



NUMBER: 23-021-13

GROUP: Body

DATE: May 30, 2013

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THIS BULLETIN SUPERSEDES SERVICE BULLETIN 23-025-12, DATED SEPTEMBER 09, 2012, WHICH SHOULD BE REMOVED FROM YOUR FILES. THIS IS A COMPLETE REVISION AND NO ASTERISKS HAVE BEEN USED TO HIGHLIGHT REVISIONS.

SUBJECT:

Replacing Door, Hood And/Or Tailgate Hinges

OVERVIEW:

This bulletin involves replacing, refinishing and sealing door, tailgate and hood hinges.

MODELS:

2007-2013 (JK) Wrangler

PARTS REQUIRED:

Qty.	Part No.	Description
(AR) 1	NPN	Isopropyl Alcohol
(AR) 1	IES 8460 Inter-Mix 5 Epoxy Clear 10oz or Equivalent	IES 8460 Inter-Mix 5 Epoxy Clear 10oz or Equivalent. Paintable 2K Clear Sealer (If IES clear sealer cannot be sourced locally a clear sealer that has a hardener must be used)
(AR) 6	NPN	IES 8260 10oz Adhesive Mixing Tips
(AR) 1	NPN	Crest East Coast Clear Seal #ZCEC 1.7oz or Equivalent (If Crest East Coast clear seam sealer cannot be sourced locally a clear sealer that has a hardener must be used).
(AR) 1	NPN	Crest East Coast 1.7oz Clear Seal Mixing Tips #GMMN (Sold in quantities of 18)
(AR) 4	55395384AE	HINGE, Door, Right
(AR) 4	55395385AE	HINGE, Door, Left
(AR) 2	55395396AE	HINGE, Hood
(AR) 2	55395401AC	HINGE, Tailgate

NOTE: IES 8460 Inter-Mix 5 Epoxy Clear and Crest East Coast ZCEC Clear Seal have a 5 minute working time. IES 8460 will service 36 hinges and Crest East Coast ZCEC will service 6 hinges.

REPAIR PROCEDURE:

1. Hinge removal procedures:
 - a. If removing door hinges refer to the detailed removal procedures available in: DealerConnect> TechCONNECT under: Service Info> 23-Body> Exterior> Door-Front or Rear, Full or Half> Hinge- Door> Removal.
 - b. If removing hood hinges refer to the detailed removal procedures available in: DealerConnect> TechCONNECT under: Service Info> 23-Body> Hood> HINGE, Hood> Removal.
 - c. If removing tailgate hinges refer to the detailed removal procedures available in: DealerConnect> TechCONNECT under: Service Info> 23-Body> Decklid/Hatch/Liftgate/Tailgate> HINGE> Removal.
2. Refinish hinges and current hinge fasteners per your refinish paint suppliers recommendations.
3. Once the paint has fully cured and is ready for installation clean the panel and hinges with isopropyl alcohol where adhesive will be applied and follow your adhesive suppliers recommendations for further preparation details.
4. Mask and protect the areas adjacent to the hinge location as shown in (Fig. 1) (1) to protect the panel surface from adhesive.

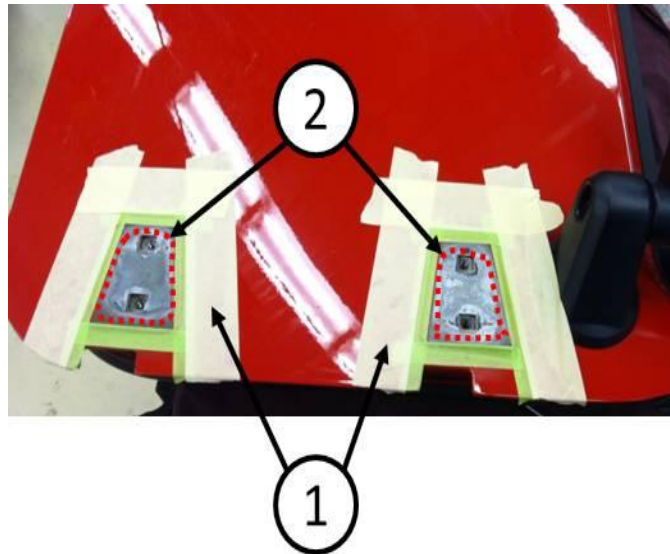


Fig. 1 Right Front Door

- 1 - Masking Tape
2 - Adhesive Application Area

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5. Apply IES 8460 Inter-mix 5 epoxy clear sealer or Crest clear seal ZCEC or equivalent to the outboard edge of panel surface per the adhesive suppliers recommendations as shown in (Fig. 1) (2).

NOTE: Apply IES 8460 Inter-mix 5 epoxy clear sealer or Crest clear seal ZCEC to the panel surface of the designate hinges that can be installed and adjusted within 5 minutes. The adhesive has a 5 minute handling time and once it has been elapsed, the sealer will not meet the sealing requirements for this repair procedure.

- 6. Install refinished hinges.
 - a. If installing door hinges refer to the detailed removal procedures available in: DealerConnect> TechCONNECT under: Service Info> 23-Body> Exterior> Door-Front or Rear, Full or Half> Hinge- Door> Installation.
 - b. If installing hood hinges refer to the detailed removal procedures available in: DealerConnect> TechCONNECT under: Service Info> 23-Body> Hood> HINGE, Hood> Installation.
 - c. If installing tailgate hinges refer to the detailed removal procedures available in: DealerConnect> TechCONNECT under: Service Info> 23-Body> Decklid/Hatch/Liftgate/Tailgate> HINGE> installation.
- 7. Once the hinges have been adjusted accordingly remove all sealer squeeze out with a lint free rag and isopropyl alcohol.
- 8. Return the vehicle to the customer.

POLICY:
Information Only.

FAILURE CODE:

ZZ	Service Action
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