



**NUMBER:** 23-034-07

**GROUP:** Body

**DATE:** August 4, 2007

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**SUBJECT:**

Scratch Marks Or Paint Repair Needed At Lower Corners Of Liftgate Handle

**OVERVIEW:**

This bulletin involves repairing paint and isolating the lower corners of the liftgate handle with foam tape.

**MODELS:**

- 2006-2007 (XK) Commander
- 2006-2007 (XH) Commander (International Markets)

**NOTE: This bulletin applies to XK models built through May 14, 2007 and XH models built through May 28, 2007.**

**SYMPTOM/CONDITION:**

Contact between liftgate handle and liftgate may cause paint scratches.

**DIAGNOSIS:**

The lower corners of the liftgate handle come in contact with the liftgate, two procedures are available depending on the severity of the condition. Repair Procedure "A" is for conditions that do not show through to primer and Repair Procedure "B" is for conditions that show primer within the damaged area.

**PARTS REQUIRED:**

Qty.	Part No.	Description
1	05019056AA	High Density Urethane Foam Cut to 44mm X 10 mm (1 piece will service approximately 7 vehicles)
AR	04796236AB	Mopar Car Wash Concentrate
AR	BSMM8432	Mopar Compound Power Cleaner
AR	BSMM8232	Mopar Swirl Free Polish
AR	NPN	Grease and Wax Remover
AR	BSMK2000	Mopar 2000 grit Wet/Dry sand paper
AR	NPN	600 grit sand paper

Qty.	Part No.	Description
AR	NPN	Paint Refinish Material Corrosion resistant primer, Primer Surfacer, Base Coat and Clear Coat

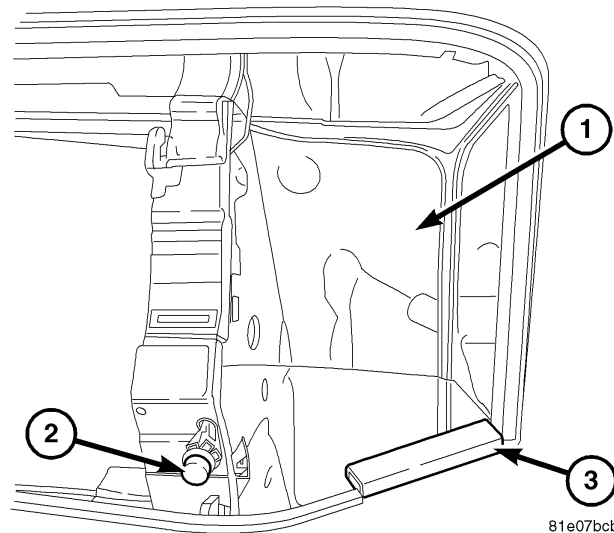
**SPECIAL TOOLS/EQUIPMENT REQUIRED:**

EMA312FNFB1	Elcometer 312, Automotive Refinish Meter or equivalent (Available through the PSE program)
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**REPAIR PROCEDURE:**

1. Open liftgate.
2. Disconnect and isolate negative battery cable.
3. Remove the liftgate handle. Refer to the detailed removal procedures available in DealerCONNECT > TechCONNECT under: Service Info > 23 - LIFTGATE > HANDLE > HANDLE REMOVAL. Place liftgate handle on protected surface.
4. Cut 2 pieces of foam tape (p/n 05019056AA), 10mm (.39in.) wide x 35mm (1.37in.) long and install at both lower corners with 1mm (.04in.) protrusion from edge as shown in (Fig. 1).

**NOTE: Clean surface before applying tape.**



**Fig. 1 LIFTGATE HANDLE**

- 1 - Liftgate Handle Assembly
- 2 - Rubber Bumpers (1 per side)
- 3 - Install Foam Tape As Shown With 1mm Protrusion From Outside Edge

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5. Set handle aside for installation after paint repair.
  6. Inspect paint surface at liftgate handle. Perform the necessary repair based on extent of damage:
    - a. For touch-up procedure, proceed to REPAIR PROCEDURE "A" FINESSE below.

b. For repaint procedure, proceed to REPAIR PROCEDURE "B" REFINISH below.

**REPAIR PROCEDURE "A" FINESSE:**

1. Clean with Mopar Car Wash Concentrate, and water.
2. Wipe with an alcohol based cleaner
3. Evaluate the paint condition.
4. Measure and record paint film thickness in areas to be sanded using an electronic mil gauge (PSE).
5. Use 2000 grit sand paper mounted to a ridged backer to remove all etching.
6. If you remove more than 0.5 mil of clear coat you will need to refinish using repair procedure "B" refinish.
7. If refinishing is not required polish sanded areas using Mopar Compound Power Cleaner # BSMM8432.
8. Remove swirl marks using Mopar Swirl Free polish #BSMM8232.
9. Detail vehicle as required.

**REPAIR PROCEDURE "B" REFINISH:**

1. Clean with Mopar Car Wash Concentrate, and water.
2. Wipe with an alcohol based cleaner
3. Evaluate the paint condition.
4. DA surface with 600 grit sand paper.
5. Clean with appropriate solvent per paint supplier recommendations.
6. Feather edge the damaged areas.
7. Apply corrosion resistant primer to bare metal spots if they exist.
8. Spot prime with primer surfacer.
9. Block sand the primer surfacer.
10. Final sand per paint suppliers recommendations.
11. Clean with appropriate solvent.
12. Tack off the repair area.
13. Apply basecoat with appropriate hardener per paint supplier recommendations.
14. Allow flash time per paint suppliers recommendations and tack off area.
15. Apply clear coat per paint suppliers recommendations.
16. Detail vehicle as required.

**INSTALL LIFTGATE HANDLE:**

1. Install the liftgate handle on the vehicle. Refer to the detailed installation procedures available in DealerCONNECT > TechCONNECT under: Service Info > 23 - LIFTGATE > HANDLE > HANDLE INSTALLATION.
2. Connect the negative battery cable.
3. Set the clock to the proper time.

**POLICY:**

Reimbursable within the provisions of the warranty.

**TIME ALLOWANCE:**

<b>Labor Operation No:</b>	<b>Description</b>	<b>Amount</b>
23-65-42-91	Liftgate handle, Remove, Perform Repair Procedure "A", Isolate and Install (A)	A/T
23-70-42-92	liftgate handle, Remove, Perform Repair Procedure "B", Isolate and Install (A)	A/T

**FAILURE CODE:**

ZZ	Service Action
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