
Door seal on front door/rear door loose

Topic number	LI72.00-P-055756
Version	2
Design group	72.00 General
Date	10-08-2014
Validity	W/S 204 Model series 212 Model series 218 Model series 205
Reason for change	Model series 205 added
Reason for block	

Complaint:

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

Attachments

File	Description
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 of up to max. 20 cm (Figure 1):

- Partially tape down door frame seal to body using suitable adhesive tape to allow 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 and repositioning the door seal.
- The doors must not be closed for 20 minutes after applying the repair adhesive, to achieve optimal adhesion.

Situation 2:

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

- Replace door frame seal on front door.
- 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	Description
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
AR72.10-P-2120LW	Remove/install door frame seal	Front door BR 205	Remedy
AR72.12-P-1015LW	Remove/install door frame seal on rear door	Rear door BR 205	Remedy

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	*	*
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204.202	*	*
204.203	*	*
204.207	*	*
204.208	*	*
204.222	*	*
204.223	*	*
204.225	*	*
204.231	*	*
204.241	*	*
204.245	*	*
204.246	*	*
204.248	*	*
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204.252	*	*
204.254	*	*
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204.257	*	*
204.277	*	*
204.282	*	*
204.284	*	*
204.289	*	*
204.292	*	*
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205.009	*	*
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205.040	*	*
205.042	*	*
205.045	*	*
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205.049	*	*
205.066	*	*
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205.087	*	*
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205.145	*	*

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205.287	*	*
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218.959	*	*
218.973	*	*
218.974	*	*
218.991	*	*
218.992	*	*
218.993	*	*

Attachments

Figure2.JPG:



Figure3.jpg:



Figure4.jpg:



Figure 1.jpg:

