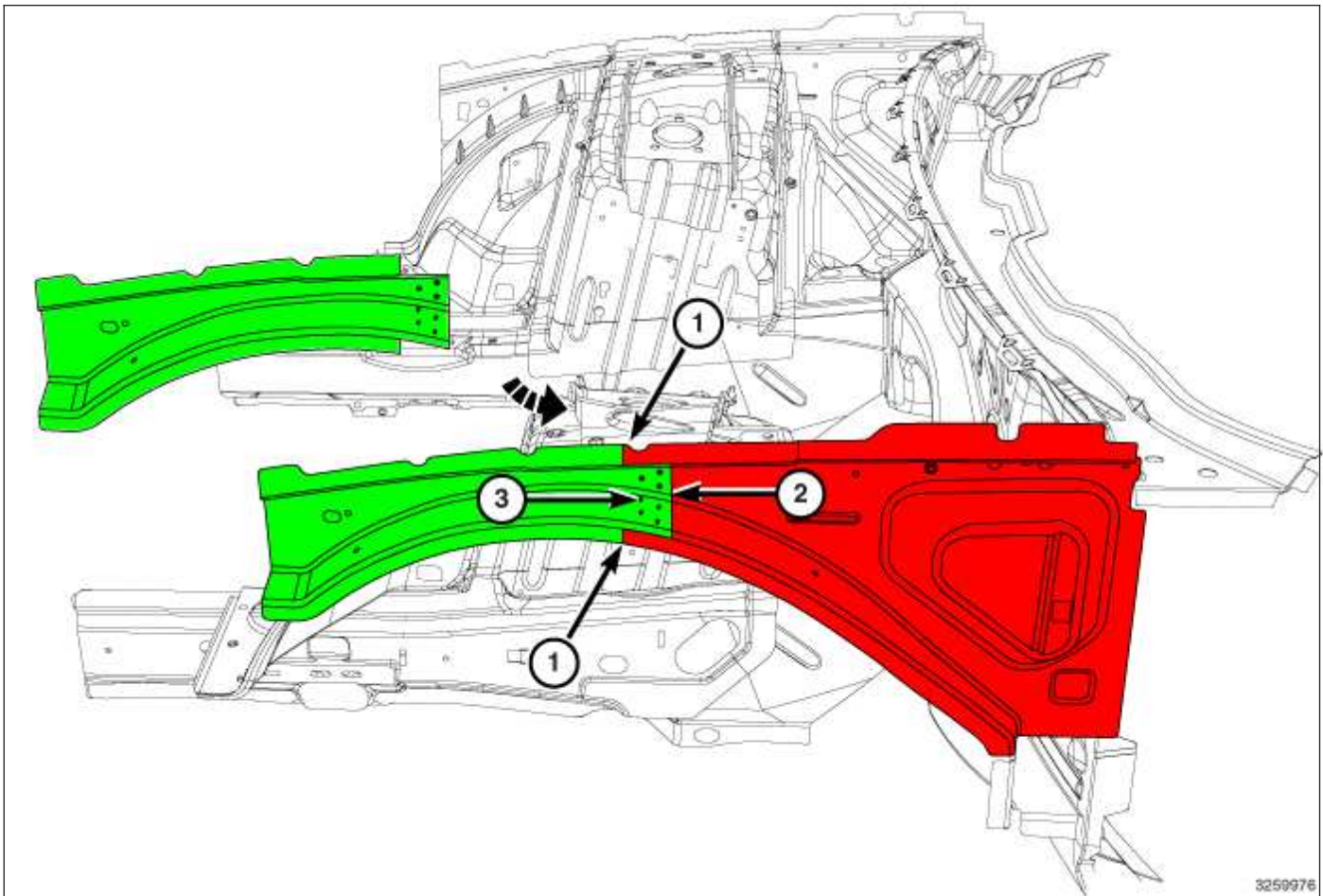
6. Release all the spot welds forward of the cut line.
7. Remove front section with an air chisel equipped with a flat blade bit and discard the front section (1).



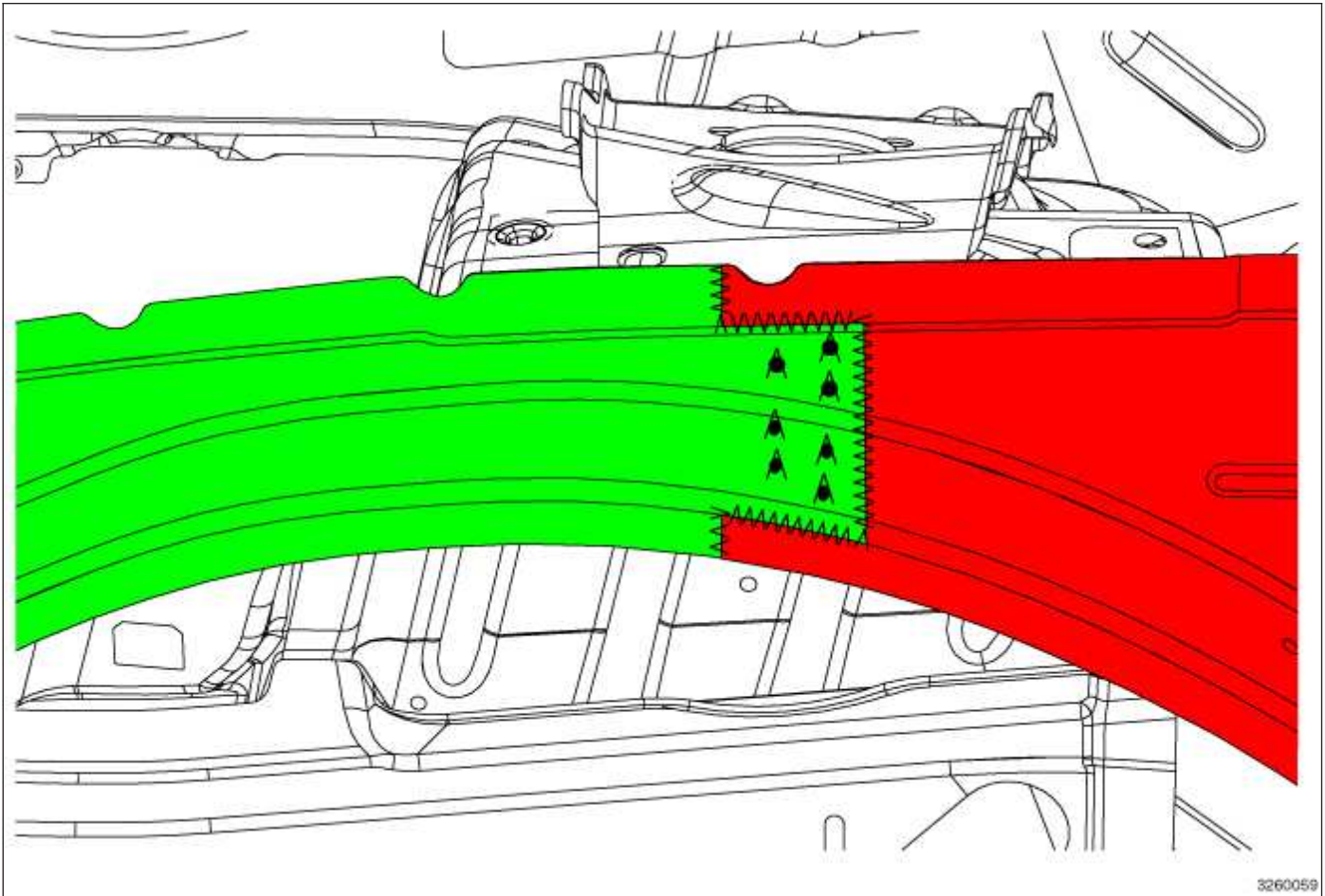
8. On the existing (original) inner load path beam (2), measure 500 mm (19.5 in) from the rear edge shown forward, and scribe top edge.
9. With the use of a "square", placed to the rear of beam cut line (3), scribe the upper load path beam upper and lower flanges. With a straight edge, scribe the center section of original inner load path beam.
10. Cut through the beam using a reciprocating saw or similar tool, while being careful not to cut into the wheelhouse.
11. Release all the spot welds forward of the cut line (3).
12. Remove front section of the upper load path beam (1) with an air chisel equipped flat bladed bit. Discard the front section.



13. On the replacement part, measure and scribe 500 mm (19.5 in) as the original part in the above steps.
14. With the use of a "square", placed to the rear of beam cut line, scribe the load path beam upper and lower flanges (1).
15. Measure 32 mm (1.25 in) aft the scribe marks made on new part flanges, and with a straight edge scribe accordingly, creating the outline for the tongue (2).
16. Use a reciprocating saw or similar tool to cut along the scribed edges.
17. Use layout in Weld / Weld Bonding section "Modified Lap Joint", (Refer to Collision Information - Standard Procedure), to layout plug weld pattern on tongue and drill holes accordingly.
18. Grind all contaminants and coatings off of the mating surfaces. The metal should be completely bare and shiny in appearance, if the metal appears pewter in color all of the galvanized coating has not been completely removed.



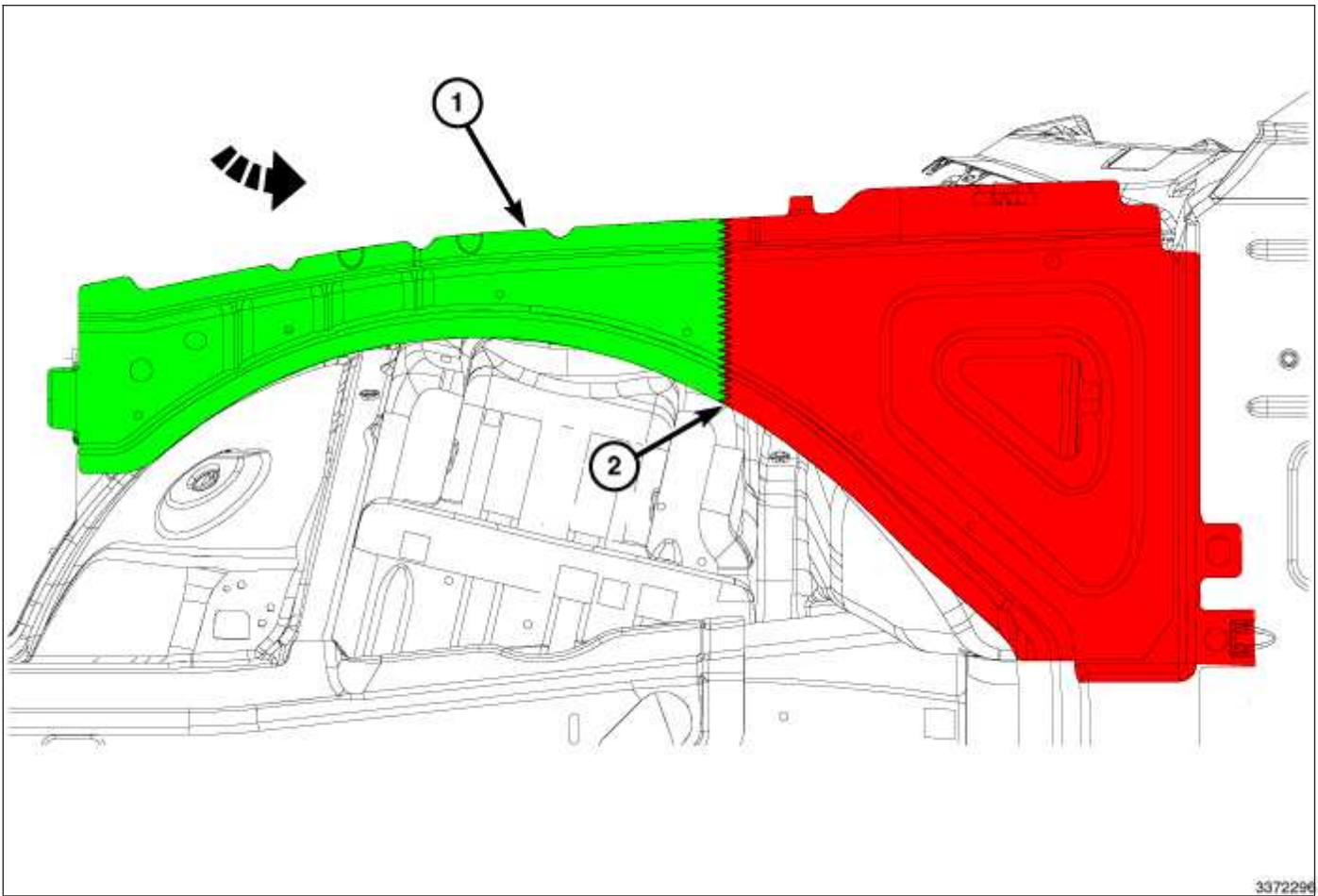
19. Place the replacement part into position. Flanges (1) should fit tightly together, forming the "butt-joint". Tongue (2) will overlap the original section of the inner load path beam, forming the lap joint.
20. With welding clamps or similar tools, tightly clamp the two sections together.
21. Re-measure structural dimensions to ensure new section is positioned correctly. If not within specifications, reposition as necessary until proper dimensions have been achieved.
22. Weld into position, alternating between plug welds (3), lap and seam welds to reduce the heat effected zone.



NOTE: Be certain to completely (100%) weld all exposed, accessible seams around the entire joint. Inner and outer in All accessible areas

CAUTION: Do not apply any corrosion protection to the weld zones until the outer panel is fully installed and all welding is completed as materials are flammable.

23. The exposed area should be cleaned and welds dressed.



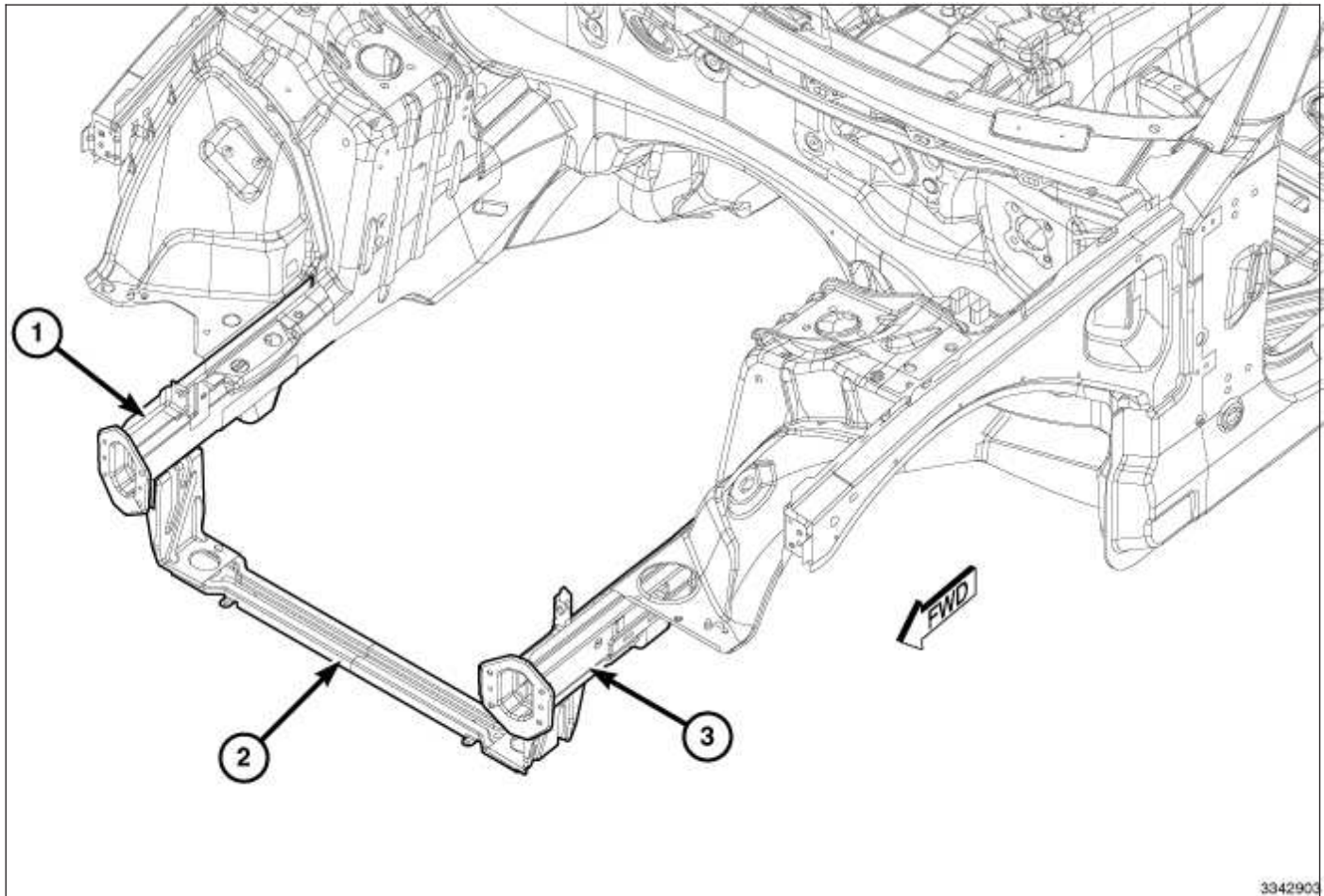
NOTE: Outer load path beam will be installed using a butt-joint with weld backer

24. On the replacement outer load path beam, measure and scribe 400 mm (15.75 in) as the original part in the above steps.
25. Use a reciprocating saw or similar tool to cut along the scribed edges.
26. Cut a 19 mm (0.75 in) weld backer out of the unused portion of the rear section of replacement outer.
27. Grind all contaminants and coatings off of the mating surfaces. The metal should be completely bare and shiny in appearance, if the metal appears pewter in color all of the galvanized coating has not been completely removed.
28. Tack weld backer into place.
29. Re-measure and position outer load path beam.
30. MIG weld into position, stagger stitch welds to minimize heat effect zone. Weld seam completely.
31. Upon completion of welding, inject Moper Cavity wax kit (part #68042969AA), Mopar wax refill (part #68042970AA) or equivalent, to the inner cavity. A double application should be applied. Allow a minimum of 30-minutes flash time between the first and second coats.
32. Complete the remainder of repairs.

NOTE: Due to component replacement it will be necessary to shim the front of fender to replace net, form pierce area.

33. Follow paint manufacturer instructions and refinish accordingly.

Front Rail Assembly

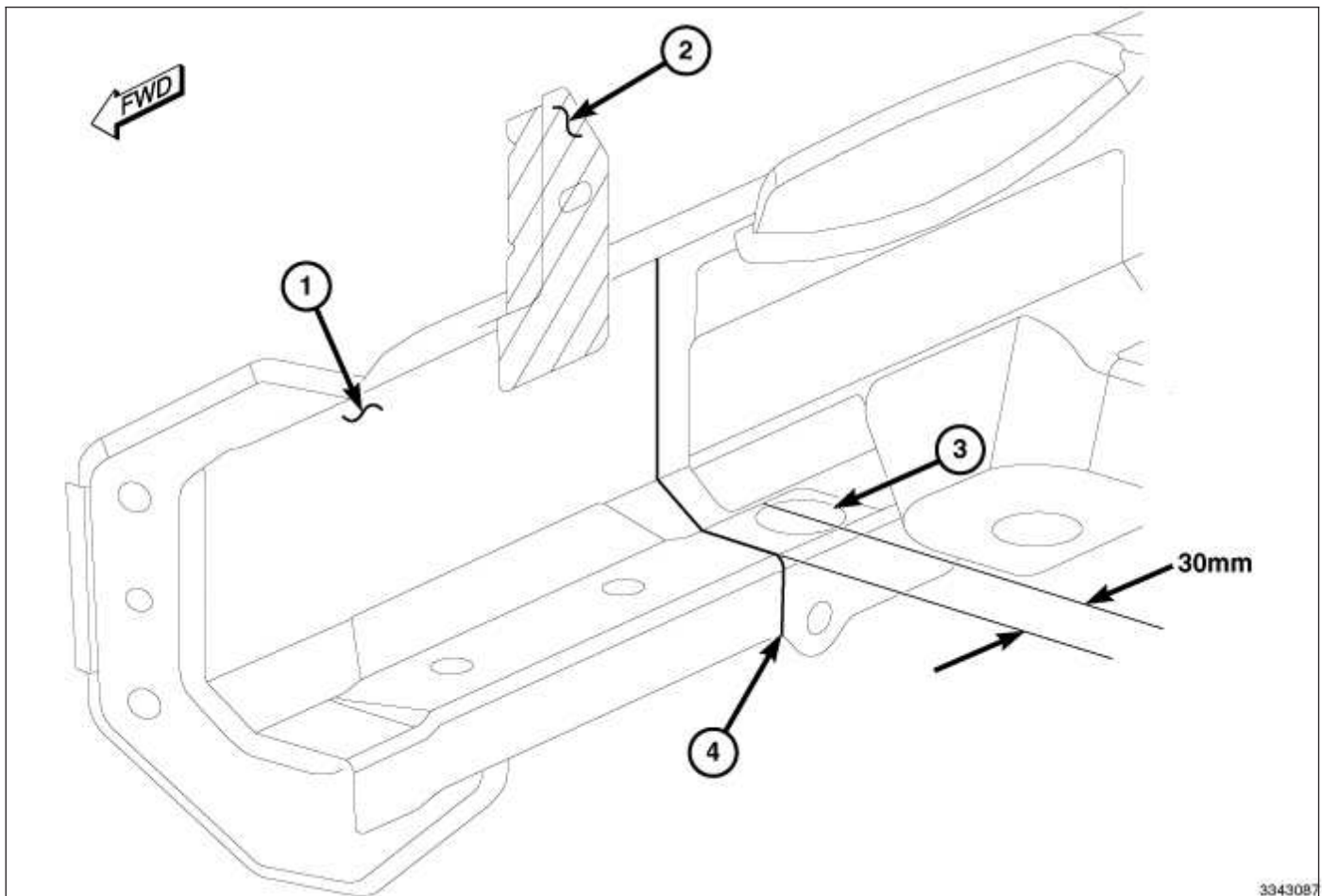


3342903

- 1 - Right Side Rail
- 2 - Lower Radiator Crossmember
- 3 - Left Side Rail

Damage to the frame rail, rearward of the area covered by this procedure, which is not eliminated during preliminary structural corrections and pulls, necessitates complete rail replacement to restore the vehicle to pre-loss condition.

1. Mount, measure and make structural corrections as needed.
2. Using 3-dimensional measuring equipment verify that dimensions have been restored.
3. Remove all components in the area of repair allowing unimpeded access for cutting and welding operations.
4. Remove bolts holding lower radiator crossmember (3) to the rail. If crossmember is to be replaced remove completely.



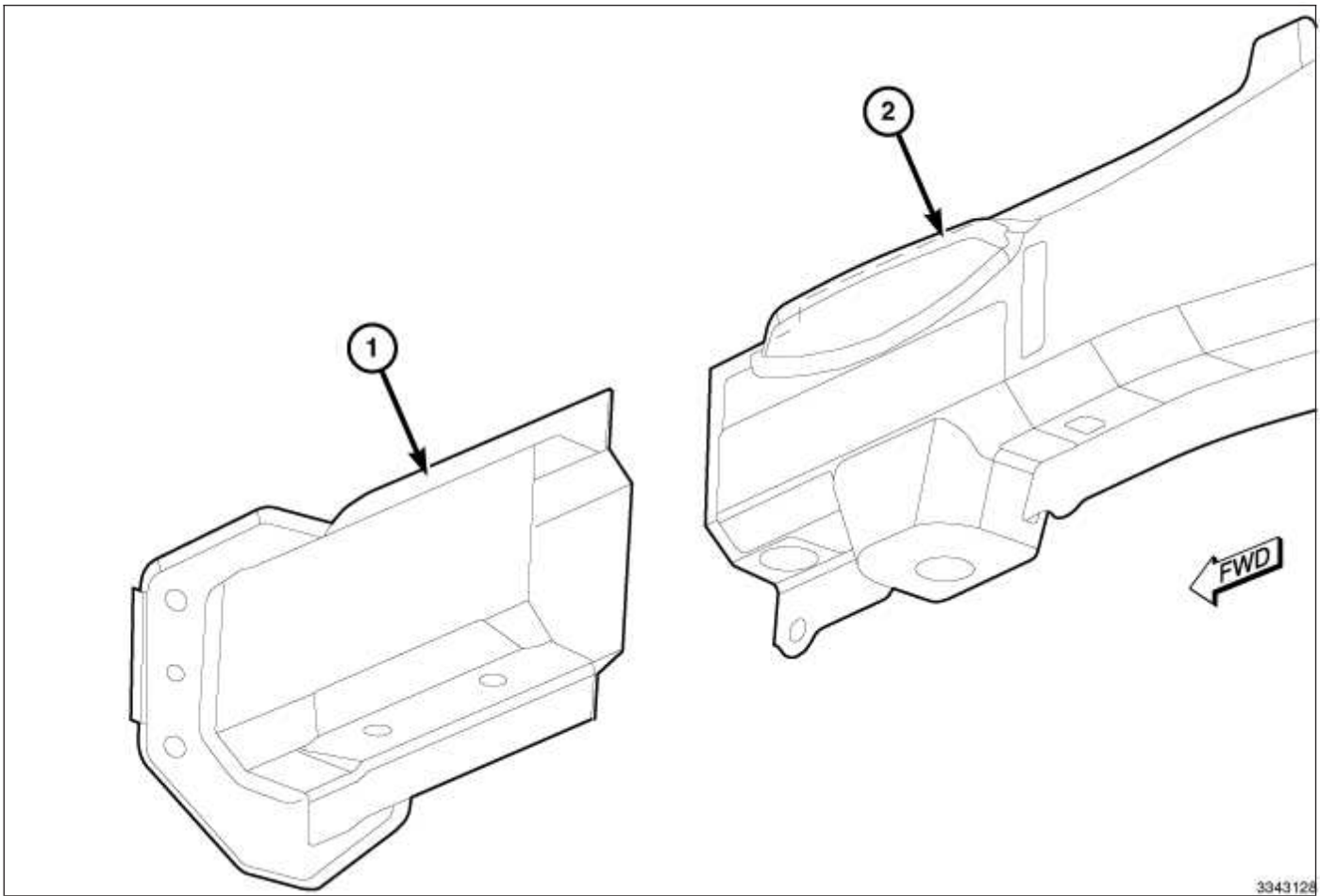
1 - Inner Rail

2 - Bracket

3 - PLP (Principal Location Point)

4 - Cut Line

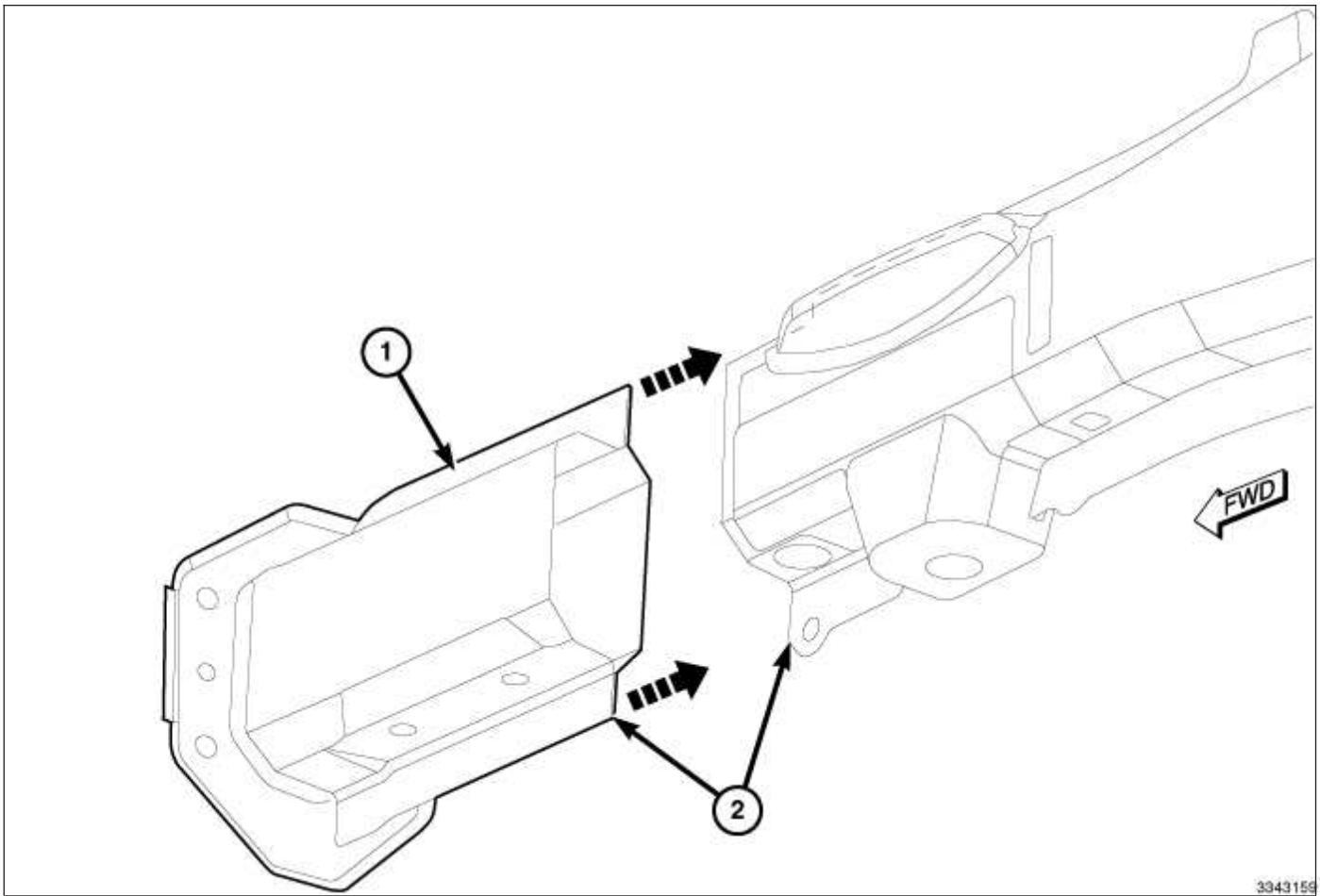
5. Remove bracket - carefully as it will be re-used.
6. Using the Principal Location Point (PLP) hole in the bottom of the frame rail, measure 30 mm forward from center of the PLP and mark rail. Using appropriate straight edge, complete a vertical cut line on the inner and outer rail.



3343128

- 1 - Damaged Rail tip
- 2 - Original Rail (Undamaged)

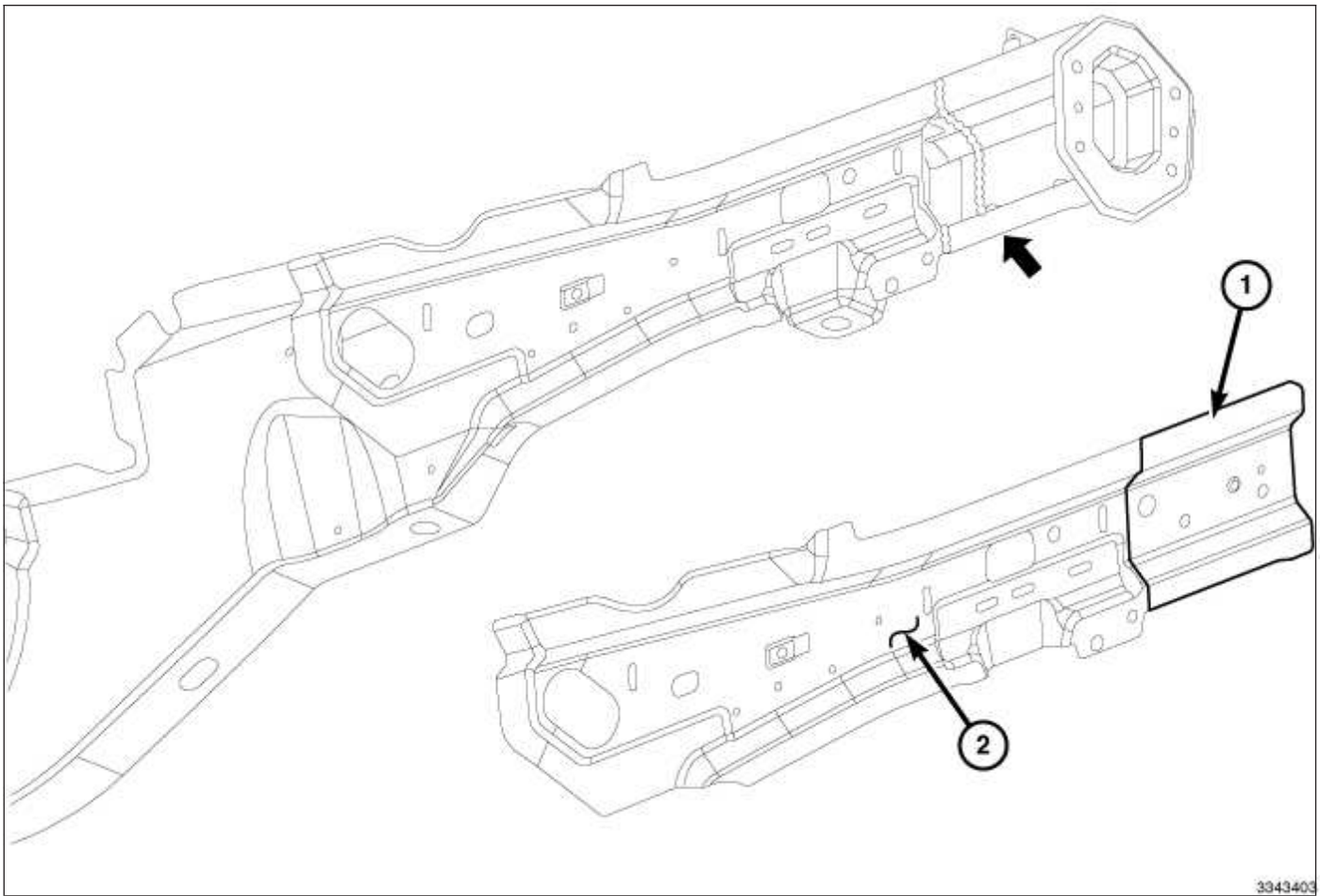
7. Using a reciprocating saw or a cut-off wheel, cut through the rail and remove the damaged rail tip (1).
8. Utilize the same measuring and cutting process above to remove the rail tip from the inner rail service part.
9. Using a surface conditioning disc, remove all e-coat within 25 mm (1 in.) of the cut location of the original rail (2) and the inner service component also deburr and slightly taper the cut edge.



1 - Replacement Inner Rail

2 - Position and Clamp

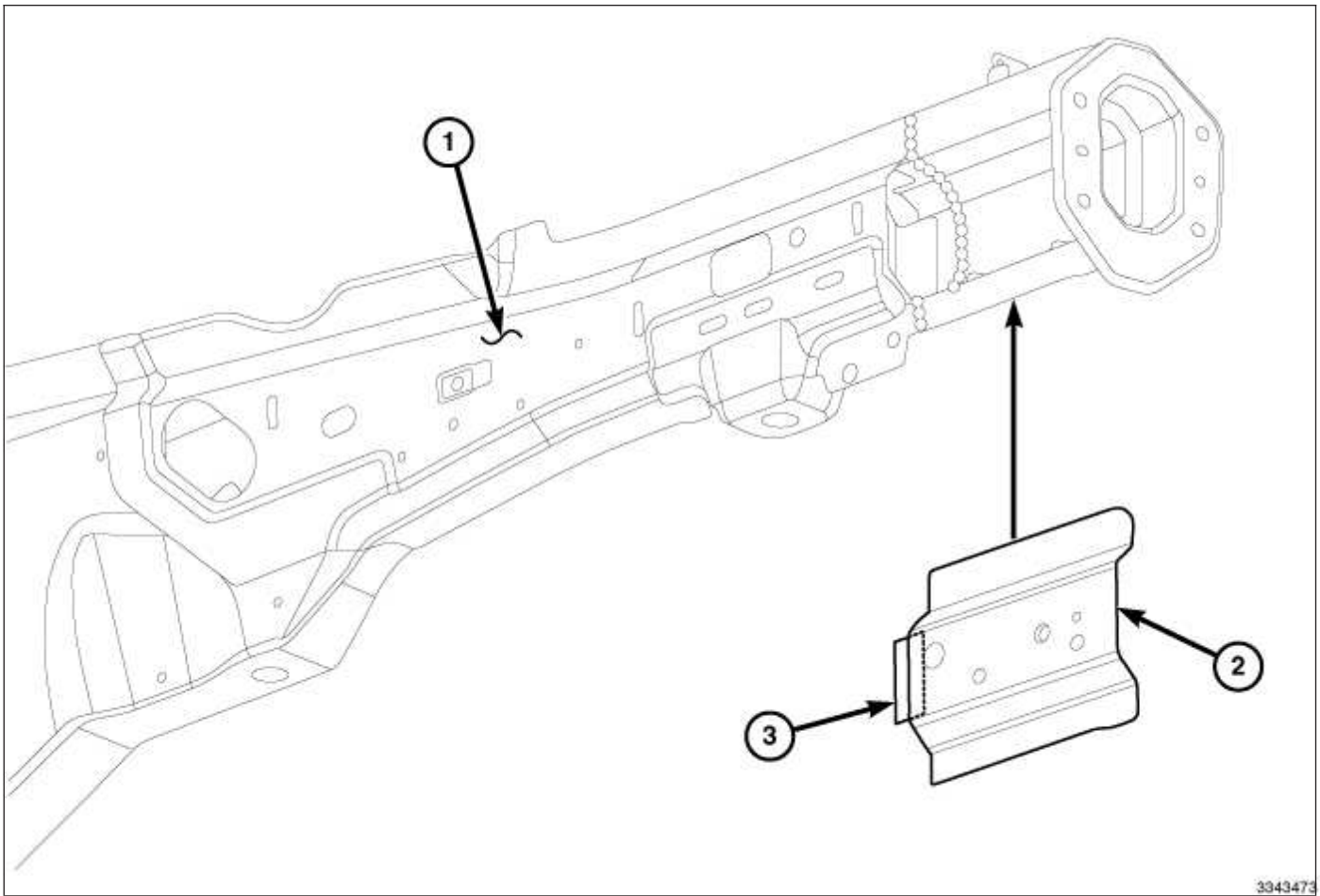
10. Position and clamp the replacement inner rail (1) and confirm the proper position with measuring equipment.
11. Weld the service part into position in the sequence as follows:
 - Weld inside of rail upper half
 - Weld outside of rail lower half
 - Clean the back sides of the above welds in preparation for welding
 - Weld inside of rail lower half
 - Weld outside of rail upper half



1 - Replacement Outer Rail Closure Plate

2 - Outer Rail Closure Plate Section

12. Roughly trim the outer rail closer plate (1) to length
13. Hold cover plate in proper position and mark top and bottom at cut location and mark. Remove plate and trim to proper dimensions, then remove e-coat within 1 inch of the cut line.
14. From the cover plate waste, cut a 19mm (3/4in.) wide strip of material and fabricate into a weld backer and tack it to the rail.



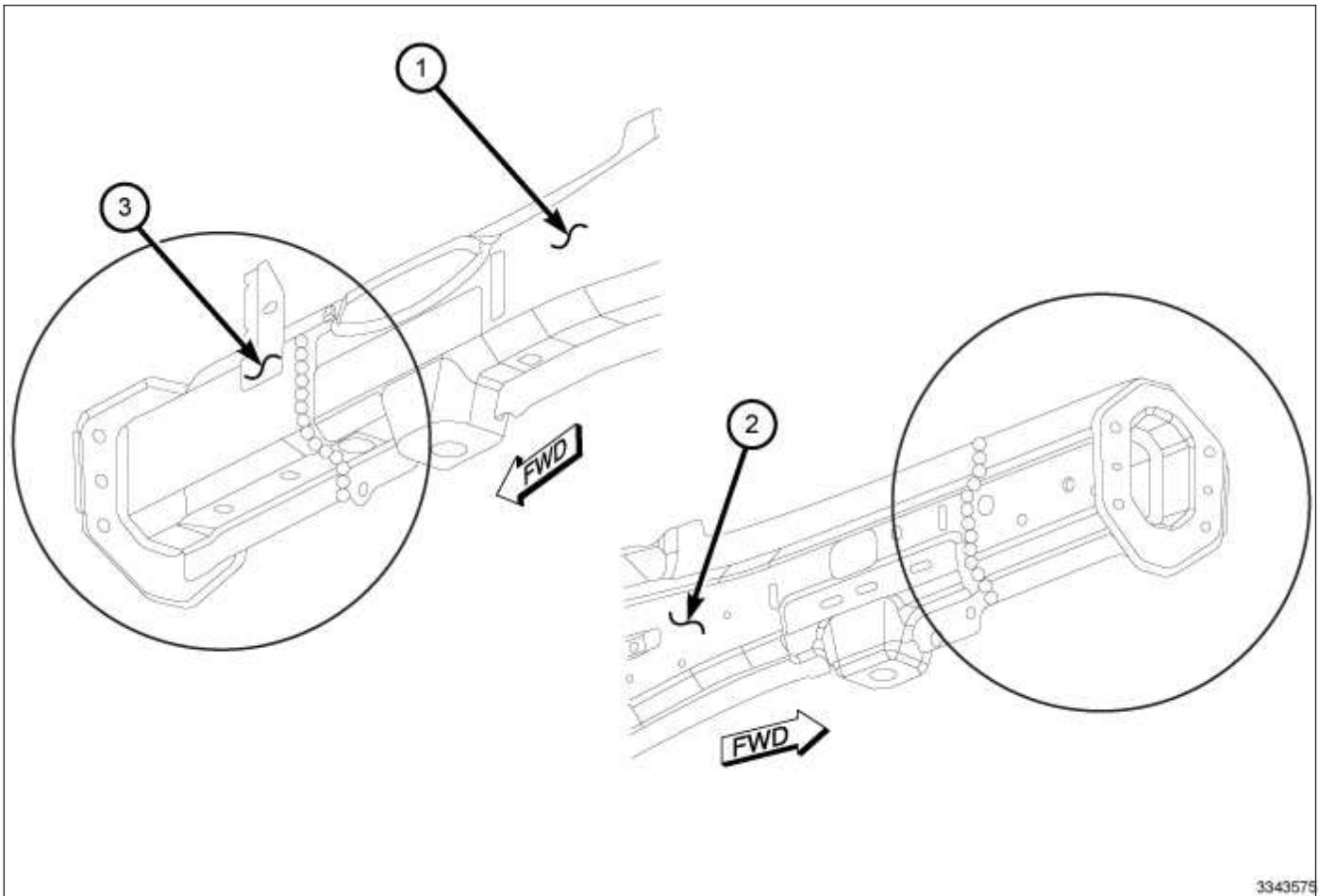
1 - Original Rail Closure Plate

2 - Weld Backer

3 - Replacement Outer Rail Closure Plate

15. Install the closure plate (3) and weld:

- The inner rail and cover plate are welded preferably using Squeeze Type Resistance Spot Welding (STRSW) equipment as the original. If STRSW is not available, then MIG ring fillet welds may be substituted
- MIG Weld the butt-joint location



3343575

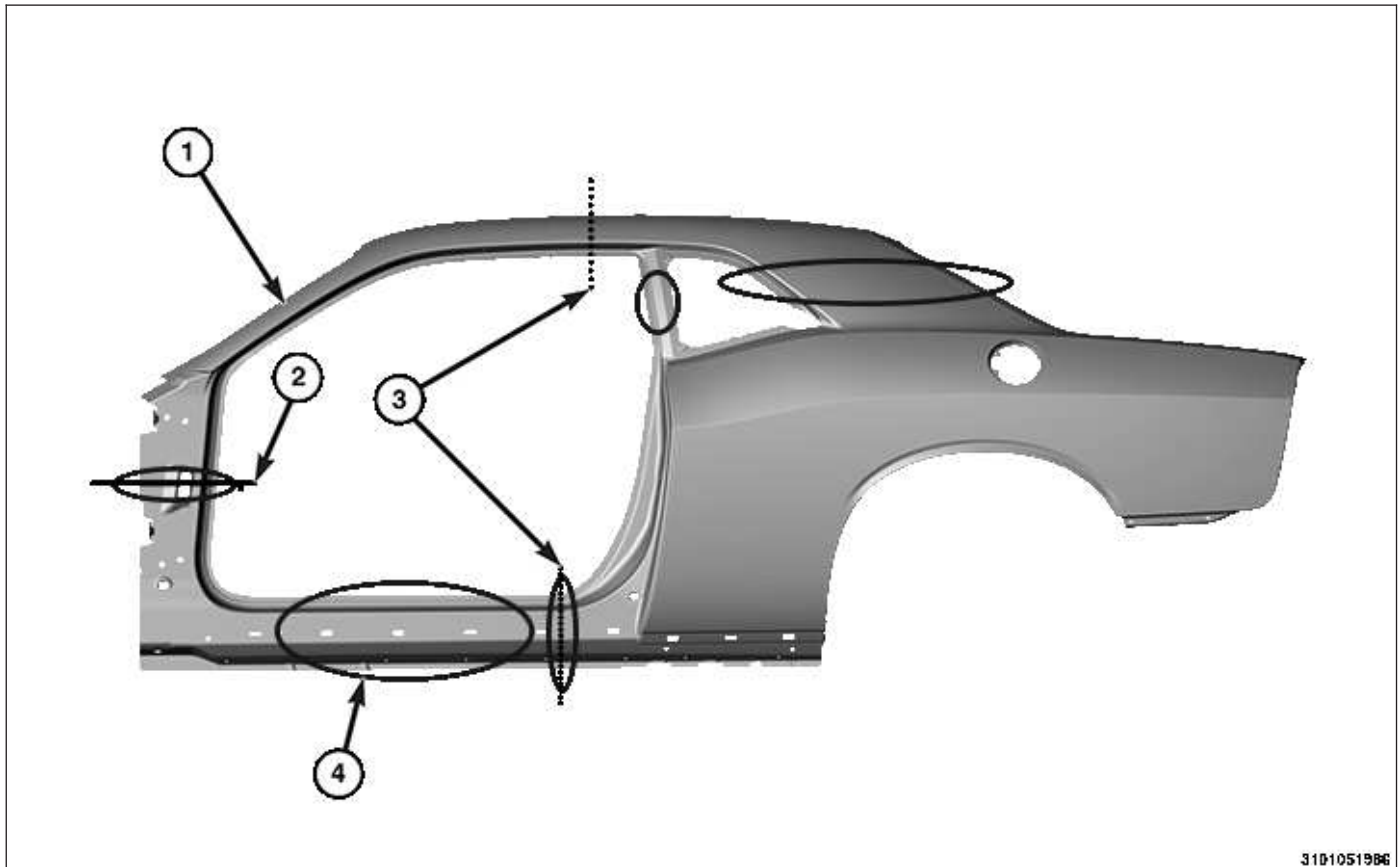
1 - Inner Frame Rail

2 - Outer Frame Rail

3 - Bracket

16. Reattach bracket (3) to inner frame rail (1).
Reattach lower radiator crossmember to inner rail (1).
17. Dress the welded area and apply corrosion resistant coatings inside and out:
 - Inside the rail, inject a creeping wax based rust inhibitor compound through the existing holes in the frame ensuring 100% coverage including the space between the original frame and the reinforcing sleeve, using Mopar Cavity Wax Kit (part #68042969AA), Mopar Wax refill (part #68042970AA), or equivalent. Apply to the rail inner cavity areas in two applications with a 30-minute flash period between applications. Pay particular attention to areas which have been welded.
 - Apply a durable top coat to the outside of the repair area.
18. Complete the balance of repairs.

Outer Body Side Aperture



WARNING: When sectioning the Outer Body Side B-pillar, care must be taken as NOT to cut into the B-pillar reinforcement.

WARNING: Failure to follow these directions may result in serious or fatal injury

NOTE: Dashed lines represent service parts cut lines.

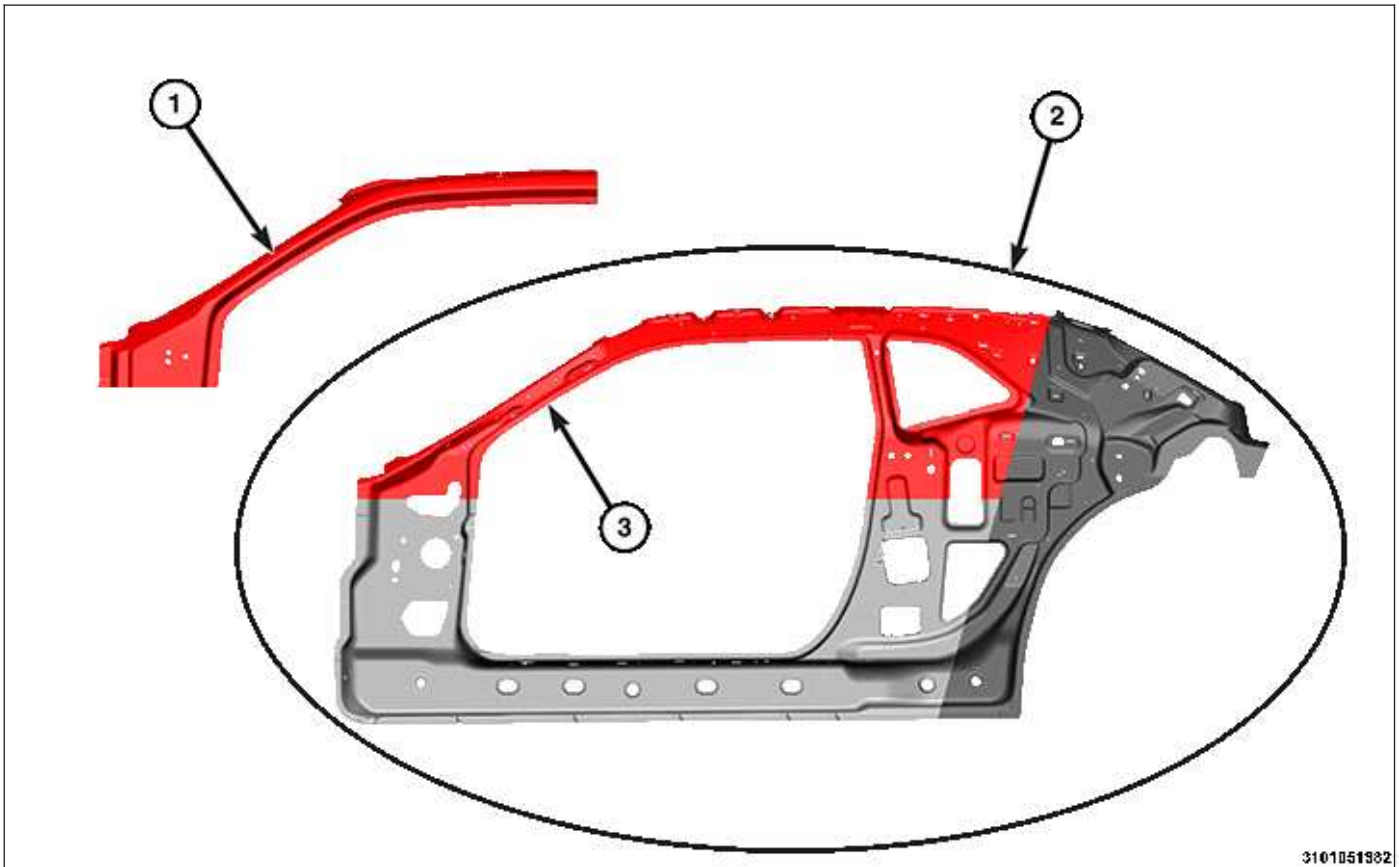
NOTE: The A-pillar is dedicated to where it is to be sectioned, as compared to the general location within the outlined areas.

- 1 - BODY SIDE APERTURE (OUTER)
- 2 - A-PILLAR SECTIONING LOCATIONS (see note)
- 3 - SILL SECTIONING LOCATIONS (see note)
- 4 - SERVICE PARTS CUT LOCATIONS (see note)

The body side aperture has many areas in which it may be sectioned in. The A-pillar is to be sectioned at the base or **between** the wire harness pass through and the upper door hinge as shown in figure. All other outlined areas represent general sectioning areas and may be sectioned within.

A butt-joint with a 13 mm. (0.5in.) weld backer is to be used in all sectioning areas of the outer body side aperture.

Inner Body Side Components - Do Not Section



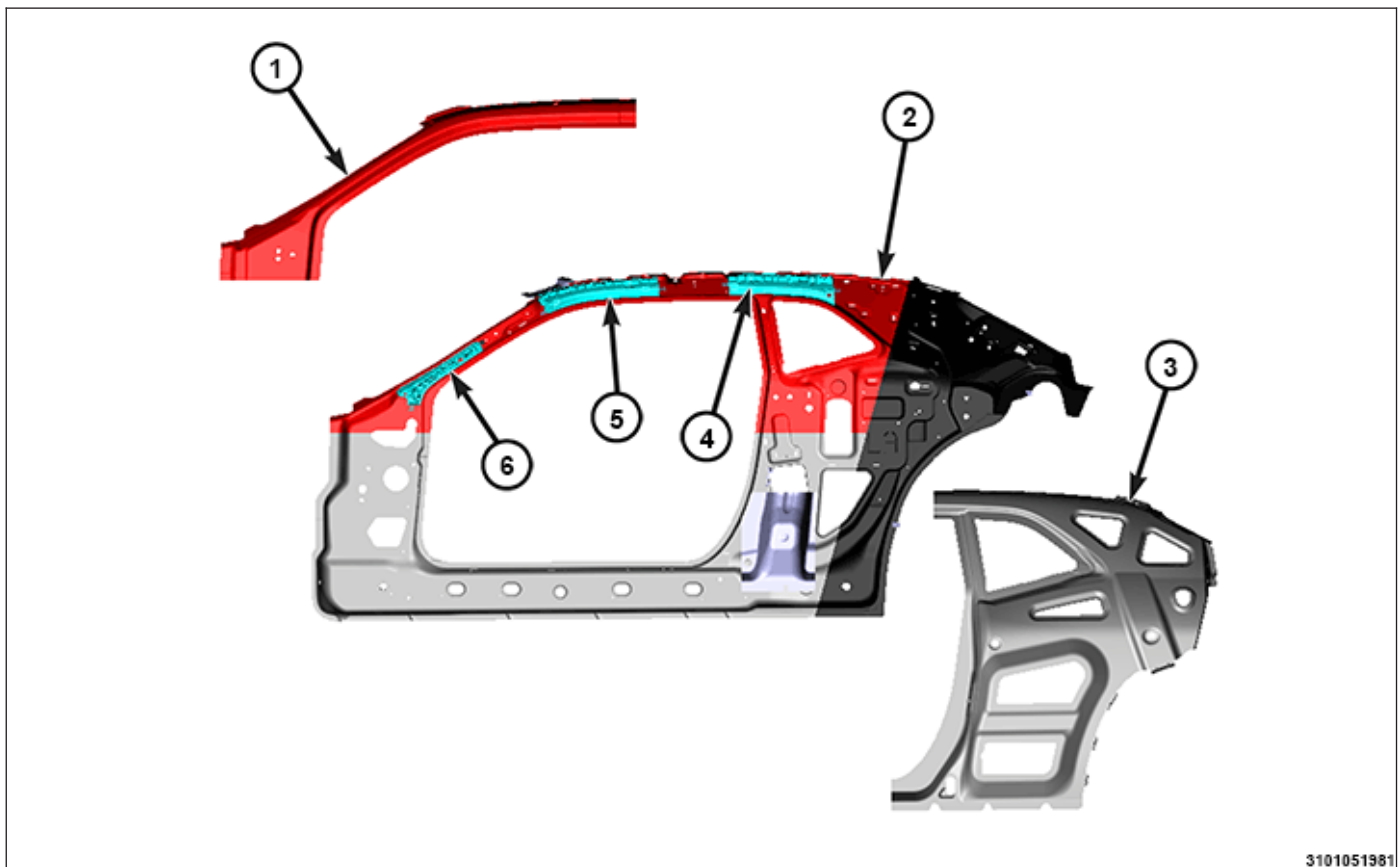
3101051932

VERY HIGH STRENGTH (VHS) STEEL REINFORCEMENTS AND PANELS SHOWN IN RED — DO NOT SECTION

- 1- A-PILLAR REINFORCEMENT
- 2- INNER BODY SIDE ASSEMBLY
- 3- VHS PORTION OF INNER BODY SIDE ASSEMBLY

Due to the usage of VHS on the inner components and reinforcements sectioning of these parts are not allowed. Complete replacement of the component or reinforcement is the only acceptable repair. It will be necessary to use a **Tungsten Carbide Drill Bit** to release the spot welds along the areas where these parts join other components.

A-pillar and Roof Rail Composite Inserts



3101051981

- 1 - A-PILLAR REINFORCEMENT
- 2 - INNER BODY SIDE APERTURE
- 3 - C-PILLAR REINFORCEMENT
- 4 - COMPOSITE ROOF SIDE RAIL REINFORCEMENT
- 5 - COMPOSITE A-PILLAR UPPER REINFORCEMENT
- 6 - COMPOSITE A-PILLAR LOWER REINFORCEMENT

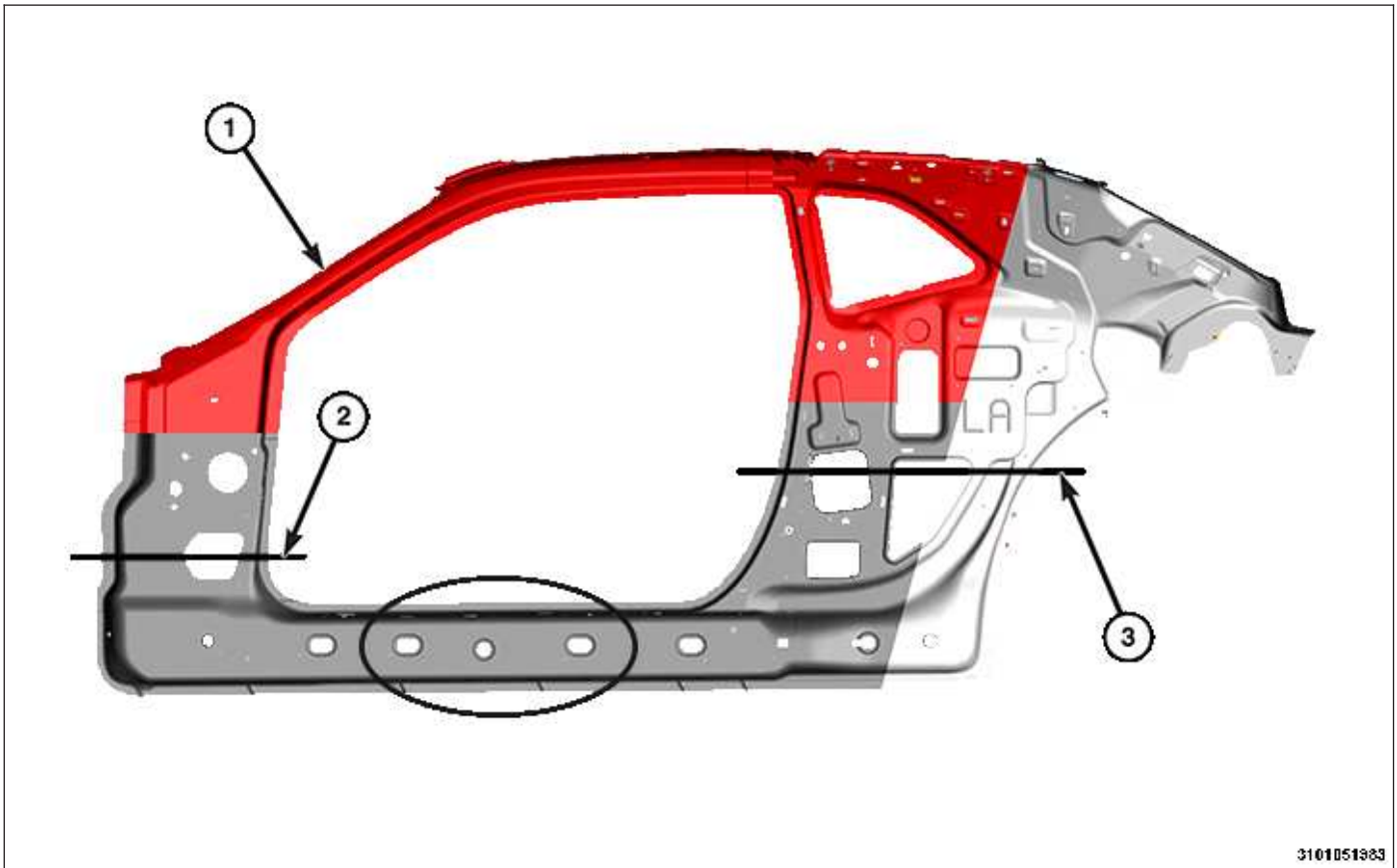
WARNING: Composite Reinforcements must be installed to maintain roof strength standards

WARNING: Failure to follow these directions may result in serious or fatal injury

If a composite roof rail reinforcement (1, 2 and 3) or any component that makes contact with the composite reinforcement is replaced it will need to be re-secured. **Composite Reinforcements absolutely must be reinstalled.** Replace the new or re-used, composite roof rail reinforcement with structural adhesive during the repair process. Approved structural adhesives include Fusor 112B and 3M 08116.

A composite roof rail reinforcement may have a mounting nut on the back, utilized for mounting of separate component. Be certain the composite reinforcement's nut is aligned properly to the corresponding hole in the mating component. Do not allow any adhesive to interfere with the threads of the nut.

Inner Body Side Assembly



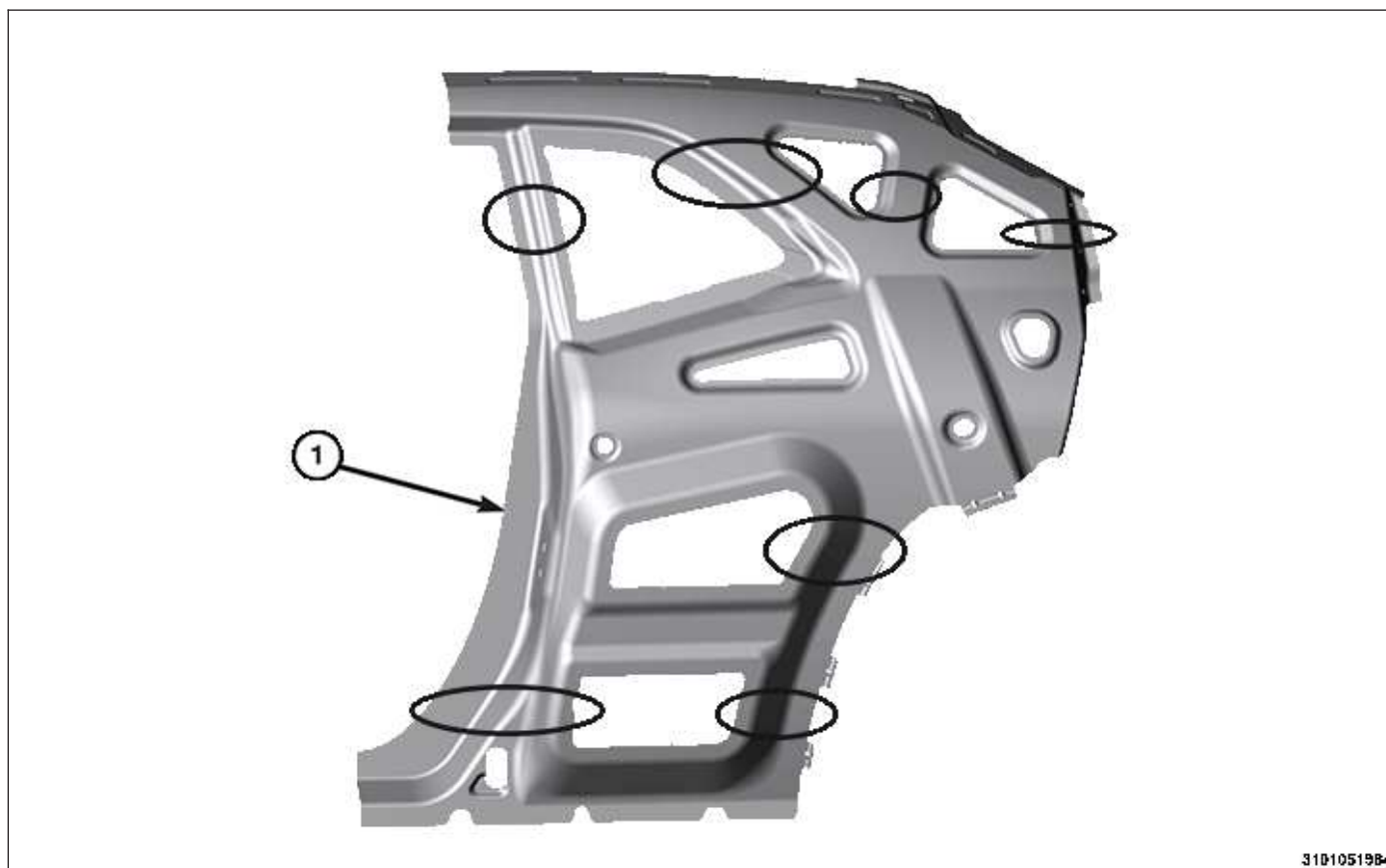
Inner Body Side Assembly

- 1 - VERY HIGH STRENGTH STEEL (VHS) Do not section
- 2 - A-PILLAR SECTIONING LOCATION
- 3 - REAR SECTIONING LOCATION

The sill outlined area represents general sectioning areas within.

The body side inner aperture is to be sectioned using Modified Lap-joints. Further information on "Modified Lap-Joint" can be found in "Welding and Weld Bonding" section, (Refer to Collision Information - Standard Procedure).

Inner Body Side Reinforcement



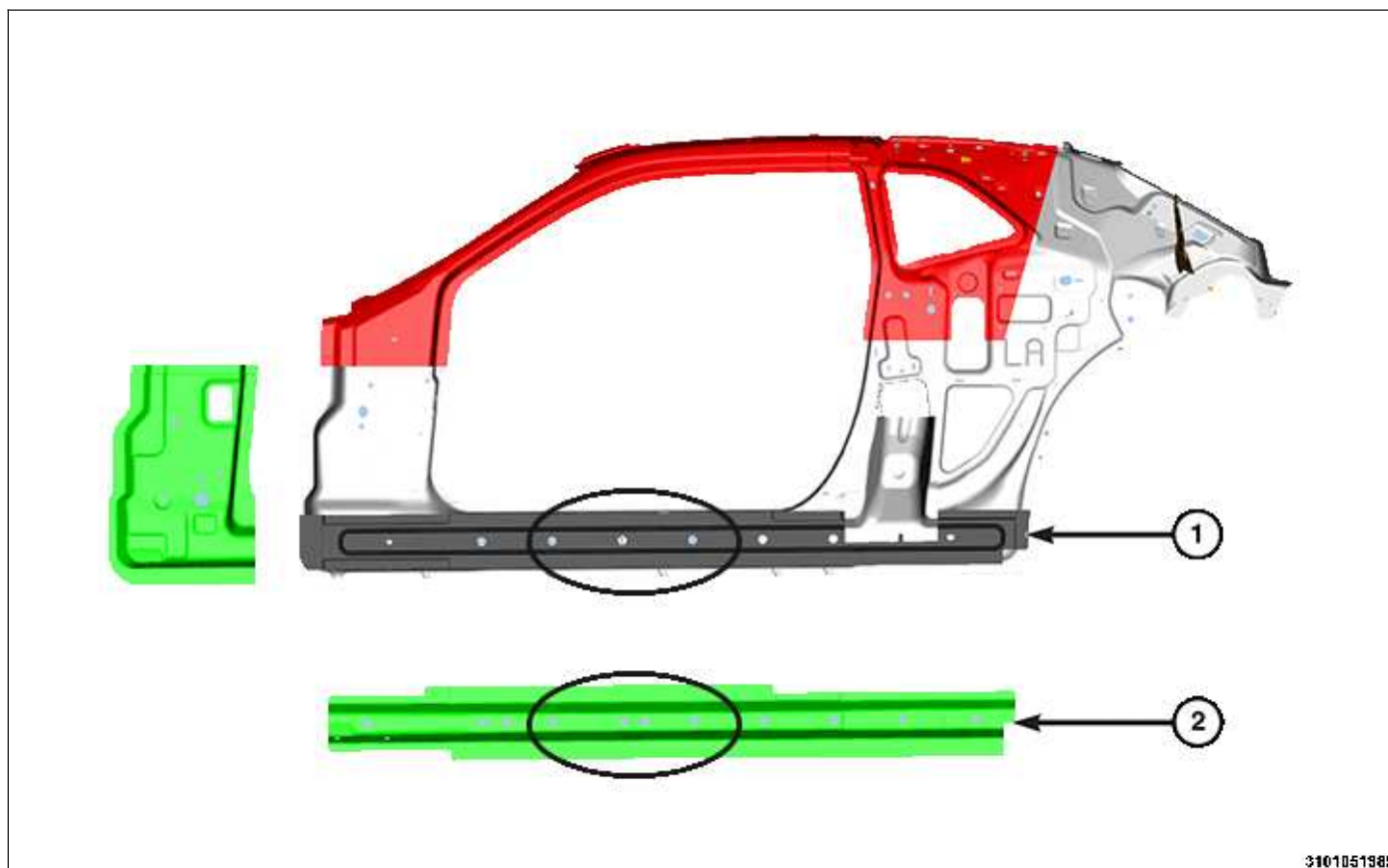
31D10519B4

1 - REAR INNER REINFORCEMENT PANEL

Outlined areas represent general sectioning areas within.

The inner reinforcement panel is to be sectioned using lap-joints.

Sill Panel and Sill Reinforcement



3101051985

1 - SILL PANEL

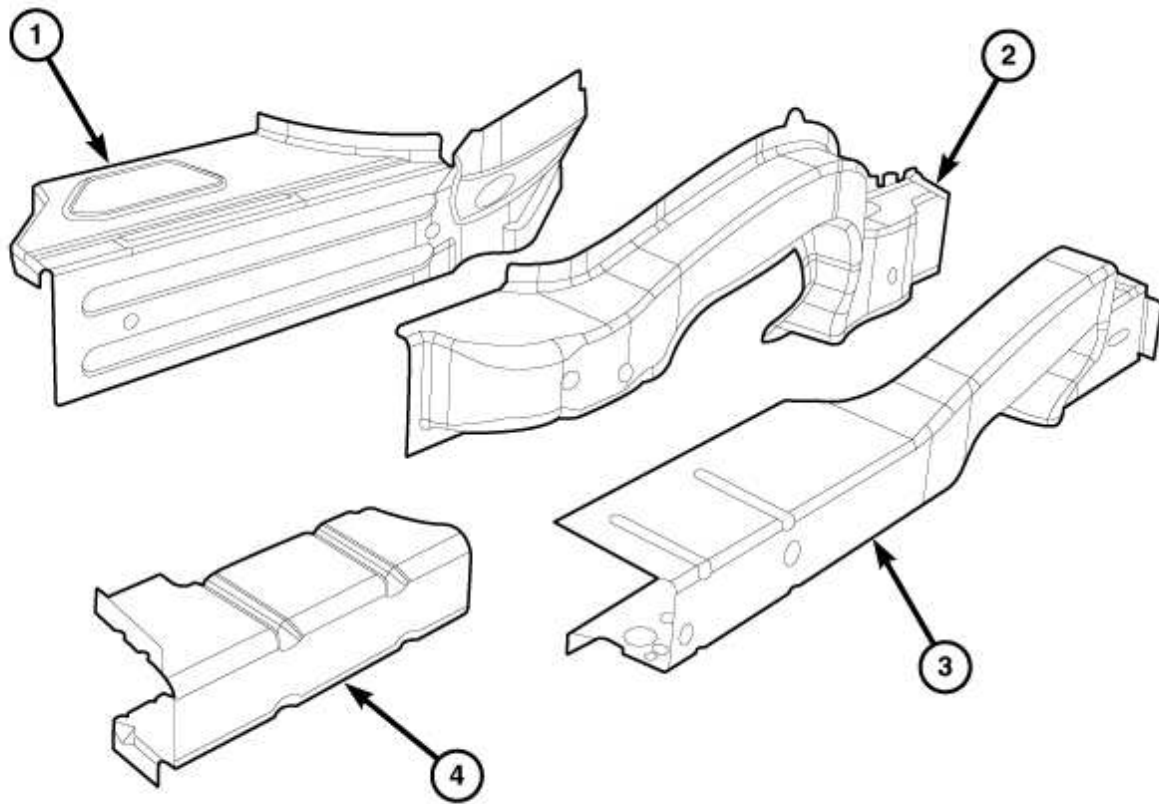
2 - SILL REINFORCEMENT

Outlined areas represent general sectioning areas within.

The sill panel and sill reinforcement is to be sectioned using lap-joints.

When sectioning both the sill panel and sill reinforcement stagger the sectioning locations to minimize panel build up/stacking.

Rear Rail



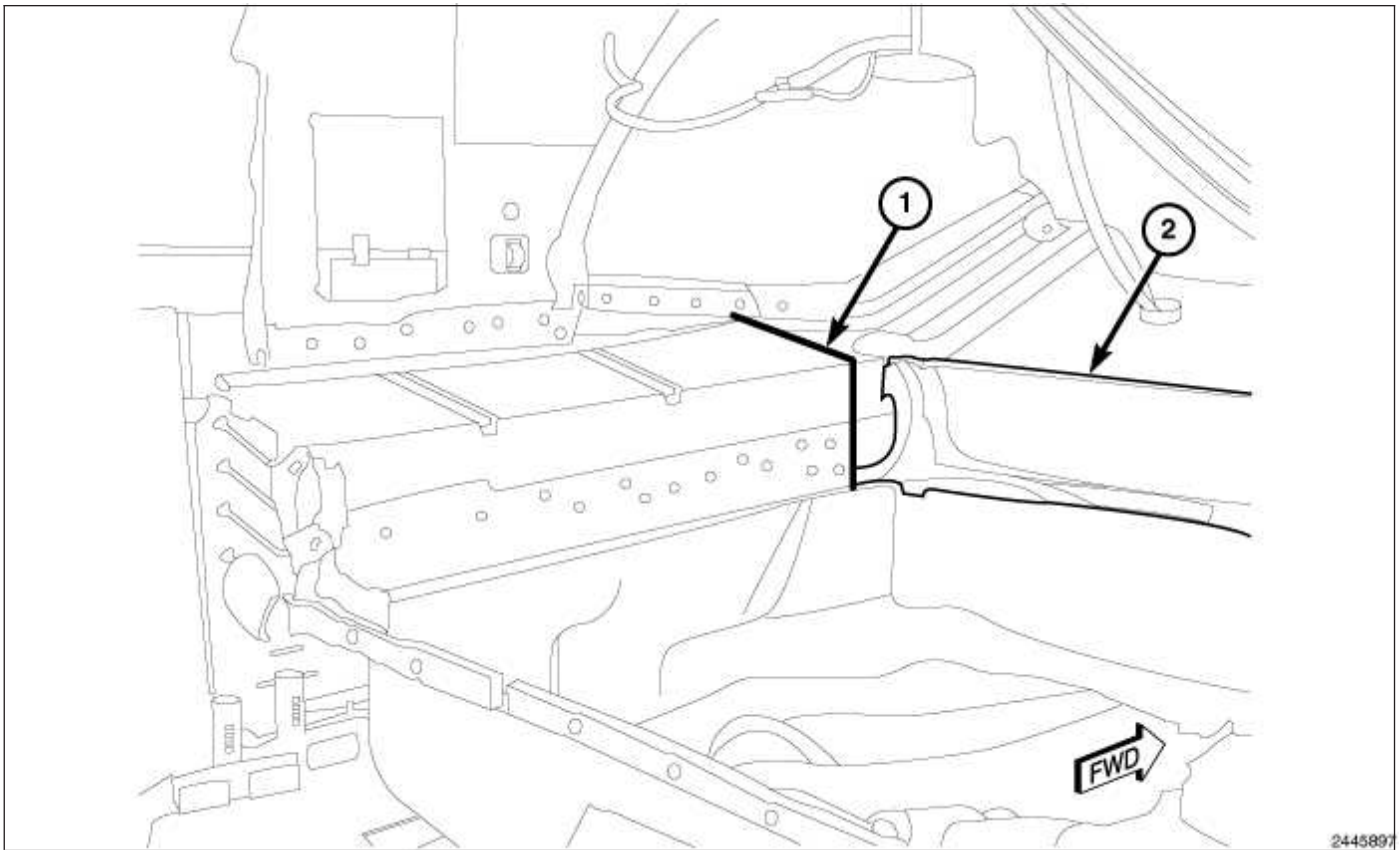
2481193

Rail Terminology

- 1 - COVER PLATE
- 2 - RAIL, REAR, OUTER (**Do not section**)
- 3 - RAIL, REAR, INNER
- 4 - REINFORCEMENT, REAR RAIL INNER, REAR

“Rail, rear, outer” (2) **may not be sectioned** – this portion of the rear rail assembly is not visible as it is gloved inside the “rail, rear, inner” (3) and the “cover plate, rear rail extension” (1).

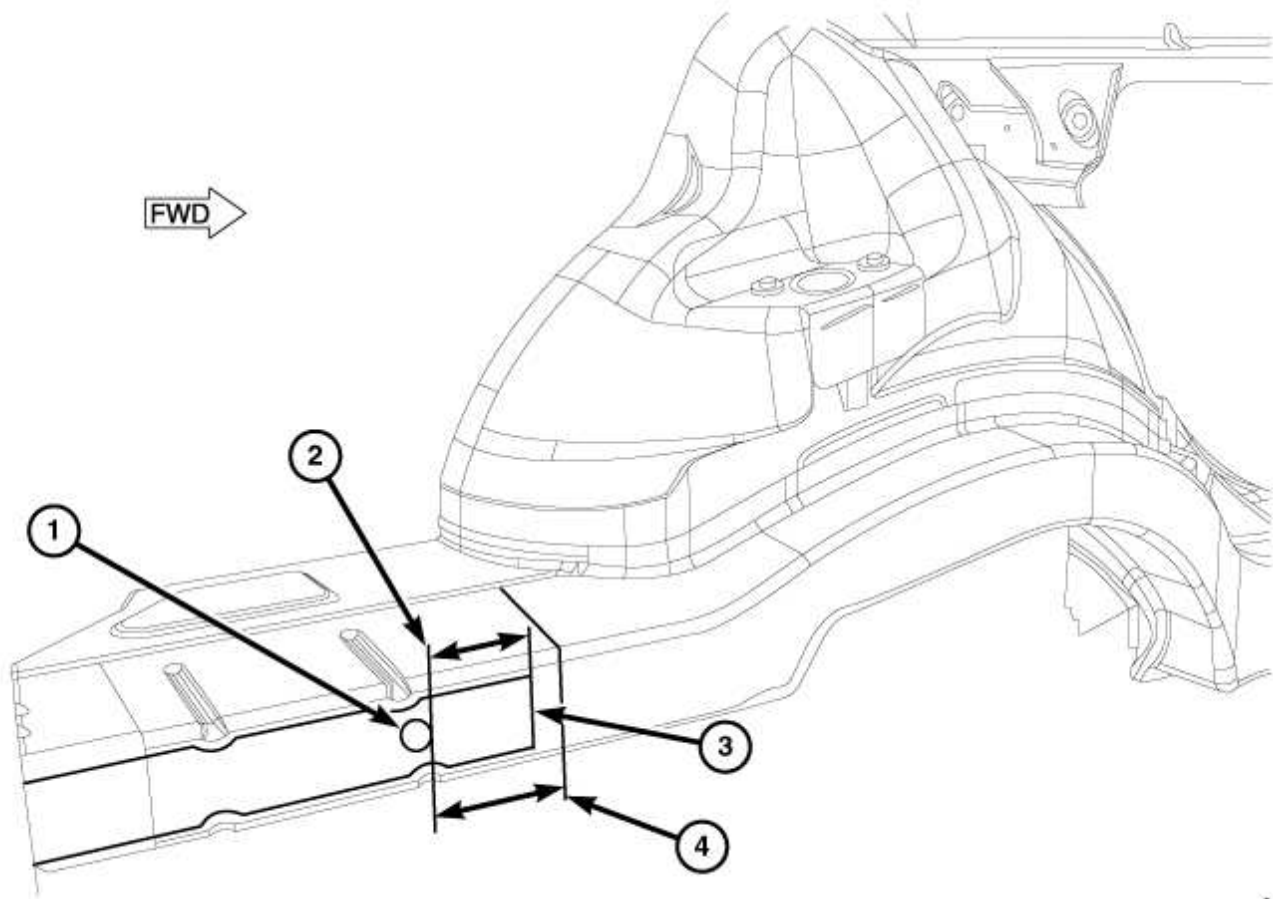
“Reinforcement, rear rail inner rear” (4) – welded inside of the “rail, rear, inner” (3) and extends from the end of that rail to the “panel, deck opening lower”.



“Rail, rear inner” may be sectioned at this location (1), greatly reducing vehicle disruption and repair costs.

This partial replacement procedure presumes that all damage to the “rail, rear inner” is aft of the crossmember (2).

Left Side



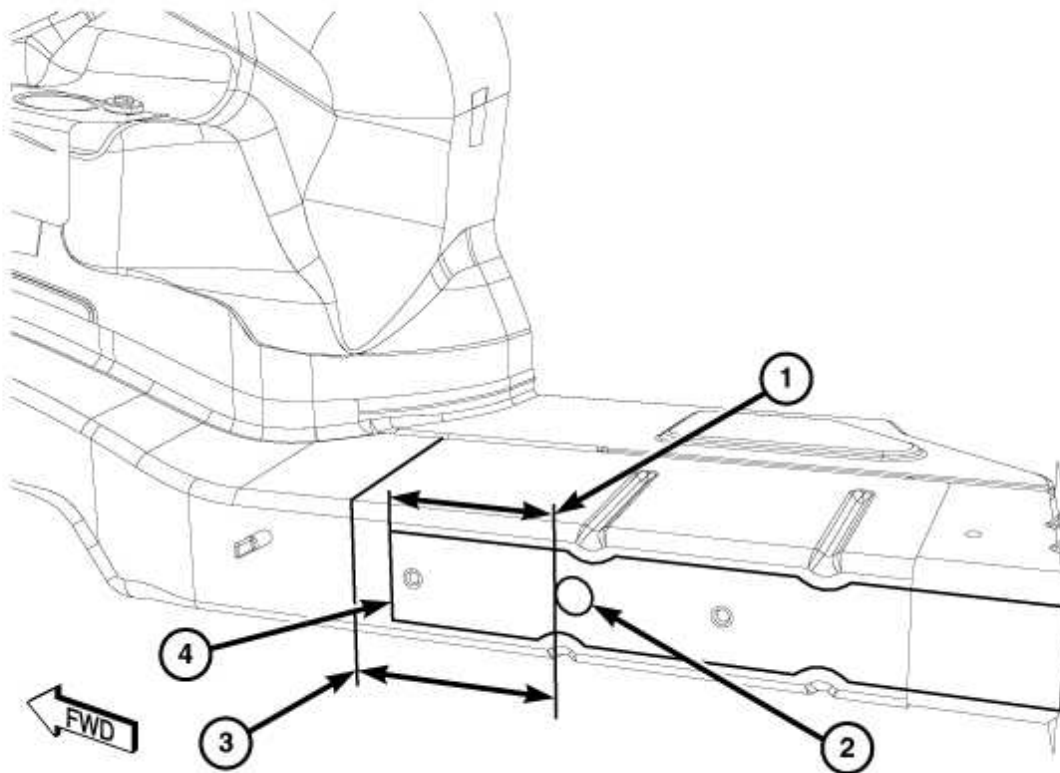
2481208

Left Rear Rail Cut Locations

- 1 - HOLE
- 2 - 100 mm (4 in.)
- 3 - REINFORCEMENT, REAR RAIL INNER, REAR
- 4 - CUT LOCATION 125 mm (5 in.)

The "Reinforcement, Rear Rail Inner, Rear" (3) ends 100 mm (4 in.) (2) forward of round hole (1) on inner face of "Rail, Rear Inner" – recommended cut location is 125 mm (5 in.) (4) from forward edge of the hole (1).

Right Side



2481242

Right Rear Rail Cut Locations

- 1 - 125 mm (5 in.)
- 2 - HOLE
- 3 - CUT LOCATION 150 mm (6 in.)
- 4 - REINFORCEMENT, REAR RAIL INNER, REAR

The “Reinforcement, Rear Rail Inner Rear” (4) ends 125 mm (5 in.) (1) forward of round hole (2) on inner face of “rail, rear inner” – recommended cut location (3) is 150 mm (6 in.) from forward edge of hole (2).

The following procedure details key points of the repair. I-CAR training is presumed, and should be followed for best-practice repair procedures.

1. Mount the damaged vehicle onto a structural straightening bench and check/correct any body misalignment utilizing three dimensional measuring equipment.
2. Remove all components in area of repair allowing unimpeded access for cutting and welding operations.
3. Trunk floor should be removed if being replaced, or the necessary welds released and the weld flange bent inboard to provide access to the rail for the butt-joint.
4. Using the round hole in the “Rail, Rear, Inner” as a point of reference, measure 125 mm (5 in.) forward for the left rail, or 150 mm (6 in.) forward for the right rail, and scribe a vertical line on the rail.
5. With the vertical line just made as reference, cut off the damaged “Rail, Rear, Inner” taking care not to damage the “Rail, Rear, Outer”, using a reciprocating saw or cut-off wheel, and remove the damaged portion.
6. Utilize the same measuring and cutting process above to remove the replacement portion from the service part.
7. Using a surface conditioning disk, remove all e-coat within 25 mm (1 in.) of the cut location and de-bur the cut edge.
8. If the “Rail, Rear, Outer” was damaged during the cutting operation, MIG weld the damage and dress the weld.
9. Fabricate 19 mm (0.75 in.) weld backers from the damaged component, or the remains of the service part, and tack in place on the replacement rail section at the butt-joint location.

10. Position and clamp the replacement rail and confirm proper position with measuring equipment.
11. Weld the service part in position using a skip-stitch process.
12. Complete remaining repairs in the damaged area.
13. Clean and dress all welded areas.
14. Apply epoxy primer to the exterior of the rail at the repair location.
15. Apply quality body sealer to all areas previously sealed to duplicate the original appearance. Note that additional sealer may be applied to better protect the exterior exposed seams from road spray.
16. Refinish all exposed surfaces in trunk and on underbody using quality refinish materials.
17. Apply inner panel rust proofing, such as Mopar Cavity Wax Kit (part #68042969AA) Mopar Wax Refill (part #68042970AA), or equivalent. Apply to the inner cavity areas in two applications, with a 30-minute flash period between the applications. Pay particular attention to areas which have been welded.
18. Reassemble vehicle and complete repairs.

Butt joint should be metal finished without thinning the base rail material or weldment. This is a cosmetic finishing process to disguise the repair and should have the surface coating (paint) duplicated as well.

CORROSION PROTECTION

Corrosion Protection Restoration

"Corrosion protection" encompasses all the materials and coatings which protect a vehicle from corrosion and include:

- Coated steels
- E-coat primer on the complete body
- Body sealing to eliminate water and air intrusion where panels join
- Structural adhesives in some joints
- Chip resistant primer applications on the entire body
- Paint application
- Underbody corrosion protection
- Inner panel corrosion protection added to repair areas

Corrosion protection must be restored during a repair anytime it may have been compromised. All areas that have been subjected to structural pulls, clamping, straightening, welding, or any other any other operation that may have imparted damage to the corrosion protection system will need to be addressed.

In the repair process corrosion protection is addressed in three phases: pre-refinish, refinish and post-refinish.

Pre-refinish

In the pre-finish phase, structural adhesives, seam sealers and other applied coatings are installed. Sheet metal seams are sealed to prevent water intrusion into the "dry" areas of the vehicle, such as passenger compartment, and also to prevent intrusions of contaminants, such as water and road salt, into seams causing corrosion. Lap joints, hem flanges, and any panel mating locations need to be addressed during the repair and treated to duplicate the original vehicle build.

All bare metal should be etch primed prior to applying seam sealer, following the refinish material provider's instructions for doing so, unless the manufacture of the sealer specifically states otherwise.

When working around pinch weld flanges, seam sealer should be installed to duplicate the original appearance and function. If it is unclear whether the original sealing material **between** the flanges is strictly a sealer or structural adhesive, always default to a structural adhesive such as Fusor 112B, or 3M 08116. For additional information related to weld-bonding and welding around adhesives and sealers, (Refer to 31 - Collision Information - Standard Procedure).

Roof and closure panels will require the use of Anti-Flutter foam. Where inner panel supports meet external panels, the proper replacement materials in these areas are Mopar part #04864015AB, or equivalent, or Fusor 121, or 3M 04274 (NVH dampening material).

All hem flanges on closure panels should be sealed whether sealer is apparent or not. This includes those disturbed during the repair, and those on new replacement panels. Either duplicate the existing bead in shape or size, or where one is not obvious, seal the hem flange in a discrete fashion. Hem flanges should be sealed using Mopar part #04318026, Fusor 129, or 3M 08308.

Lap joints, such as in floor pans, should be sealed to duplicate the sealer visible, but also addressed on any exterior surface by sealing the lap whether visible or not.

NOTE: Chrysler does not recommend the use of any type of "weld-thru" primer during repairs. Weld-bonding with corrosion protecting adhesives or sealers, along with final application of inner panel corrosion protection is the proper method.

Refinish

All painted surfaces should be coated using a Chrysler group LLC approved refinish material. The refinish process includes application of undercoats, primers (filler & sealer), basecoats and clearcoat. These approved materials have been tested to the same material standards as the production materials.

Post-refinish

All new panels, and repair areas, must have inner panel corrosion protection applied after the painting operation is complete, but before all the trim is reinstalled. Mopar Cavity Wax No. 68042970AA, or 3M Rustfighter #08891 should be applied to all interior cavities, weld flanges, hem flanges as well as any are affected by the repair

especially where any type of welding was performed. Inner panel corrosion protection should be applied using "pressure pot" equipment with wands which provide 360-degree material coverage for closed cavities, and directional spray wands for visible coverage (Mopar kit #04271235). Additionally, the corrosion protecting material must be applied in two coats with a minimum 30-minute flash time between applications.

Wheel wells and underbody panels which have been involved in the repair process should also have a final undercoating applied. Use Mopar No. 05093417AA, or equivalent, and apply with "pressure pot" style application equipment.

Any disturbed or removed NVH foam needs to be replaced. Use Mopar part No. 05142864AA, Fusor 130, or 3M 8463.

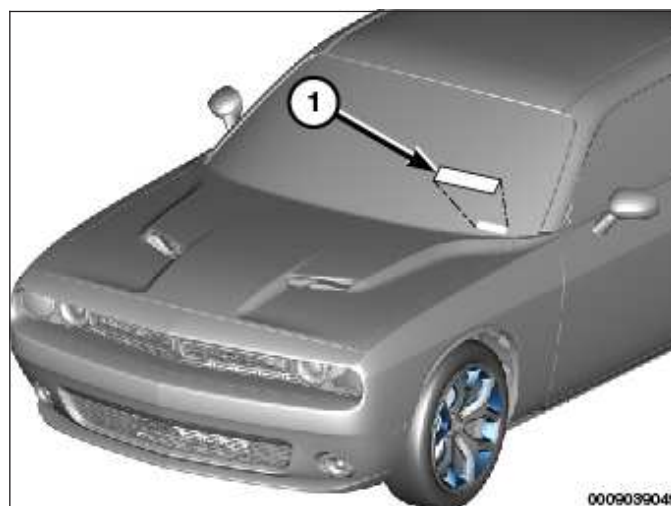
Following this arrangement, choice of materials, and proper application, the repaired vehicle should be as well protected against corrosion as it was prior to the repair.

Specifications

VEHICLE IDENTIFICATION NUMBER

The Vehicle Identification Number (VIN) label (1) can be viewed through the windshield at the upper left corner of the instrument panel, near the left windshield pillar. The VIN consists of 17 characters in a combination of letters and numbers that provide specific information about the vehicle. Refer to the charts below for decoding information.

To protect the consumer from theft and possible fraud the manufacturer is required to include a Check Digit at the ninth position of the vehicle identification number. The check digit is used by the manufacturer and government agencies to verify the authenticity of the vehicle and official documentation. The formula to use the check digit is not released to the general public.



VEHICLE IDENTIFICATION INFORMATION	DECODING CHARTS
2015 Dodge Challenger	2015 VIN DECODING INFORMATION

2015 VIN DECODING INFORMATION

POSITIONS 1 - 3: WORLD MANUFACTURER IDENTIFIER

1	2	3	Manufacturer	Vehicle Type
1	C	3	Chrysler Group LLC (USA)	Passenger Car
2	C	3	Chrysler Canada	Passenger Car

POSITION 4: RESTRAINT SYSTEM

NOTE:

- All Seating Positions (ASP)
- Outboard Seating Position (OSP)

Code	Description
C	Active Belts (ASP), Front Air Bags (OSP), With Side Inflatable Restraints - All Rows

POSITIONS 5 - 7:

5	6	7	Series	Drive Position	Drive Type	Body Type
D	Z	A	Base	Left Hand Drive	Rear Wheel Drive	2 Door Sedan
D	Z	B	Premium			
D	Z	C	SRT Super-charged			
D	Z	D	SRT Premium			
D	Z	F	SCAT Pack			

POSITION 8: ENGINE

Code	Displacement	Cylinders	Fuel	Turbo	Sales Codes
G	3.6 Liter	6	Gasoline	No	ERB
T	5.7 Liter	8	Gasoline	No	EZC, EZH
J	6.4 Liter	8	Gasoline	No	ESG; ESH
9	6.2 Liter Super-charged	8	Gasoline	No	ESD

POSITION 9: CHECK DIGIT

0 through 9 or X

POSITION 10: MODEL YEAR

F = 2015

POSITION 11: ASSEMBLY PLANT

Code	Plant
H	Brampton Assembly

POSITION 12 - 17: PLANT SEQUENCE NUMBER

A six digit number assigned by assembly plant.

STANDARDIZED STEEL IDENTIFICATION

In an effort to reduce confusion over the large number of steel grades in use, and the repairability and weldability concerns involved with each, Chrysler Group LLC has instituted new nomenclature which is applicable to material call-outs and BIW exploded views released for use in the repair industry.

All materials listed in the key may not be used on a given model, nor may every panel be identified in the blow-up (ex: some groups do not show fascias).

- WARNING:** Chrysler Group LLC engineering’s position on the use of heat during collision repair is as follows:
- Any body panel or frame component damaged which is to be repaired and reused, must be repaired using the “cold straightening” method. No heat may be used during the straightening process.
 - During rough straightening prior to panel replacement, damaged panels or frame components may be heated to assist in body/frame realignment. The application of heat must be constrained to the parts which will be replaced and not allowed to affect any other components.

This “no heat” recommendation is due to the extensive use of high strength and advanced high strength steels in Chrysler Group LLC products. High-strength materials can be substantially and negatively affected from heat input which will not be obviously known to the repairer or consumer.



Ignoring these recommendations may lead to serious compromises in the ability to protect occupants in a future collision event, reduce the engineered qualities and attributes, or decrease the durability and reliability of the vehicle.

This statement supersedes any previously released information by the Chrysler Group LLC.

Failure to follow these instructions may result in serious or fatal injury.

NOTE: Corrosion protection must be restored after repair.

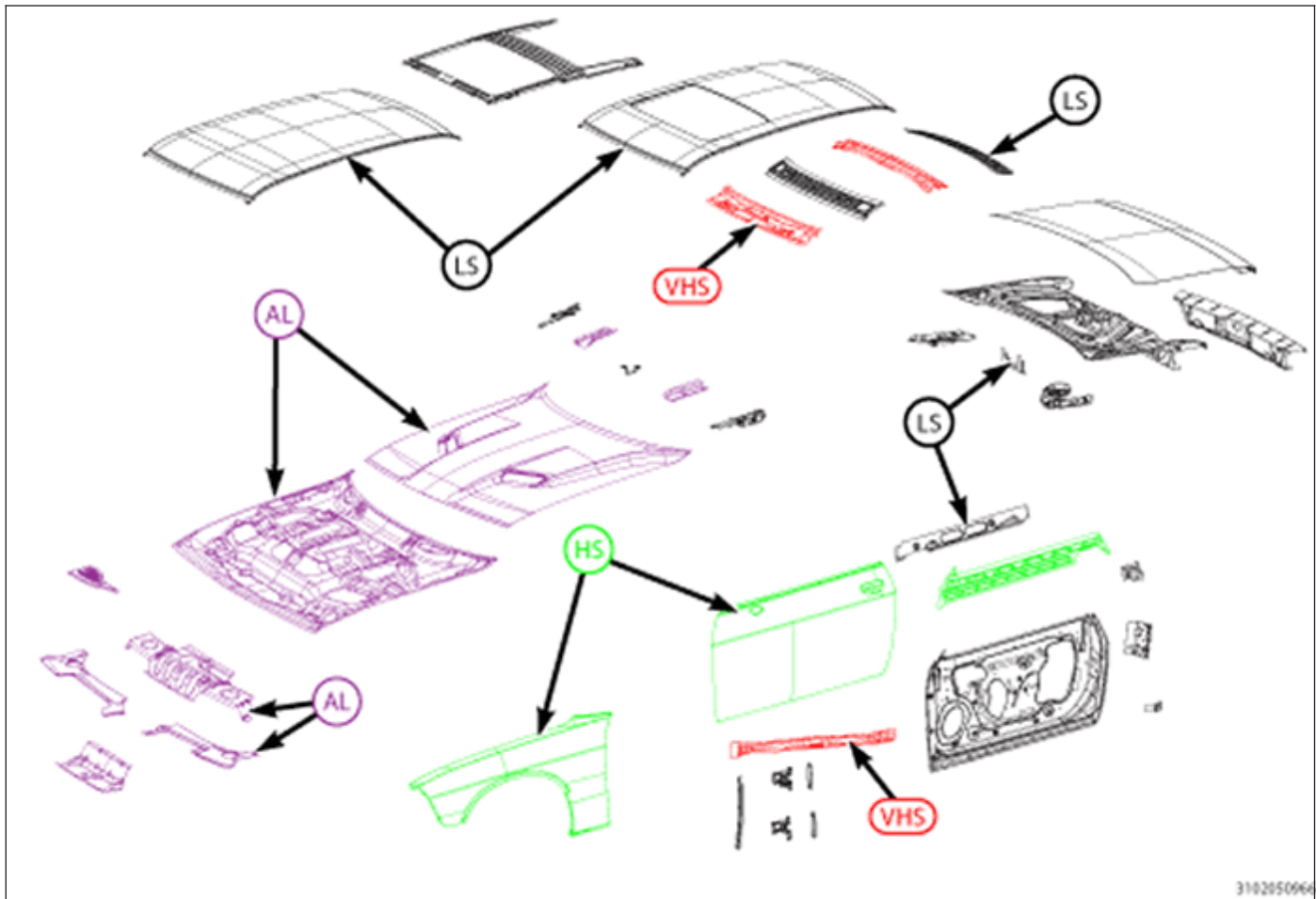
- LS** - Good repairability and weldability (least sensitive to heat). May be attached using the preferred Squeeze Type Resistance Spot Welding (STRSW) process, weld bonding where appropriate, or MIG welding. Materials have a tensile strength of less than 270 MPa.
- HS** - Some repairability and good weldability (the higher the strength of the steel, the greater the sensitivity to heat). May be attached using STRSW, weld bonding, and MIG welding. Material tensile strength range between 270 MPa and 600 MPa and includes DP590.
- VHS** - Very limited repairability and weldability (very sensitive to heat). Attach only at OE defined locations using OE defined procedures. Material tensile strengths are greater than 600 MPa. This category includes hot-stamped boron materials which are also termed “press hardened”. Specialized cutters are required with many materials in this group.
- LM** - Good repairability and weldability. May be attached using STRSW, weld bonding, and Flux Core Arc Welding (FCAW).
- AL** - Stamped aluminum sheet metal panels may be repairable with specialized tools and techniques.
- MG** - Magnesium - no repairability, replacement components only.
- PL and PL-R** - Some repairability depending upon the type of plastic involved, the degree of damage, and the component function. Cosmetic components such as fascias (PL) have a higher degree of repair allowed than those components which can carry components and loads. Where PL-R components are bonded to steel structure, Chrysler Group LLC will identify the proper adhesive to attach the replacement panel. Repair materials for PL are commonly available in the collision repair market.
- CO** - Composite materials may be fiber reinforced (ex: Kevlar) panels or co-molded assemblies of steel and plastic. Any of these require specialized repair materials and processes.

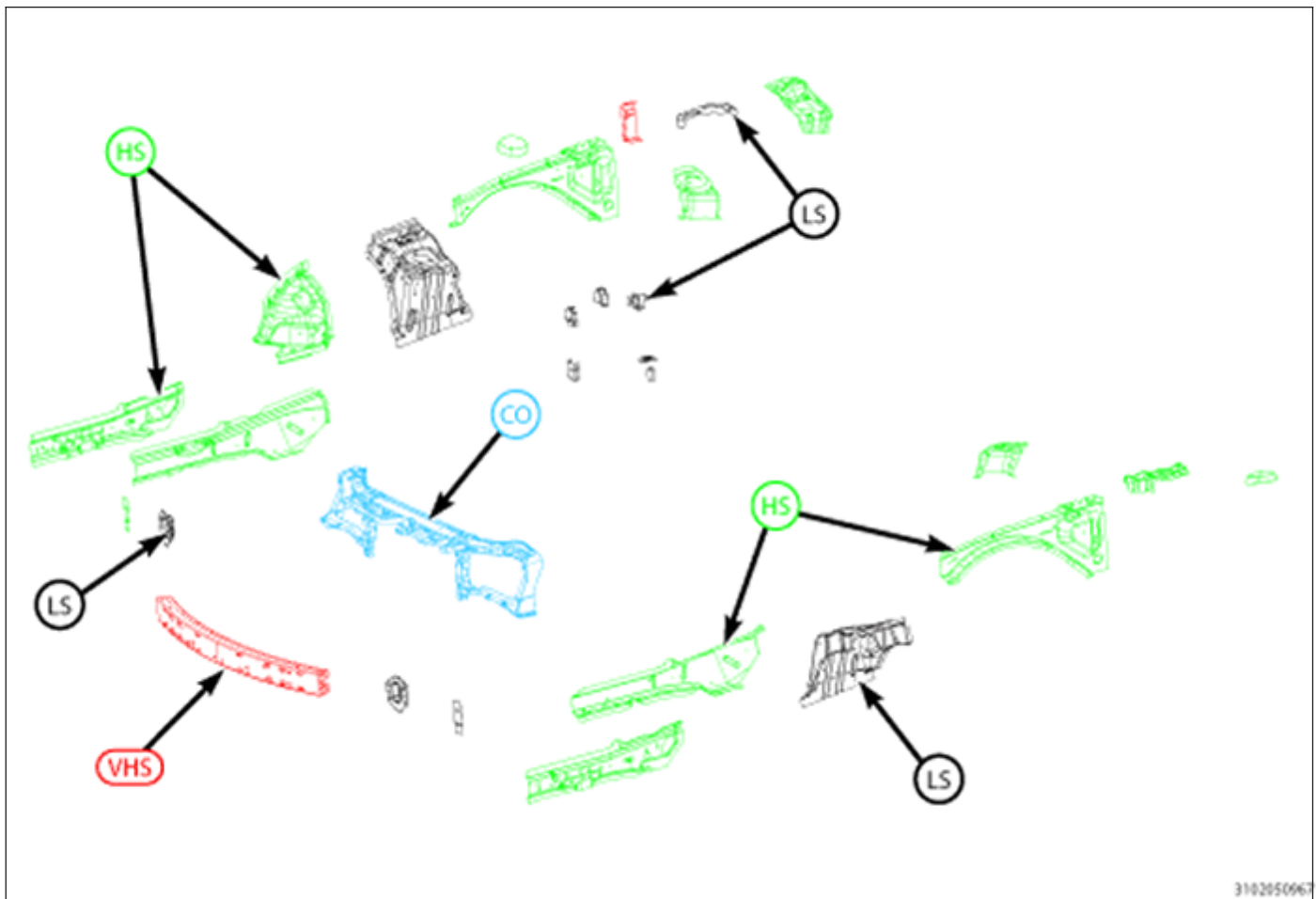
2627969

Information on sectioning of components will be identified in **Non-Structural Sheet Metal Repair, Weld /Weld Bonding and Sectioning Procdures**, ([Refer to Collision Information - Standard Procedure](#)).

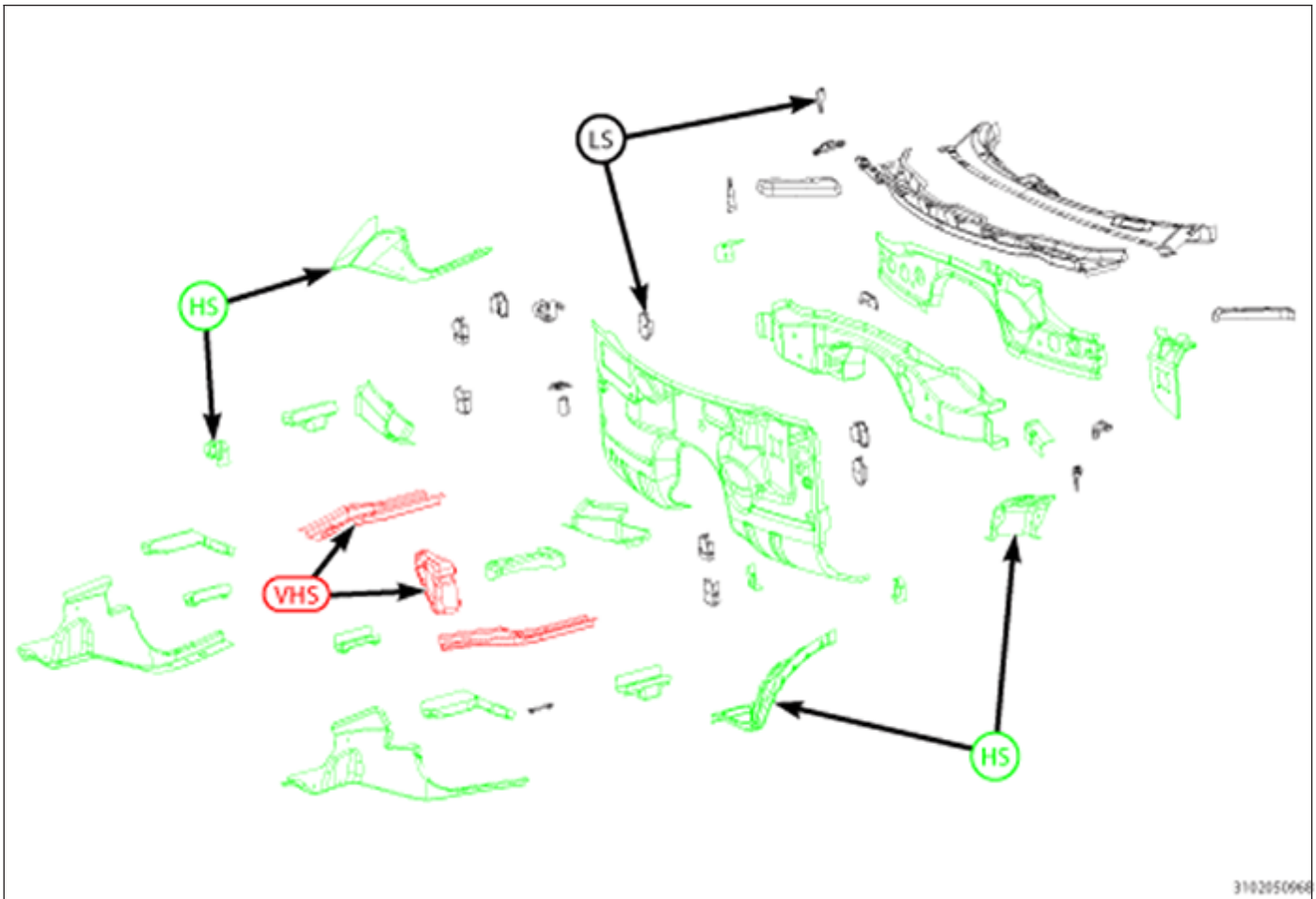
CALLOUT KEY	DESCRIPTION	COLOR
LS	Low-Strength Steel	Black
HS	High-Strength Steel	Green
VHS	Very High-Strength Steel	Red
LM	Laminated Steel	Grey
AL	Sheet Aluminium	Purple
MG	Magnesium	Brown
PL	Plastic	Blue
PL-R	Fiber Reinforced Plastic	Purple
CO	Composite Material	Blue



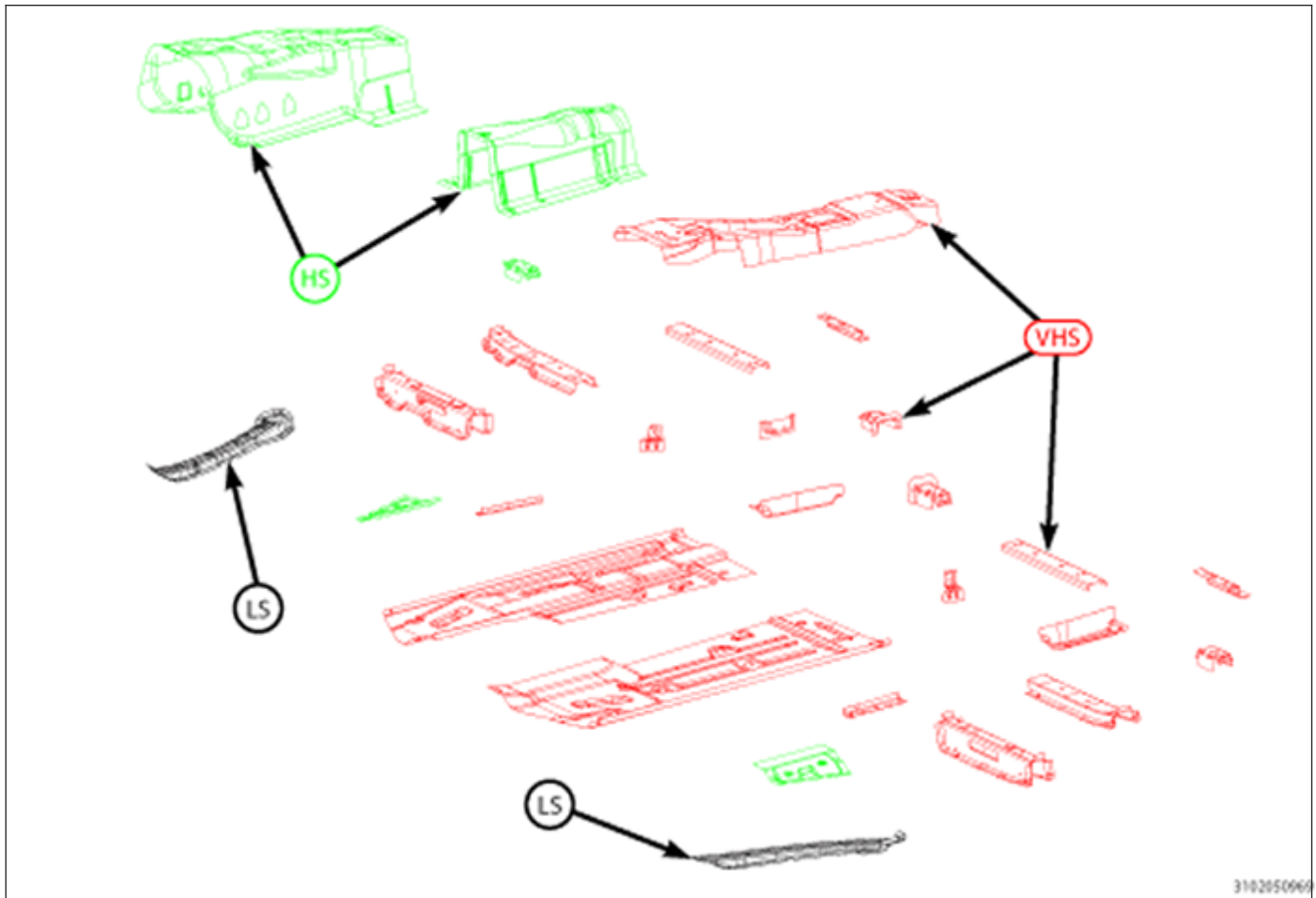
BODY IN WHITE COMPONENT IDENTIFICATION - CLOSURES



BODY IN WHITE COMPONENT IDENTIFICATION - ENGINE BOX



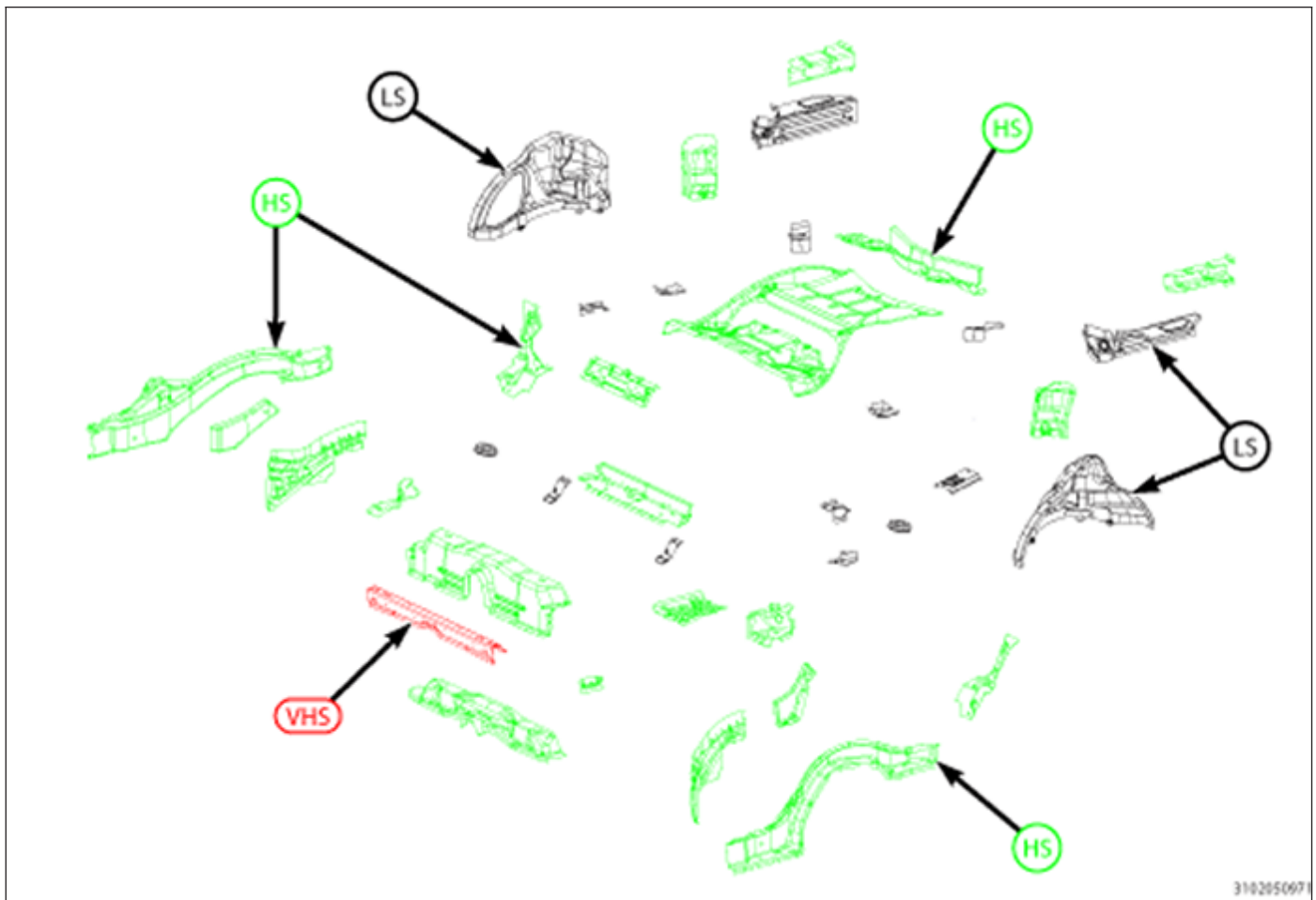
BODY IN WHITE COMPONENT IDENTIFICATION - DASH/COWL



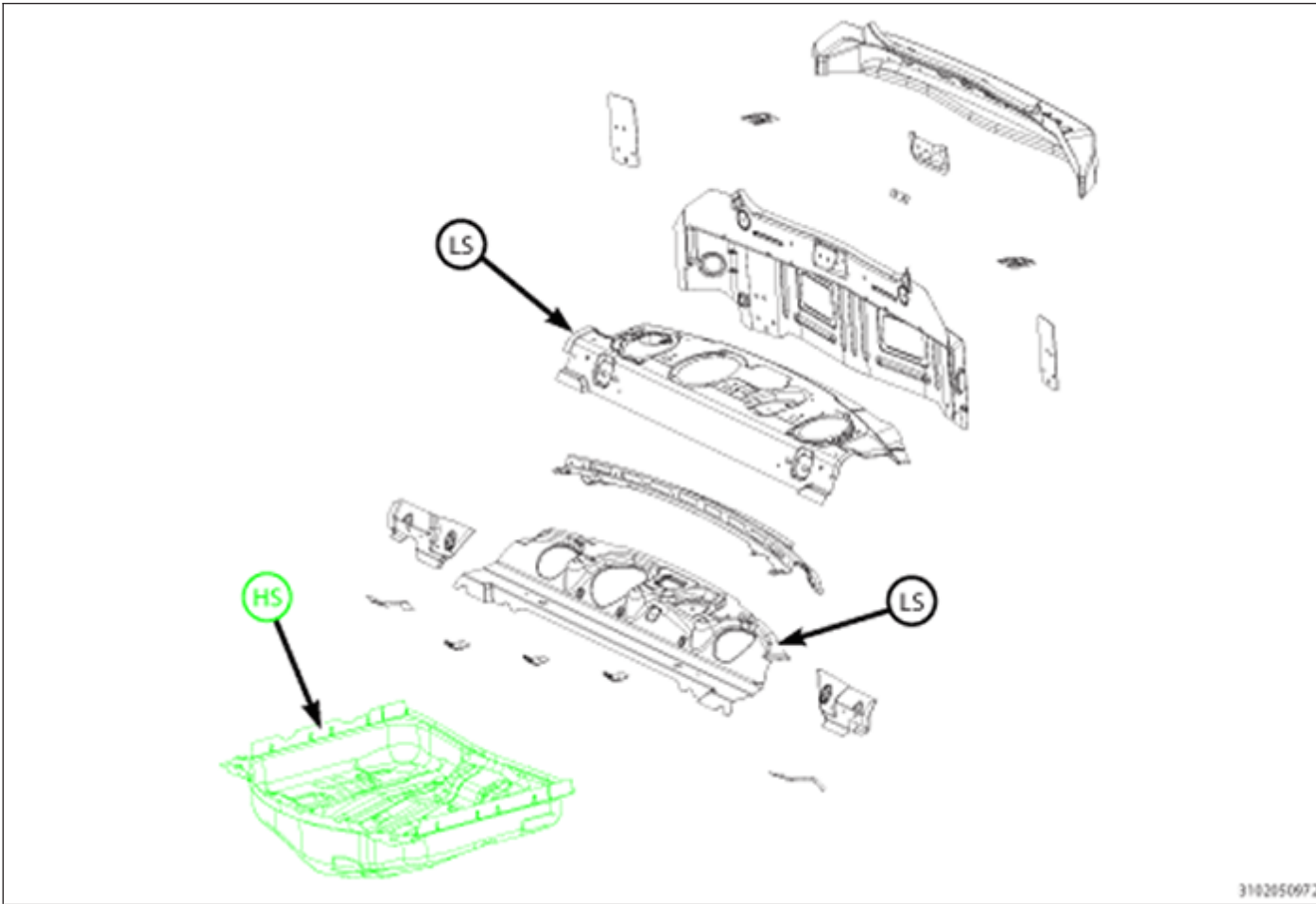
BODY IN WHITE COMPONENT IDENTIFICATION - FRONT FLOOR



BODY IN WHITE COMPONENT IDENTIFICATION - BODY SIDE



BODY IN WHITE COMPONENT IDENTIFICATION - REAR FLOOR



BODY IN WHITE COMPONENT IDENTIFICATION - REAR COMPONENTS

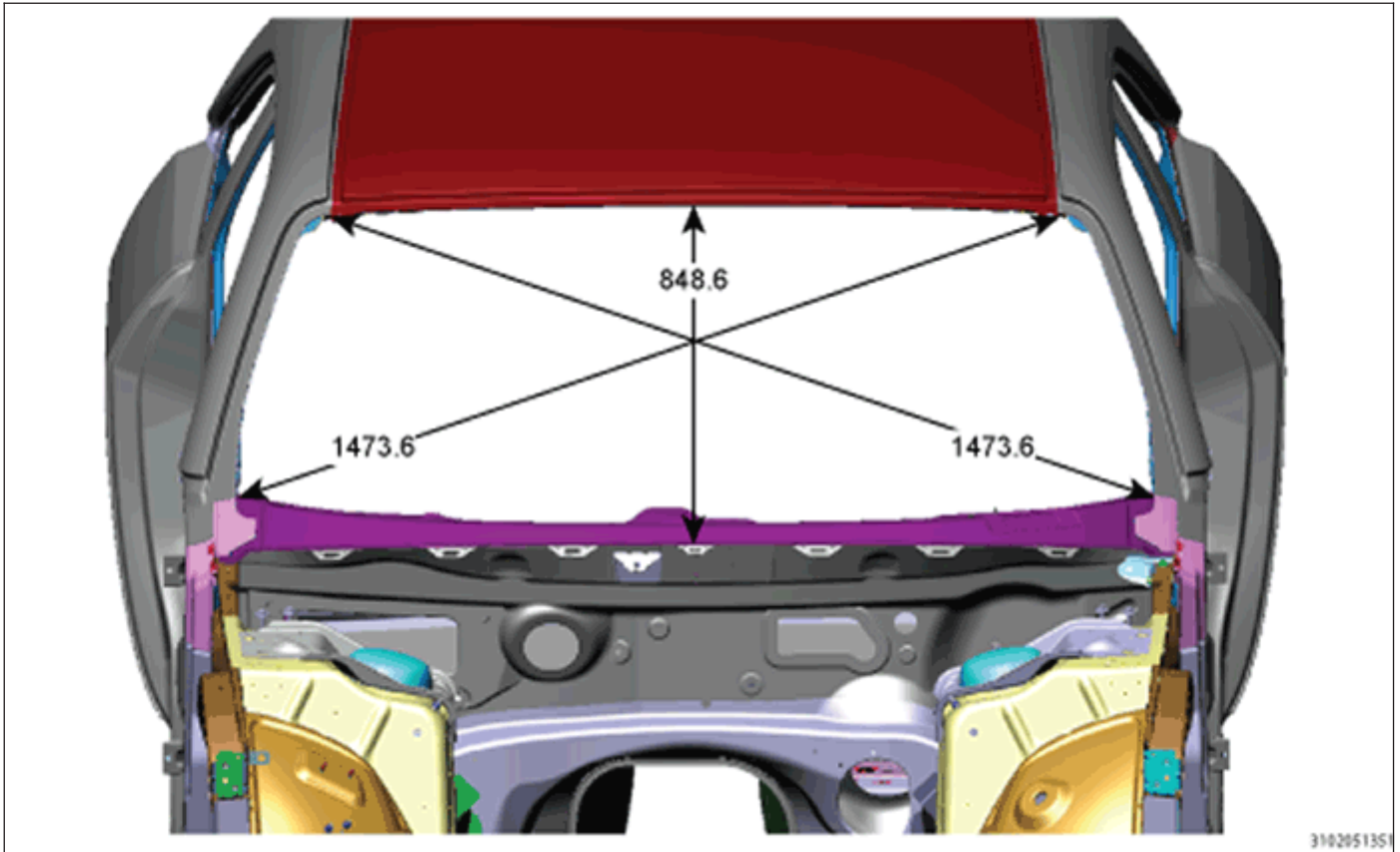
BODY OPENING DIMENSIONS

NOTE: Body opening dimensions are listed in metric scale millimeter (mm). Principal Locating Points (PLP), fastener locations, and holes are measured to center, unless noted otherwise.

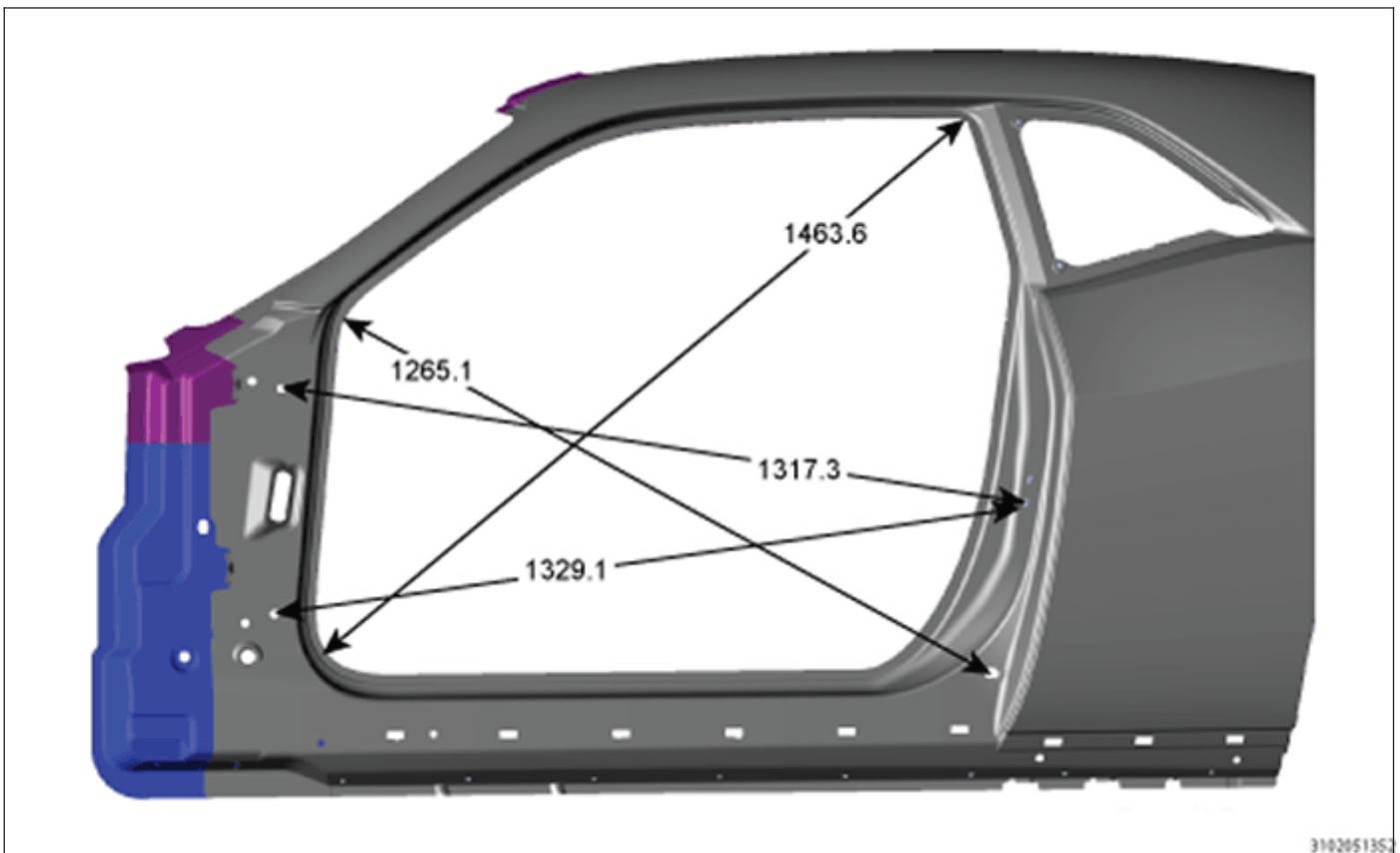
Vehicle Preparation –

Position the vehicle on a level work surface. Remove any weatherstrips, door strikers or any other parts that may interfere with the reference point.

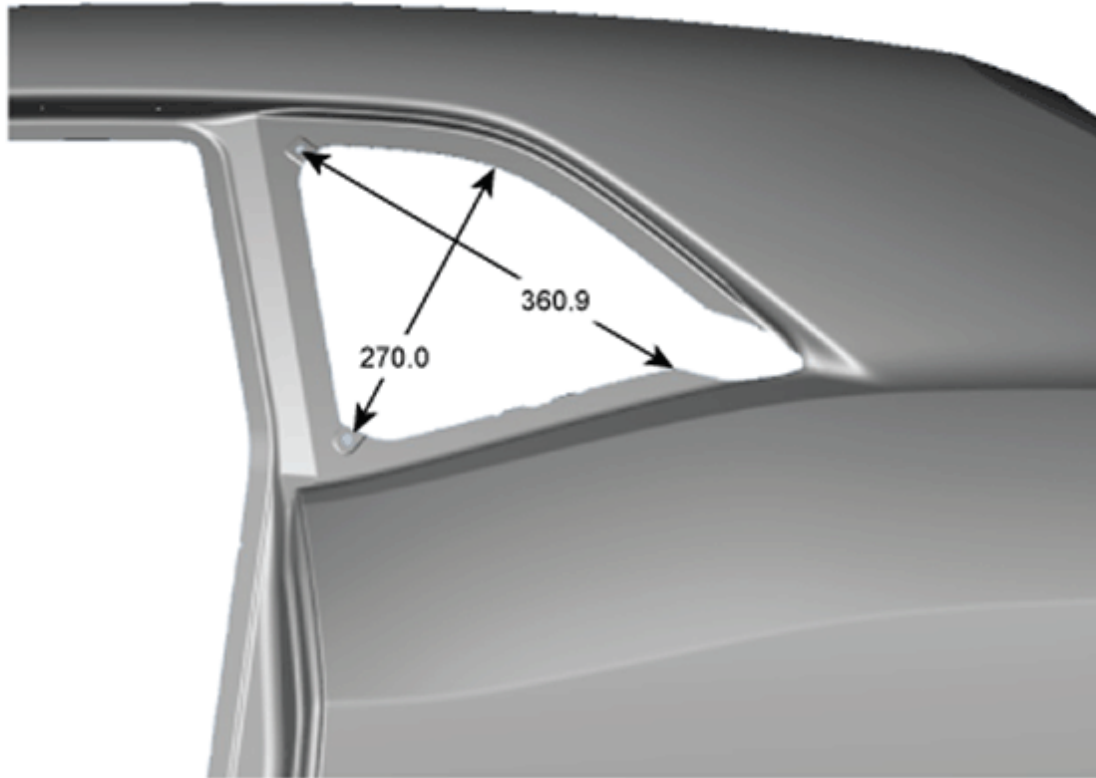
DESCRIPTION	FIGURE
WINDSHIELD OPENING	Figure 1
BODY SIDE APERTURE OPENING	Figure 2
QUARTER PANEL GLASS	Figure 3
BACKLIGHT OPENING	Figure 4
DECK LID OPENING	Figure 5



WINDSHIELD OPENING

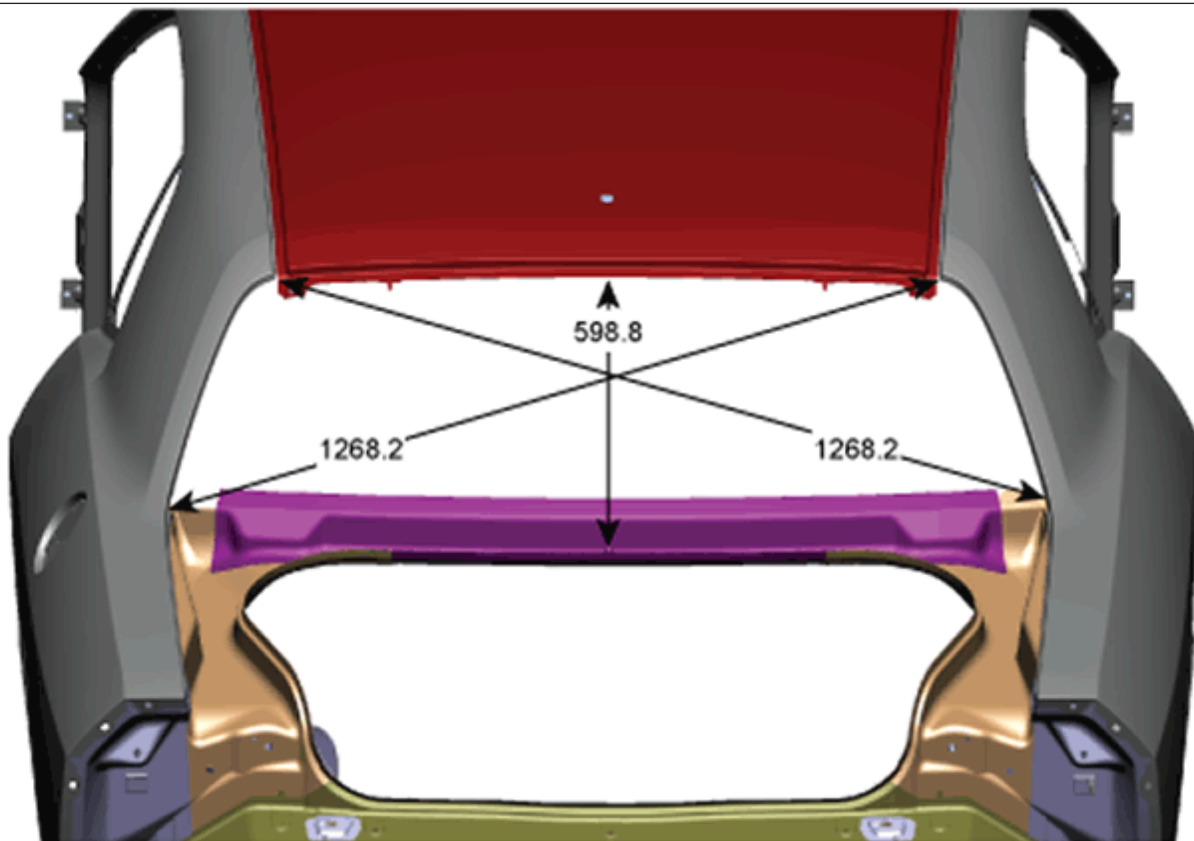


BODY SIDE OPENING



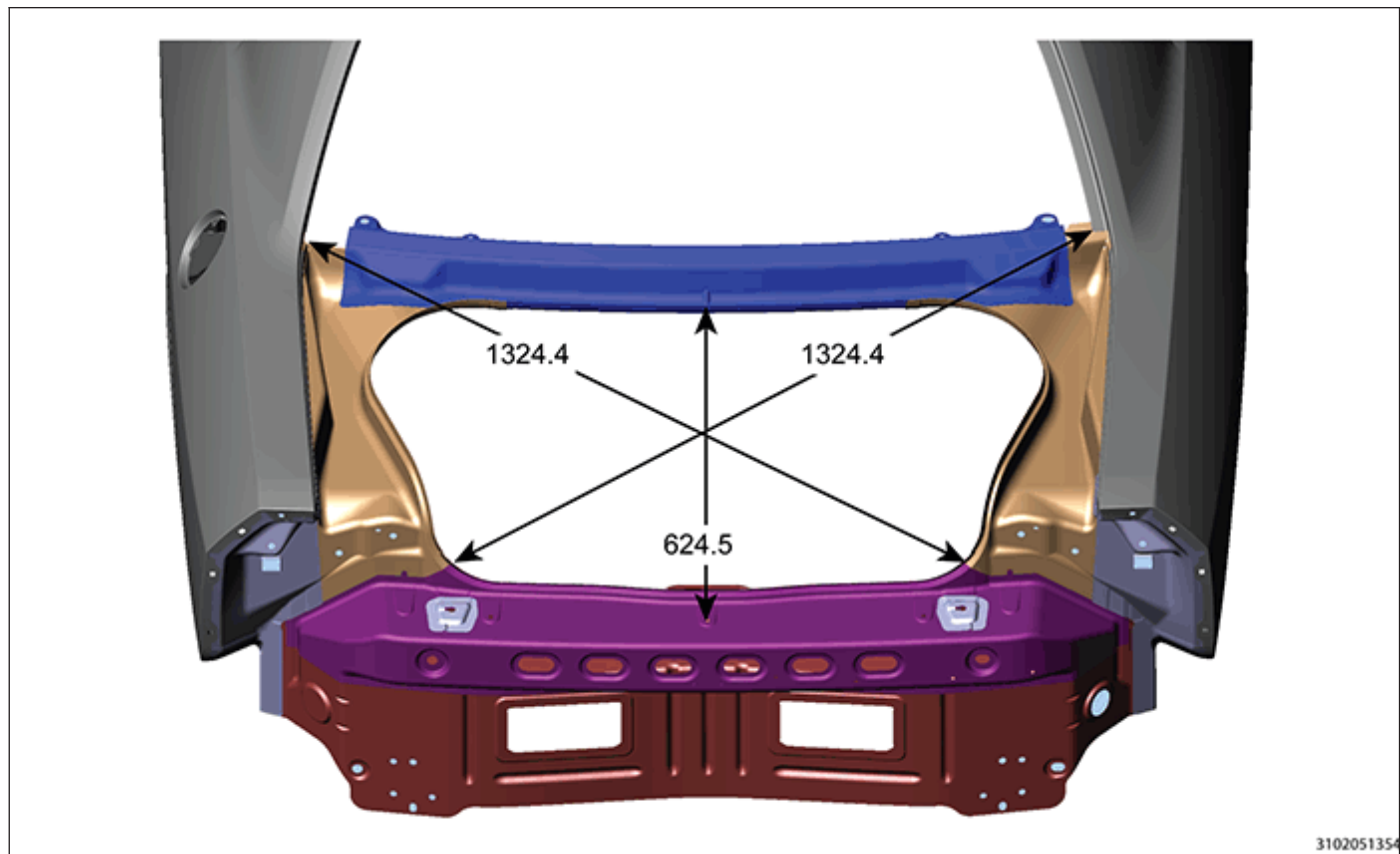
3102051355

QUARTER PANEL GLASS



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BACKLIGHT OPENING



DECK LID OPENING

FRAME DIMENSIONS

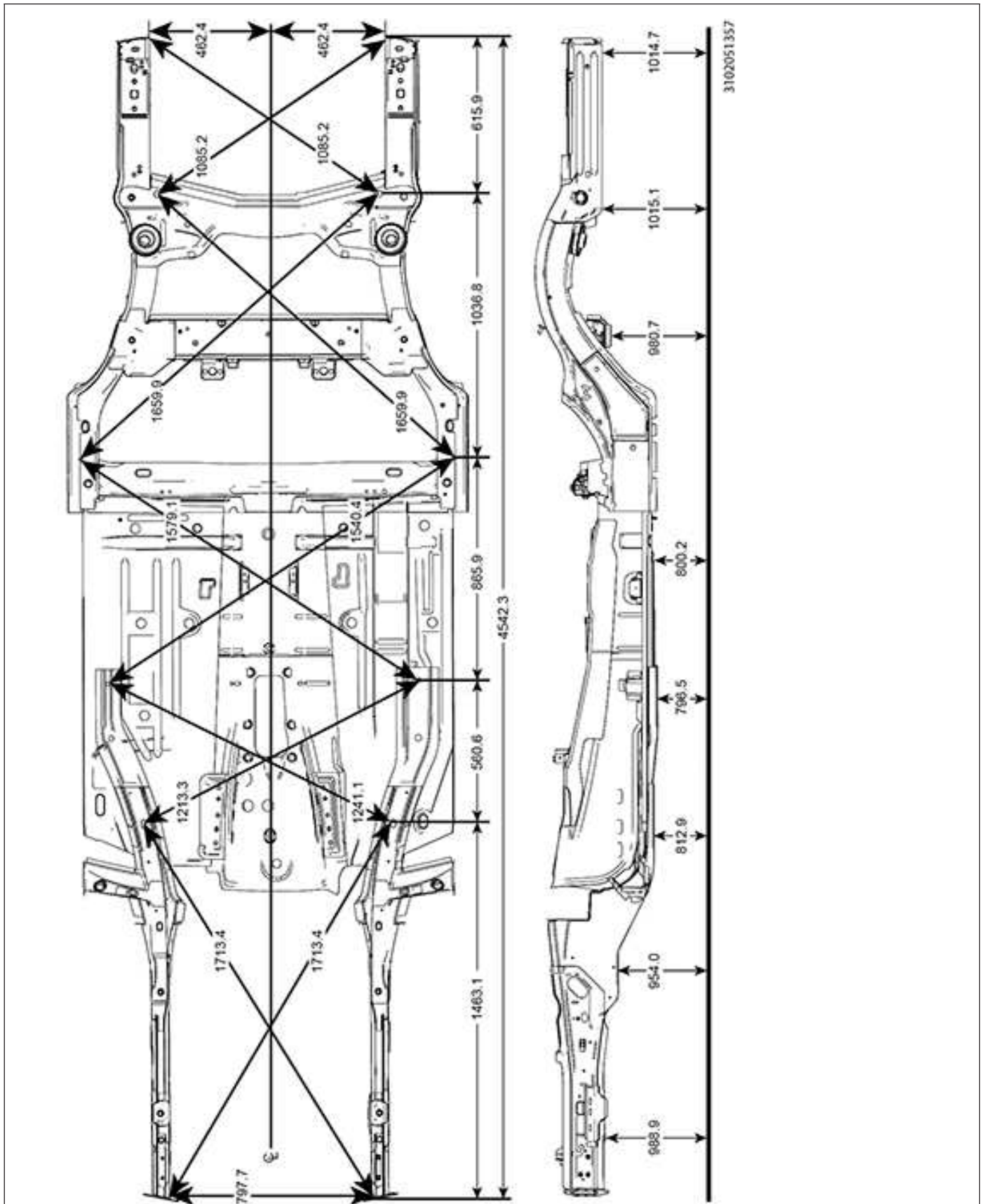
NOTE: Frame dimensions are listed in metric scale millimeter (mm). All dimensions are from center to center of Principal Locating Point (PLP), or from center to center of PLP and fastener location.

VEHICLE PREPARATION –

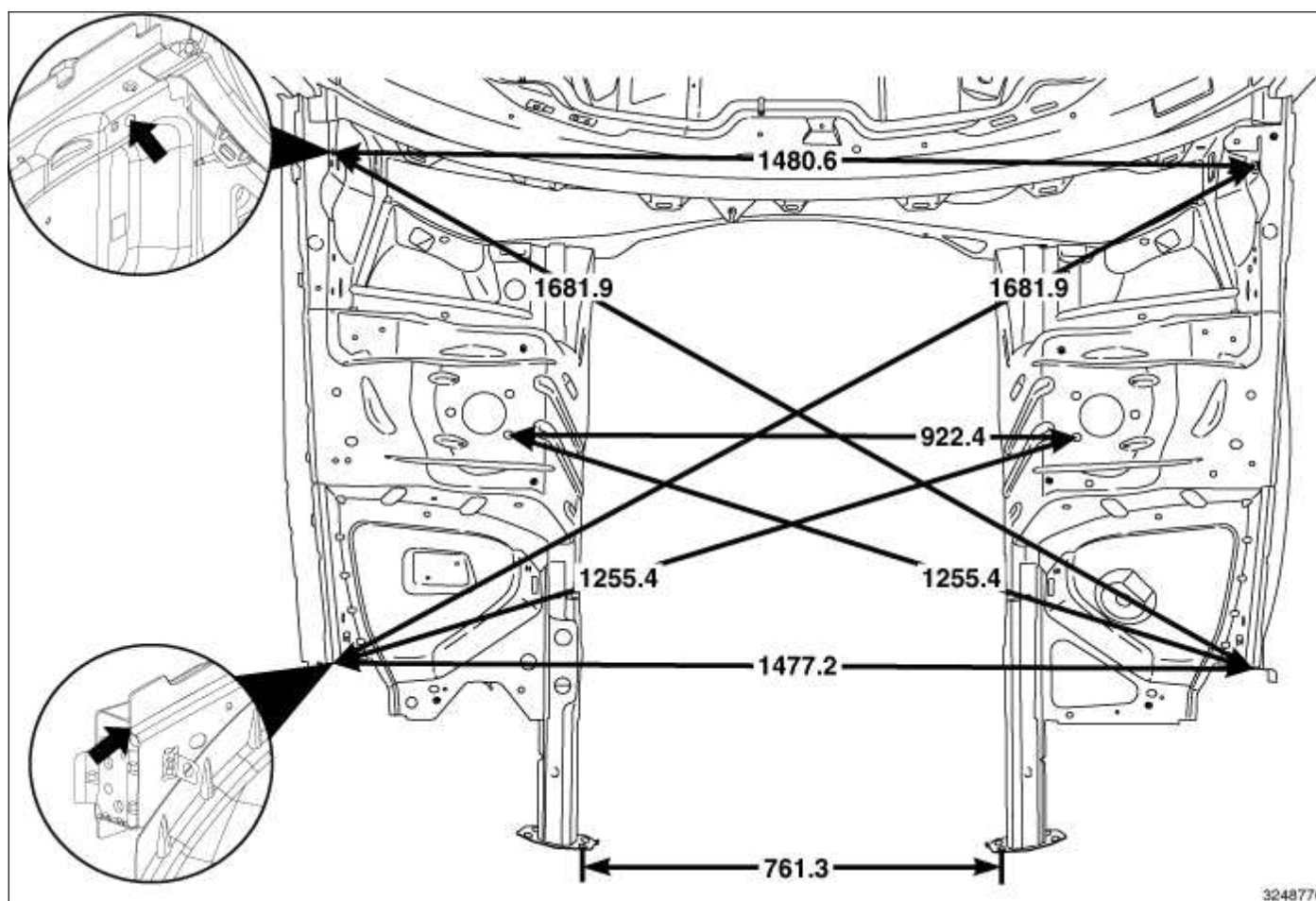
Position the vehicle on a level work surface. Using screw or bottle jacks, adjust the vehicle PLP heights to the specified dimension above a level work surface. Vertical dimensions can be taken from the work surface to the locations indicated were applicable.

INDEX

DESCRIPTION	FIGURE
Under Body Dimensions	Figure 1
Under Hood	Figure 2

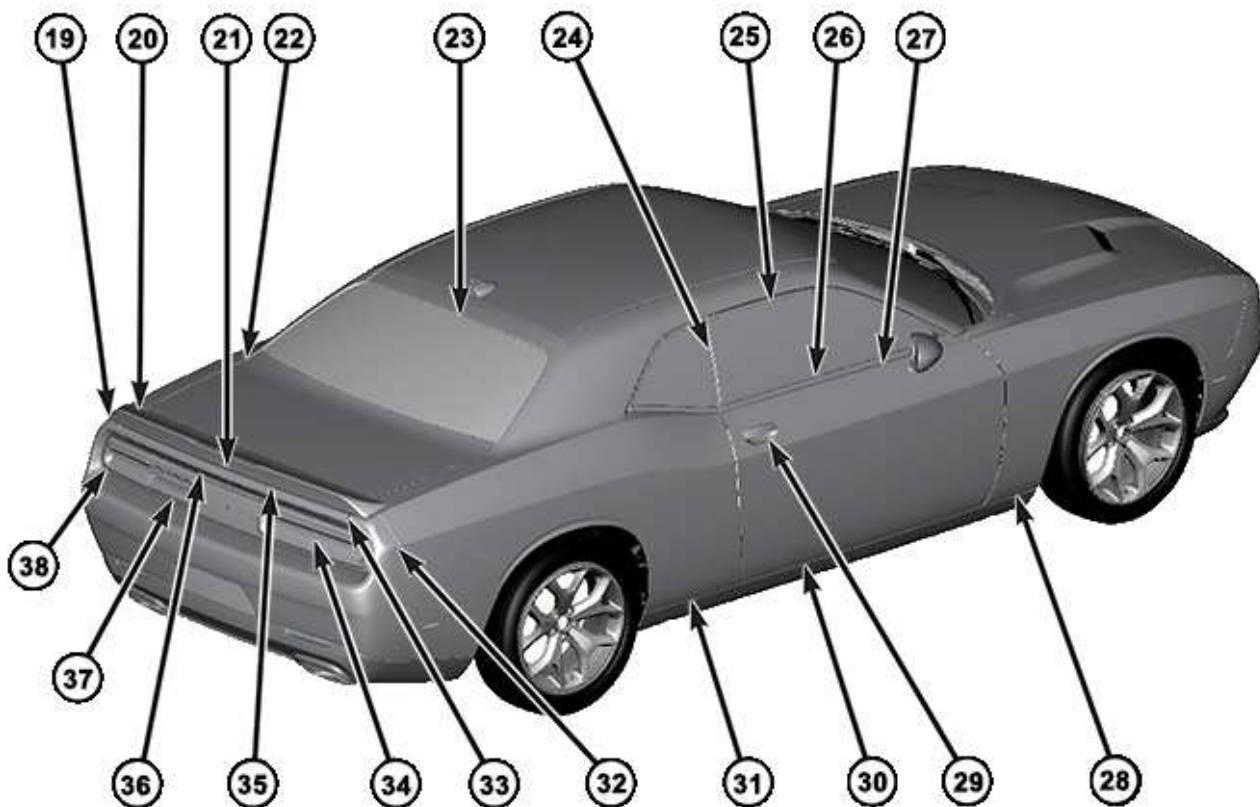
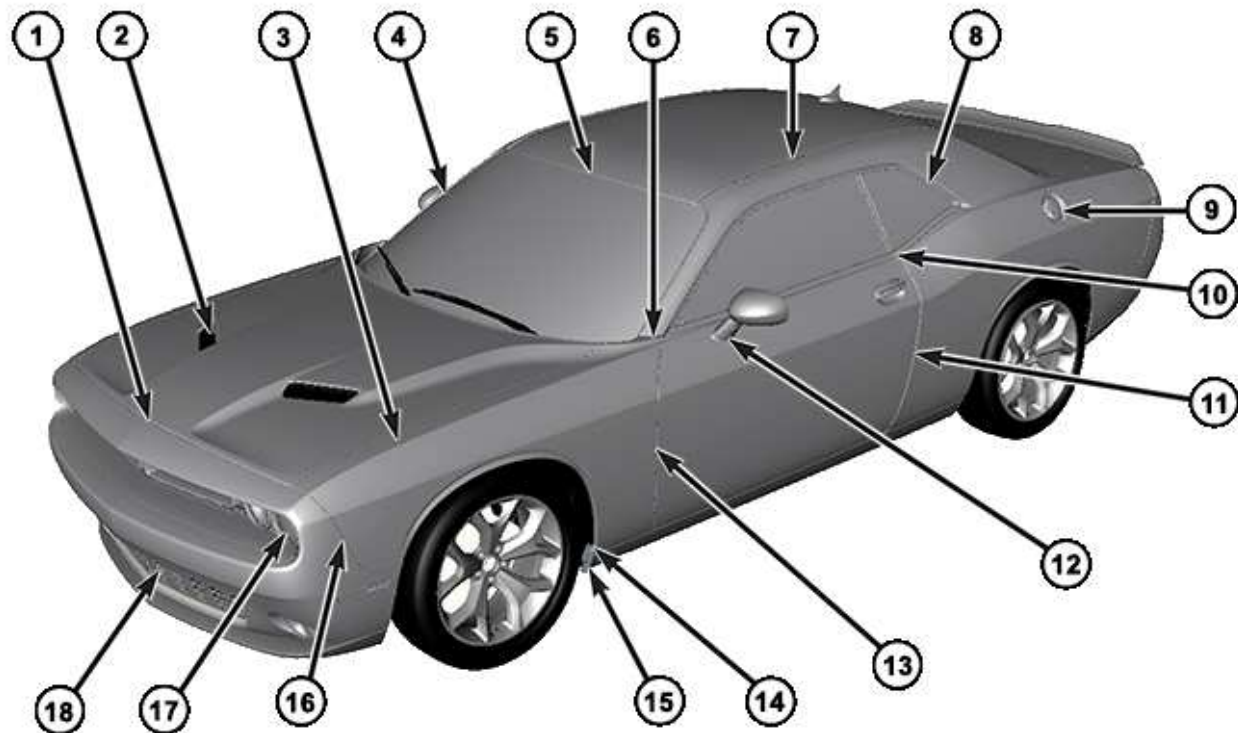


Underbody Dimensions



Under Hood Dimensions

GAP AND FLUSH DIMENSIONS



NOTE: All measurements are in millimeters.

O/F = Over Flush

U/D = Up/Down

U/F = Under Flush

F/A = Fore/Aft

DIMENSION	DESCRIPTION	GAP	FLUSH
1	Hood to Fascia	3.5 +/- 1.5 Parallel within 1.5	Hood U/F 0.5+/- 1.0 Consistent within 1.5
2	Hood Scoop to Hood (Base and RT models)	Top 0.0 +/- 1.0 Bottom 0.5 +/- 0.5 Sides 0.5 +/- 0.5	Scoop U/F 0.5 +/- 0.5 (at front only)
3	Hood to Fender	3.5 +/- 1.5 Parallel within 1.5 Side to side within 1.5	Hood U/F 1.0 +/- 1.5 Side to side within 1.5
4	Windshield Trim Lace to A-pillar	No Gap 0.0	Trim Lace must be U/F to A-pillar and Roof
5	Windshield Trim Lace to Roof	No Gap 0.0	Windshield U/F 2.0 +/- 2.0 Consistent within 2.0
6	Fender to Body Side Aperture (at A-pillar)	3.0 +/- 1.0	—
7	Ditch Molding to Roof	No Gap 0.0	Molding U/F 2.0 +/- 1.5 Consistent within 1.5
8	Quarter Glass Belt to Body Side Aperture	No Gap 0.0	—
9	Fuel Door Assembly to Body Side Aperture	1.0 +/- 1.0	—
10	Belt Molding to Quarter Glass	4.0 +/- 2.0	Belt Molding O/F 0.5 +/- 1.5
11	Door to Body Side Aperture Feature Line U/D 0.0 +/- 1.5	4.0 +/- 1.0 Parallel within 1.0	0.0 +/- 1.0 Parallel within 1.0
12	Mirror to Door	No Gap 0.0	—
13	Door to Fender Feature Line U/D 0.0 +/- 1.5	4.5 +/- 1.0 Parallel within 1.0	Door (above Feature Line) + 0.0/- 2.0 U/F Door (below Feature Line) 1.0 +/- 1.0 Consistent within 1.0
14	Spat to Fender	0.0 +/- 0.5	—
15	Spat to Sill Molding	2.0 +/- 2.0 Consistent within 2.0	—
16	Fascia to Fender	0.0 +/- 1.0	Fascia U/F 0.5 +/- 1.5 Consistent within 1.0
17	Headlamp Bezel to Headlamp Lens	F/A 6.0 +/- 2.0 Consistent within 1.0	—
18	Adaptive Cruise Control Bezel to Lower Grille	6.0 +/- 1.0 Parallel within 1.0	—

NOTE: All measurements are in millimeters.

O/F = Over Flush

U/D = Up/Down

U/F = Under Flush

F/A = Fore/Aft

DIMENSION	DESCRIPTION	GAP	FLUSH
19	Spoiler to Rear Fascia	8.0 +/- 1.5 Parallel within 1.5	—
20	Spoiler to Body Side Aperture	8.0 +/- 1.5 Parallel within 1.5 (Outboard)	—
21	Back-up Camera to Spoiler	0.5 +/- 0.5	—
22	Decklid to Body Side Aperture	4.0 +/- 1.0 Parallel within 1.5	Decklid U/F 1.0 +/- 1.5
23	Backlight to Roof	No Gap 0.0	Backlight U/F 2.0 +/- 2.0 Consistent within 2.0
24	Quarter Glass to Door Glass	6.0 +/- 2.0 Parallel within 2.0	Quarter Glass Flush + 0.0 /- 3.0
25	Glass Run Retainer Lip	No Gap 0.0	—
26	Outer Belt Molding Lip to Glass	No Gap 0.0	—
27	Outer Belt Molding to Door	0.0 + 1.0	—
28	Sill Molding to Fender	0.0 + 1.5	Sill Molding O\F 2.5 +/- 1.5 at front Transitioning to 3.0 at rear
29	Door Handle to Door	0.0 +/- 0.5	Door Handle O\F by design
30	Sill Molding to Door	6.0 +/- 1.5 Parallel within 1.5	Sill Molding O\F 2.5 +/- 1.5 Consistent within 1.5
31	Sill Molding to Body Side Aperture	0.0 + 1.5	Sill Molding O/F 3.0 +/- 1.5
32	Rear Fascia to Body Side Aperture	0.0 + 1.0	0.0 +/- 1.0 Consistent within 1.0
33	Decklid to Rear Fascia	Cross car 4.0 + 1.0 Parallel within 1.0	U/D Decklid U/F 1.0 +/- 1.0 F/A 1.0 +/- 1.0 Consistent within 1.0
34	Center Taillamp to Outer Taillamp	4.0 +/- 2.0 Parallel within 2.0 Side to side within 2.0	0.0 +/- 2.0
35	Spoiler to Decklid	1.0 +/- 1.0 Parallel within 1.0	—
36	Decklid to Decklid Surround	0.0 +/- 0.5	Decklid U\F 0.5 +/- 0.5
37	Center Taillamp to Rear Fascia Surround	8.0 +/- 1.5 Parallel within 1.5	—
38	Outer Taillamp to Fascia Surround	8.0 +/- 1.0	—

<div><div>NOTE:</div><div>All measurements are in millimeters.</div></div> <div><div>O/F = Over Flush</div><div>U/D = Up/Down</div></div> <div><div>U/F = Under Flush</div><div>F/A = Fore/Aft</div></div>			
DIMENSION	DESCRIPTION	GAP	FLUSH
		Parallel within 1.0 Side to side within 1.0	

PAINT CODES

Exterior vehicle body color(s) are identified on the Vehicle Certification Label or the Body Code Plate.

The first digit of the paint code listed on the vehicle indicates the sequence of application, i.e.: P = primary coat, Q = secondary coat. The color names provided in the Paint and Trim Code Description chart are the same color names used on most repair product containers.

EXTERIOR COLORS

EXTERIOR COLOR	CHRYSLER CODE
Pitch Black Clear Coat	DX8
Sublime Peal Coat	FFB
B5 Blue Pearl Coat	FQD
Bright White Clear Coat	GW7
Red Line Tri-Coat Peal	JRY
Billet Silver Metallic Clear Coat	JSC
Ivory White Tri-Coat Pearl	JWD
Jazz Blue Pearl Coat	KBX
Granite Crystal Pearl Coat	LAU
Phantom Black Tri-Coat Pearl	LXT
Torred Clear Coat	ZR3

INTERIOR COLORS

INTERIOR COLOR	CHRYSLER CODE
Black/Sepia	VX
Black / Ruby Red	XC
Black Tungsten	XG
Black Pearl	XW
Black	X9

R/T CLASSIC BODYSIDE STRIPE

STRIPE COLOR	CHRYSLER CODE
Black Satin Gloss	RXF
Stone White High Gloss	SW1
Red High Gloss	PR4

R/T AND R/T PLUS HOOD GRAPHIC

STRIPE COLOR	CHRYSLER CODE
Black Satin Gloss	RXF

SHAKER CENTER STRIPE

STRIPE COLOR	CHRYSLER CODE
Black Satin Gloss	RXF


SCAT PACK DECKLID STRIPE

STRIPE COLOR	CHRYSLER CODE
Black Satin Gloss	RXF

V6 BODYSIDE STRIPE

STRIPE COLOR	CHRYSLER CODE
Black Satin Gloss	RXF

VEHICLE CERTIFICATION LABEL

MFD BY CHRYSLER LLC			DATE OF MFG: 8-08			
GVWR: 02012 KG	GAWR: 01080 KG	GAWR: 00998 KG				
04435 LB	FRONT: 02380 LB	REAR: 02200 LB				
THIS VEHICLE CONFORMS TO ALL APPLICABLE U.S.A FEDERAL MOTOR VEHICLE SAFETY. BUMPER AND THEFT PREVENTION STANDARDS IN EFFECT ON THE DATE OF MANUFACTURE SHOWN ABOVE.			VIN: 1B3HB48A39D132596	TYPE: PASSENGER CAR		
			MDH: 08113 980AA	PAINT: PQD	TRIM: ZSDV	
			VEHICLE MADE IN U.S.A.	4658843		

000874415

A vehicle certification label is attached to every Chrysler Group LLC vehicle. The label certifies that the vehicle conforms to all applicable Federal Motor Vehicle Standards. The label also lists:

- Month and year of vehicle manufacture.
- Gross Vehicle Weight Rating (GVWR). The gross front and rear axle weight ratings (GAWR's) are based on a minimum rim size and maximum cold tire inflation pressure.
- Vehicle Identification Number (VIN).
- Type of vehicle.
- Type of rear wheels.
- Bar code.
- Month, Day and Hour (MDH) of final assembly.
- Paint and Trim codes.
- Country of origin.

The label is located on the driver-side door shut-face.

Locations

SEALERS AND SOUND DEADENERS

Terminology

- **Work Time** : The length of time a sealer can continue to be applied or tooled effectively.
- **Set Time** : Time when there is no longer product transfer.
- **Handling Time** : The time when a part can be safely transported and sealer can no longer be tooled or repositioned.
- **Full Cure Time** : Time when a sealer has reached full strength.
- **Paintable Time** : Established time when refinish materials can safely be applied to a sealer.

Sealers

- **Brushable** : Single component sealer applied with a brush.
- **Flowable** : Sealer with low viscosity and self-leveling characteristics.
- **Pumpable** : A two component or one component sealer that seals interior and exterior joints and voids.
- **Resistance Weld-through** : Sealer / adhesive that can be used in conjunction with resistance spot welding.
- **Sealer Tape** : Preformed sealer.
- **Sprayable** : Sealer applied with a pneumatic dispenser to duplicate original textured appearance.
- **Thumb Grade** : Heavy bodied sealer for sealing large gaps and filling voids. Should remain soft and pliable.

Sound Deadeners

- **Non-Structural Flexible Acoustical** : Flexible foam with sealing and sound deadening properties.
- **Non-Structural Ridged Acoustical** : Ridged foam with sealing and sound deadening properties.
- **Mastic Pads** : Sound deadener pad that is preformed to fit a specific area.

Identifying Sealers

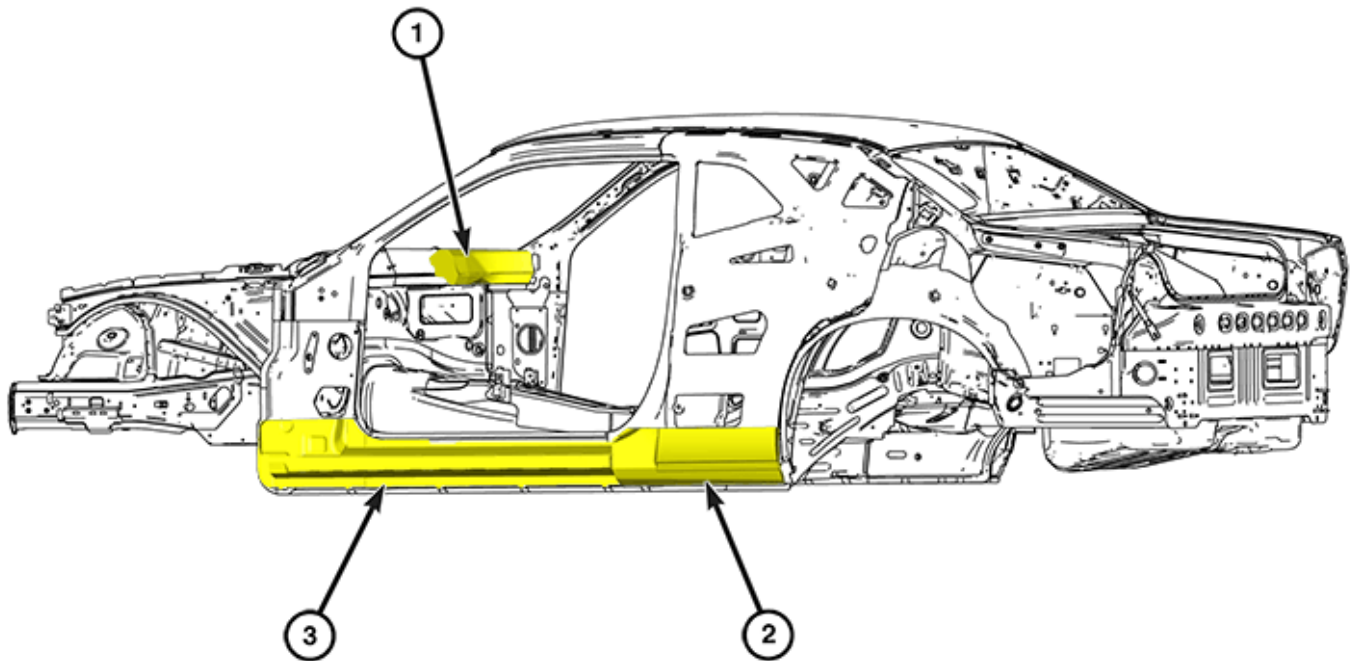
- Several types of sealers and sound deadeners are used during assembly. Therefore, specific applications may not be identified in this publication. General applications and the various types of products for repair will be featured to identify and replace OEM sealers and sound deadeners.

Helpful Sealer Tips

- Check shelf life or expiration date prior to beginning sealer applications.
- Be sure "work time" is appropriate for sealer application.
- Temperature, humidity and thickness of sealer will affect the work, set and paintable times.
- Test fit replacement panels prior to installation to insure tight fit and proper seal.
- Equalize 2K Products according to adhesive manufacturer's recommendations.
- Always follow manufacturer's recommendations for storage, usage and application to achieve best performance of the product.

SOUND DEADENER LOCATIONS

DESCRIPTION	FIGURE
PUR FOAM LOCATIONS	Figure 1
HOOD	Figure 2
FENDER	Figure 3
FRONT DOOR	Figure 4
ROOF	Figure 5
FRONT SIDE RAIL AND WHEELHOUSE	Figure 6
DASH PANEL (OUTER)	Figure 7
DASH PANEL (INNER)	Figure 8
COWL PLENUM UPPER PANEL	Figure 9
FRONT FLOOR PAN	Figure 10
INTERIOR FLOOR TUNNEL	Figure 11
EXTERIOR FLOOR TUNNEL	Figure 12
REAR FLOOR (1 OF 2)	Figure 13
REAR FLOOR (2 OF 2)	Figure 14
INNER BODY SIDE (1 OF 2)	Figure 15
INNER BODY SIDE (2 OF 2)	Figure 16
REAR SHELF PANEL	Figure 17
INNER WHEELHOUSE AND REAR SHELF PANEL	Figure 18
OUTER WHEELHOUSE	Figure 19



3103052241

PUR Foam Locations

NOTE: Right side shown, left side similar.

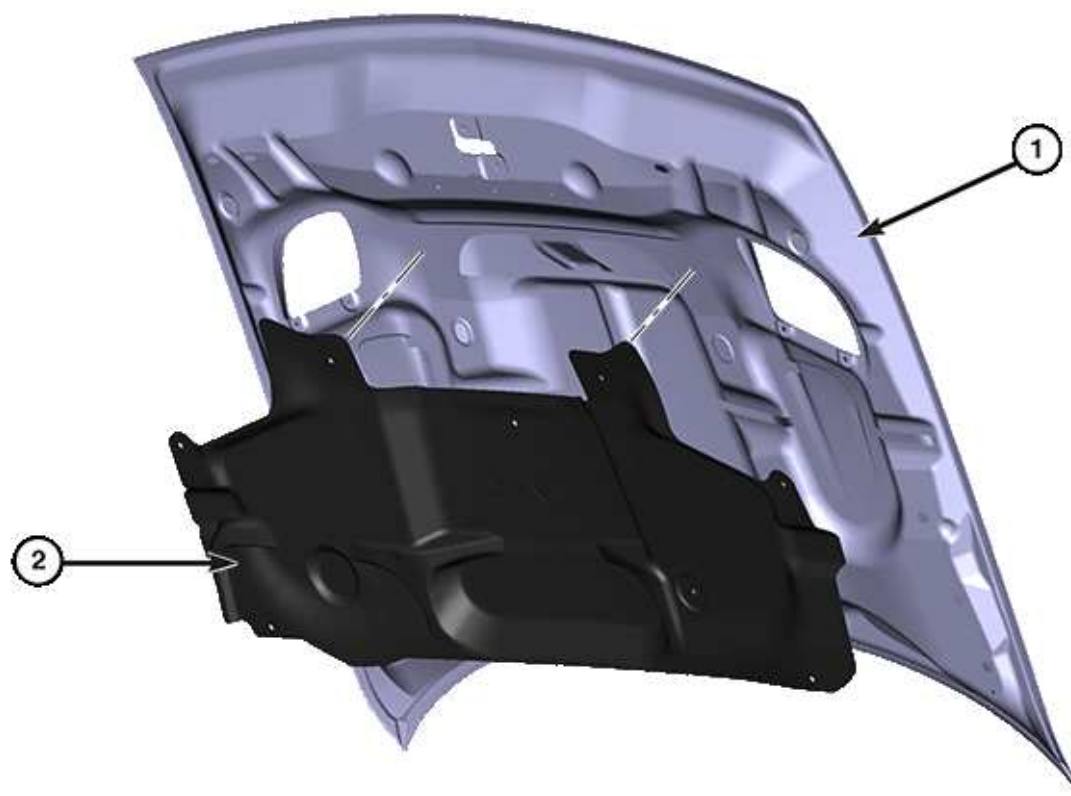
1 - COWL PANEL

NOTE: Left side shown, right side similar.

2 - BODY SIDE REAR REINFORCEMENT

NOTE: Left side shown, right side similar.

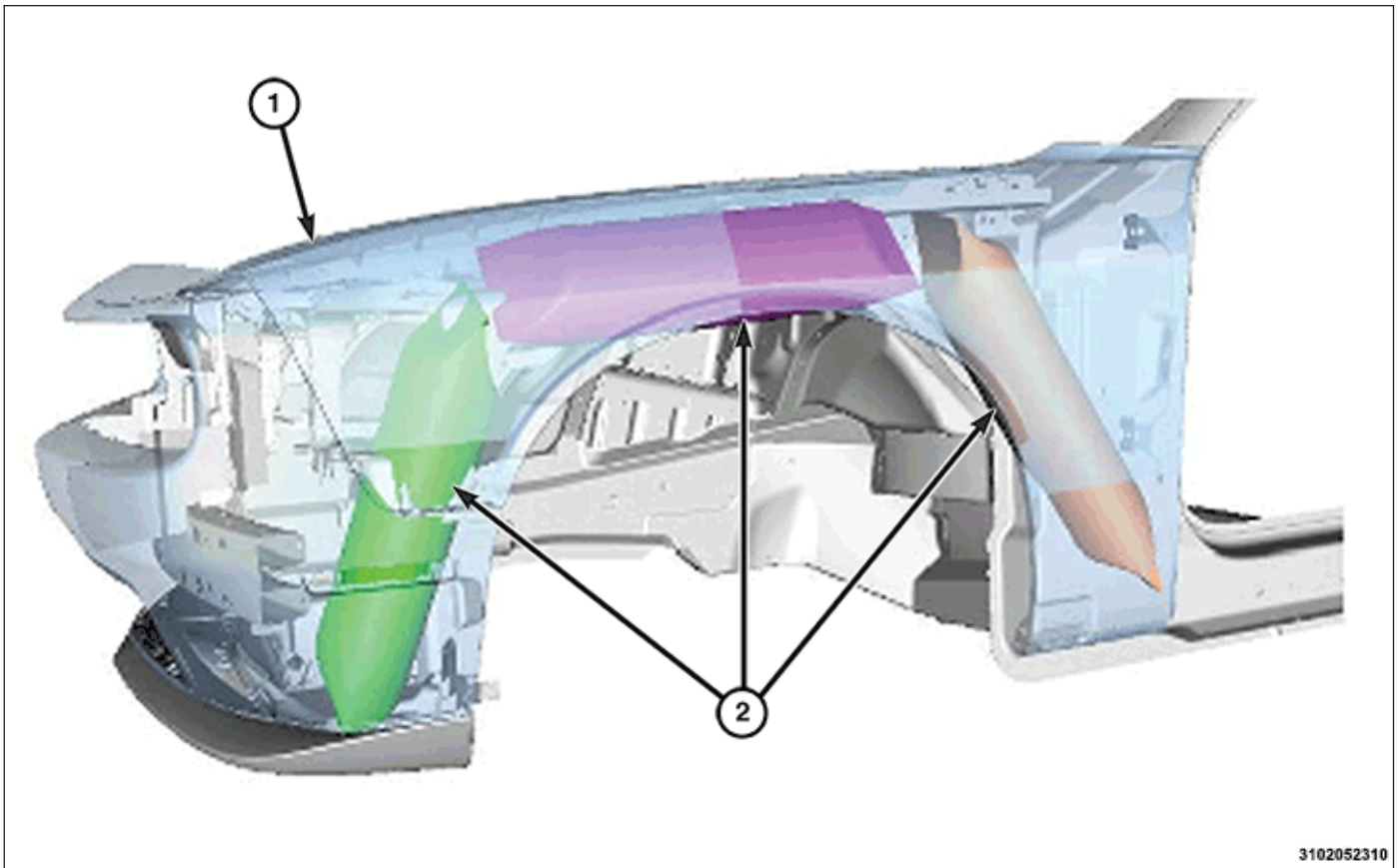
3- SILL AREA



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Hood

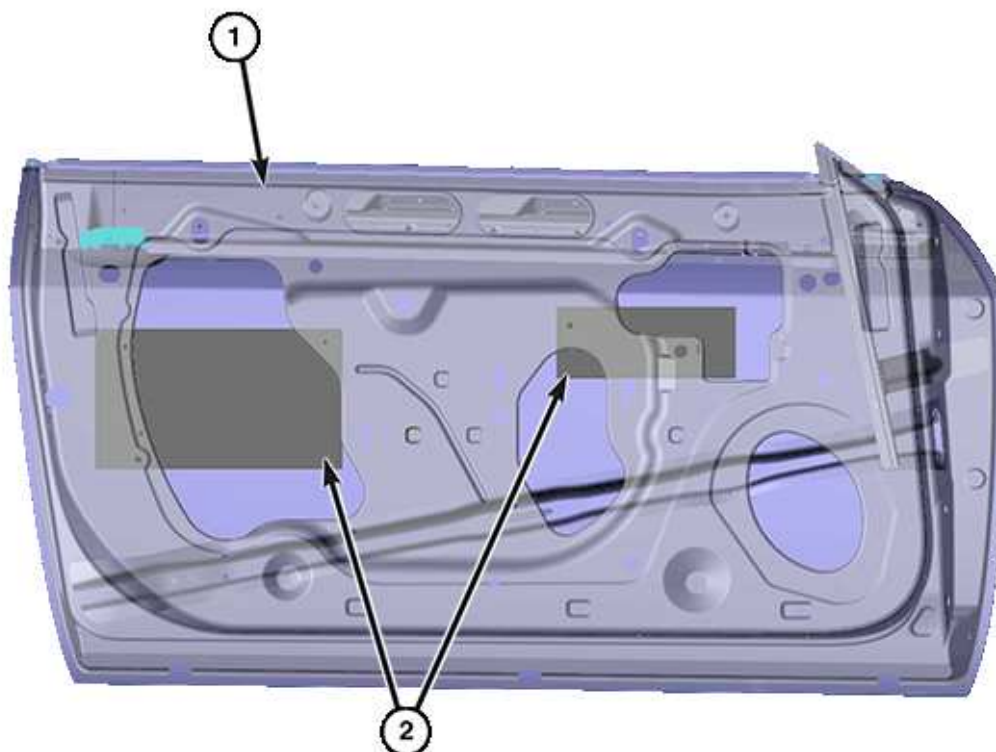
- 1 - HOOD
- 2 - HOOD SILENCER PAD



NOTE: Left side shown, right side similar.

1 - FENDER

2 - FENDER STUFFER PADS

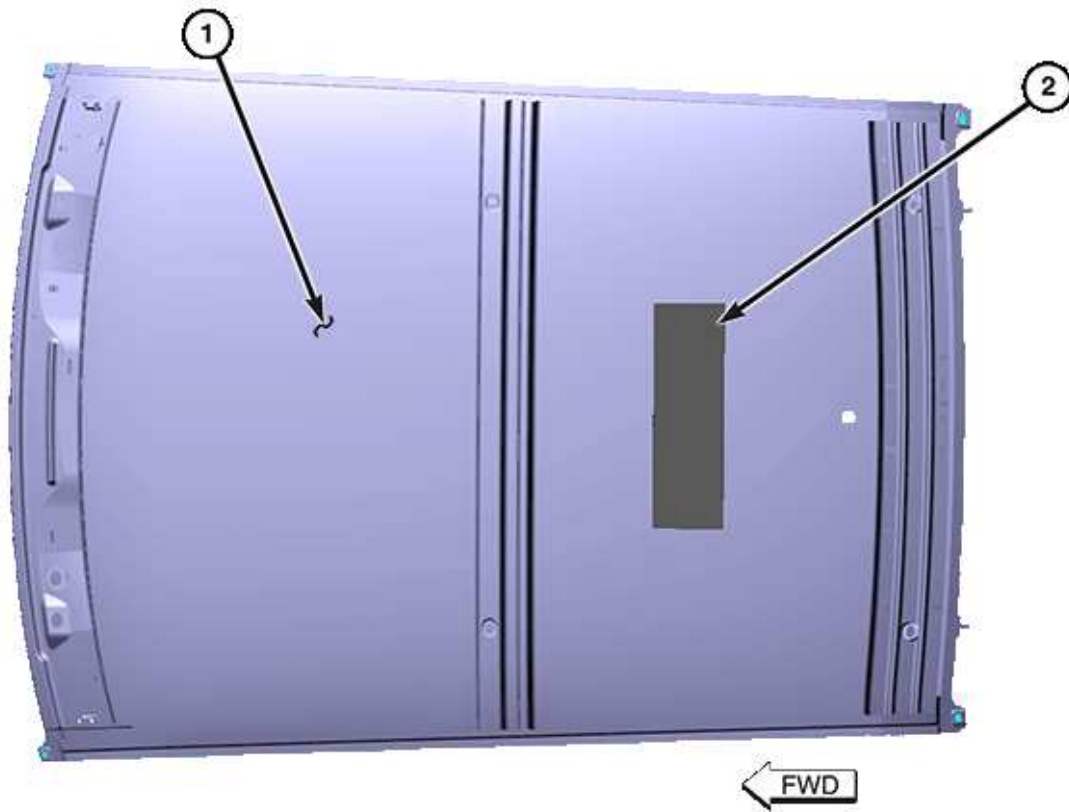


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Front Door

NOTE: Left side shown, right side similar.

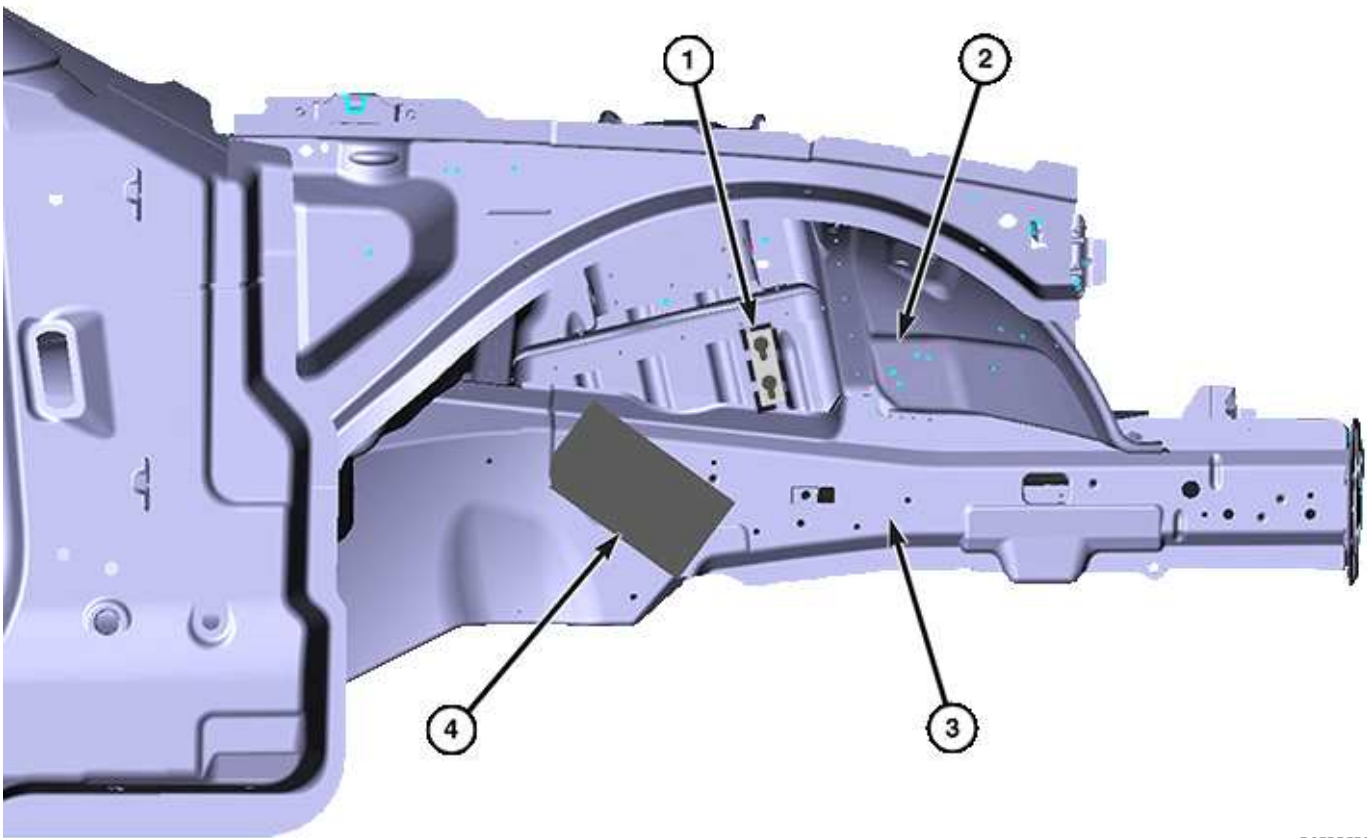
- 1 - FRONT DOOR
- 2 - MASTIC PADS



3103062200

Roof

- 1 - ROOF
- 2 - MASTIC PAD



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Front Side Rail and Wheelhouse

NOTE: Wheelhouse mastic pad (1) utilized on right side only.

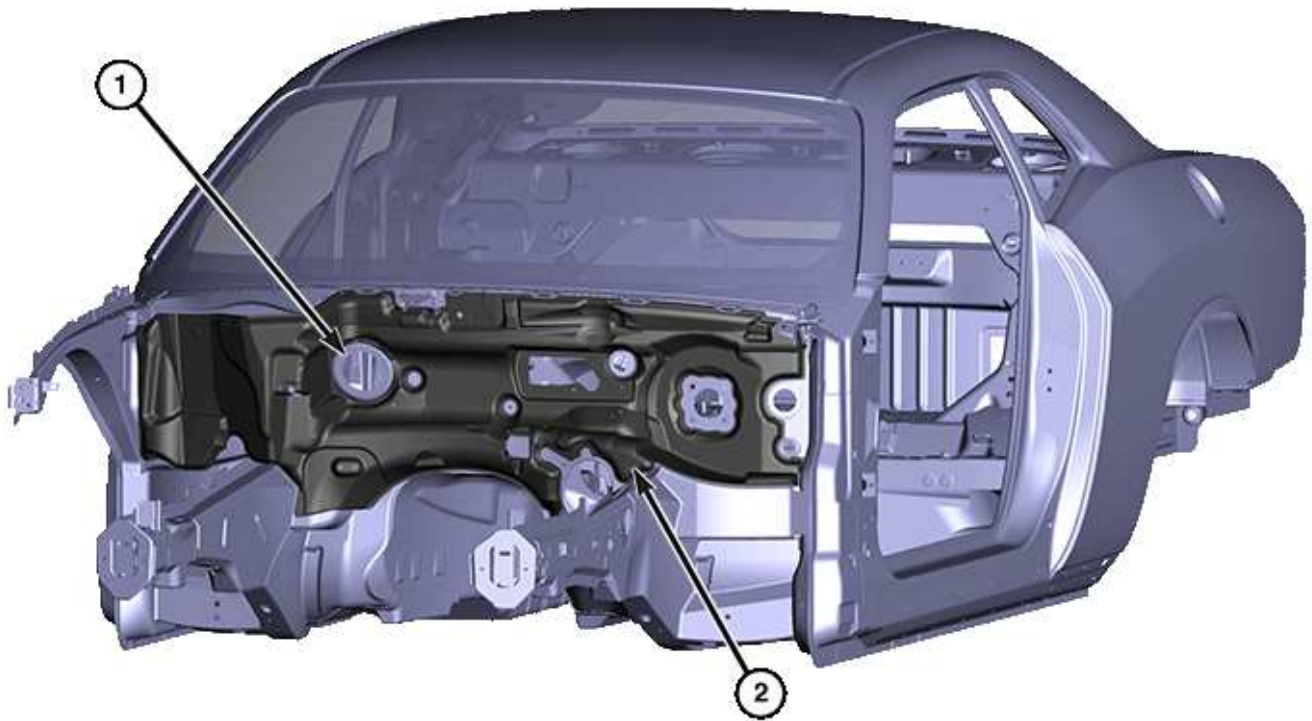
1 - WHEELHOUSE MASTIC PAD

2 - WHEELHOUSE

NOTE: Right side shown, left side similar.

3 - FRONT SIDE RAIL

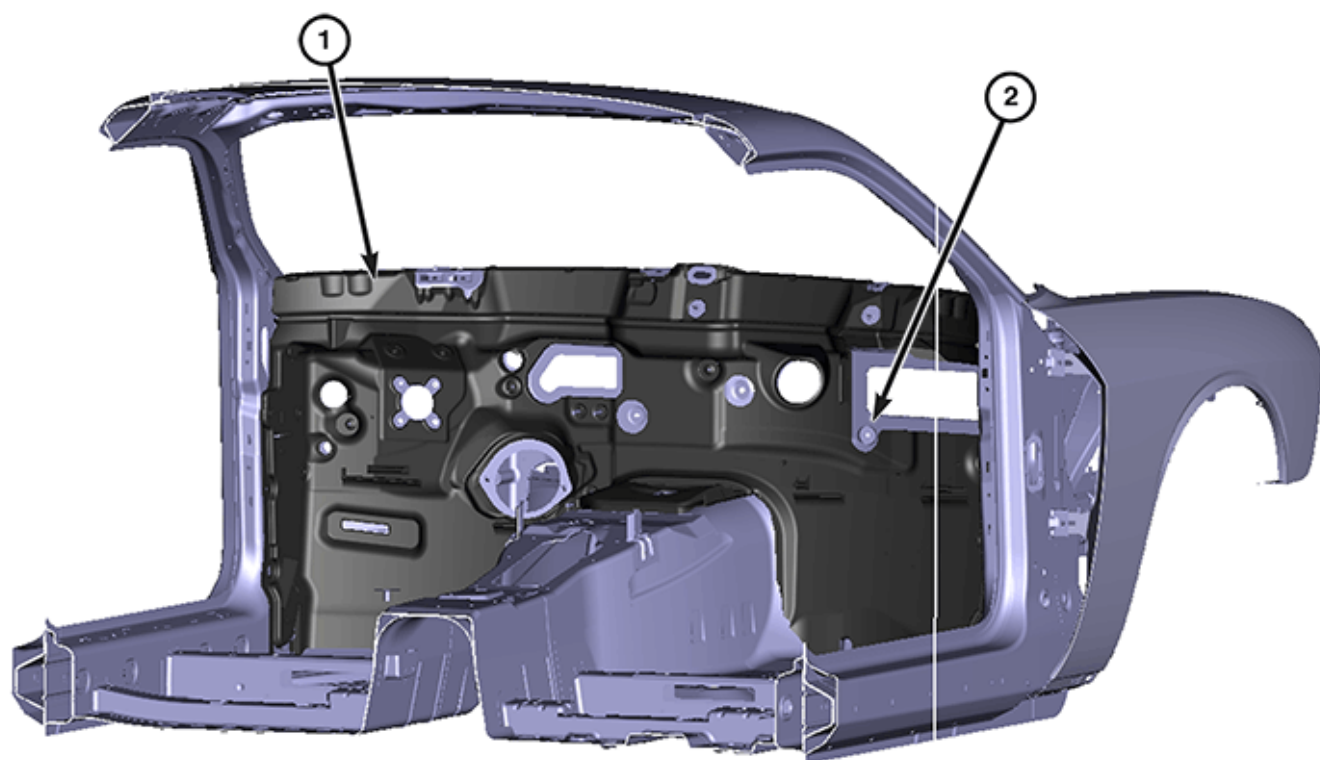
4 - FRONT SIDE RAIL MASTIC PAD



3103052245

Dash Panel (Outer)

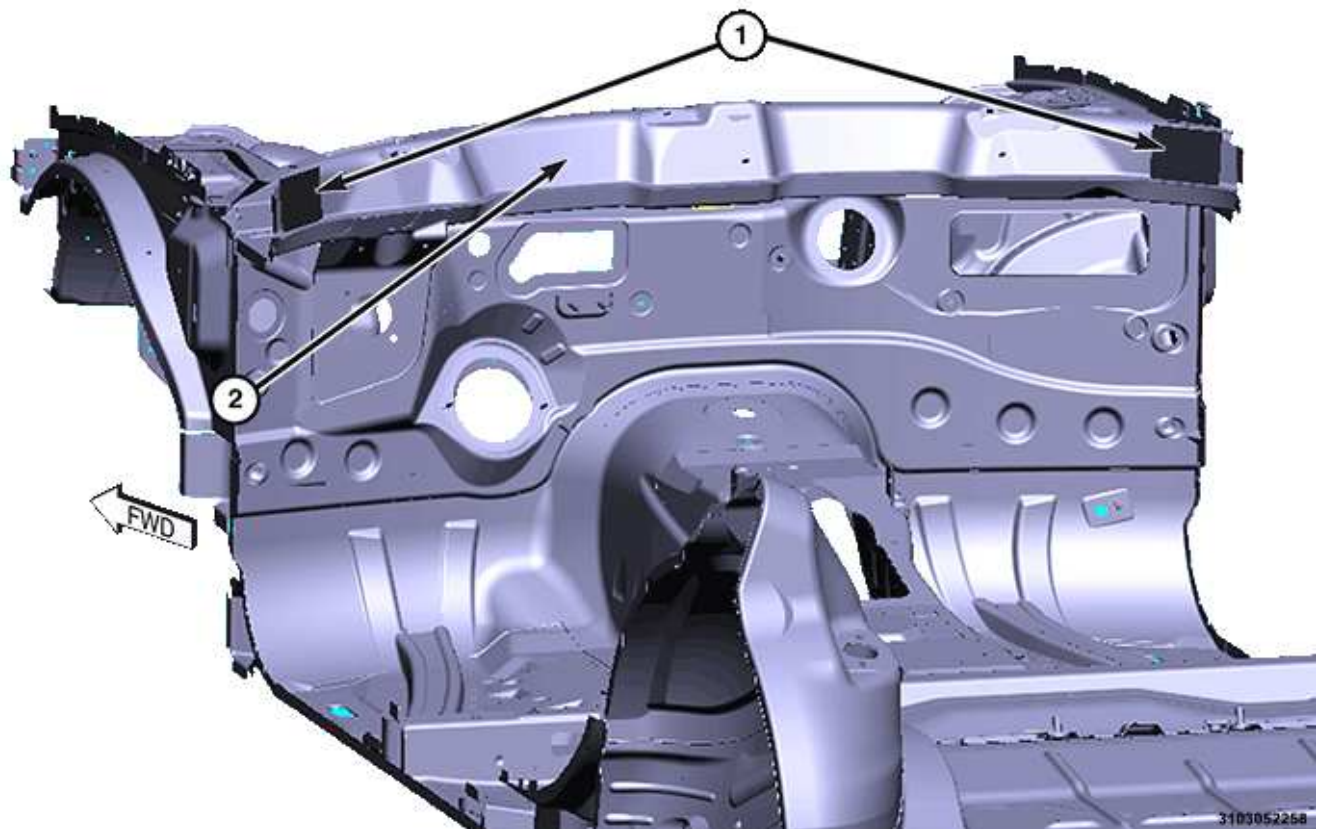
- 1 - DASH PANEL
- 2 - OUTER DASH PANEL SILENCER PAD



3103052246

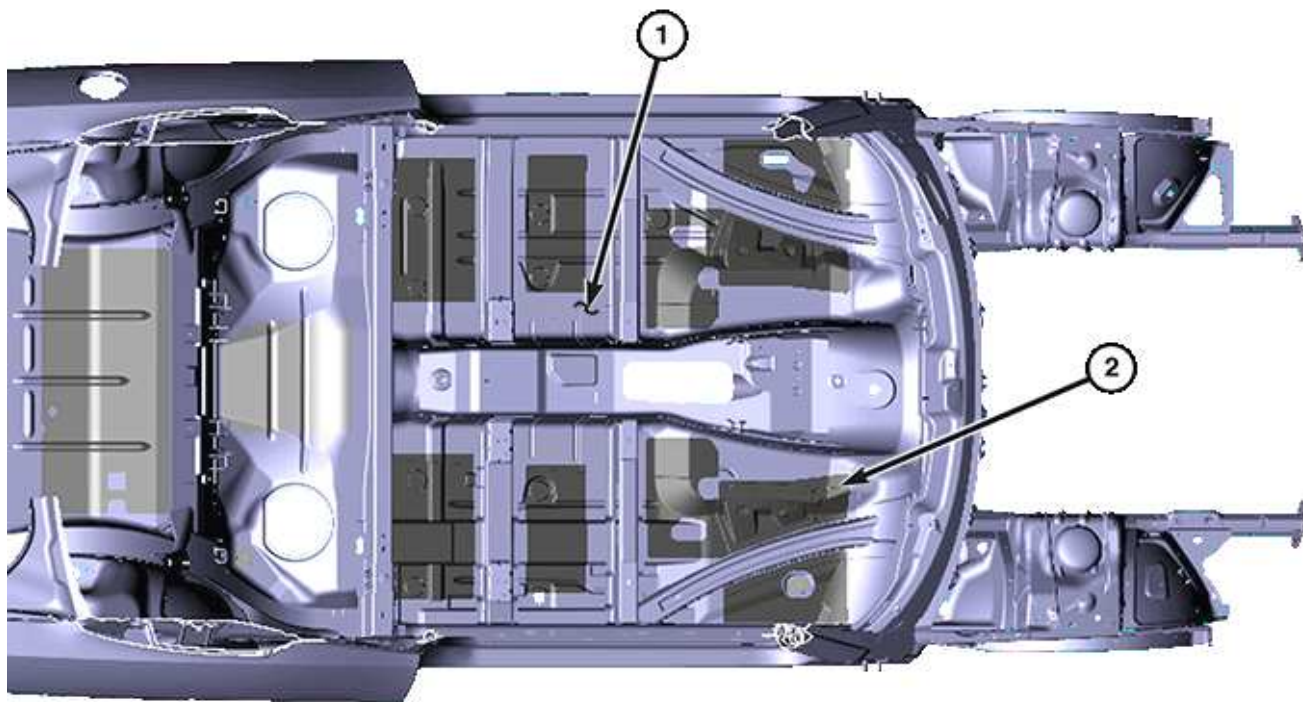
Dash Panel (Inner)

- 1 - DASH PANEL
- 2 - INNER DASH PANEL SILENCER PAD



Cowl Plenum Upper Panel

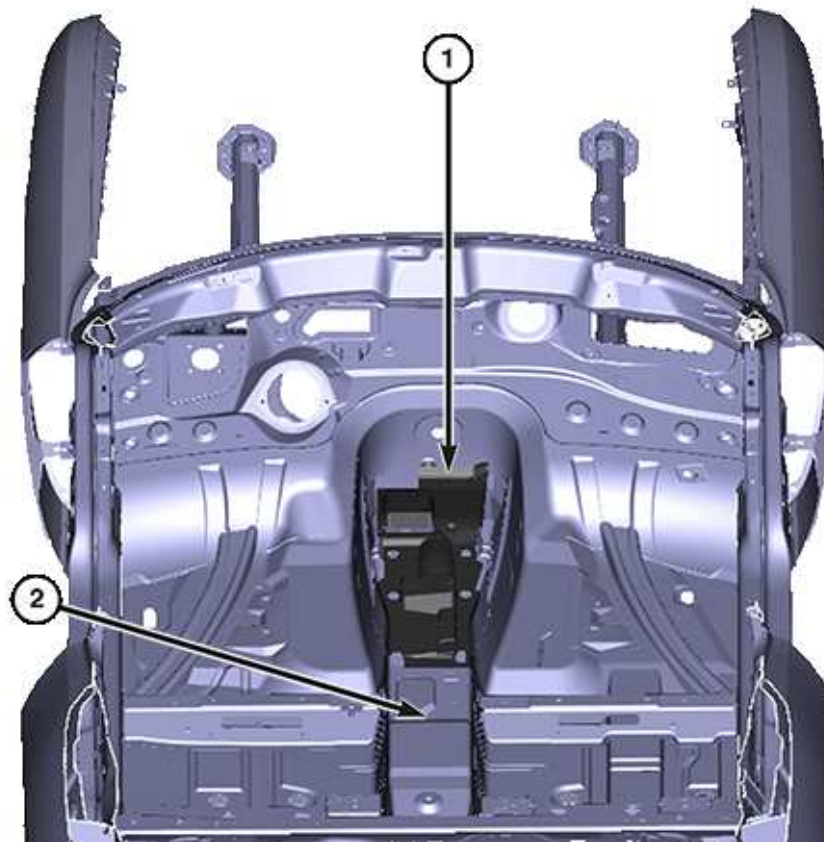
- 1 - COWL PLENUM UPPER PANEL MASTIC PADS
- 2 - COWL PLENUM UPPER PANEL



3103052242

Front Floor Pan

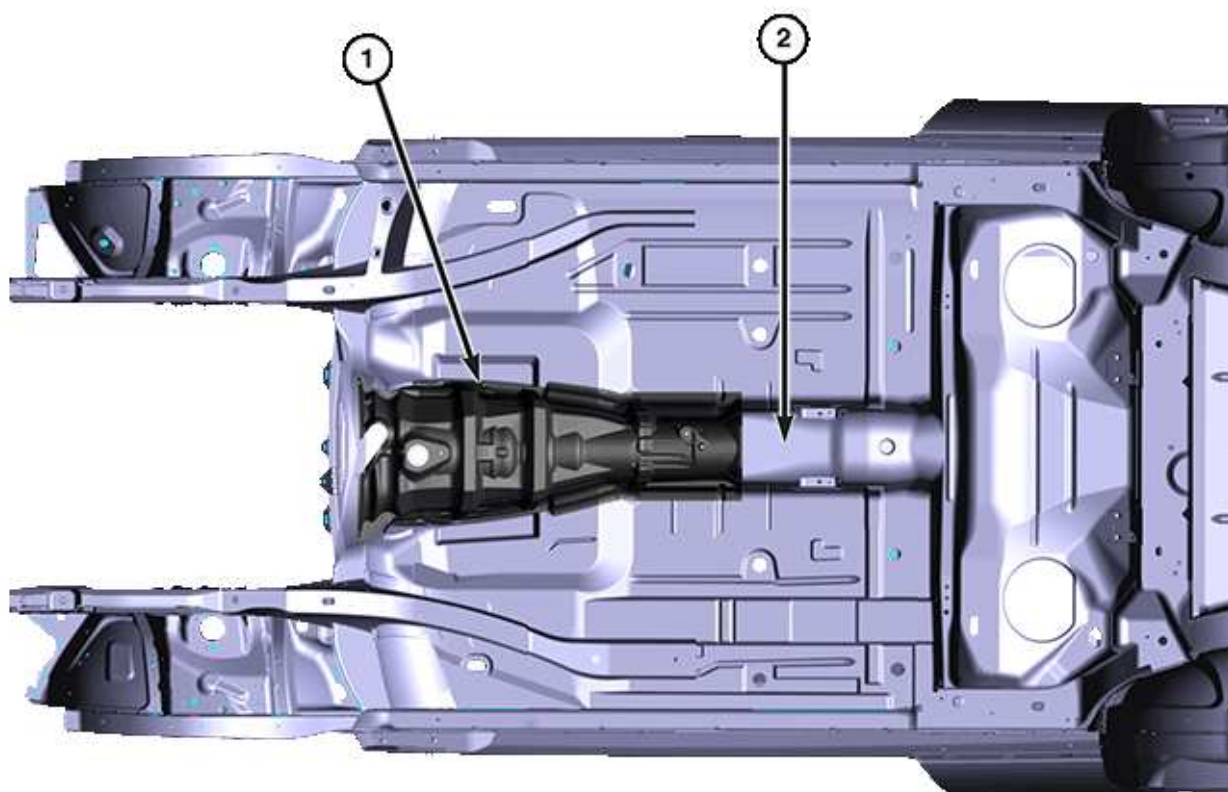
- 1 - FRONT FLOOR PAN
- 2 - MASTIC PADS



3103052248

Interior Floor Tunnel

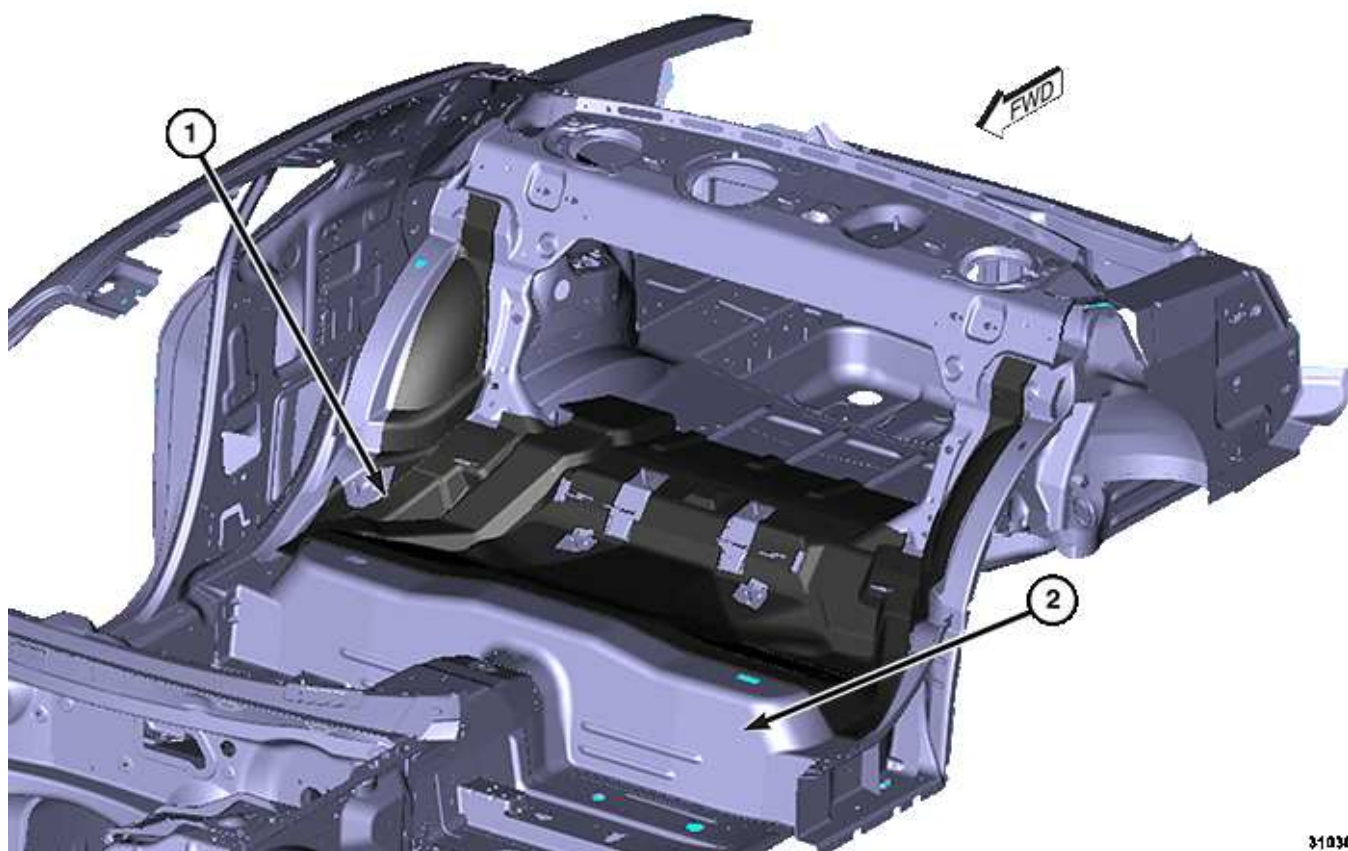
- 1 - INTERIOR TUNNEL SILENCER PAD
- 2 - INTERIOR FLOOR TUNNEL



3103052249

Exterior Floor Tunnel

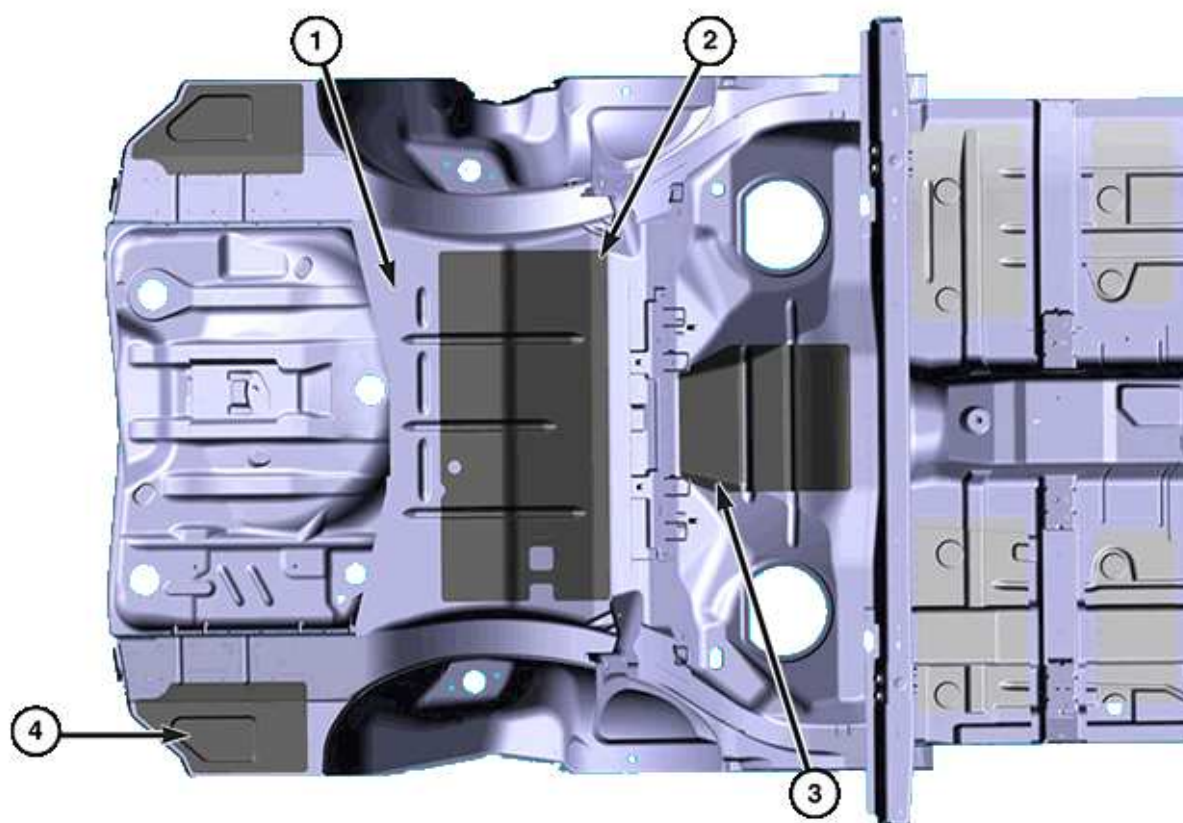
- 1 - EXTERIOR FLOOR TUNNEL SILENCER PAD
- 2 - EXTERIOR FLOOR TUNNEL



3103052252

Rear Floor Pan (1 of 2)

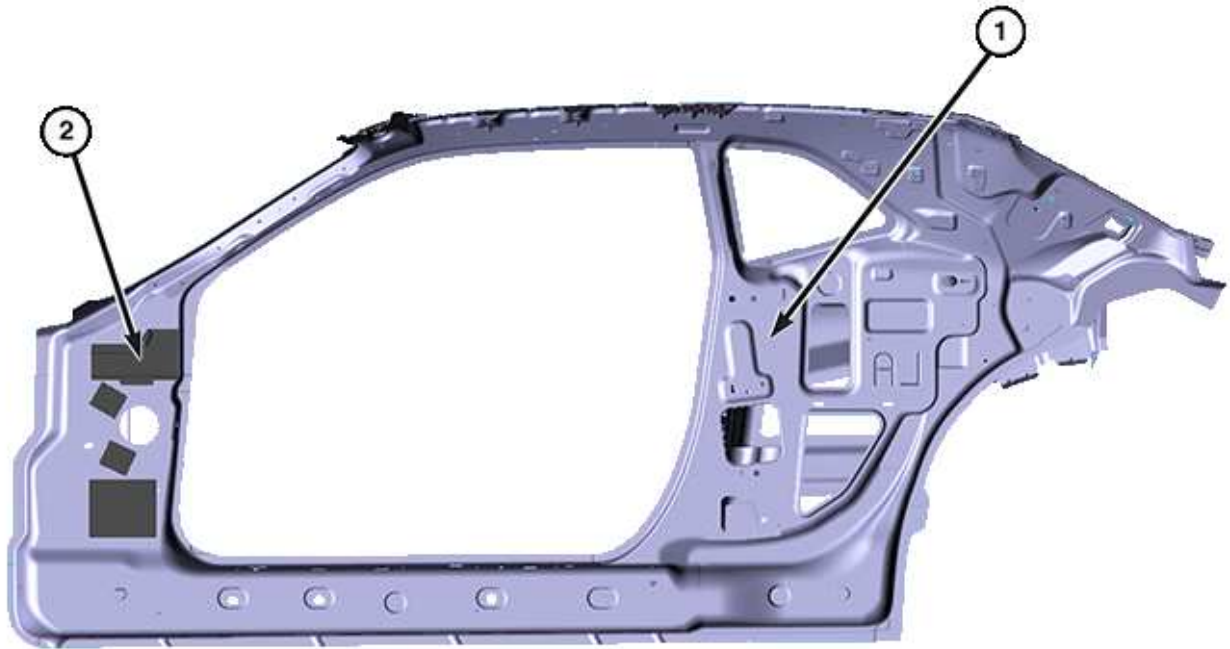
- 1 - REAR FLOOR SILENCER PAD
- 2 - REAR FLOOR



3103052243

Rear Floor Pan (2 of 2)

- 1 - REAR FLOOR PAN
- 2 - REAR FLOOR MASTIC PAD
- 3 - REAR KICK-UP MASTIC PAD
- 4 - REAR RAIL COVER MASTIC PAD

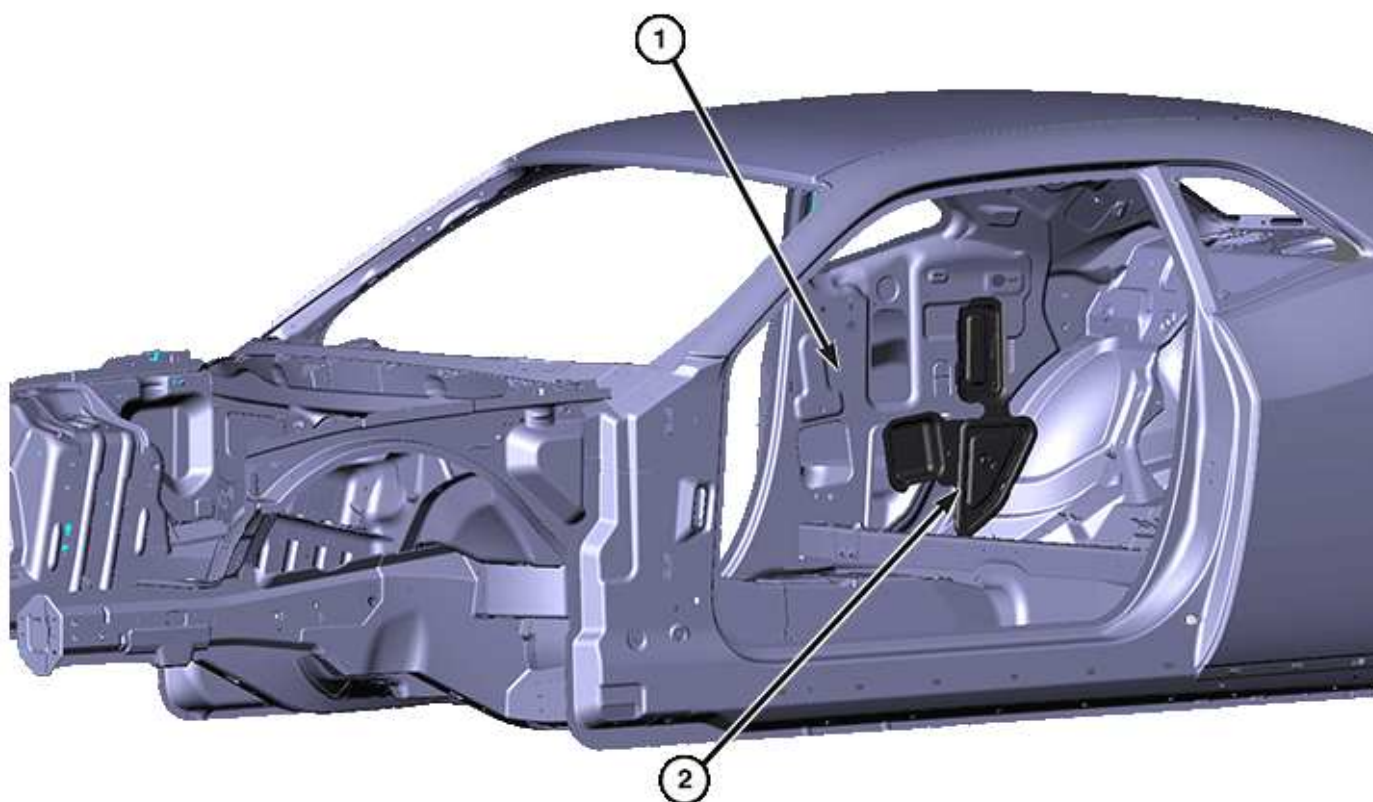


3103052259

Inner Body Side (1 of 2)

NOTE: Right side shown, left side similar.

- 1 - INNER BODY SIDE
- 2 - INNER BODY MASTIC PADS



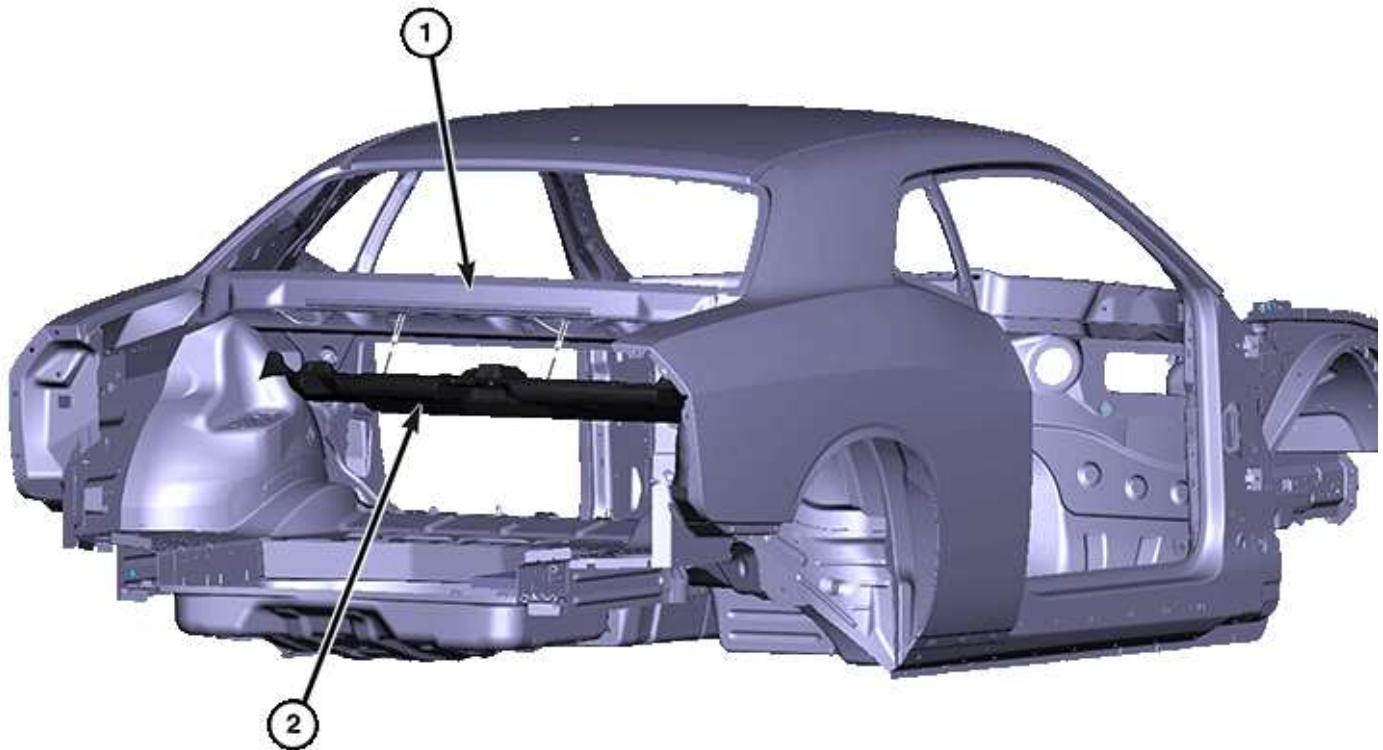
3103052250

Inner Body Side

NOTE: Right side shown, left side similar.

1 - INNER BODY SIDE

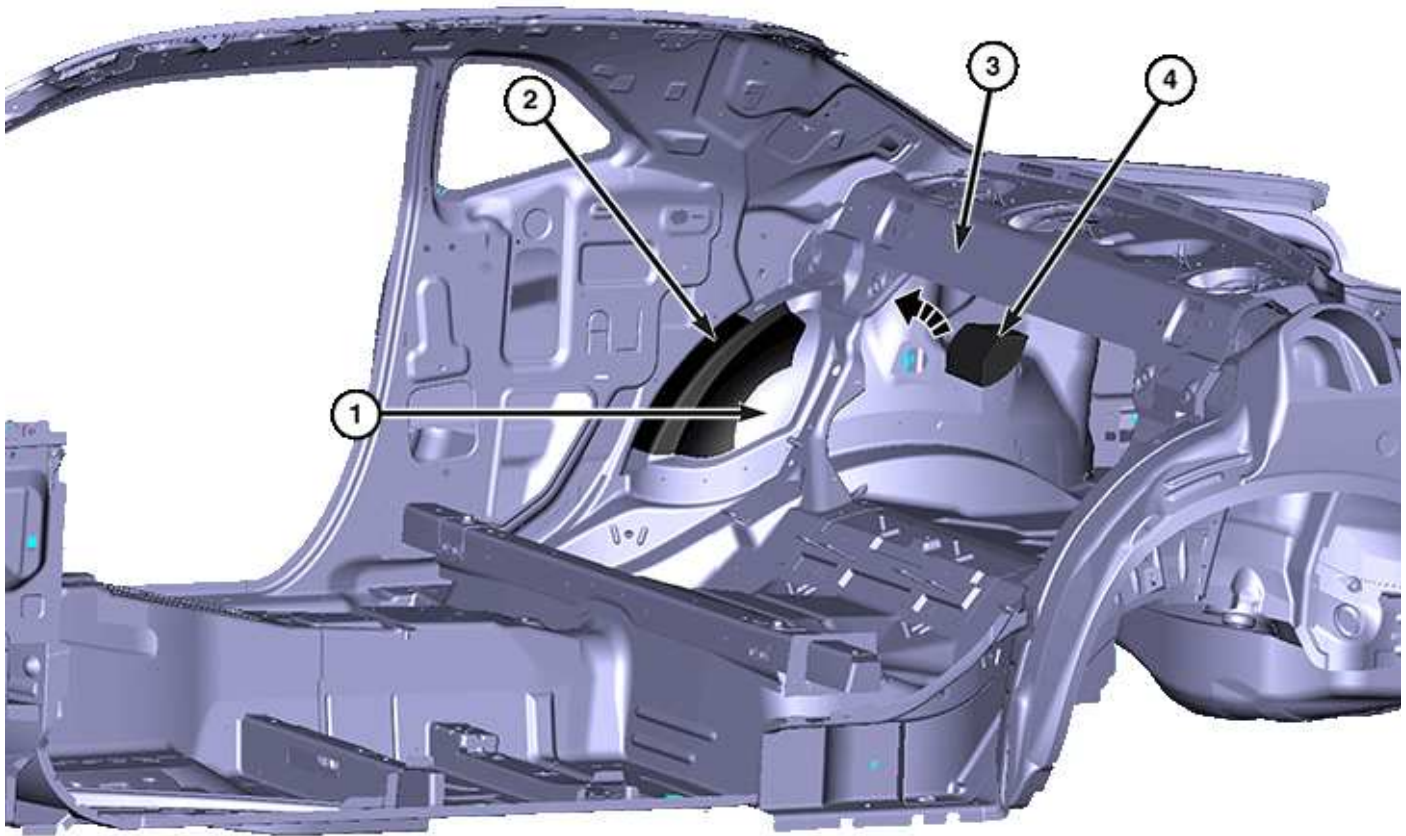
2 - INNER BODY SIDE FOAM SILENCER



3103052251

Inner Body Side

- 1 - REAR SHELF PANEL
- 2 - REAR SHELF SILENCER PANEL

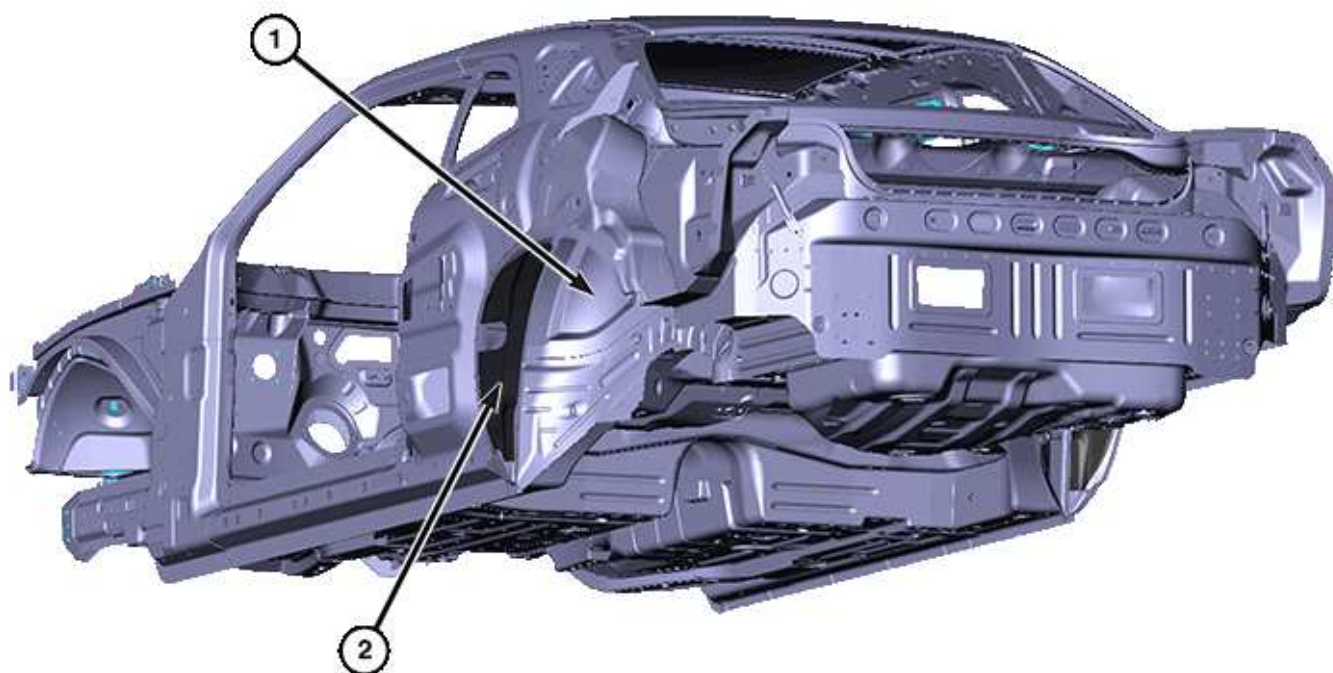


3103052255

Inner Body Side

NOTE: Right side shown, left side similar.

- 1 - INNER WHEELHOUSE
- 2 - INNER WHEELHOUSE MASTIC PAD
- 3 - REAR SHELF PANEL
- 4 - REAR SHELF STUFFER PAD



3103052256

Outer Wheelhouse

NOTE: Left side shown, right side similar.

1 - INNER WHEELHOUSE

2 - OUTER WHEELHOUSE MASTIC PAD

STRUCTURAL ADHESIVE, FLEXIBLE ADHESIVES AND SEAM SEALER LOCATIONS

Structural adhesives, flexible adhesives and seam sealers should only be applied by trained technicians. Follow the manufactures instructions for proper applications of products.

Structural adhesive is applied by itself or in conjunction with Squeeze Type Resistance Spot Welds and is to be re-assembled in the same manner as vehicle build. Any situation where it is undetermined weather it is structural adhesives or seam sealer always default to structural adhesive.

Anti- flutter adhesive is applied to areas of the vehicle where adhesive properties with flexibility are required. Typically found on supports and braces throughout the closure panels, roof and body side gas fill areas.

Seam sealers are only to be used topically, never within weld flanges or hem flanges. All sealers being replaced should duplicate the factory style sealer in shape and size.

For additional information on Corrosion Protection, (Refer to Collision Information - Standard Procedure).

For additional information on Sealer and Sound Description, (Refer to Collision Information-Locations).

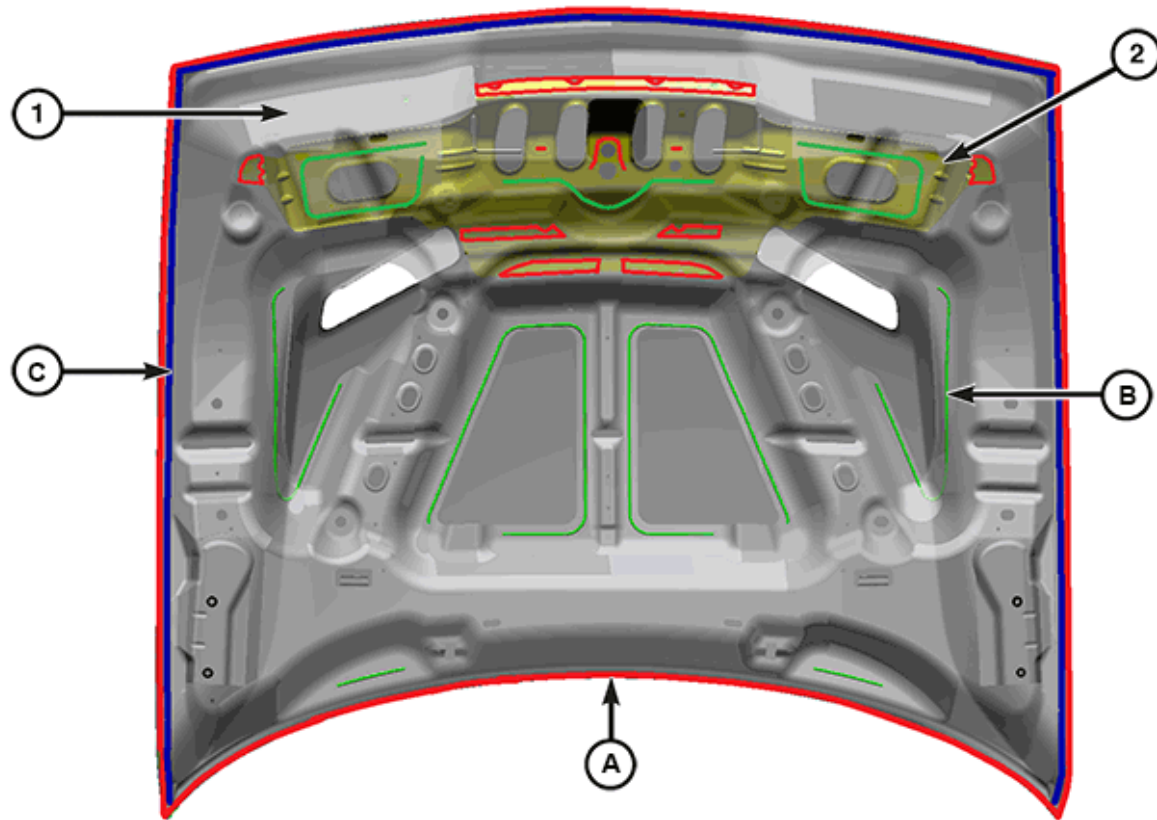
Chrysler approved replacement materials include –

- **Structural Adhesives:** Fusor 112B, 3M 08116.
- **Anti-Flutter Adhesives:** Fusor #121 or #124 (Flexible Foam, 3M #8463 Flexible Foam, Crest – CFF Flexi-Foam.
- **Seam Sealer:** Mopar #04318026, Fusor 129, 3M 08308.

MATERIAL TYPE	COLOR
Structural Adhesive	Red
Anti-Flutter Adhesive	Green
Seam Sealer	Blue

DESCRIPTION	FIGURE
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Front Door	Figure 2
Decklid	Figure 3
Strut Tower	Figure 4
Cowl / Dash	Figure 5
Floor Pan Crossmember	Figure 6
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Door Hinge Reinforcements / A-Pillar Reinforcement	Figure 8
Dash / Body Side Inner	Figure 9
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Rear Rail / Closeout Panel	Figure 35
Rear Floor Pan (Interior)	Figure 36
Rear Floor Panel (Exterior)	Figure 37
Taillamp Mounting Panel	Figure 38



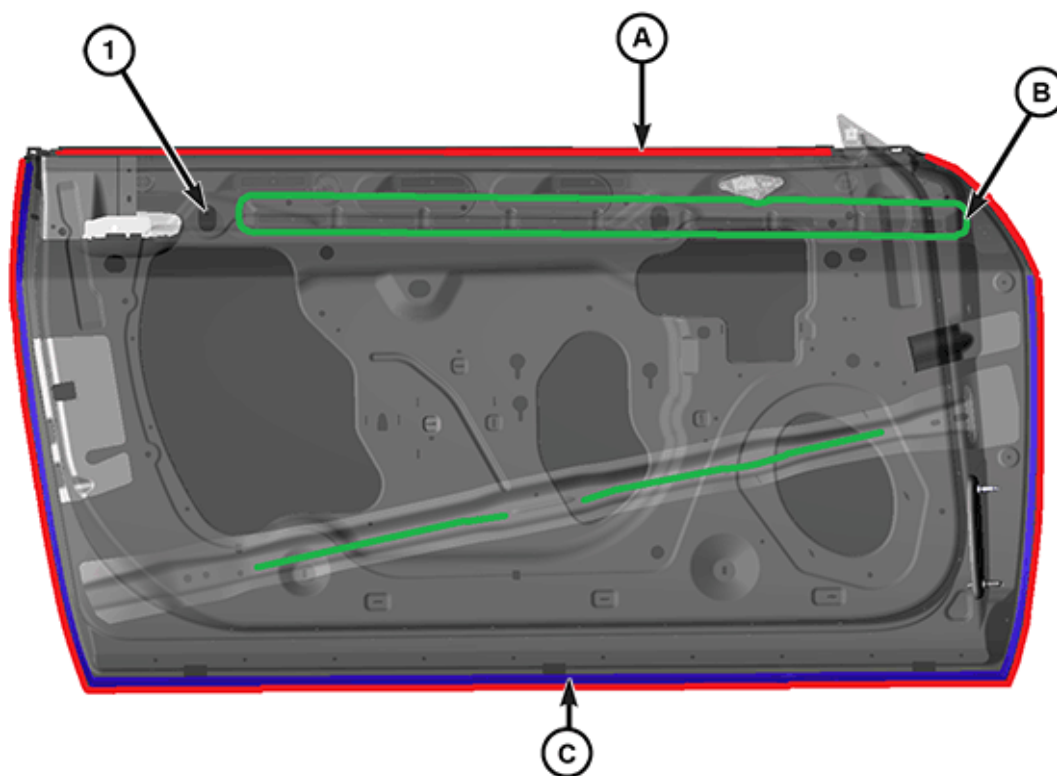
3103055440

Hood

NOTE: Inner hood panel shown semi-transparent for clarity.

NOTE: Drain holes must remain clear of obstructions from adhesives and sealers.

- 1 - HOOD
- 2 - INNER REINFORCEMENT
- A - STRUCTURAL ADHESIVE
- B - ANTI-FLUTTER ADHESIVE
- C - SEAM SEALER



Front Door

3103055441

NOTE: Inner door panel shown semi-transparent for clarity.

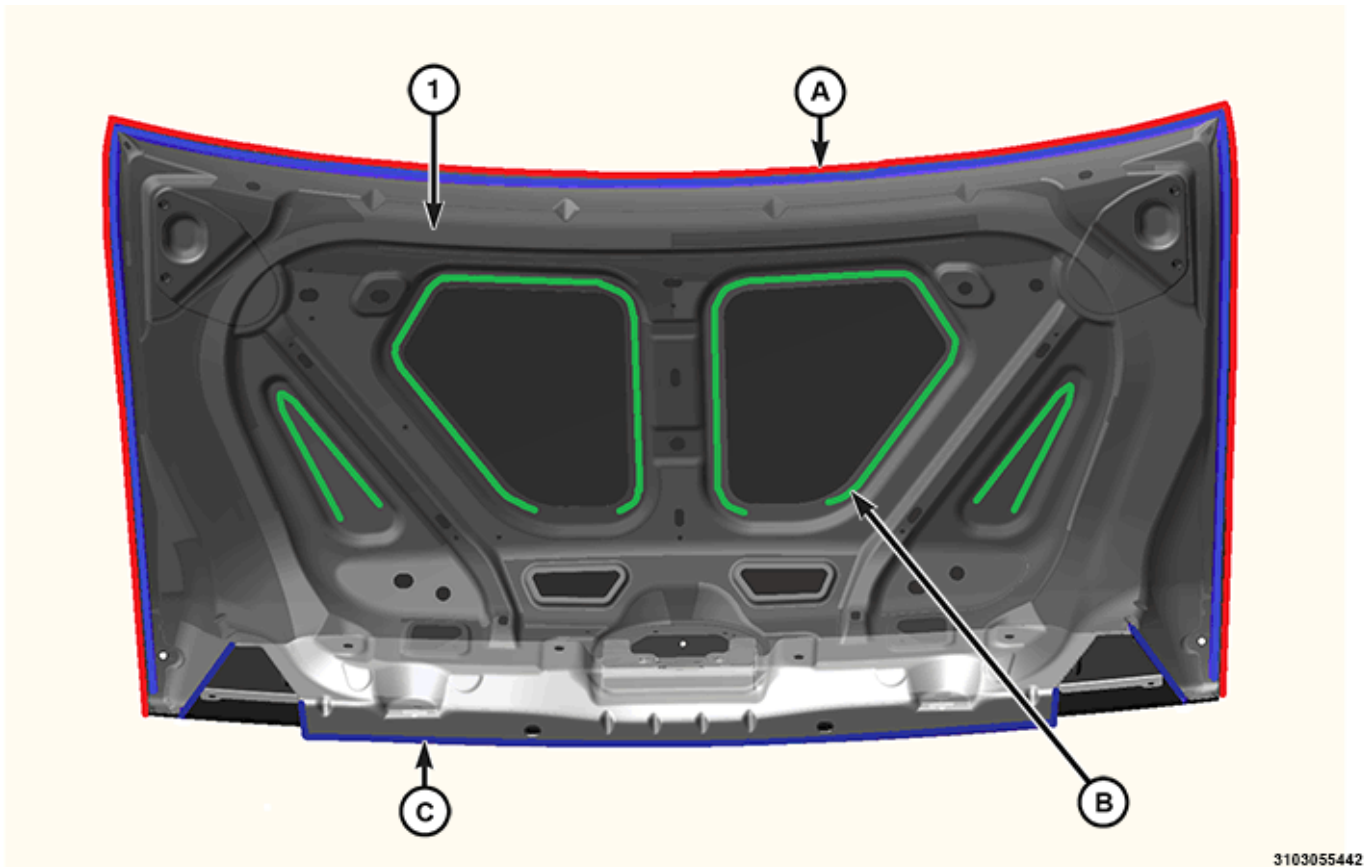
NOTE: Drain holes must remain clear of obstructions from adhesives and sealers.

1 - FRONT DOOR

A - STRUCTURAL ADHESIVE

B - ANTI-FLUTTER ADHESIVE

C - SEAM SEALER



Decklid

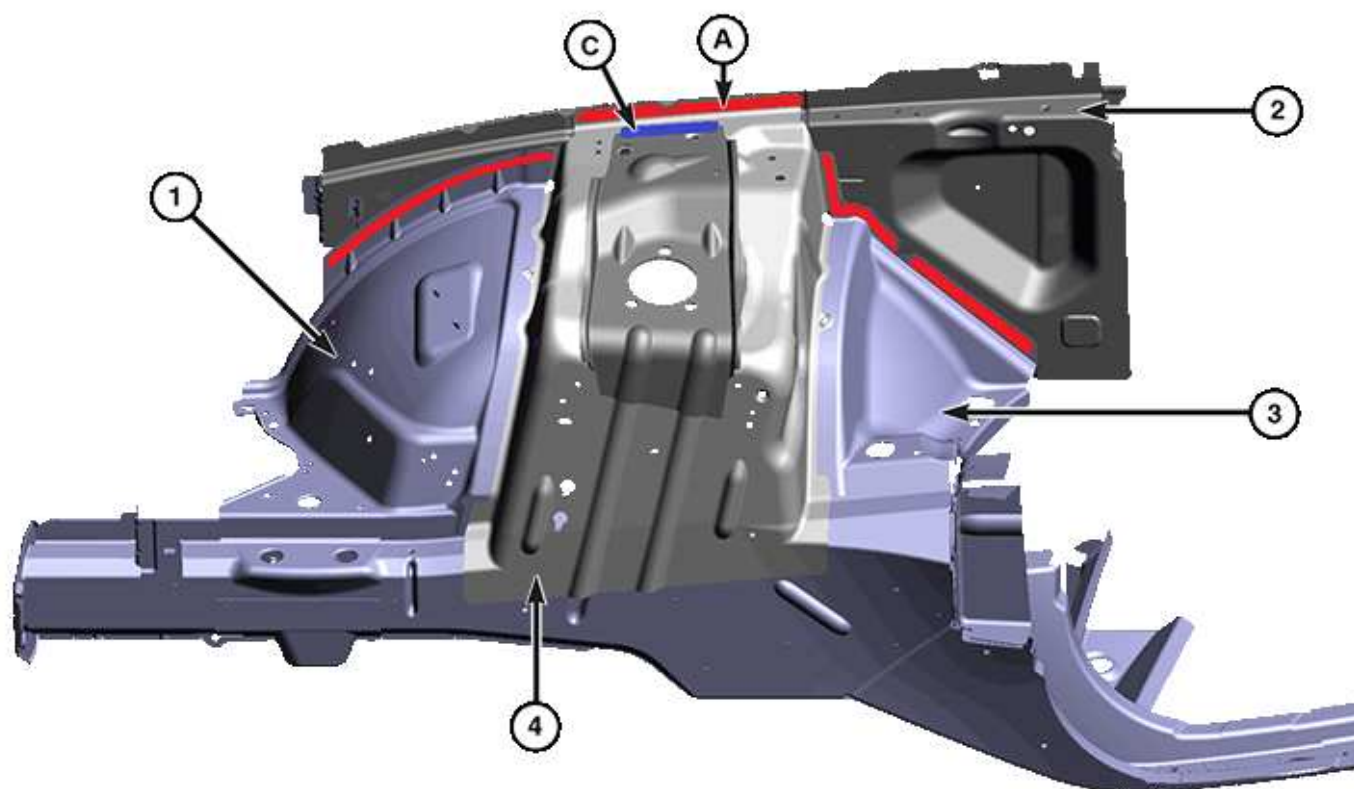
NOTE: Drain holes must remain clear of obstruction from adhesives and sealers

1 - DECKLID

A - STRUCTURAL ADHESIVE

B - ANTI-FLUTTER ADHESIVE

C - SEAM SEALER

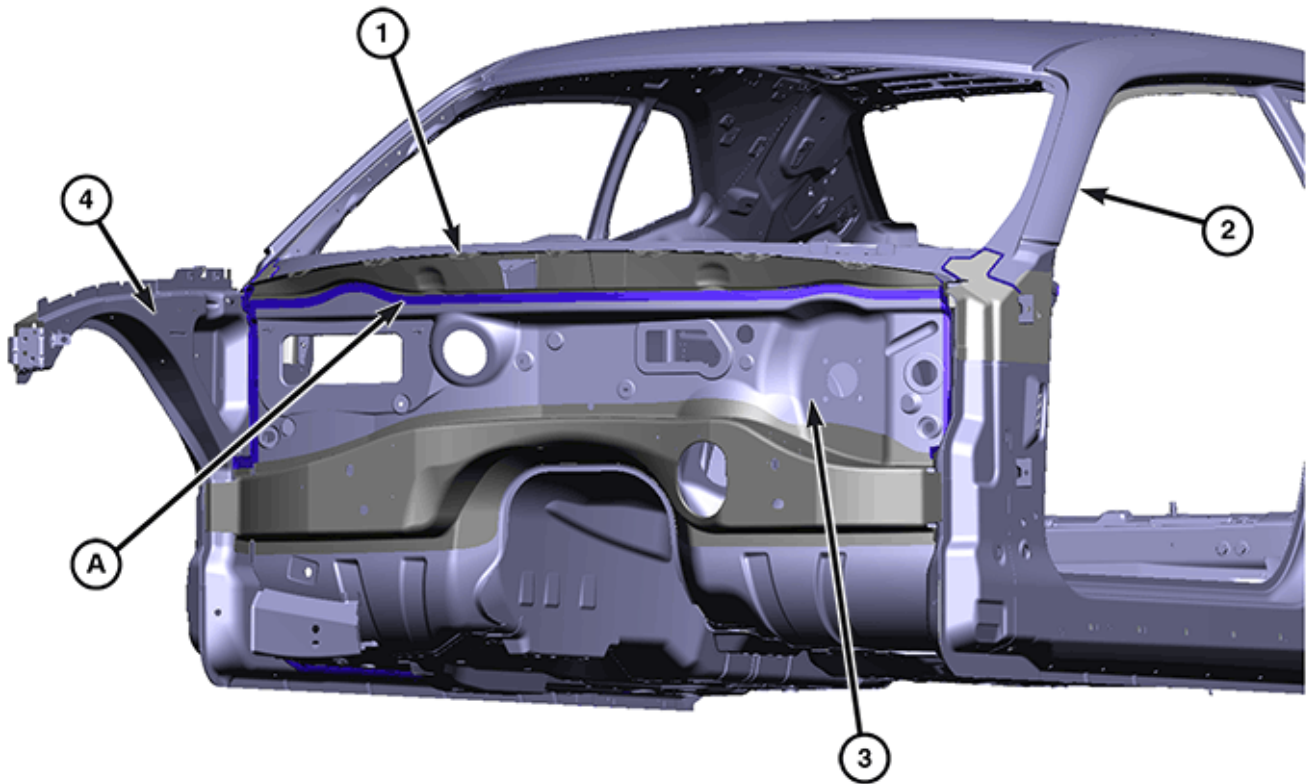


3103055447

Strut Tower

NOTE: Right side shown, left side similar.

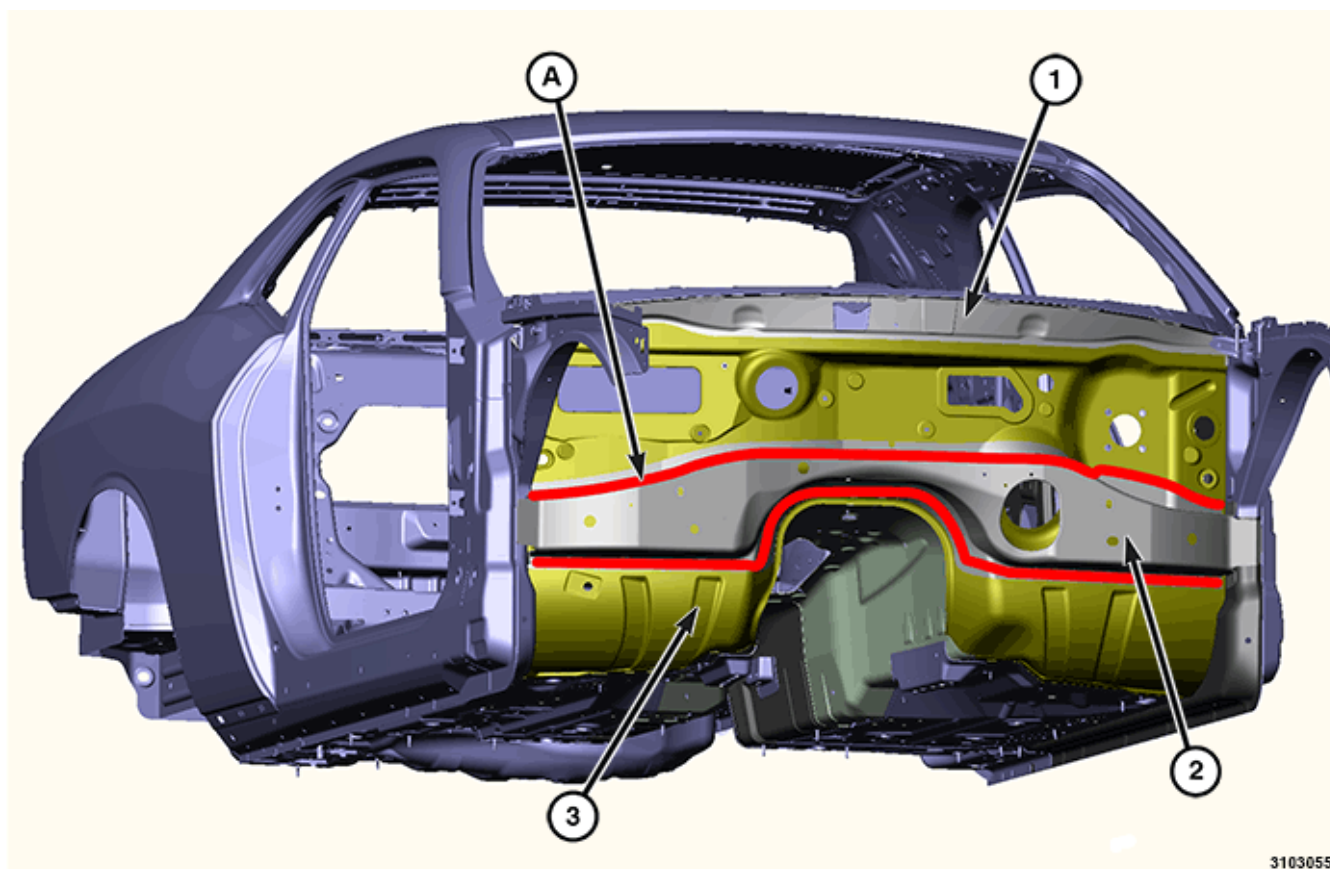
- 1 - FRONT WHEELHOUSE (FRONT)
- 2 - UPPER LOAD PATH BEAM
- 3 - FRONT WHEELHOUSE (REAR)
- 4 - STRUT TOWER
- A - STRUCTURAL ADHESIVE
- C - SEAM SEALER



3103055446

Cowl / Dash

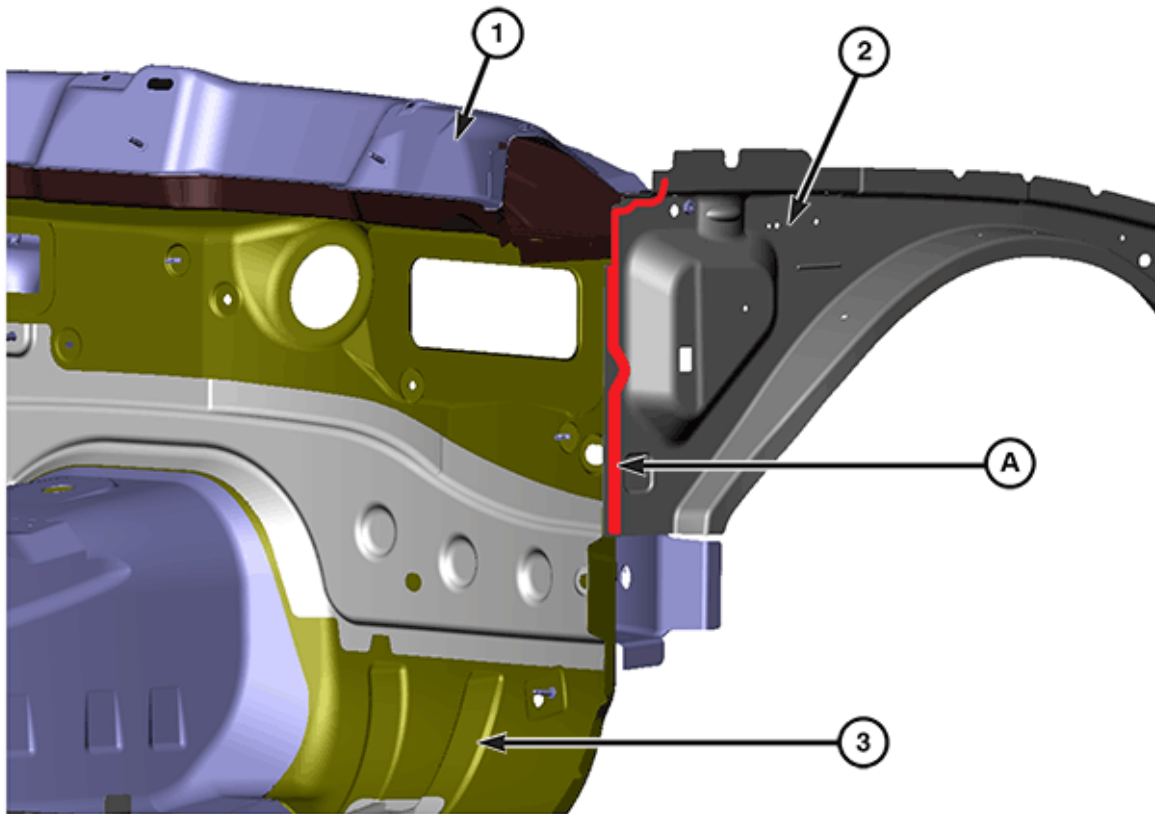
- 1 - COWL PLENUM UPPER PANEL
- 2 - FRONT BODY SIDE APERTURE
- 3 - DASH PANEL
- 4 - INNER LOAD PATH BEAM
- C - SEAM SEALER



3103055452

Floor Pan Crossmember

- 1 - COWL PLENUM LOWER PANEL
- 2 - FLOOR PAN CROSSMEMBER
- 3 - DASH PANEL
- A - STRUCTURAL ADHESIVE

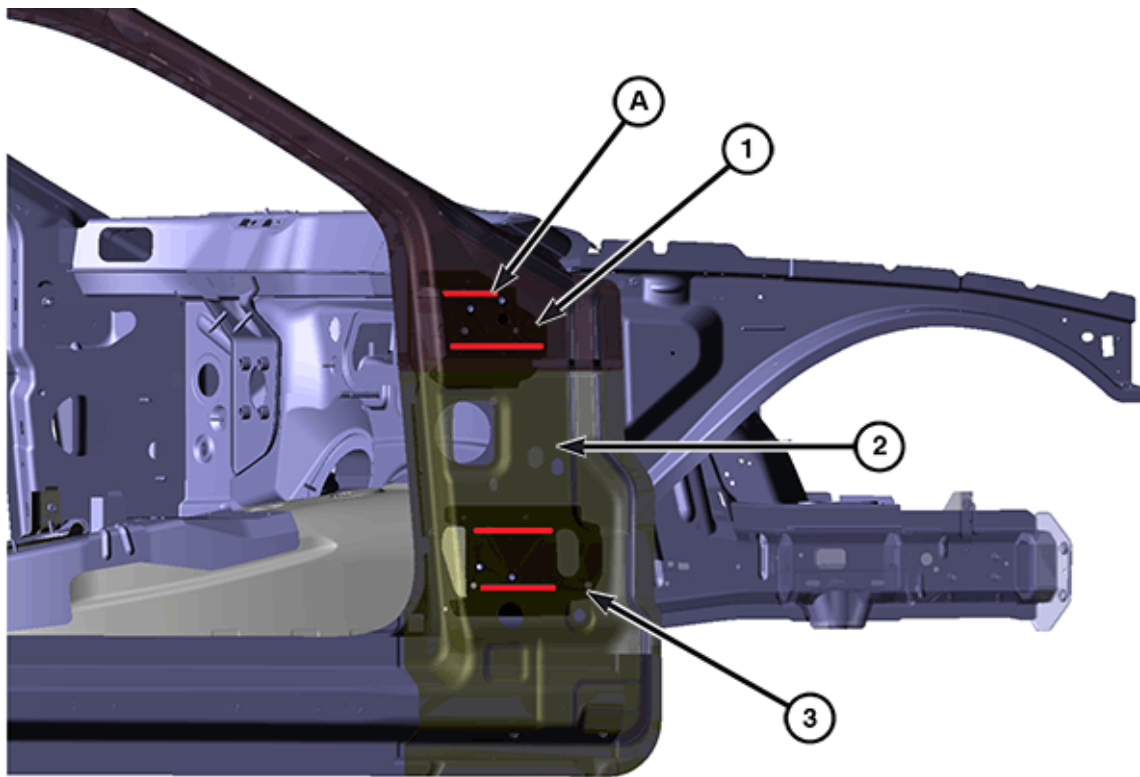


3103055454

Upper Cowl Plenum / Dash / Upper Load Path Beam

NOTE: Right side shown, left side typical.

- 1 - UPPER COWL PLENUM PANEL
- 2 - UPPER LOAD PATH BEAM (INNER)
- 3 - DASH PANEL
- A - STRUCTURAL ADHESIVE



3103055455

Door Hinge Reinforcements / A-Pillar Reinforcement

NOTE: A-pillar shown semi-transparent for clarity.

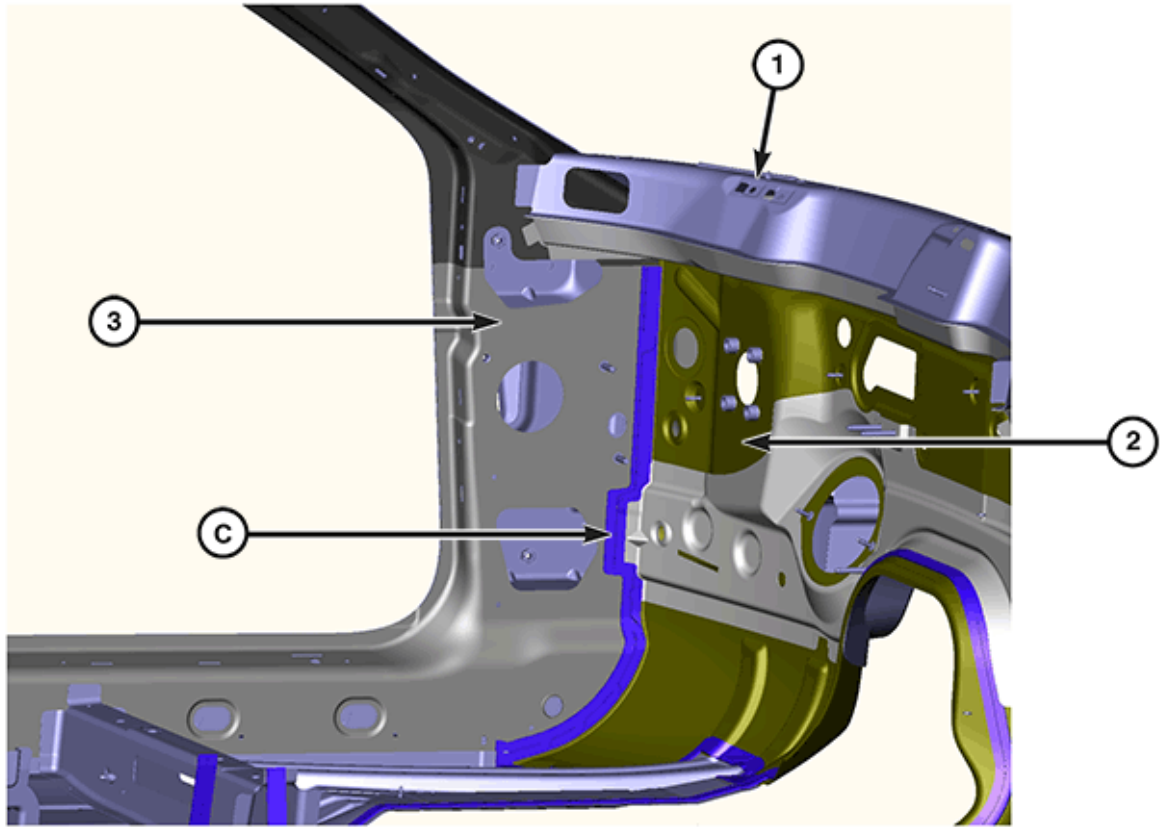
NOTE: Right side shown, left side typical.

1 - UPPER DOOR HINGE REINFORCEMENT

2 - LOWER A-PILLAR REINFORCEMENT

3- LOWER HINGE REINFORCEMENT

A - STRUCTURAL ADHESIVE

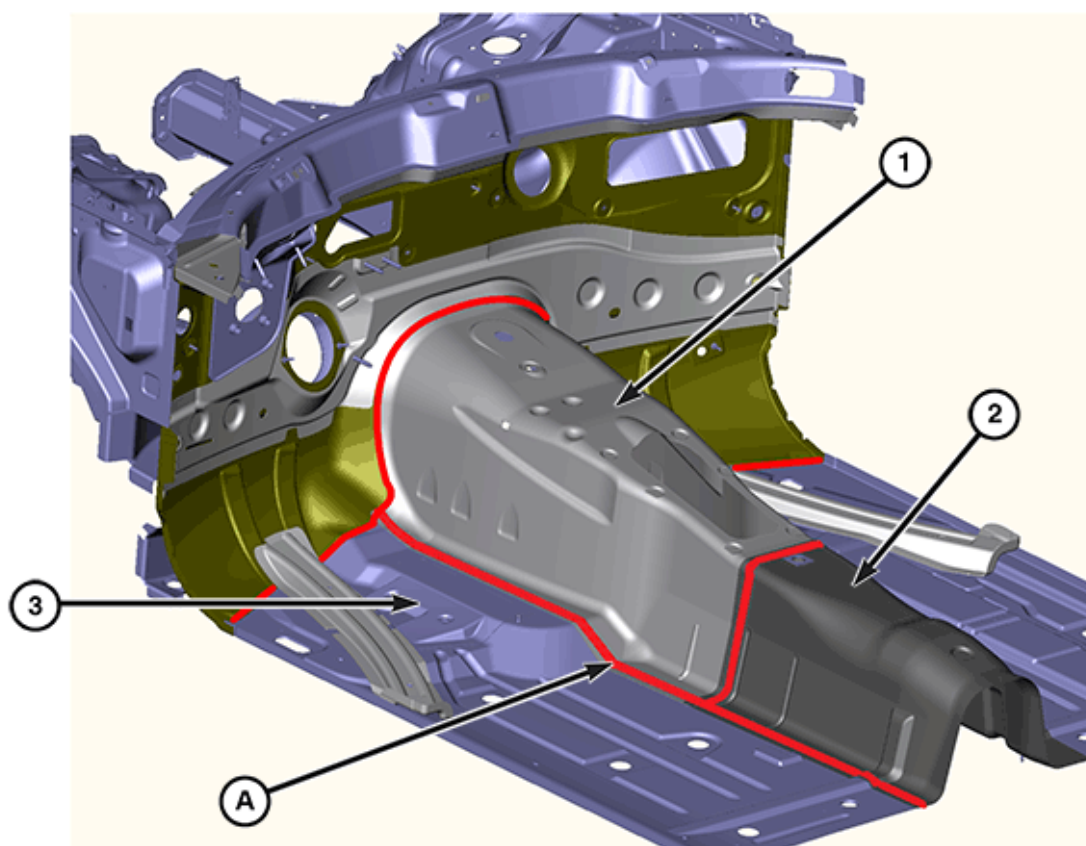


3103055448

Dash / Inner Body Side Aperture Reinforcement

NOTE: Left side shown, right side typical

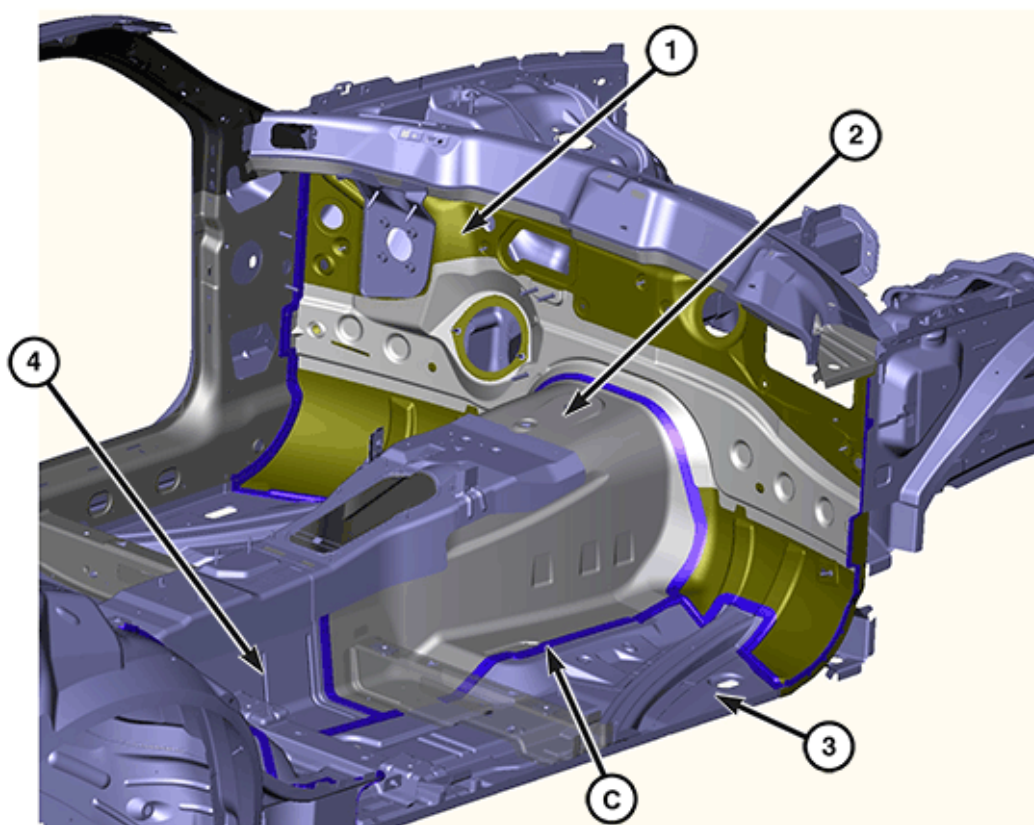
- 1- UPPER COWL PLENUM PANEL
- 2 - DASH PANEL
- 3 - INNER BODY SIDE APERTURE REINFORCEMENT
- C - SEAM SEALER



3103055450

Dash / Front Floor / Tunnel (1 of 2)

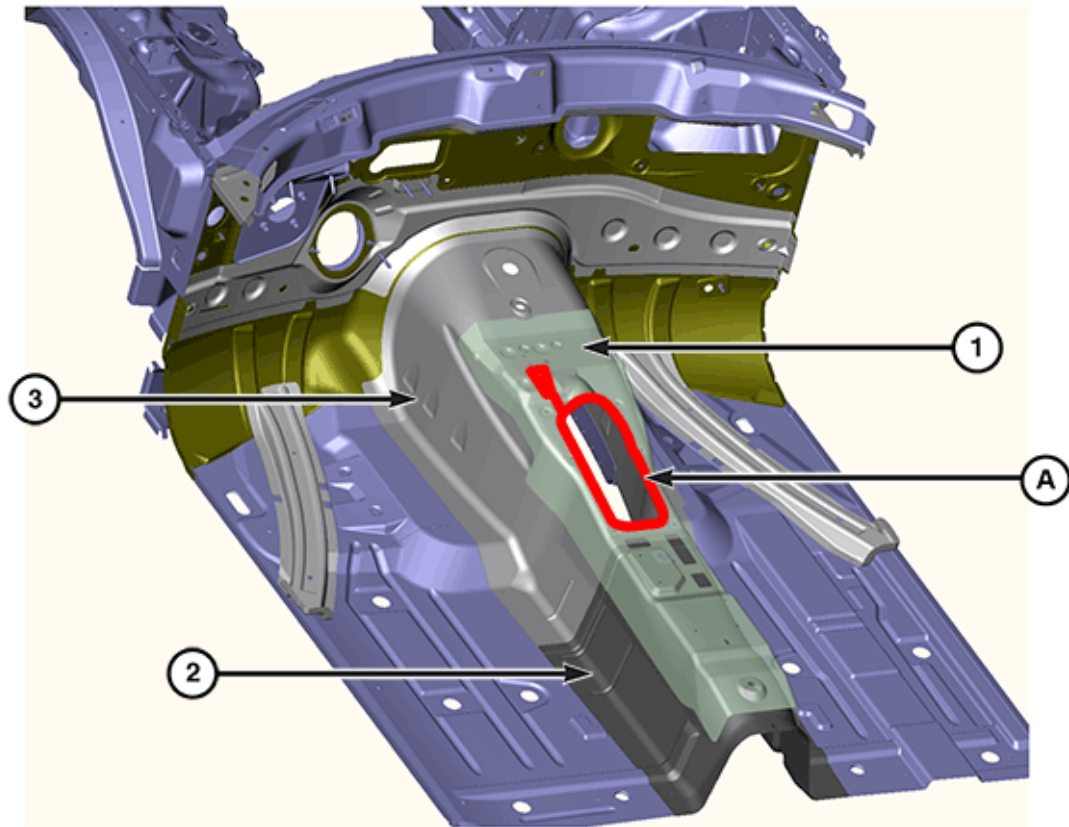
- 1- TUNNEL
- 2 - TUNNEL EXTENSION
- 3 - FRONT FLOOR PANEL
- A - STRUCTURAL ADHESIVE



3103055449

Dash / Front Floor / Tunnel (2 of 2)

- 1- DASH PANEL
- 2 - TUNNEL
- 3 - FRONT FLOOR
- 4 - TUNNEL EXTENSION
- C - SEAM SEALER

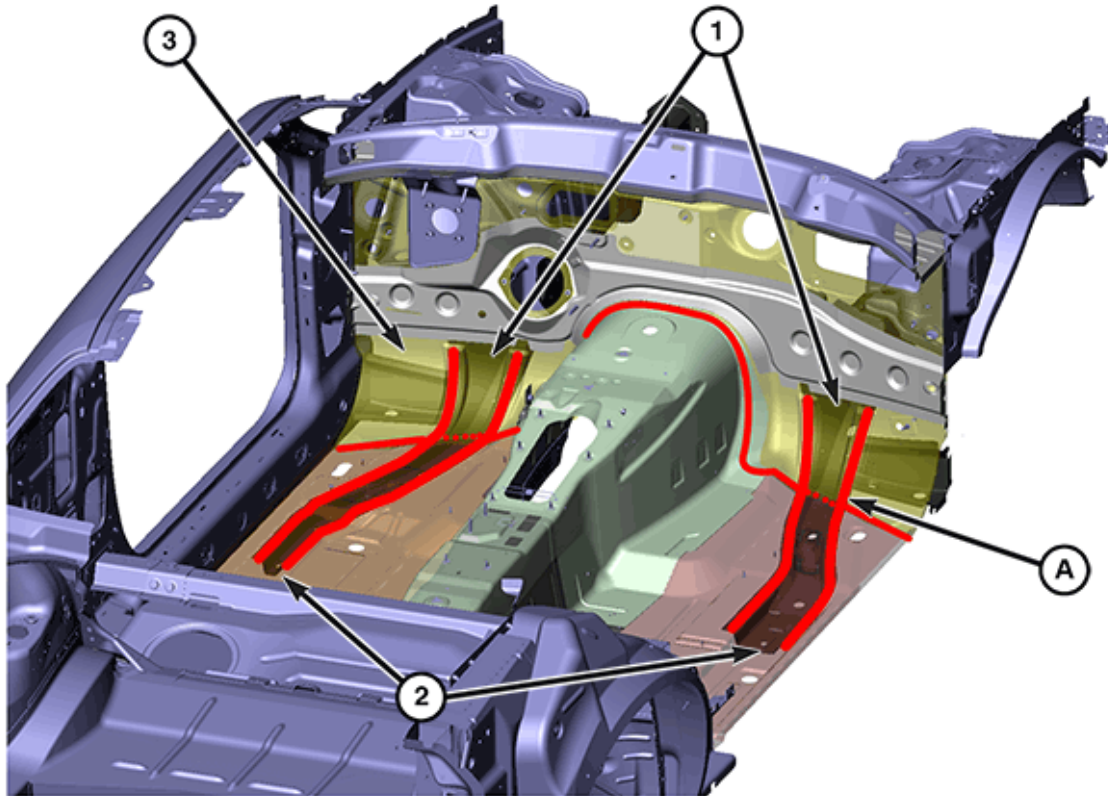


3103055451

Tunnel Reinforcement

NOTE: Tunnel reinforcement (1) is semi-transparent for clarity

- 1 - TUNNEL REINFORCEMENT
- 2 - TUNNEL EXTENSION
- 3 - TUNNEL
- A - STRUCTURAL ADHESIVE

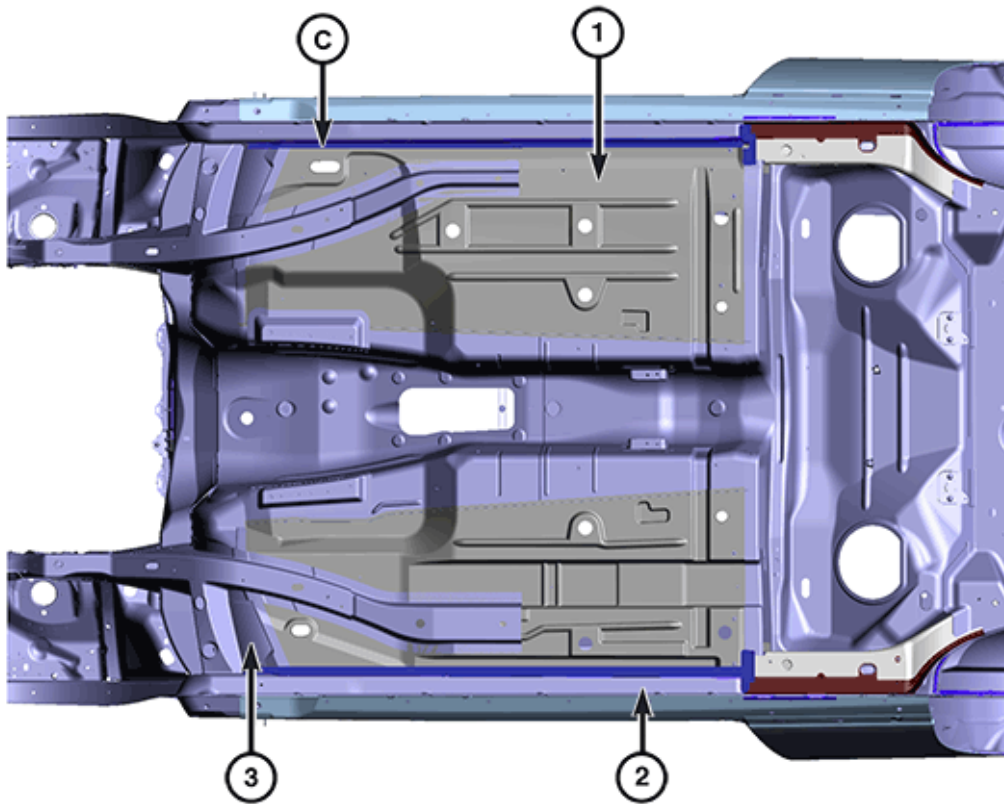


3103055453

Front Rail Extension / Rail Extension Doubler

NOTE: Dash panel (3) is semi-transparent for clarity

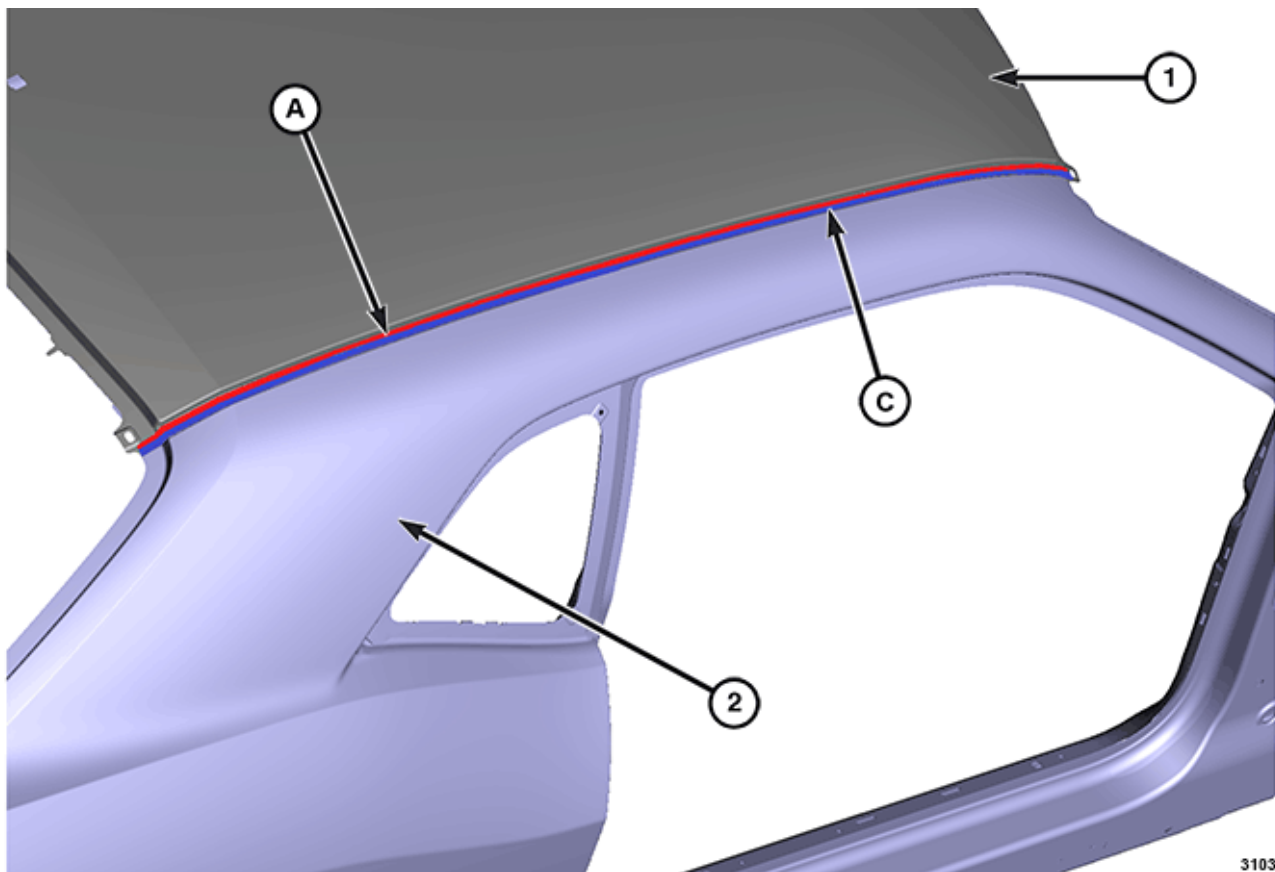
- 1 - FRONT RAIL EXTENSION
- 2 - RAIL EXTENSION DOUBLER
- 3 - DASH PANEL
- A - STRUCTURAL ADHESIVE



3103055456

Front Floor Exterior

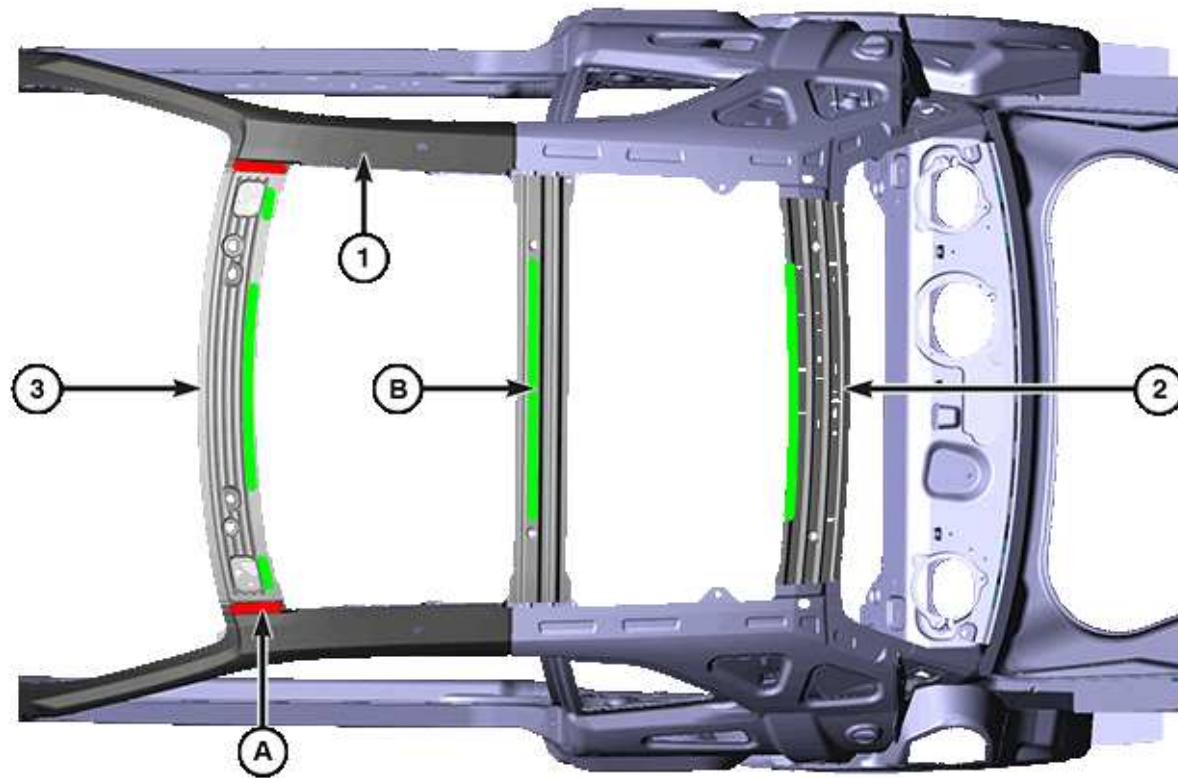
- 1 - FRONT FLOOR PAN
- 2 - INNER BODY SIDE APERTURE
- 3 - DASH PANEL
- C - SEAM SEALER



Standard Roof and Sunroof Roof

NOTE: Right side shown, left side similar.

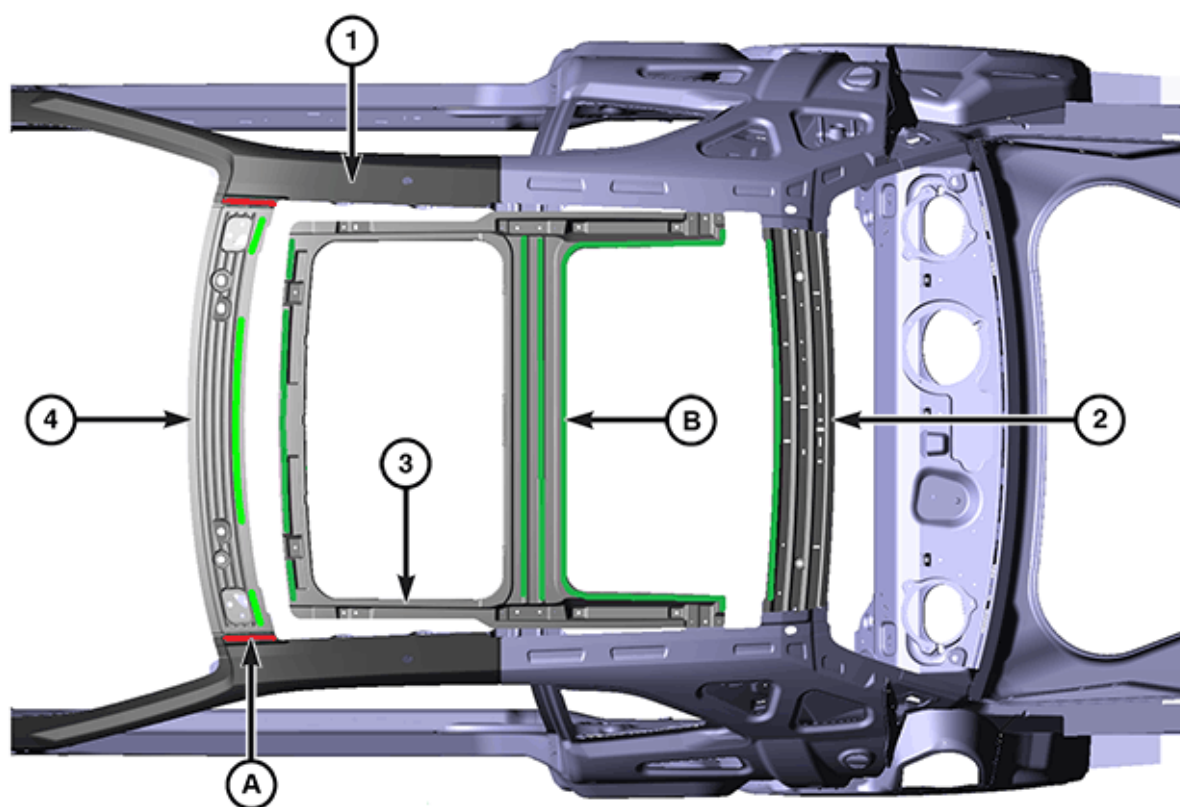
- 1 - ROOF PANEL
- 2 - BODY SIDE APERTURE
- A - STRUCTURAL ADHESIVE
- C - SEAM SEALER



3103055445

Standard Roof

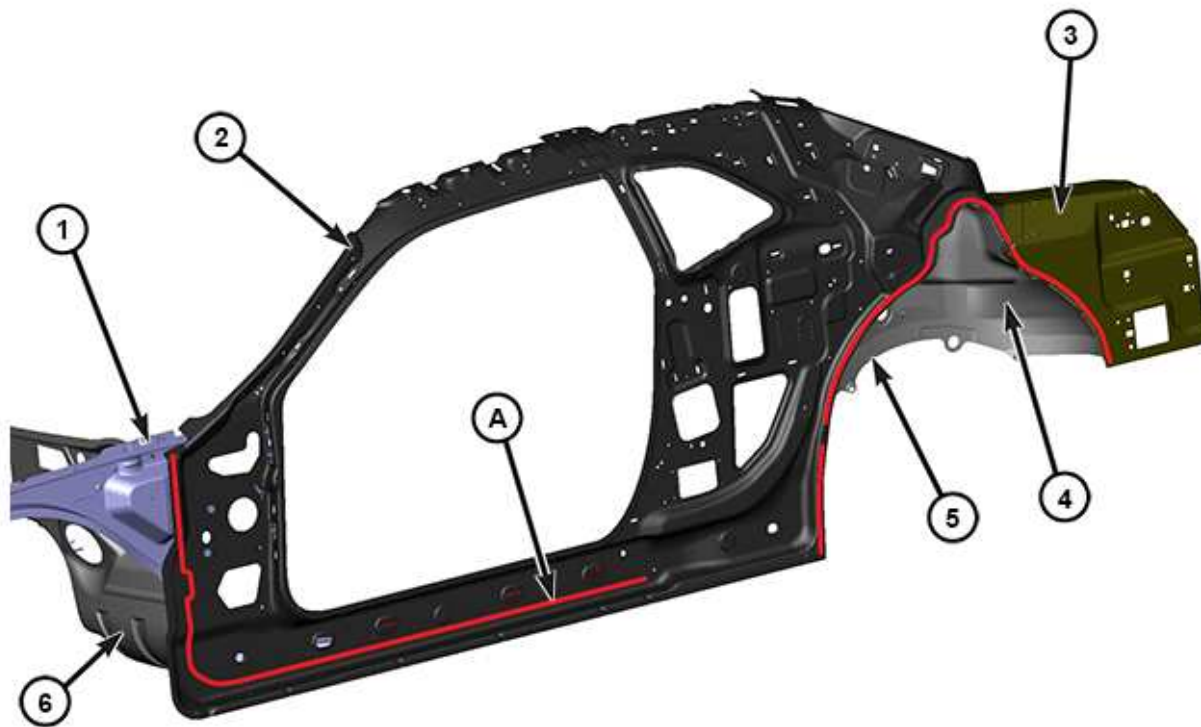
- 1 - A-PILLAR REINFORCEMENT
- 2 - REAR ROOF HEADER
- 3 - FRONT ROOF HEADER
- A - STRUCTURAL ADHESIVE
- B - ANTI-FLUTTER ADHESIVE



3103055444

Sunroof Roof

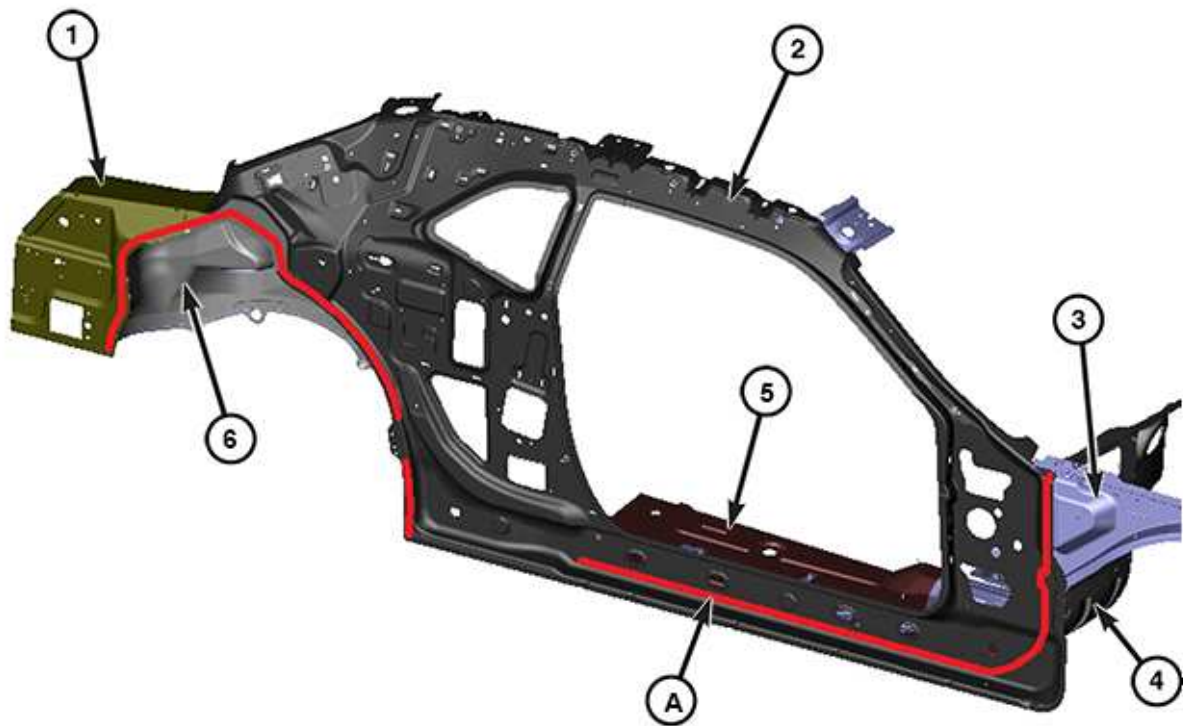
- 1 - A-PILLAR REINFORCEMENT
- 2 - REAR ROOF HEADER
- 3 - SUNROOF REINFORCEMENT
- 4 - FRONT ROOF HEADER
- A - STRUCTURAL ADHESIVE
- B - ANTI-FLUTTER ADHESIVE



310305547D

Left Inner Body Side Aperture

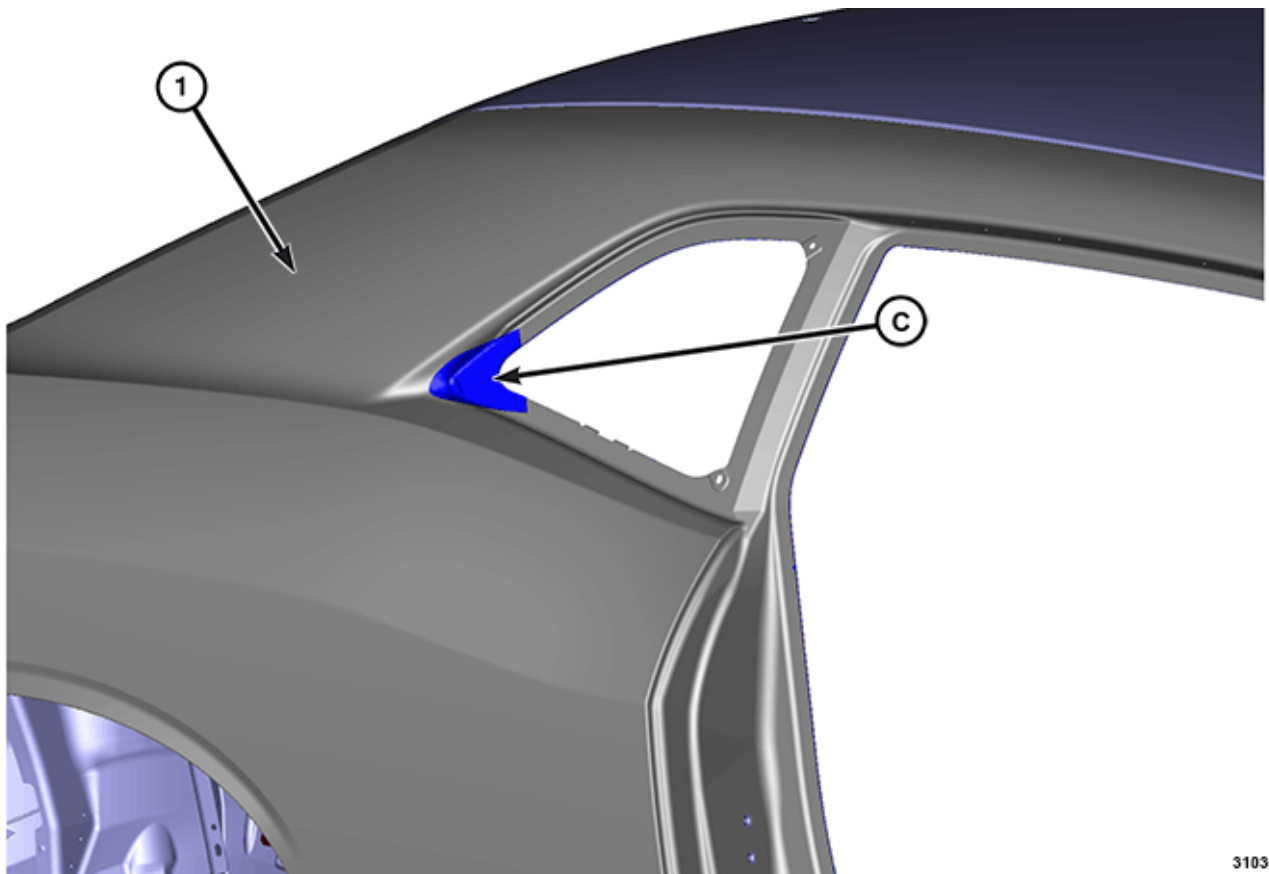
- 1 - UPPER LOAD PATH BEAM
- 2 - INNER BODY SIDE APERTURE
- 3 - QUARTER TO FLOOR PAN EXTENSION
- 4 - REAR INNER WHEELHOUSE
- 5 - REAR RAIL COVER PLATE
- 6 - DASH PANEL
- A - STRUCTURAL ADHESIVE



3103055468

Right Inner Body Side Aperture

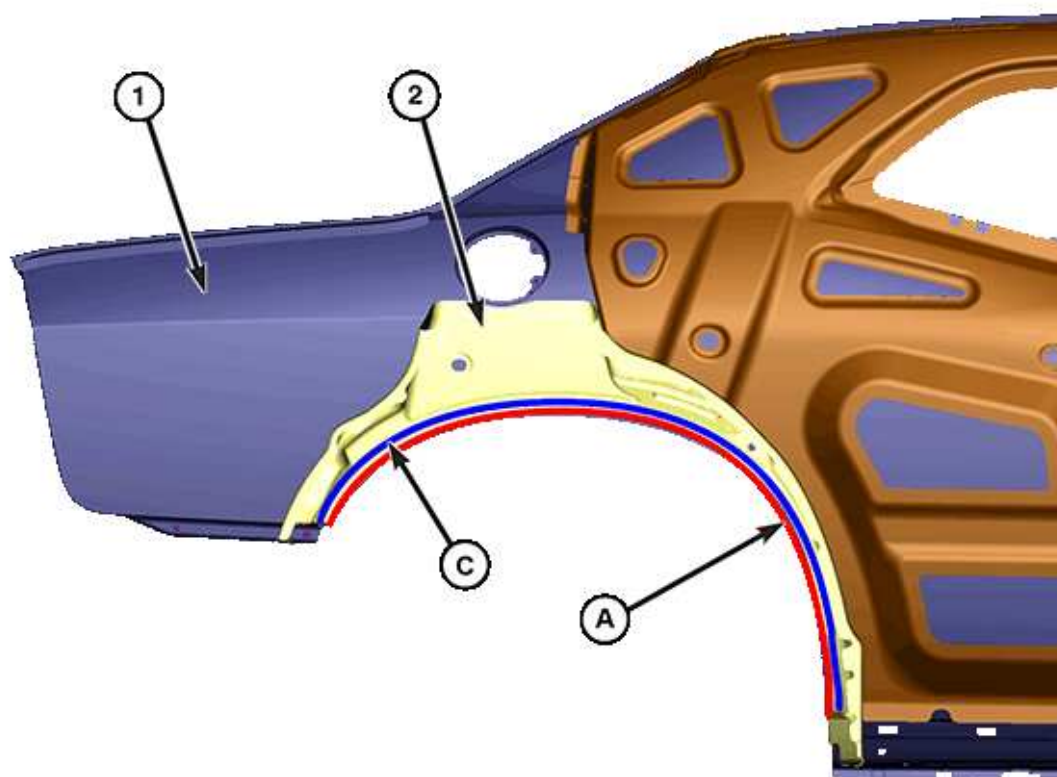
- 1 - QUARTER TO FLOOR PAN EXTENSION
- 2 - INNER BODY SIDE APERTURE
- 3 - UPPER LOAD PATH BEAM
- 4 - DASH PANEL
- 5 - FRONT FLOOR PAN
- 6 - REAR INNER WHEELHOUSE
- A - STRUCTURAL ADHESIVE



3103055458

Quarter Panel Glass Opening

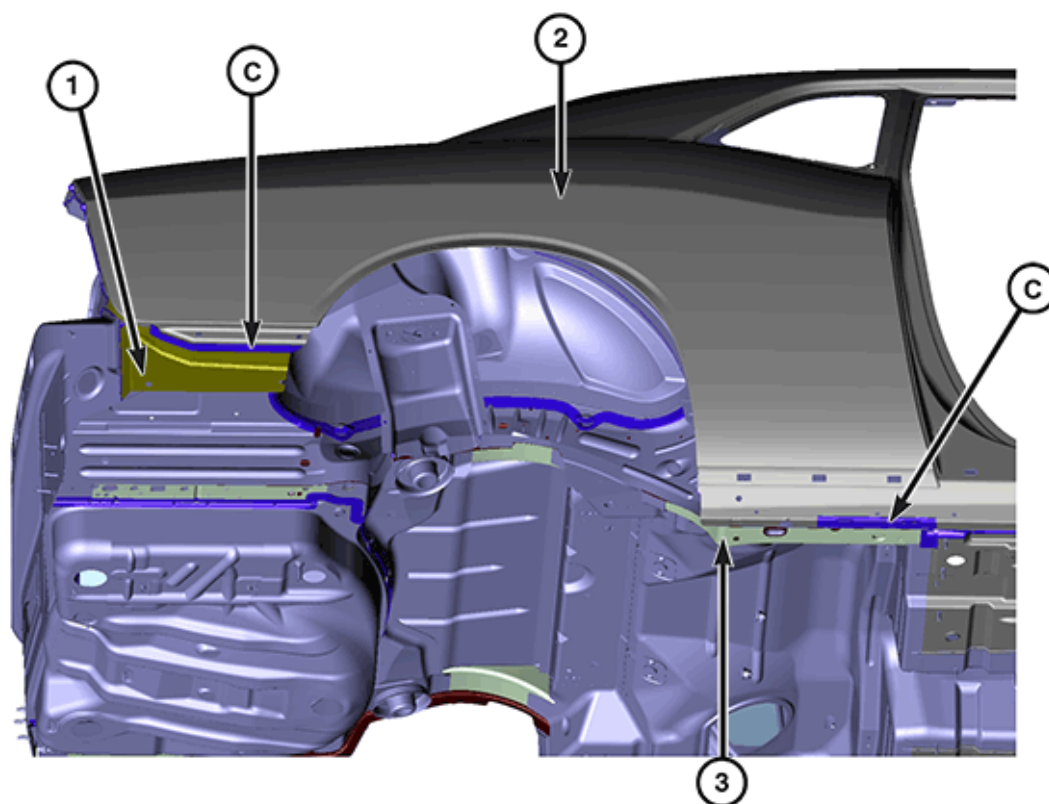
- 1 - REAR BODY SIDE APERTURE PANEL
- C - SEALER (TAPE)



3103055462

Rear Body Side Aperture / Outer Wheelhouse

- 1 - OUTER BODY SIDE APERTURE
- 2 - OUTER WHEELHOUSE
- A - STRUCTURAL ADHESIVE
- C - SEAM SEALER



3103055457

Rear Body Side Aperture / Inner Quarter Reinforcement

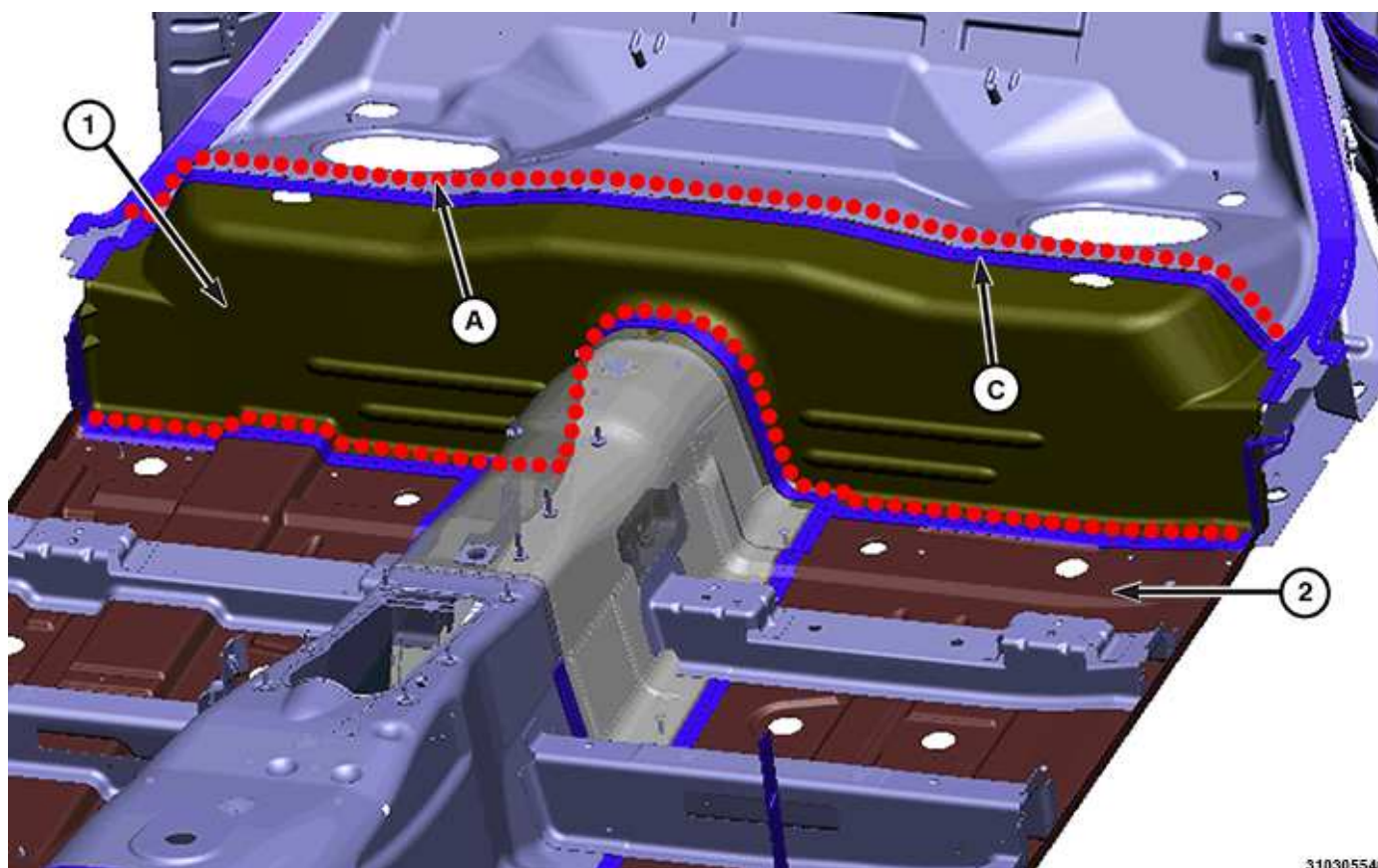
- 1 - INNER QUARTER PANEL REINFORCEMENT
- 2 - REAR BODY SIDE APERTURE
- 3 - REAR RAIL
- C - SEAM SEALER



3103055463

Inner Body Side Aperture / C-Pillar Reinforcement

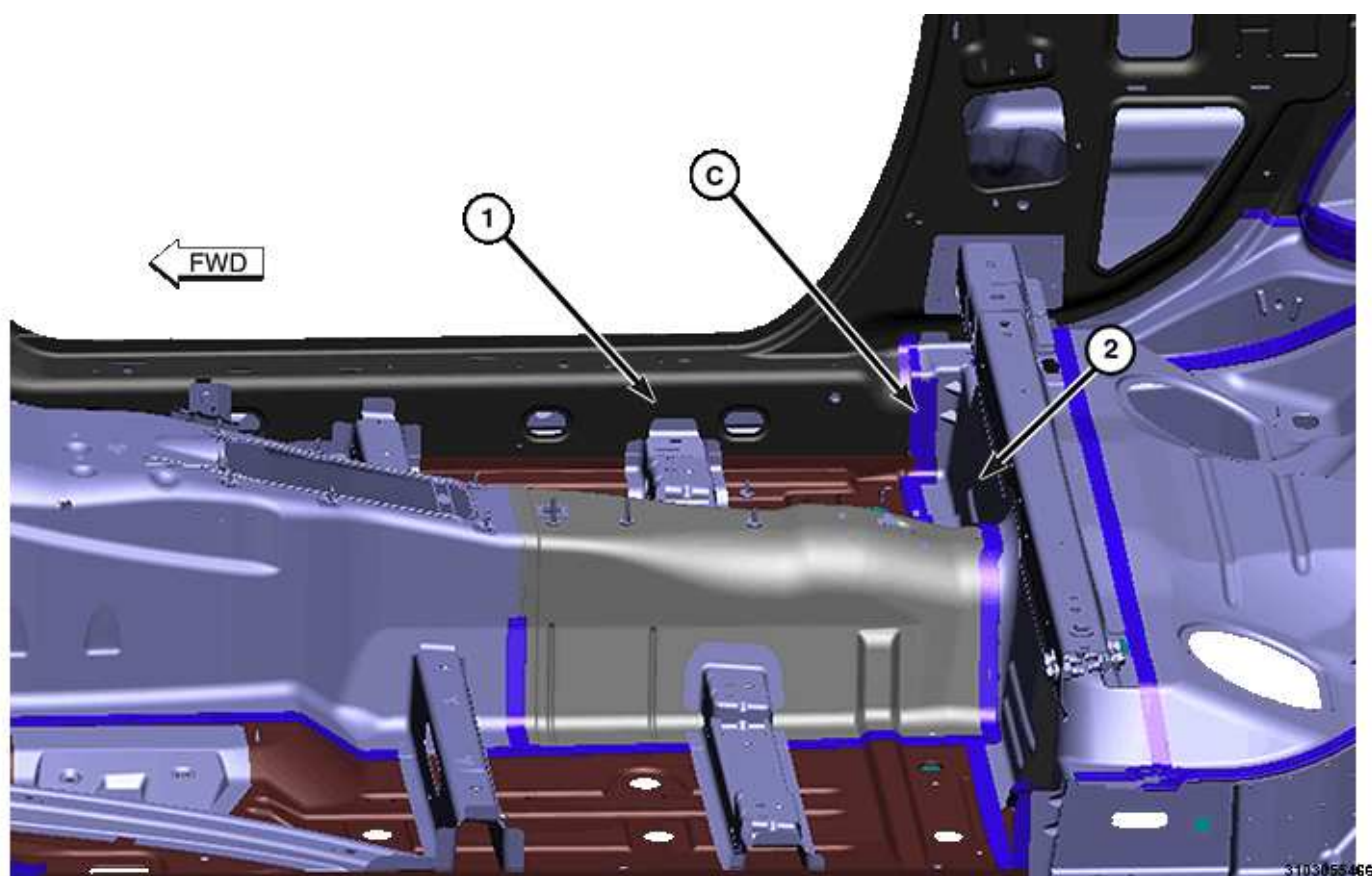
- 1 - INNER BODY SIDE APERTURE
- 2 - C-PILLAR REINFORCEMENT
- A - STRUCTURAL ADHESIVE



3103055467

Floor Pan Crossmember (1 of 2)

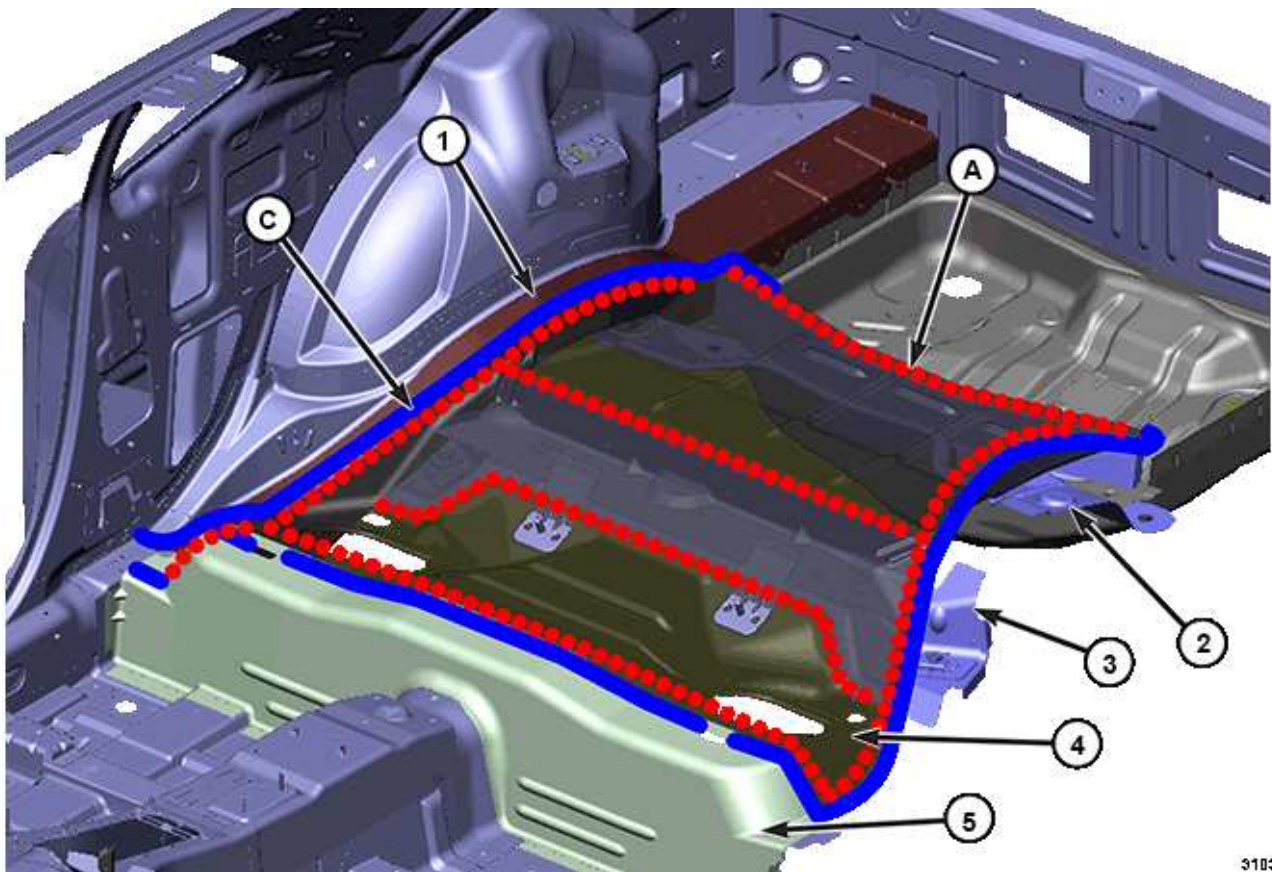
- 1 - REAR FLOOR CROSSMEMBER
- 2 - FRONT FLOOR PAN
- A- STRUCTURAL ADHESIVE
- C - SEAM SEALER



Floor Pan Crossmember (2 of 2)

NOTE: Right side shown, left side typical.

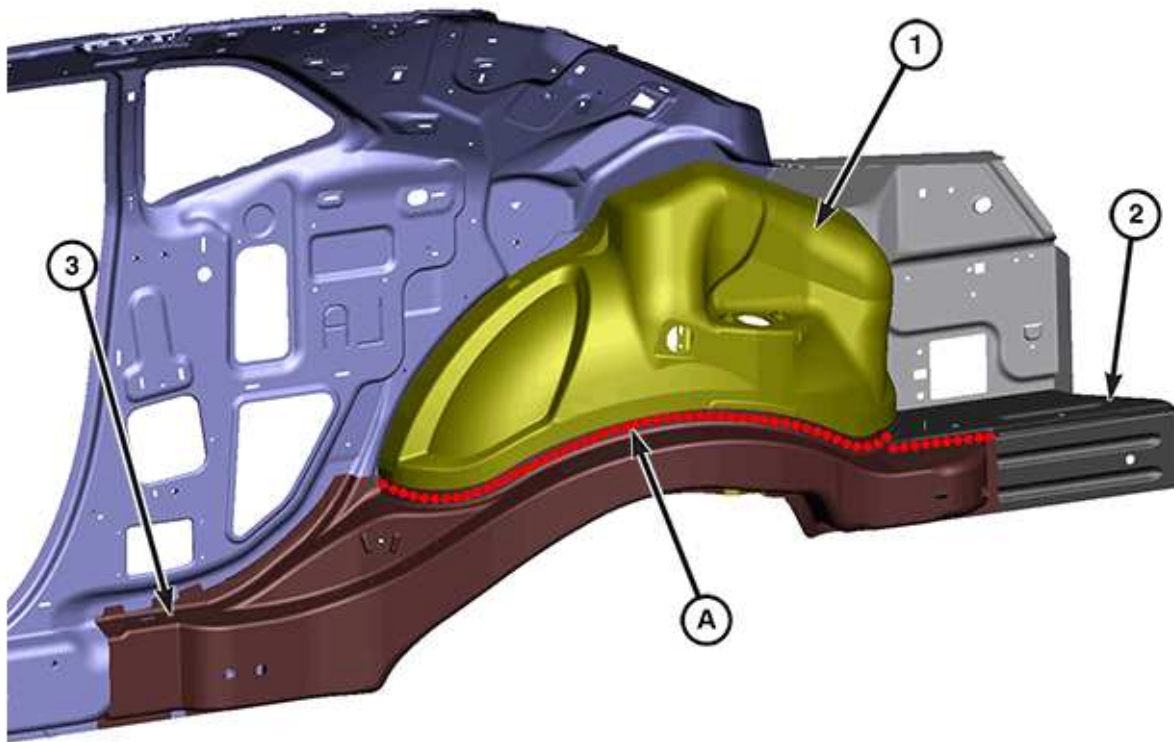
- 1 - INNER BODY SIDE APERTURE
- 2 - REAR FLOOR CROSSMEMBER
- C - SEAM SEALER



3103055471

Center Floor Pan

- 1 - REAR INNER RAIL
- 2 - REAR SUSPENSION CROSSMEMBER (REAR)
- 3 - REAR SUSPENSION CROSSMEMBER (FRONT)
- A- STRUCTURAL ADHESIVE
- C - SEAM SEALER

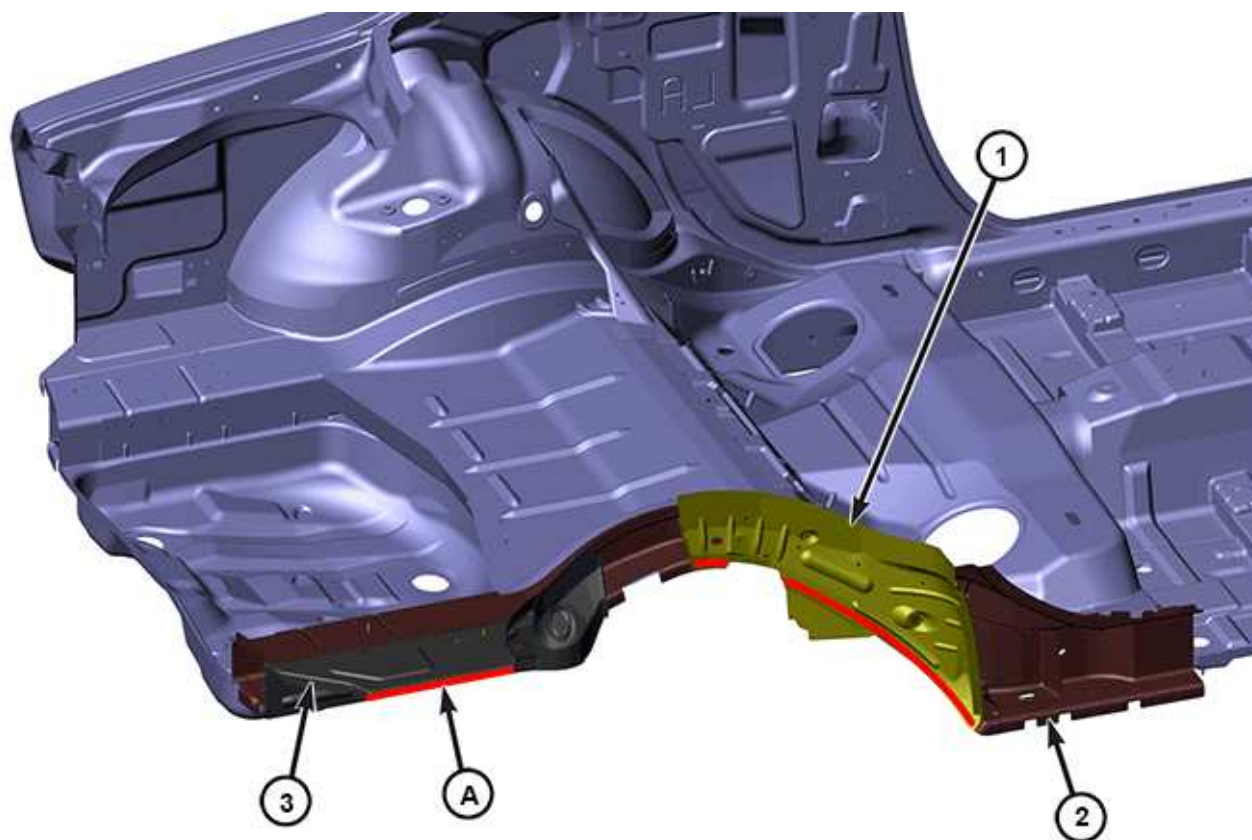


3103055476

Rear Wheelhouse

NOTE: Right side shown, left side typical.

- 1 - INNER WHEELHOUSE
- 2 - REAR RAIL COVER PLATE
- 3 - INNER REAR RAIL
- A - STRUCTURAL ADHESIVES

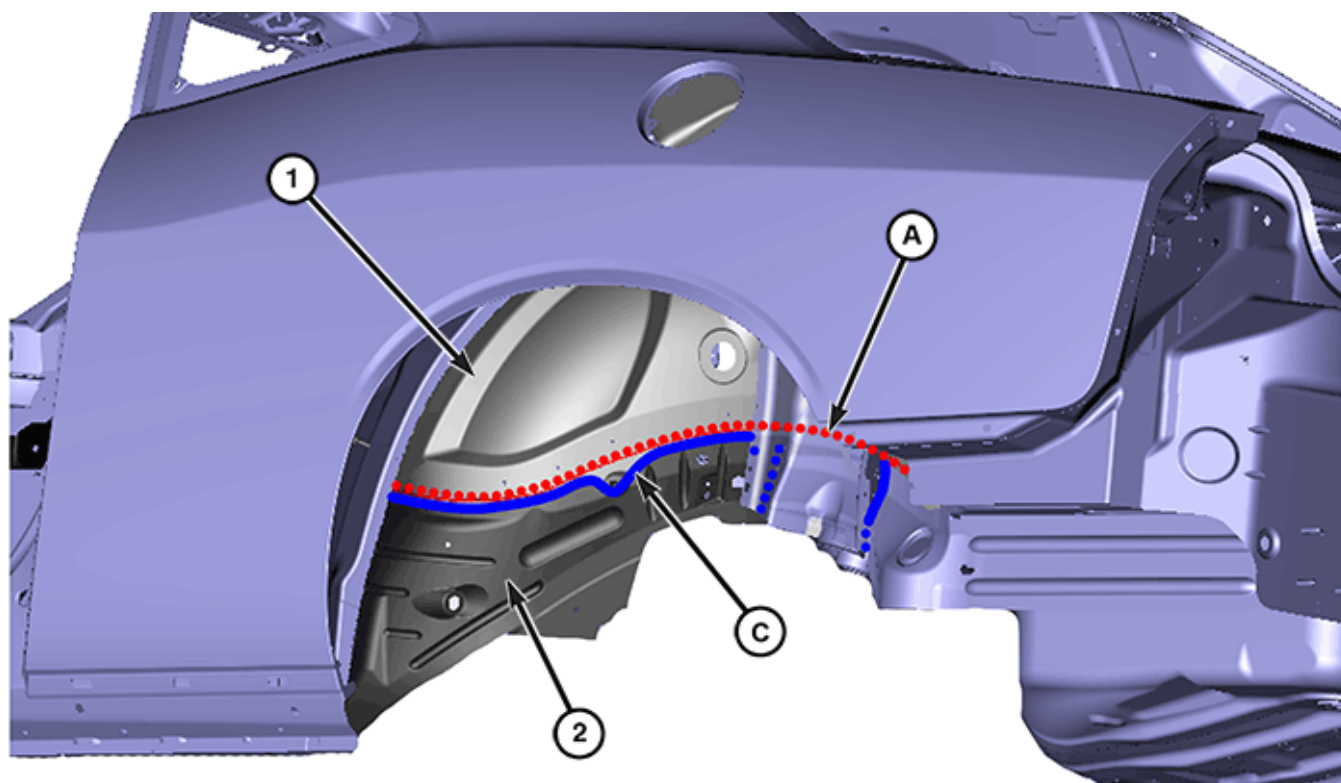


3103055477

Rear Rail

NOTE: Right side shown, left side typical.

- 1 - REAR RAIL COVER PLATE
- 2 - OUTER REAR RAIL
- 3 - REAR RAIL COVER PLATE
- A - STRUCTURAL ADHESIVES

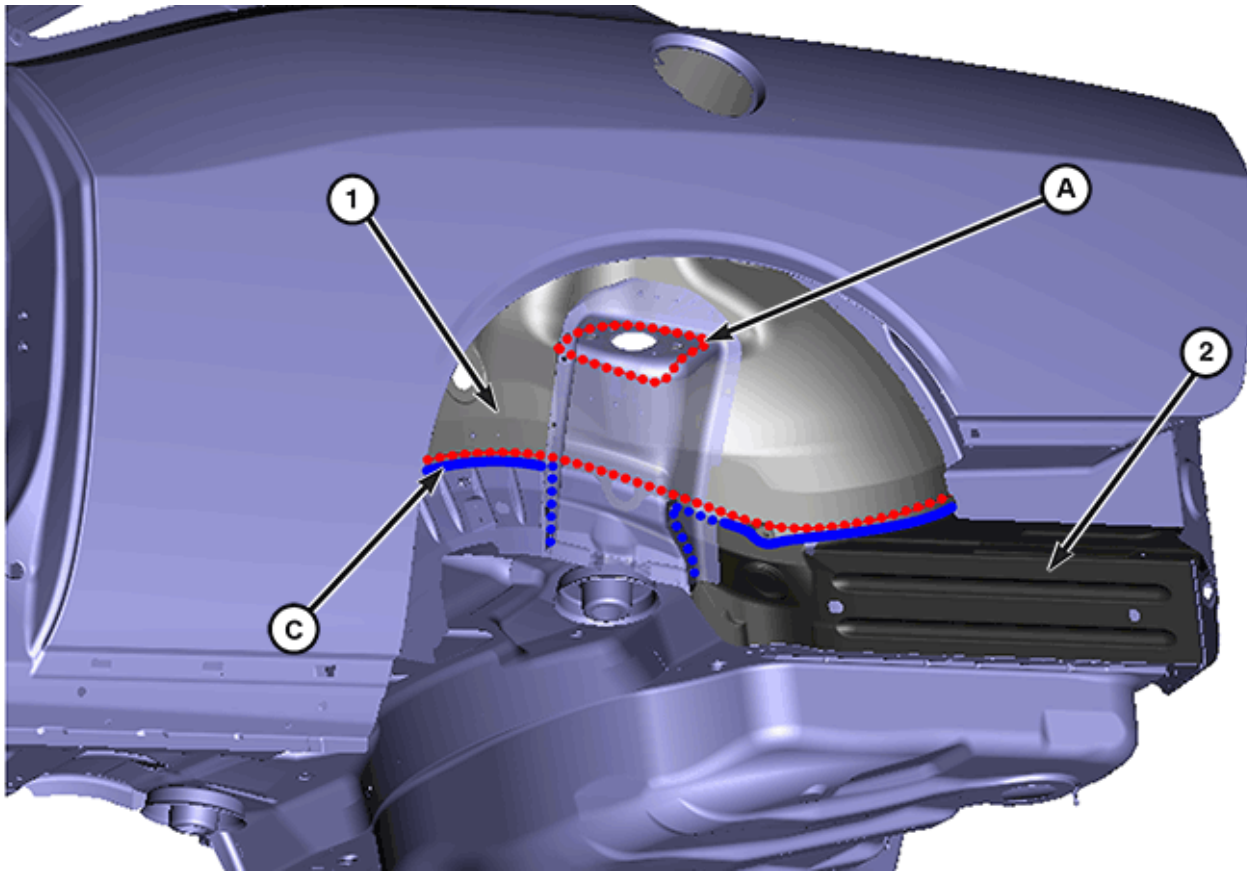


3103055463

Inner Wheelhouse (Exterior 1 of 2)

NOTE: Left side shown, right side typical.

- 1 - INNER WHEELHOUSE
- 2 - REAR RAIL
- A - STRUCTURAL ADHESIVES
- C - SEAM SEALER

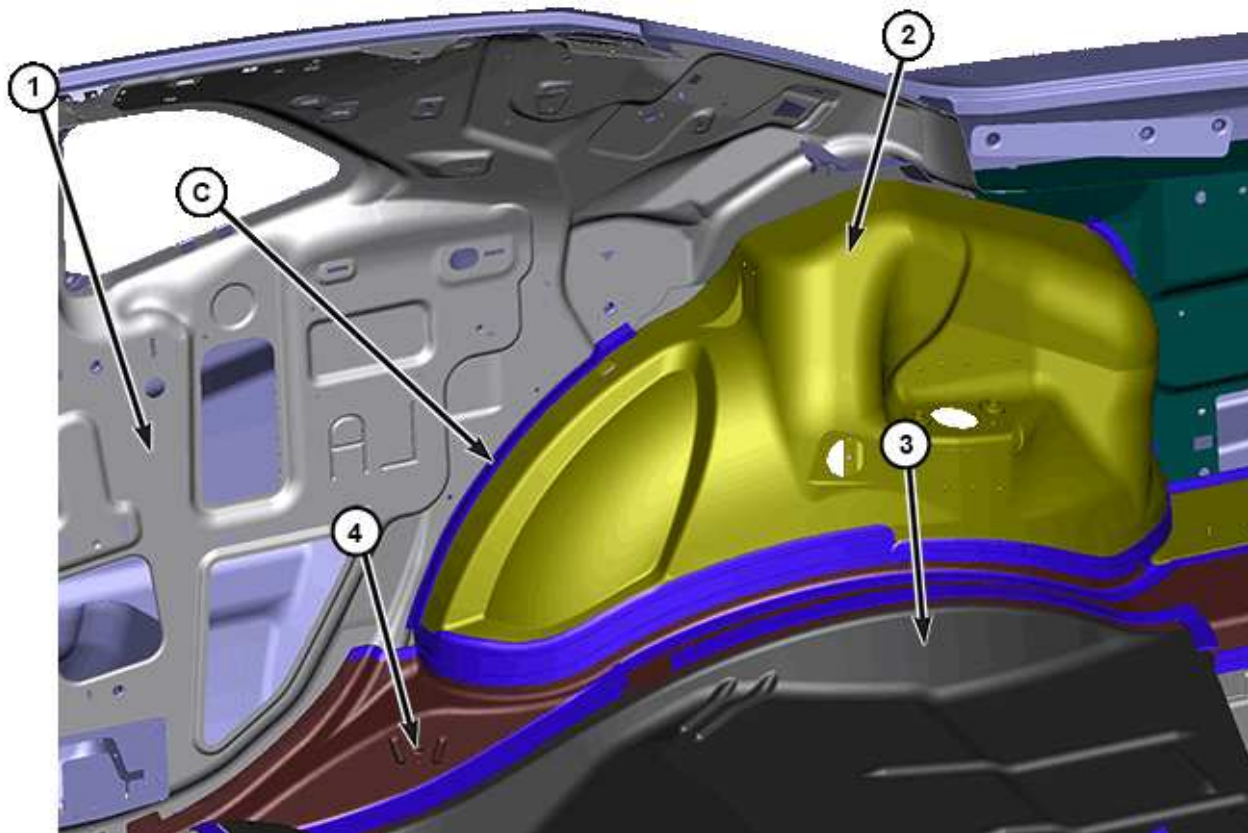


3103055464

Inner Wheelhouse (Exterior 2 of 2)

NOTE: Left side shown, right side typical.

- 1 - INNER WHEELHOUSE
- 2 - REAR RAIL
- A - STRUCTURAL ADHESIVE
- C - SEAM SEALER

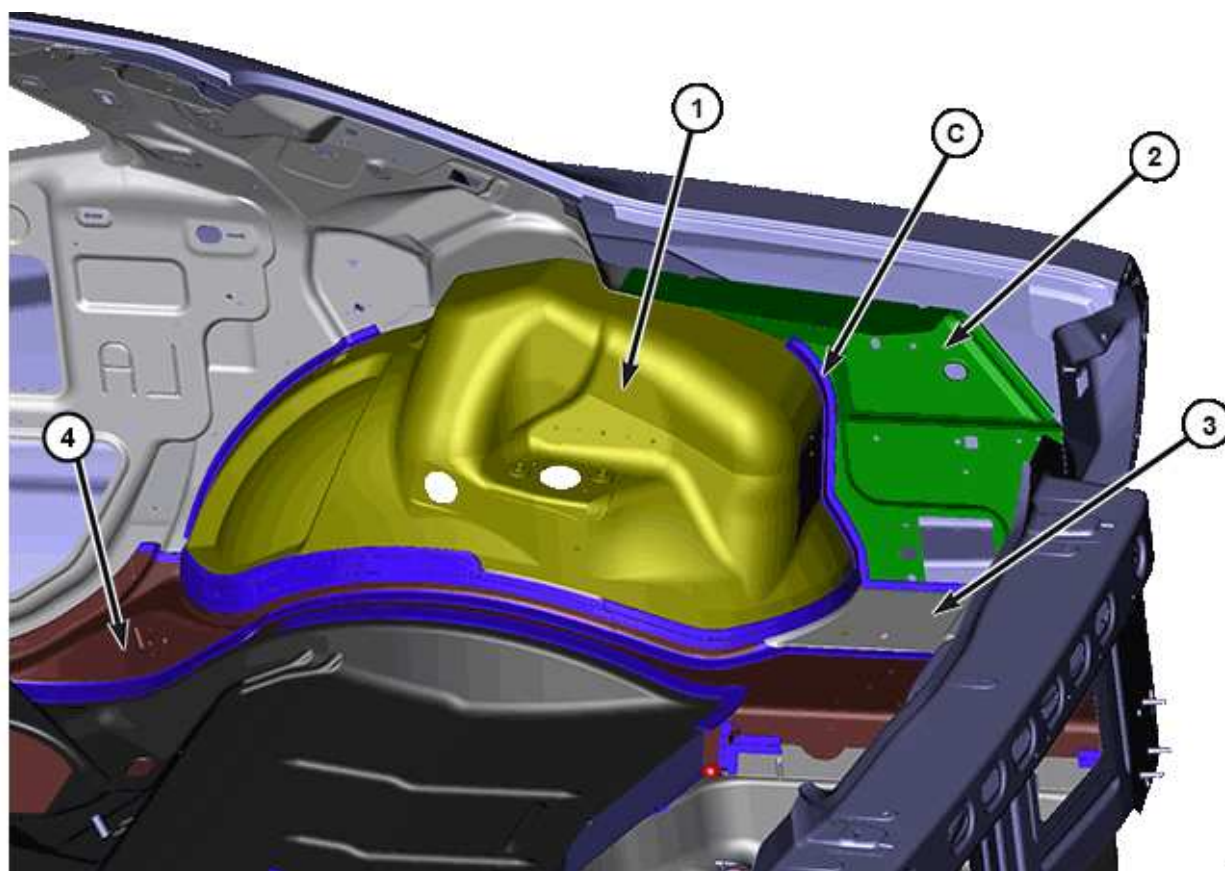


3103055472

Rear Inner Wheelhouse (1 of 2)

NOTE: Right side shown, left side typical.

- 1 - INNER BODY SIDE APERTURE
- 2 - INNER WHEELHOUSE
- 3 - INNER WHEELHOUSE
- 4 - REAR OUTER RAIL
- C - SEAM SEALER

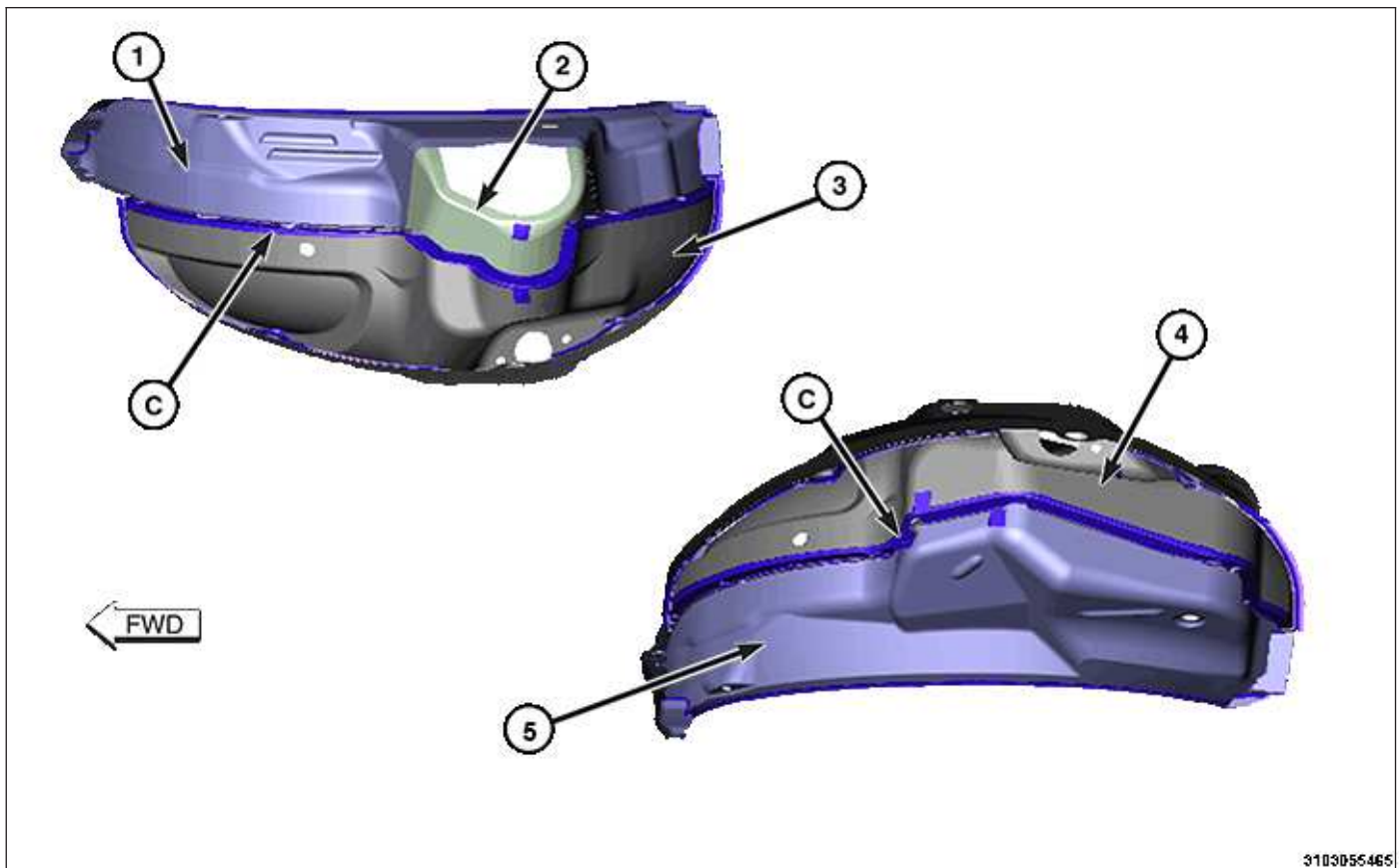


3103055473

Rear Inner Wheelhouse (2 of 2)

NOTE: Right side shown, left side typical.

- 1 - INNER WHEELHOUSE
- 2 - QUARTER TO FLOOR PAN EXTENSION
- 3 - RAIL COVER PLATE
- 4 - INNER REAR RAIL
- C - SEAM SEALER



3103055465

Inner and Outer Wheelhouses

NOTE: Completely cover inboard and outboard flange

NOTE: Completely cover air vent holes

1 - LEFT OUTER WHEELHOUSE

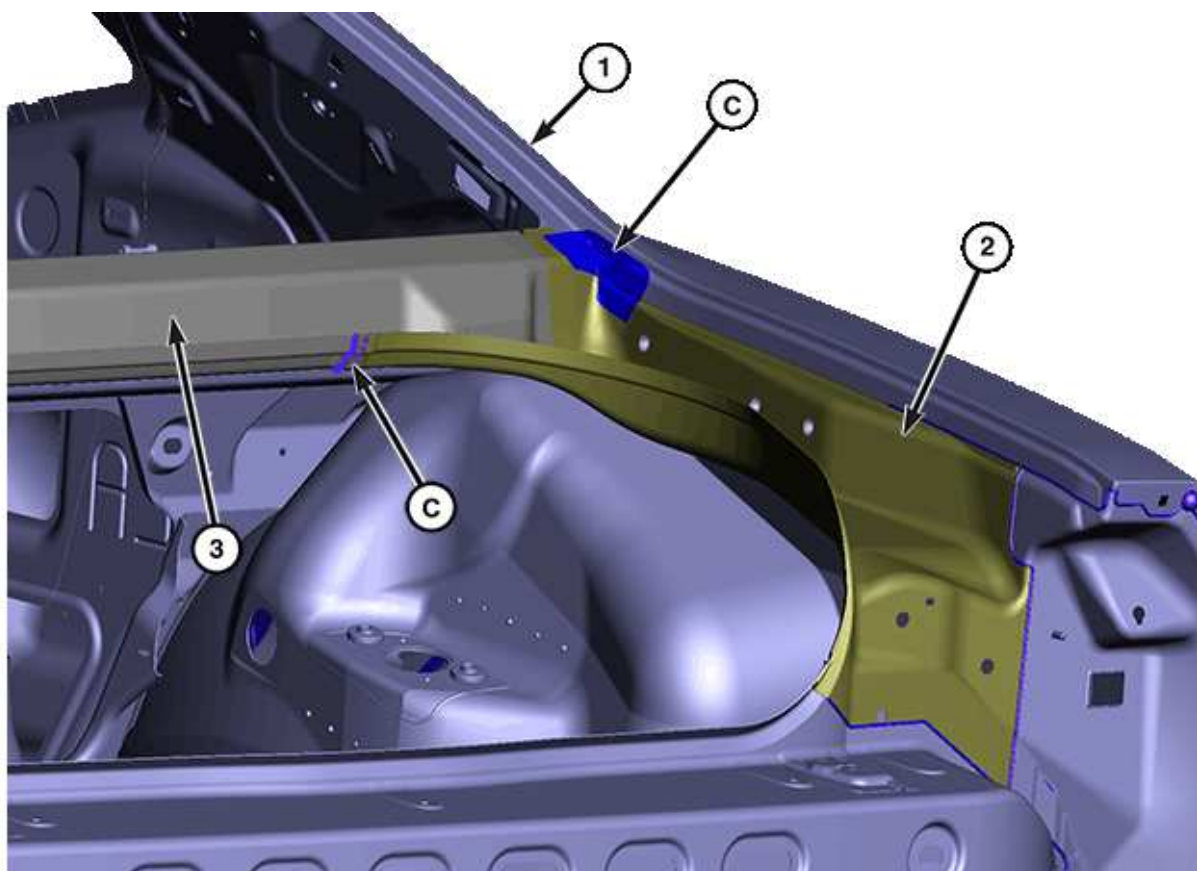
2 - WHEELHOUSE REINFORCEMENT

3 - LEFT INNER WHEELHOUSE

4 - RIGHT INNER WHEELHOUSE

5 - RIGHT INNER WHEELHOUSE

C- SEAM SEALER

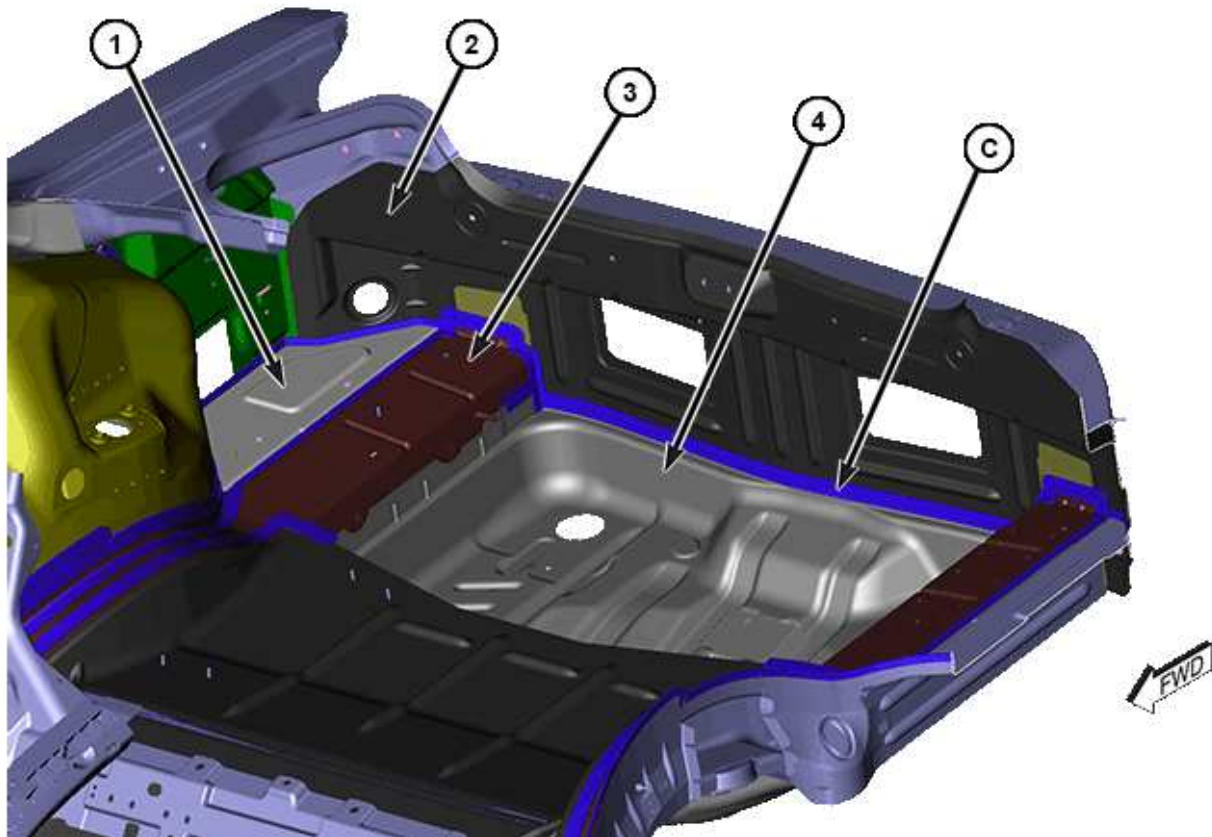


3103055461

Deck Opening Trough / Rear Shelf

NOTE: Right side shown, left side typical.

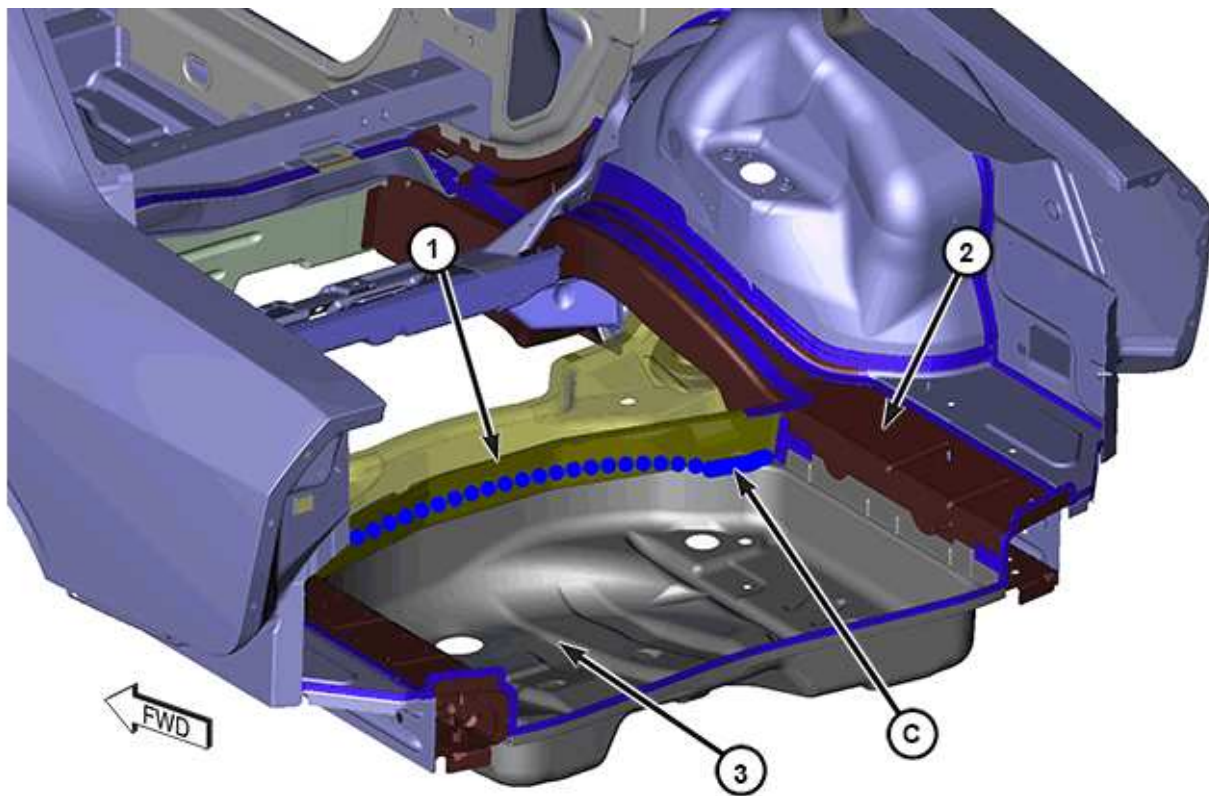
- 1 - REAR BODY SIDE APERTURE
- 2 - DECKLID OPENING TROUGH
- 3 - SHELF PANEL REINFORCEMENT
- C - SEAM SEALER



Rear Rail / Closeout Panel

NOTE: Right side shown, left side typical.

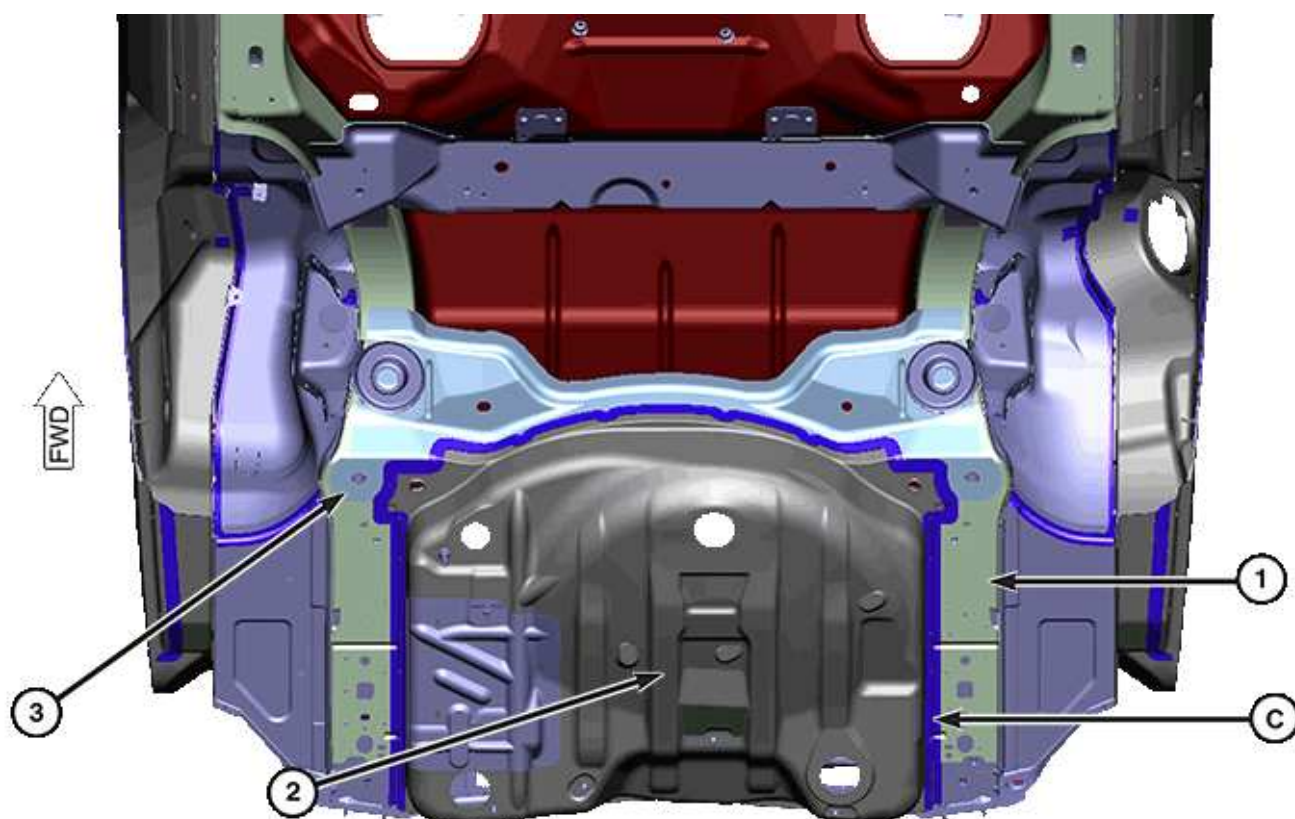
- 1 - RAIL COVER PLATE
2 - DECKLID OPENING LOWER PANEL
3 - REAR RAIL
4 - REAR FLOOR
C - SEAM SEALER



3103055475

Rear Floor Interior

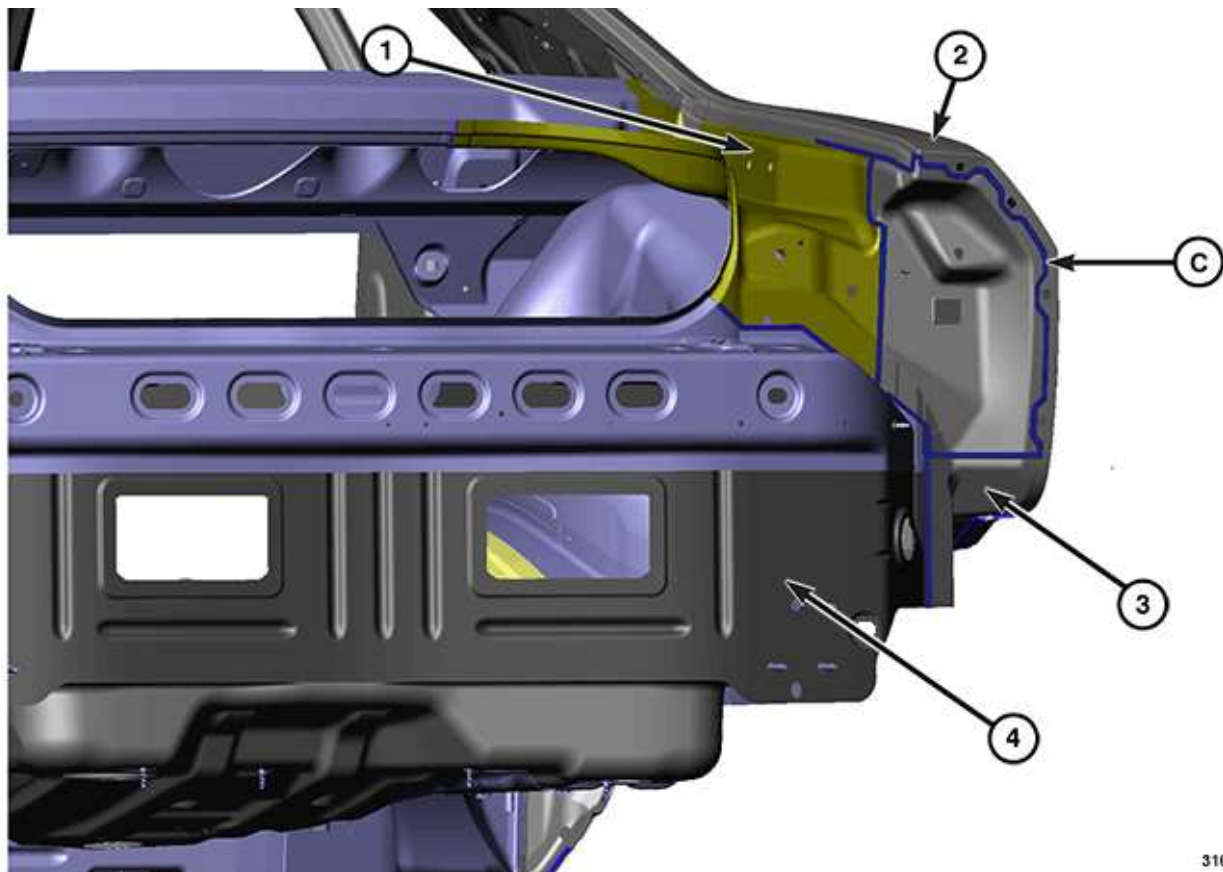
- 1 - REAR SUSPENSION CROSSMEMBER
- 2 - REAR RAIL
- 3 - REAR FLOOR PAN
- C - SEAM SEALER



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Rear Floor Panel (Exterior)

- 1 - REAR RAIL
- 2 - REAR FLOOR PANEL
- 3 - REAR SUSPENSION CROSSMEMBER
- C - SEAM SEALER



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Taillamp Mounting Panel

NOTE: Right side shown, left side typical.

- 1 - DECK OPENING TROUGH
- 2 - REAR BODY SIDE APERTURE
- 3 - QUARTER INNER REINFORCEMENT
- 4- DECK OPENING LOWER PANEL
- C - SEAM SEALER