



**NUMBER:** 23-017-02

**GROUP:** Body

**DATE:** May 20, 2002

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**SUBJECT:**

Door Sag/Creaking Sound - Weld Separation

**OVERVIEW:**

This bulletin involves installing one of two hinge reinforcement kits based on inspection.

**NOTE: \*\*IF DOOR HINGE/S WERE PREVIOUSLY CHANGED, THE PARTS KITS AND INFORMATION MAY NOT APPLY.\*\***

**MODELS:**

1993 - \*\*1997\*\* (XJ) Cherokee

**SYMPTOM/CONDITION:**

A creaking noise may be heard from the front door hinge area or the door may sag. The door hinge welds may be separated from the A-post. This condition may occur on the upper drivers door hinge. This condition may be seen on heavy use type vehicles, such as police or other severe service type fleet vehicles.

**DIAGNOSIS:**

Inspect the front upper door hinge welds for separation from the A-post.

There are two levels of repair:

1. If weld separation is present but the separation is less than 75% of the length of the weld and the door will close without lifting it, repair method "A" is required.
2. If weld separation is more than 75% of the length of the weld and the door will not close without lifting, repair method "B" is required.

**PARTS REQUIRED:**

Qty.	Part No.	Description
1	05083060AA	Kit A
1	05083061AA	Kit B

**EQUIPMENT REQUIRED:**

Qty.	Tool #	Description
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1	TTX40E	$\frac{1}{4}$ Inch drive T40 Socket (Snap-on)
1	TTX30E	$\frac{1}{4}$ Inch drive T30 Socket (Snap-on)
1	Tm10f	$\frac{1}{4}$ Inch drive breaker bar (Snap-on)
1	W-AK175ACH	Power Set Riveter (pneumatic Rivet Gun) (PSE)

**NOTE: ALL CHRYSLER AND DODGE DEALERS RECEIVED ONE POWER SET RIVETER TO PERFORM RECALL #785. ADDITIONAL RIVET GUNS CAN BE ORDERED THROUGH PENTASTAR SERVICE EQUIPMENT (PSE) BY CALLING 1-800-223-5623 OR BY FAXING 1-800-734-4334. RIVETERS ARE NOT REIMBURSABLE BY DAIMLERCHRYSLER FOR THIS REPAIR.**

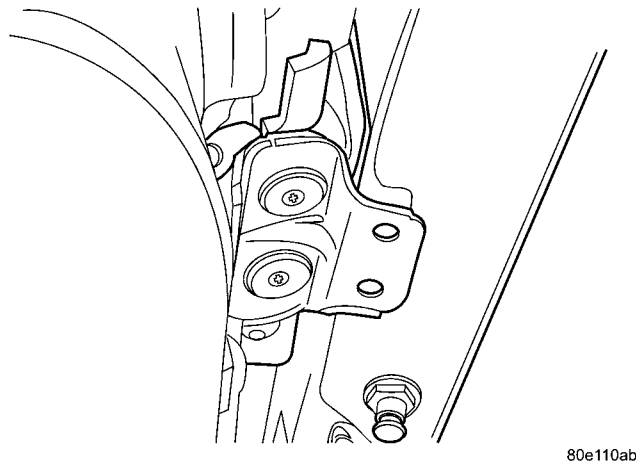
### ***REPAIR PROCEDURES:***

#### **REPAIR "A"**

WELD SEPARATION LESS THAN 75% OF THE WELD LENGTH.

This procedure involves installing a hinge reinforcement and tapping block kit (A) p/n 05083060AA. Each repair kit contains parts to service one upper hinge. The kits are universal in design and work on the right or left side.

1. Position hinge reinforcement bracket on "A" pillar and place tapping block behind the upper hinge with foot facing outside of vehicle (Fig. 1).

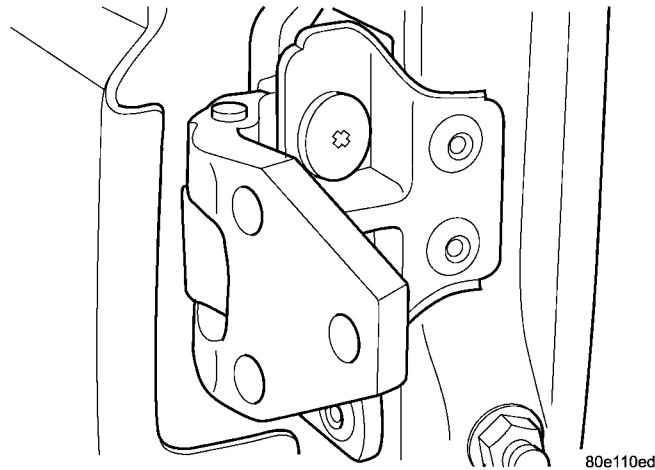


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***Fig. 1 HINGE PLATE/TAPPING BLOCK***

2. Insert supplied wafer head bolts through hinge reinforcement bracket and original hinge so that the wafer head bolts screw into the tapping block (hand tighten only). It may be necessary to reposition the hinge flush to the A-pillar to achieve proper alignment of the reinforcement bracket.
3. Using the hinge reinforcement bracket holes as a template, drill two  $\frac{17}{64}$  inch holes for the installation of the structural rivets.
4. Apply a small amount of corrosion resistant primer into the two holes drilled in step 3 to prevent corrosion.

5. Install the supplied structural rivets using the pneumatic rivet gun (p/n W-AK175ACH) or equivalent (Fig. 2).



**Fig. 2 HINGE PLATE WITH STRUCTURAL RIVETS**

6. Tighten the wafer head bolts into the tapping plate to 12 N·m (105 in-lbs) (Fig. 3).

**CAUTION: DO NOT OVER TIGHTEN THE WAFER BOLTS AS HEAD SEPARATION MAY OCCUR.**



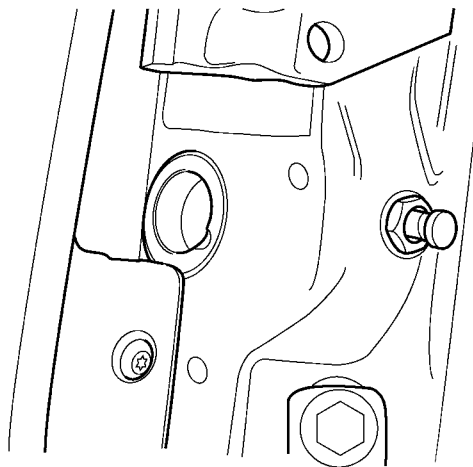
**Fig. 3 WAFER HEAD BOLTS INTO TAPPING BLOCK**

**REPAIR “B”**

WELD SEPARATION MORE THAN 75% OF THE WELD LENGTH, CAUSING DOOR SAGGING THAT REQUIRES LIFTING TO CLOSE.

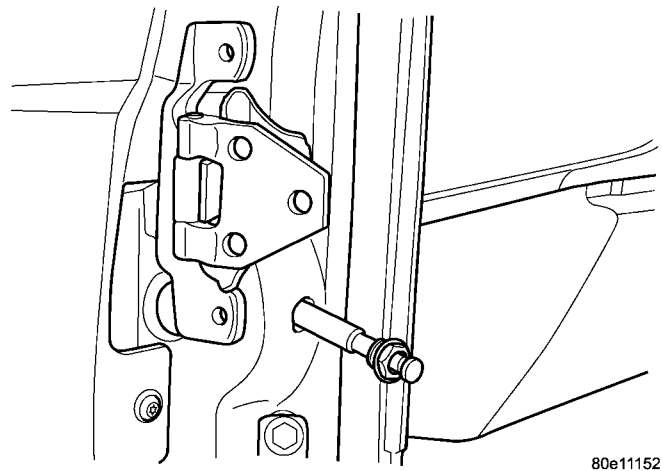
This procedure involves installing a hinge reinforcement and tapping block kit (B) p/n 05083061AA. Each repair kit contains parts to service one upper hinge. The kits are universal in design and work on the right or left side.

1. Disconnect battery, making note of saved radio settings.
2. Remove cowl side trim panel (kick panel) to access door wiring harness connectors.
3. Disconnect wiring harness connectors and slide boot and harness from cowl side panel.
4. Loosen the upper and lower hinge-to-door retaining bolts.
5. Remove the door restraint (check strap) retaining pin.
6. Remove lower hinge retaining bolts while supporting door.
7. While supporting the door, remove and discard the upper hinge bolts. Then carefully remove the door from the vehicle.
8. Reposition the upper door hinge so that it is flush against the "A" pillar.
9. Remove body plug under upper hinge on "A" pillar where hinge plate will be located. (Fig. 4)



**Fig. 4 BODY PLUG UNDER HINGE**

10. Place the hinge plate and hinge reinforcement bracket in position for wafer bolt installation.
11. Install the supplied wafer bolts to hold the hinge plate and reinforcement bracket to the upper hinge. Hand tighten the wafer bolts.
12. Verify that hinge plate, hinge reinforcement bracket and hinge are flush with "A" pillar. Adjust hinge position as necessary.
13. Remove the door ajar switch from the "A" pillar. Locate the switch away from the area where drilling will take place. (Fig. 5)

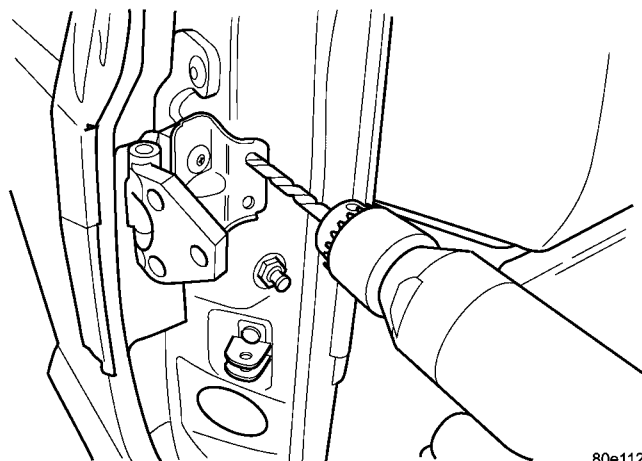


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**Fig. 5 DOOR AJAR SWITCH**

**NOTE: PROTECT FENDER EDGE (Fig. 6) WITH TAPE DURING DRILLING AND RIVETING PROCESS.**

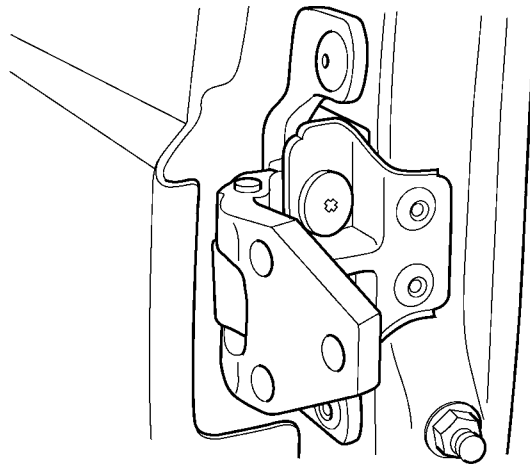
14. Using the hinge plate holes as a template, drill a 17/64 th inch hole in the "A" pillar, through the lower hinge plate hole, apply corrosion resistant primer to the hole and install one of the structural rivets using the pneumatic rivet gun (p/n W-AK175ACH) or equivalent.
15. Using the hinge plate holes as a template, drill a 17/64 th inch hole in the "A" pillar, through the upper hinge plate hole, apply corrosion resistant primer to the hole and install one of the structural rivets using the pneumatic rivet gun (p/n W-AK175ACH) or equivalent.
16. Using the hinge reinforcement bracket mounting holes as templates, drill two 17/64 th inch holes in the "A" pillar. (Fig. 6).



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**Fig. 6 DRILLING HINGE PLATE**

17. Apply corrosion resistant primer into the two holes drilled in step 16 to prevent corrosion.
18. Install the hinge reinforcement bracket using the supplied structural rivets.
19. Use the pneumatic rivet gun (p/n W-AK175ACH) or equivalent to install the rivets.
20. Tighten wafer bolts to 12 N·m (105 in-lbs) torque. (Fig. 7)



**Fig. 7 WAFER BOLTS**

**CAUTION: DO NOT OVER TIGHTEN THE WAFER BOLTS AS HEAD SEPARATION MAY OCCUR.**

21. While positioning the door against the upper and lower door hinges, route the door wiring harness through the "A" post.
22. Insert supplied wafer bolts through upper hinge into the door, hand tighten only.
23. Insert supplied wafer bolts through lower hinge into the door, hand tighten only.
24. Align the door to hinge as necessary using the upper bolt on both upper and lower hinges. Snug tighten only until correct alignment is achieved.
25. Tighten all wafer bolts to 12 N·m (105 in-lbs) once door is properly aligned.

**CAUTION: DO NOT OVER TIGHTEN THE WAFER BOLTS AS HEAD SEPARATION MAY OCCUR.**

26. Install the door restraint (check strap) retaining pin.
27. Install the door ajar switch into the "A" pillar.
28. Connect the wiring harness electrical connectors
29. Install the cowl side trim panel (kick panel).
30. Touch up paint as necessary.

**NOTE: THESE PROCEDURES HAVE BEEN TIME STUDIED TO PROVIDE GUIDANCE FOR ESTIMATING CUSTOMER REPAIRS.**

1. Repair "A" 0.5 Hrs.
2. Repair "B" 3.0 Hrs.

***POLICY:***

Information Only.