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## Door seal on front door/rear door loose

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Topic number	LI72.00-P-055756
Version	1
Design group	72.00 General
Date	03-14-2013
Validity	W/S 204 Model series 212 Model series 218
Reason for change	Model series 212 and 218 added
Reason for block	

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**Complaint:**

- Door frame seal loose
- Door frame seal protrudes from bodyshell

Attachments	
File	Designation
Figure 1.jpg	Door seal protruding/loose (Figure 1)

**Cause:**

Insufficient adhesion between adhesive strip of door frame seal and paint surface.

**Remedy:****Situation 1:**

Door frame seal is loose over a length less than 20 cm (Figure 1):

- Partially tape down door frame seal to body using suitable adhesive tape to allow a gap for the repair adhesive to be more easily applied (Figure 2).
- Thinly coat the entire surface of the affected area of the door frame seal (only the surface of the adhesive tape) and the affected paint surface with repair adhesive using a spatula (Figures 3 and 4).
- Allow a minimum flash-off time of 25 minutes so that the adhesive surface is sufficiently dry (check by touching the adhesive - it must be dry and no longer tacky).
- Then join the two adhesive surfaces together under pressure (contact adhesive), without separating or repositioning the door seal.
- To achieve optimal adhesion the doors must not be closed for 20 minutes after applying the repair adhesive.

**Situation 2:**

Door frame seal is loose over a length of more than 20 cm:

- Replace door frame seal on front door.

or

- Replace door frame seal on rear door.

- The new door frame seal must always be pressed on firmly after installation using a roller.

Attachments	
File	Designation
Figure2.JPG	Fix door seal with adhesive tape (Figure 2)
Figure3.jpg	Apply adhesive with spatula #1 (Figure 3)
Figure4.jpg	Apply adhesive with spatula #2 (Figure 4)

Symptoms
Body / Door/Flap / Door / Door / Seal loose
Body / Door/Flap / Door / Door / Seal deformed
Body / Door/Flap / Door / Door / Seal chafes/rubs

Parts							
Part number	ES1	ES2	Designation	Quantity	Note	EPC	Other ma- ke part
A 000 989 92 71			Repair adhesive (Terokal 2444)	0	Quantity as required	X	
A 005 989 19 71			Cleaning agent (Terostat-8550)	0	Quantity as required	X	
A 204 727 11 87			Front/rear door frame seal (left/right)	1	Same door frame seal for left and right	X	

Work units				
Op. no.	Operation text	Time	Damage code	Note
			72A31 38	Left front door frame seal
			72N31 38	Right front door frame seal
			73A31 38	Left rear door frame seal
			72N31 38	Right rear door frame seal

WIS-References			
Document number	Title	Note	Allocation
AR72.10-P-2120CW	Remove/install door frame seal	Front door W/S 204 / BR 212	Remedy
AR72.12-P-1015CW	Remove/install door frame seal on rear door	Rear door W/S 204	Remedy
AR72.12-P-1015CY	Remove/install door frame seal on rear door	Rear door BR 212	Remedy
AR72.10-P-2120EL	Remove/install door frame seal	Front door BR 218	Remedy

AR72.12-P-1015EL	Remove/install door frame seal on rear door	Rear door BR 218	Remedy
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Validity		
Vehicle	Engine	Transmission
204.000	*	*
204.001	*	*
204.002	*	*
204.003	*	*
204.006	*	*
204.007	*	*
204.008	*	*
204.022	*	*
204.023	*	*
204.025	*	*
204.031	*	*
204.041	*	*
204.044	*	*
204.045	*	*
204.046	*	*
204.047	*	*
204.048	*	*
204.049	*	*
204.052	*	*
204.054	*	*
204.055	*	*
204.056	*	*
204.057	*	*
204.065	*	*
204.077	*	*
204.080	*	*
204.081	*	*
204.082	*	*
204.084	*	*
204.085	*	*
204.087	*	*
204.088	*	*
204.089	*	*
204.092	*	*
204.200	*	*
204.201	*	*
204.202	*	*

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204.207	*	*
204.208	*	*
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204.223	*	*
204.225	*	*
204.231	*	*
204.241	*	*
204.245	*	*
204.246	*	*
204.248	*	*
204.249	*	*
204.252	*	*
204.254	*	*
204.256	*	*
204.257	*	*
204.277	*	*
204.282	*	*
204.284	*	*
204.289	*	*
204.292	*	*
212.002	*	*
212.003	*	*
212.004	*	*
212.005	*	*
212.020	*	*
212.021	*	*
212.023	*	*
212.024	*	*
212.025	*	*
212.026	*	*
212.027	*	*
212.034	*	*
212.036	*	*
212.040	*	*
212.041	*	*
212.047	*	*
212.048	*	*
212.052	*	*
212.053	*	*
212.054	*	*
212.055	*	*
212.056	*	*

212.057	*	*
212.059	*	*
212.065	*	*
212.067	*	*
212.072	*	*
212.073	*	*
212.074	*	*
212.077	*	*
212.080	*	*
212.082	*	*
212.087	*	*
212.088	*	*
212.089	*	*
212.090	*	*
212.091	*	*
212.092	*	*
212.093	*	*
212.094	*	*
212.095	*	*
212.097	*	*
212.098	*	*
212.147	*	*
212.148	*	*
212.154	*	*
212.165	*	*
212.195	*	*
212.202	*	*
212.203	*	*
212.205	*	*
212.220	*	*
212.221	*	*
212.223	*	*
212.224	*	*
212.225	*	*
212.226	*	*
212.227	*	*
212.234	*	*
212.236	*	*
212.247	*	*
212.248	*	*
212.254	*	*
212.255	*	*
212.256	*	*

212.257	*	*
212.259	*	*
212.265	*	*
212.267	*	*
212.272	*	*
212.273	*	*
212.274	*	*
212.277	*	*
212.280	*	*
212.282	*	*
212.287	*	*
212.288	*	*
212.289	*	*
212.291	*	*
212.292	*	*
212.293	*	*
212.294	*	*
212.298	*	*
218.303	*	*
218.323	*	*
218.326	*	*
218.355	*	*
218.359	*	*
218.373	*	*
218.374	*	*
218.391	*	*
218.392	*	*
218.393	*	*
218.394	*	*
218.903	*	*
218.923	*	*
218.959	*	*
218.973	*	*
218.974	*	*
218.991	*	*
218.992	*	*
218.993	*	*

Full model designation breakdown		
Vehicle	Engine	Transmission
204.000	651.913	711.653
204.000	651.913	716.656

204.000	651.913	722.694
204.000	651.913	722.996
204.001	651.913	711.653
204.001	651.913	716.656
204.001	651.913	722.694
204.001	651.913	722.996
204.002	651.911	711.653
204.002	651.911	716.656
204.002	651.911	722.646
204.002	651.911	722.908
204.003	651.911	711.670
204.003	651.911	722.646
204.003	651.911	722.908
204.006	646.812	711.655
204.006	646.812	716.608
204.006	646.812	722.699
204.007	646.811	711.655
204.007	646.811	716.608
204.007	646.811	716.655
204.007	646.811	722.699
204.008	646.811	716.657
204.008	646.811	722.640
204.022	642.960	711.670
204.022	642.960	722.902
204.023	642.834	711.670
204.023	642.834	722.903
204.025	642.830	711.670
204.025	642.830	722.902
204.031	274.910	711.655
204.031	274.910	722.995
204.041	271.950	711.656
204.041	271.950	716.607
204.041	271.950	716.635
204.041	271.950	722.695
204.041	271.950	722.997
204.044	271.910	711.655
204.044	271.910	711.656
204.044	271.910	716.635
204.044	271.910	722.695
204.045	271.910	711.655
204.045	271.910	716.607
204.045	271.910	722.695
204.046	271.952	711.656

204.046	271.952	716.607
204.046	271.952	716.635
204.046	271.952	722.695
204.046	271.952	722.997
204.047	271.860	722.618
204.047	271.860	722.997
204.048	271.860	711.653
204.048	271.860	711.655
204.048	271.860	716.607
204.048	271.860	716.612
204.048	271.860	722.696
204.048	271.860	722.997
204.049	271.820	711.653
204.049	271.820	711.655
204.049	271.820	716.607
204.049	271.820	716.612
204.049	271.820	722.696
204.049	271.820	722.997
204.052	272.921	711.656
204.052	272.921	716.636
204.052	272.921	722.998
204.054	272.947	711.654
204.054	272.947	716.671
204.054	272.947	722.999
204.055	276.957	722.906
204.056	272.961	722.906
204.057	276.957	722.906
204.065	272.982	722.906
204.077	156.985	722.907
204.077	156.985	722.930
204.080	276.957	722.960
204.081	272.948	722.964
204.082	651.912	722.965
204.084	651.912	711.653
204.084	651.912	722.965
204.085	272.911	722.963
204.087	272.971	722.960
204.088	276.957	722.960
204.089	642.961	722.962
204.092	642.832	722.962
204.200	651.913	711.653
204.200	651.913	716.656
204.200	651.913	722.694



204.200	651.913	722.996
204.201	651.913	711.653
204.201	651.913	716.656
204.201	651.913	722.694
204.201	651.913	722.996
204.202	651.911	711.653
204.202	651.911	716.656
204.202	651.911	722.646
204.202	651.911	722.908
204.203	651.911	711.670
204.203	651.911	722.646
204.203	651.911	722.908
204.207	646.811	711.655
204.207	646.811	716.608
204.207	646.811	716.655
204.207	646.811	722.699
204.208	646.811	716.657
204.208	646.811	722.640
204.222	642.960	711.670
204.222	642.960	722.902
204.223	642.834	711.670
204.223	642.834	722.903
204.225	642.830	711.670
204.225	642.830	722.902
204.231	274.910	711.655
204.231	274.910	722.995
204.241	271.950	711.656
204.241	271.950	716.635
204.241	271.950	722.695
204.241	271.950	722.997
204.245	271.910	711.655
204.245	271.910	716.607
204.245	271.910	722.695
204.246	271.952	711.656
204.246	271.952	716.635
204.246	271.952	722.695
204.246	271.952	722.997
204.248	271.860	711.653
204.248	271.860	711.655
204.248	271.860	716.607
204.248	271.860	716.612
204.248	271.860	722.696
204.248	271.860	722.997

204.249	271.820	711.653
204.249	271.820	711.655
204.249	271.820	716.607
204.249	271.820	716.612
204.249	271.820	722.696
204.249	271.820	722.997
204.252	272.921	711.656
204.252	272.921	716.636
204.252	272.921	722.998
204.254	272.947	711.654
204.254	272.947	716.671
204.254	272.947	722.999
204.256	272.961	722.906
204.257	276.957	722.906
204.277	156.985	722.907
204.277	156.985	722.930
204.282	651.912	722.965
204.284	651.912	711.653
204.284	651.912	722.965
204.289	642.961	722.962
204.292	642.832	722.962
212.002	651.924	711.653
212.002	651.924	716.656
212.002	651.924	722.646
212.002	651.924	722.908
212.002	651.924	725.011
212.003	651.924	711.670
212.003	651.924	722.646
212.003	651.924	722.908
212.003	651.924	725.011
212.004	651.924	711.670
212.004	651.924	722.646
212.004	651.924	722.908
212.004	651.924	725.011
212.005	651.925	711.653
212.005	651.925	716.656
212.005	651.925	722.694
212.005	651.925	722.996
212.005	651.925	725.011
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212.021	642.852	711.670
212.021	642.852	722.903
212.021	642.852	725.011

212.023	642.852	711.670
212.023	642.852	722.903
212.023	642.852	725.011
212.024	642.850	711.670
212.024	642.850	722.902
212.024	642.850	725.011
212.025	642.850	711.670
212.025	642.850	722.902
212.025	642.850	725.011
212.025	642.856	711.670
212.025	642.856	722.902
212.025	642.856	725.011
212.026	642.852	711.670
212.026	642.852	722.903
212.026	642.852	725.011
212.027	642.852	711.670
212.027	642.852	722.903
212.027	642.852	725.011
212.034	274.920	711.655
212.034	274.920	722.995
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212.036	274.920	722.995
212.040	274.910	711.655
212.040	274.910	722.995
212.041	271.958	722.695
212.047	271.860	722.618
212.047	271.860	722.997
212.048	271.860	711.655
212.048	271.860	716.612
212.048	271.860	722.696
212.048	271.860	722.997
212.052	272.923	716.636
212.052	272.923	722.998
212.053	272.980	722.906
212.054	272.952	711.654
212.054	272.952	722.999
212.055	276.952	722.906
212.056	272.980	722.906
212.057	272.983	722.906
212.059	276.952	722.906
212.065	276.820	722.904
212.067	276.820	722.961
212.072	273.971	722.904

212.073	278.922	722.909
212.073	278.922	725.011
212.073	278.922	725.032
212.074	157.981	722.931
212.077	156.985	722.930
212.080	276.952	722.960
212.082	651.924	722.965
212.087	272.977	722.960
212.088	276.952	722.960
212.089	642.856	722.962
212.090	273.970	722.961
212.091	278.922	722.967
212.091	278.922	725.021
212.092	157.981	722.971
212.093	642.858	722.966
212.093	642.858	725.021
212.094	642.852	722.966
212.094	642.852	725.021
212.094	642.858	722.966
212.094	642.858	725.021
212.095	276.952	724.206
212.097	651.924	722.965
212.098	651.924	724.208
212.147	271.860	722.618
212.147	271.860	722.997
212.148	271.860	711.655
212.148	271.860	722.696
212.148	271.860	722.997
212.154	272.952	711.654
212.154	272.952	722.999
212.165	276.820	722.904
212.195	276.952	724.206
212.202	651.924	711.653
212.202	651.924	716.656
212.202	651.924	722.646
212.202	651.924	722.908
212.202	651.924	725.011
212.203	651.924	711.670
212.203	651.924	722.646
212.203	651.924	722.908
212.203	651.924	725.011
212.205	651.925	711.653
212.205	651.925	716.656

212.205	651.925	722.694
212.205	651.925	722.996
212.205	651.925	725.011
212.220	642.850	722.902
212.221	642.852	711.670
212.221	642.852	722.903
212.221	642.852	725.011
212.223	642.852	711.670
212.223	642.852	722.903
212.223	642.852	725.011
212.224	642.850	711.670
212.224	642.850	722.902
212.224	642.850	725.011
212.225	642.850	711.670
212.225	642.850	722.902
212.225	642.850	725.011
212.226	642.852	711.670
212.226	642.852	722.903
212.226	642.852	725.011
212.227	642.852	711.670
212.227	642.852	722.903
212.227	642.852	725.011
212.234	274.920	711.655
212.234	274.920	722.995
212.236	274.920	711.655
212.236	274.920	722.995
212.247	271.860	722.618
212.247	271.860	722.997
212.248	271.860	711.655
212.248	271.860	716.607
212.248	271.860	716.612
212.248	271.860	722.696
212.248	271.860	722.997
212.254	272.952	711.654
212.254	272.952	722.999
212.255	276.952	722.906
212.256	272.980	722.906
212.257	272.983	722.906
212.259	276.952	722.906
212.265	276.820	722.904
212.267	276.820	722.961
212.272	273.971	722.904
212.273	278.922	722.909

212.273	278.922	725.011
212.273	278.922	725.032
212.274	157.981	722.931
212.277	156.985	722.930
212.280	276.952	722.960
212.282	651.924	722.965
212.287	272.977	722.960
212.288	276.952	722.960
212.289	642.856	722.962
212.291	278.922	722.967
212.291	278.922	725.021
212.292	157.981	722.971
212.293	642.858	722.966
212.293	642.858	725.021
212.294	642.852	722.966
212.294	642.852	725.021
212.294	642.858	722.966
212.294	642.858	725.021
212.298	651.924	724.208
218.303	651.924	722.908
218.303	651.924	725.011
218.323	642.852	722.903
218.323	642.852	725.011
218.323	642.853	722.903
218.323	642.853	725.011
218.326	642.852	722.903
218.326	642.852	725.011
218.355	276.952	722.906
218.355	276.952	725.011
218.355	276.957	722.906
218.355	276.957	725.011
218.359	276.952	722.906
218.359	276.952	725.011
218.373	278.922	722.909
218.373	278.922	725.011
218.374	157.981	722.931
218.391	278.922	722.967
218.392	157.981	722.971
218.393	642.854	722.966
218.393	642.858	722.966
218.394	642.858	722.966
218.394	642.858	725.041
218.903	651.924	722.908

218.903	651.924	725.011
218.923	642.852	722.903
218.923	642.852	725.011
218.923	642.853	722.903
218.923	642.853	725.011
218.959	276.952	722.906
218.959	276.952	725.011
218.973	278.922	722.909
218.973	278.922	725.011
218.974	157.981	722.931
218.991	278.922	722.967
218.991	278.922	725.041
218.992	157.981	722.971
218.993	642.854	722.966
218.993	642.858	722.966

Attachments

Figure2.JPG:



Figure3.jpg:

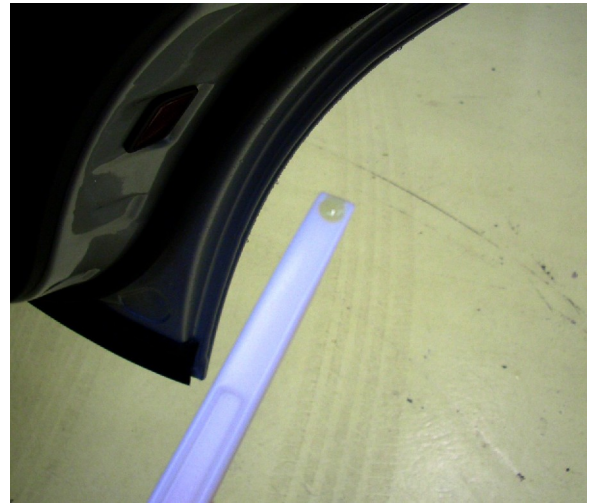


Figure4.jpg:





Figure 1.jpg:

