

DOORS

Purpose

This document outlines the installation procedure for adding the U-Skin door panel to a cargo door.

Procedure

NOTE: The door is shipped closed with the deadbolt applied (Figs. 1 and 2).

1. Unlock the deadbolt by flipping the lever to the right (Fig. 3) and open the door completely (Fig. 4).



Fig. 1

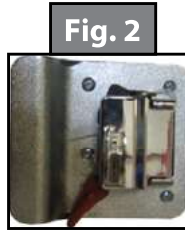


Fig. 2

Deadbolt locked

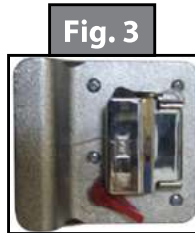


Fig. 3

Deadbolt unlocked



Fig. 4

2. Lay door on table and frame on stand (Fig. 5).
3. Door side hinges mounted with one screw per hinge bracket before door panel is added (Fig. 6).

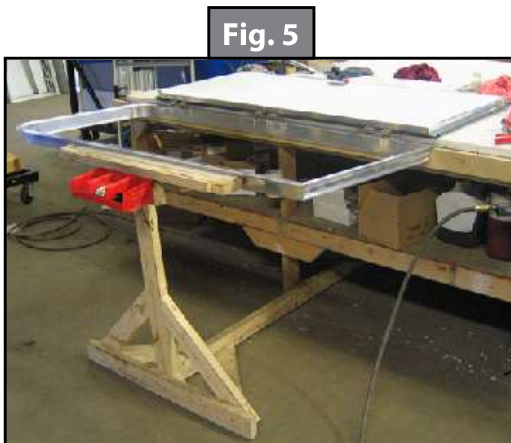


Fig. 5

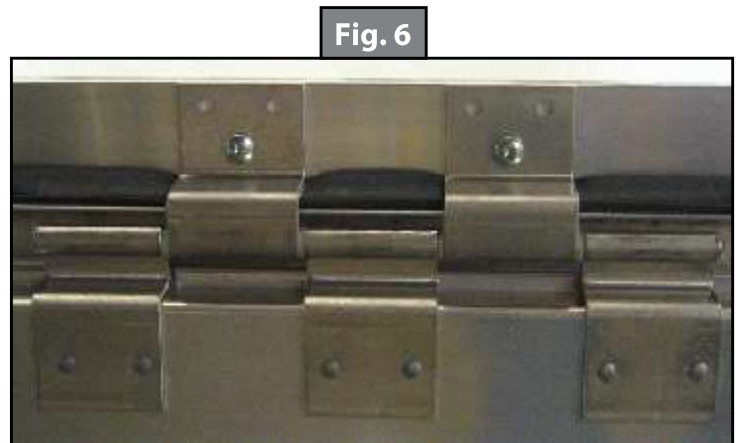


Fig. 6

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4. Remove both screws from each hinge (6) (Fig. 7). The door is now separated from frame (Fig. 8).
5. Peel seal back from the door trim (Fig. 9).

Fig. 7

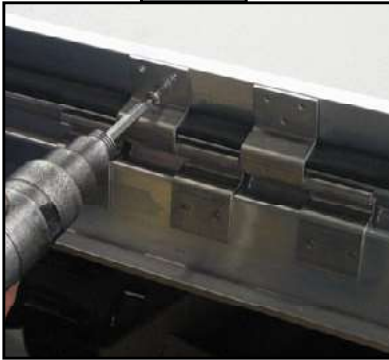


Fig. 8



Fig. 9



6. Peel back from both sides (Fig. 10).
7. Remove screws from bottom frame rail (Fig. 11).
8. Separate bottom frame rail from door (Fig. 12).

Fig. 10



Fig. 11

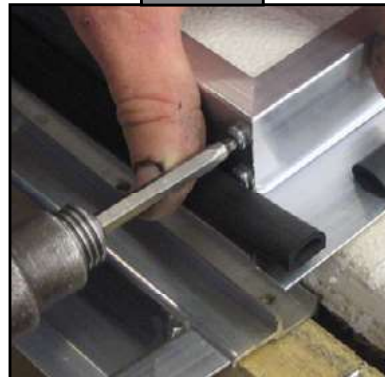


Fig. 12



9. Remove screws from door latch plate (Fig. 13).
10. Remove all four screws and from inside plate of door latch assembly (Fig. 14). Remove and retain the screws and spacer blocks by the latch.
11. Remove inside plate of door latch assembly (Fig. 15).

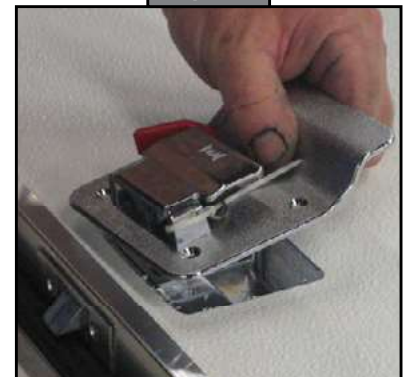
Fig. 13



Fig. 14



Fig. 15



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12. Remove latch plate (Fig. 16).
13. Remove external door latch assembly (Fig. 17).
14. Pull door rail from sides of door (Fig. 18).

Fig. 16



Fig. 17



Fig. 18



15. Pull door from door rail (Fig. 19), then pull door free and set aside (Fig. 20).
16. Fit new door panel to door (Fig. 21).

Fig. 19



Fig. 20



Fig. 21



17. Turn new door panel over and cover evenly and thoroughly with adhesive (Glue Spec: PB999-290C). Set aside (Fig. 22).
18. Cover door evenly and thoroughly with adhesive (Fig. 23), then apply and fit door panel to door (Fig. 24).

Fig. 22



Fig. 23

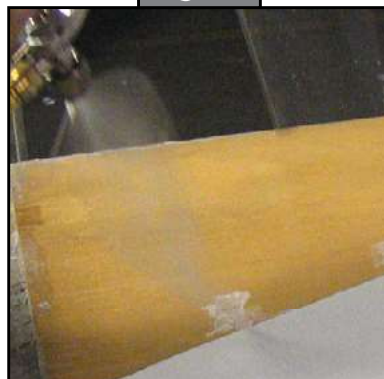


Fig. 24



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19. Apply adhesive caulk to door rail. Be sure to keep caulk on flat portion of rail (Fig. 25).
20. Apply adhesive to bottom rail in the same fashion (Fig. 26).
21. Be sure to keep caulk bead extending any higher than the internal screw rail (Fig. 27).

Fig. 25

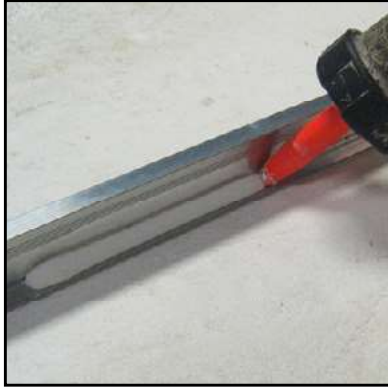
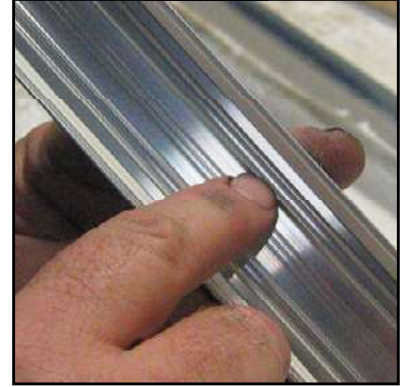


Fig. 26



Fig. 27



22. Install door back into door rail (Fig. 28), then fit bottom door rail to bottom of the door (Fig. 29).
23. Reinstall the four screws to the bottom door rail (Fig. 30).

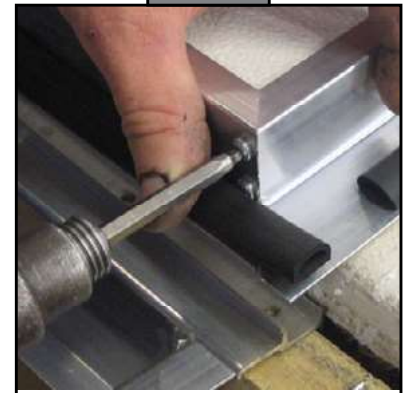
Fig. 28



Fig. 29



Fig. 30



24. Reapply seal to both sides (Figs. 31 and 32).
25. Be sure bottom spacer block is in place (Fig. 33).

Fig. 31

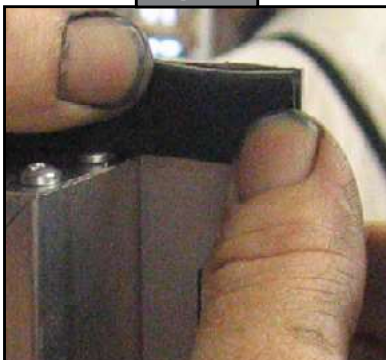


Fig. 32



Fig. 33



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26. Lay door back on bench and set frame on the stand (Fig. 34).
27. Make a latch hole in the door using a router. Reinstall the latch, spacers and screws.
28. Match hinges back to mounting holes (Fig. 35).
29. Bottom of door rail should match evenly to door frame (Fig. 36).

Fig. 34



Fig. 35



Fig. 36



30. Reinstall the six hinge screws removed during disassembly (Fig. 37).
31. Apply two more screws per hinge bracket (Fig. 38).
32. Finish all three hinges as seen above (Fig. 39).

Fig. 37

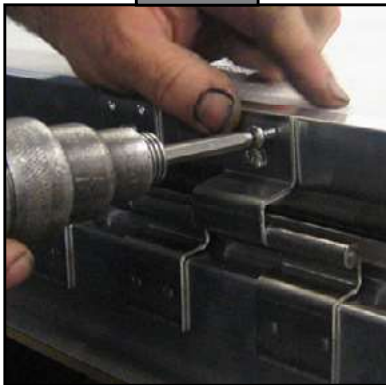


Fig. 38

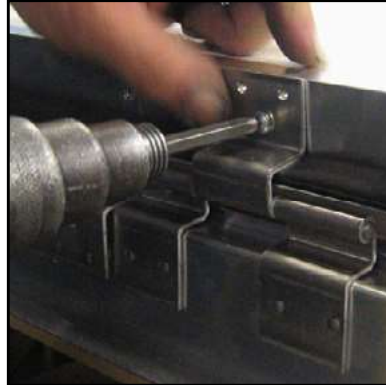


Fig. 39

