STELLANTIS
PARTS & SERVICES

Technical Service Bulletin (TSB)

Door Hem Aluminum Body Panel Corrosion Repair

REFERENCE:	**TSB:** 31-001-26 REV. A **GROUP:** 31 - Collision	**Date:**	February 21, 2026	**REVISION:**	31-001-26
VEHICLES AFFECTED:	**2018 - 2026 (JL) Jeep Wrangler** **2020 - 2026 (JT) Jeep Gladiator**			**MARKET APPLICABILITY:** ☒ NA ☒ MEA ☒ SA ☒ IAP ☒ EE ☒ CH **NOTE: This bulletin applies to North America, Enlarged Europe, China, Middle East & Africa and South America markets.**	
CUSTOMER SYMPTOM:	**Customers may experience the following:** • Filifom corrosion at the hem area of the door.				
CAUSE:	**Corrosion**				

This bulletin supersedes Technical Service Bulletin (TSB) 31-001-26, date of issue February 17, 2026, which should be removed from your files. All revisions are highlighted with **asterisks and include and updated Claims Data table.**

REPAIR SUMMARY:

This bulletin involves removing corrosion and refinishing the hem area on the vehicle door.

CLAIMS DATA:

Labor Operation No:	Labor Description	Skill Category	Labor Time
23-75-53-07	JL/JT **Front** Lower Inner Door Hem Flange Repair - ****$46.46 material allowance.**** (1 - Semi-Skilled)	6 - Electrical and Body Systems	3.9 Hrs.
23-75-54-07	JL/JT **Rear** Lower Inner Door Hem Flange Repair- ****$46.46 material allowance.**** (1 - Semi-Skilled)	6 - Electrical and Body Systems	3.9 Hrs.
Failure Code	ZZ	Service Action	

SPARE PARTS:

Qty	Part No.	Description	Notes
(AR)	NPN	3M Clean & Strip Disc	
(AR)	NPN	PPG SX533 Aluminum Cleaner	
(AR)	NPN	PPG SX503 Aluminum Conditioner	
(AR)	NPN	F4921 Epoxy Primer	
(AR)	NPN	3M Cavity Wax	

DIAGNOSIS:

If the customer describes a symptom/condition above, perform the repair procedure.

REPAIR PROCEDURE:

1. Remove door and place on a padded stand to protect the A-side surface of the door.
2. Remove the trim panel and carrier plate. Hinges can remain in place.
3. Remove factory applied seam sealer and clean any pitted areas using a 3M Clean & Strip disc or equivalent abrasive wheel.
4. Feather edge the existing OEM coating area beyond the bare aluminum areas with 320-400 grit sandpaper Fig. 1.

Fig. 1
Door Removed

5. Apply PPG's SX533 Aluminum Cleaner, or equivalent, using a 1:3 mix ratio with water using an acid-resistant brush or synthetic scuff pad, paying close attention to the deeply pitted areas Fig. 2. Allow to react two to three minutes before rinsing with cool, clean water. Rinse water should rinse over the entire surface being treated.

Fig. 2
Aluminum Cleaner Applied

6. Apply PPG's SX503 Aluminum Conditioner or equivalent, as packaged. Allow to react for one to three minutes, until a golden or tan color appears. Rinse well with cool, clean water and dry thoroughly Fig. 2.
7. Clean the area to be refinished with mild soap and water and wax and grease remover prior to masking.
8. Mask the inside of the door using the reverse taping technique around the outer perimeter of the door to reduce any edge build-up of paint material Fig. 3.

Fig. 3
Area Masked

9. Prepare a narrow blend area on both sides of the door in the area shown Fig. 4 and Fig. 5.

Fig. 4
Narrow Blend Area

Fig. 5
Narrow Blend Area

10. Apply one to two coats of F4921 Epoxy Primer or equivalent Fig. 6.

Fig. 6
Epoxy Primer

11. Melt in the edges of the epoxy primer Fig. 7.

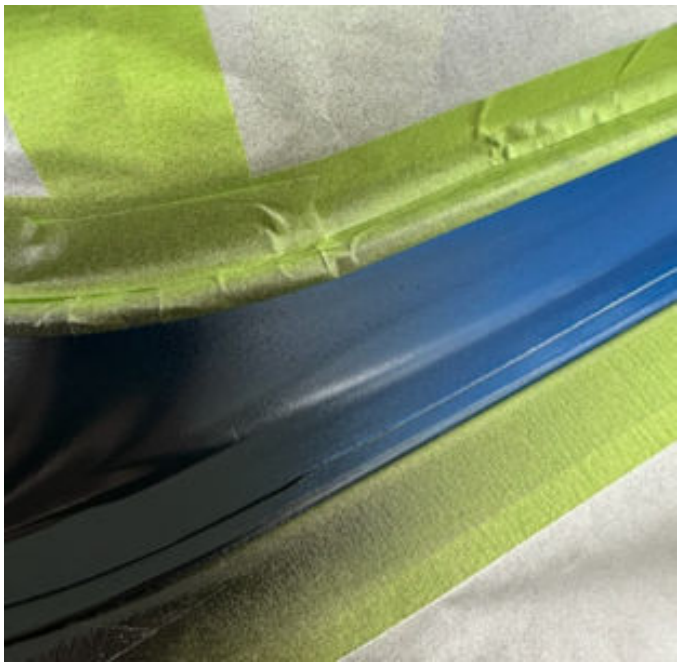

Fig. 7
Melted Edges Of Epoxy Primer

CAUTION!
Allow one-hour dry time or force dry for 25 min at 60 ºC (140 ºF) for the epoxy primer to dry before applying seam sealer.

12. Apply 2K seam sealer in the hinge opening areas and along the entire exposed hem seam Fig. 8, reducing the width and feathering the seam sealer just prior to both blend areas Fig. 9 and Fig. 10.

NOTE: Add hem sealer to the bottom and sides of the door skin hem. The areas near the belt line can be narrowed to reduce a blunt appearance near the blend area.

Fig. 8
Hem Sealer Applied To The Bottom And Sides Of The Door Skin Hem

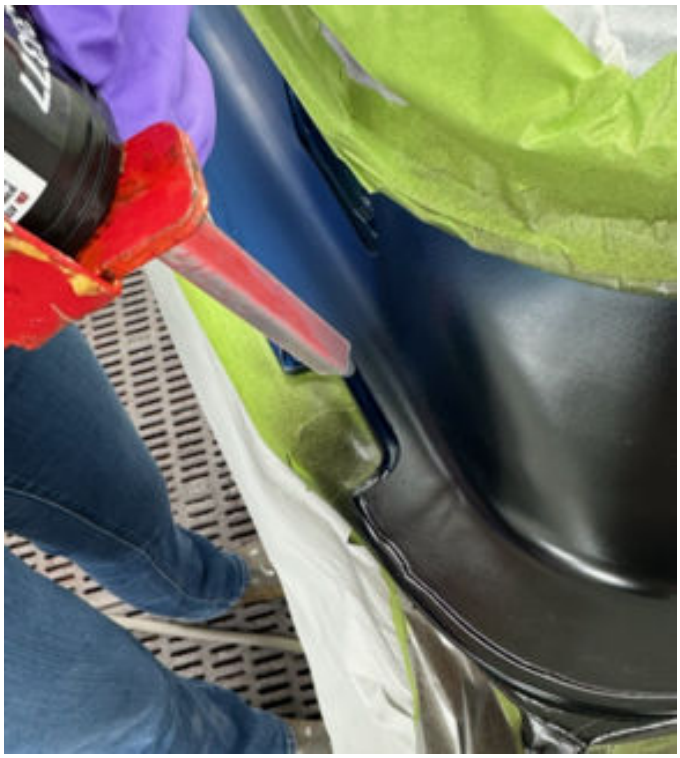

Fig. 9
Seam Sealer

Fig. 10
Seam Sealer Drying

13. Apply primer sealer for uniform hiding and adhesion prior to basecoat Fig. 11.

NOTE: If pits or sanding/grinding marks are noticeable, apply primer surfacer (not shown) to achieve filling.

Fig. 11
Primer Sealer

14. Apply basecoat color to achieve hiding and color match, blend color then clearcoat Fig. 12.

NOTE: Allow clearcoat to air dry overnight or force dry for 25 minutes at 60 ºC (140 ºF).

Fig. 12
Blended Color And Clearcoat

15. Melt in clearcoat overspray in the blend area Fig. 13, Fig. 14 and Fig. 15.

Fig. 13
Melting In Clearcoat Overspray

Fig. 14
Melting In Clearcoat Overspray

Fig. 15
Melting In Clearcoat Overspray

16. Check for clearcoat buildup on the edge of the hem Fig. 16.

Fig. 16
Edge Of Hem

17. Apply masking tape to drain holes/openings at the bottom of the door as shown to prevent overspray.
18. Apply 3M's Cavity Wax or equivalent to the inside of the door shell between the door skin and door shell frame Fig. 17.

Fig. 17
Applying Cavity Wax

NOTE: For SA market only, after applying this TSB, it is not necessary to send DID-I or DID-A.

POLICY:

Reimbursable within the provisions of the warranty.