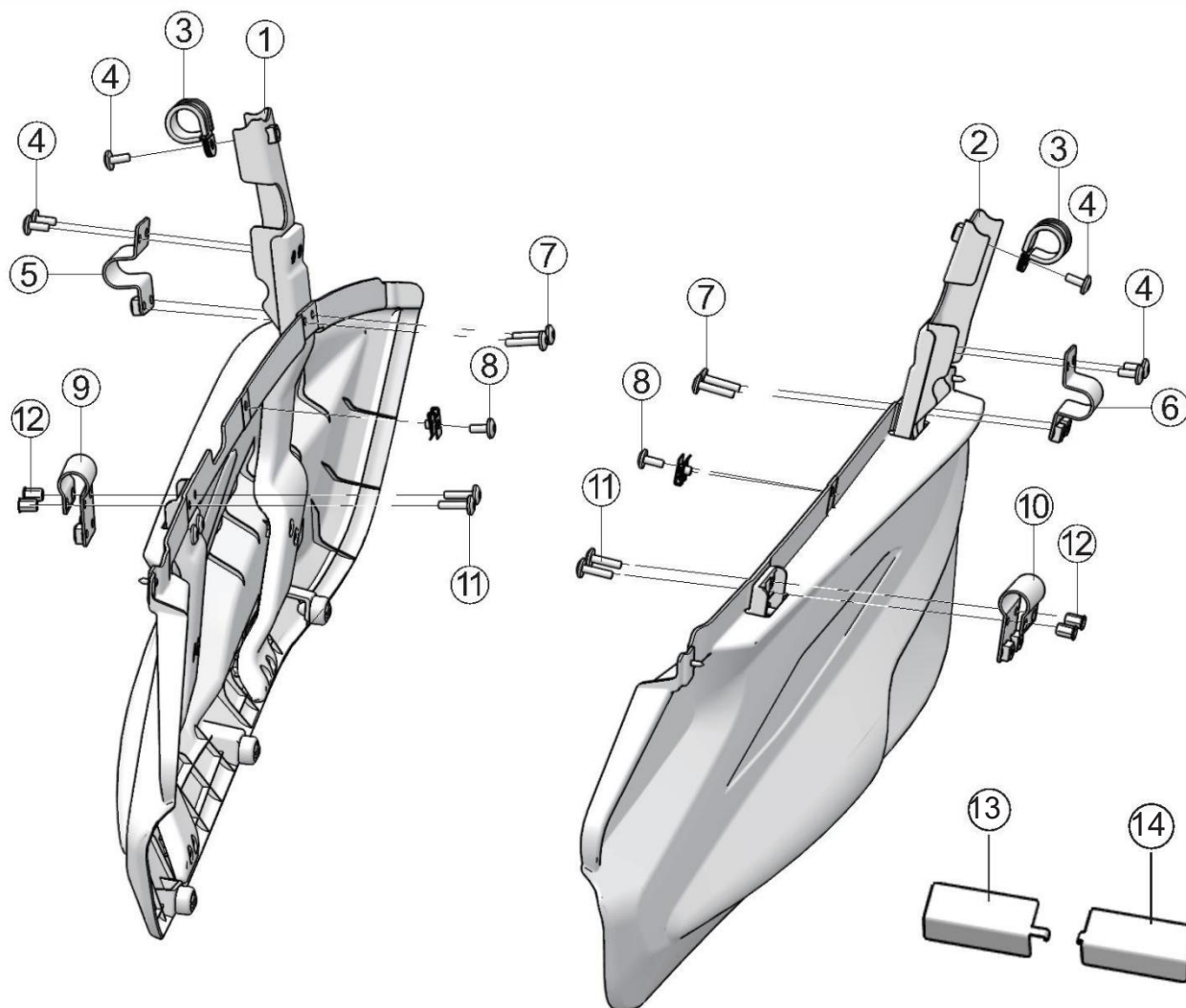


Half Door Assembly-Villain

Half Door Assembly- Villain

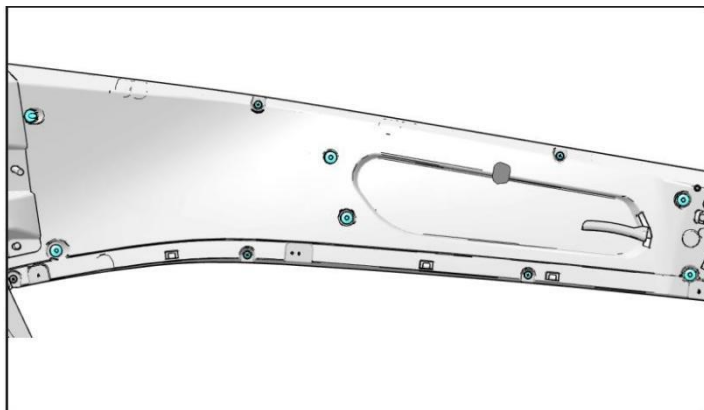


NO	Part Name	Part number	QTY	Applicable models
1	Right door connection component	S01-R120240-000-00	1	
2	Left door connection component	S01-R120250-000-00	1	
3	CLAMP, 25	T05000004001	2	
4	BOLT M6×16	T03000007002	6	
5	Right hoop bracket	S05-R017000-0MP-00	1	
6	Left hoop bracket	S05-R012000-0MP-00	1	
7	Bolt M6×30	T03000007005	4	
8	BOLT M6×16(not equipped)	T03000007002	2	
9	Front right door lower bracket	S05-R013000-0MP-00	1	
10	Front left door lower bracket	S05-R010000-0MP-00	1	
11	Bolt M6×20	T03000007003	4	
12	Hexagon rivet nut	BG178805-06100-061	4	
13	Rear door cutting tool	S05-R120242-0MP-00	1	
14	Front door cutting tool	S05-R120241-0MP-00	1	

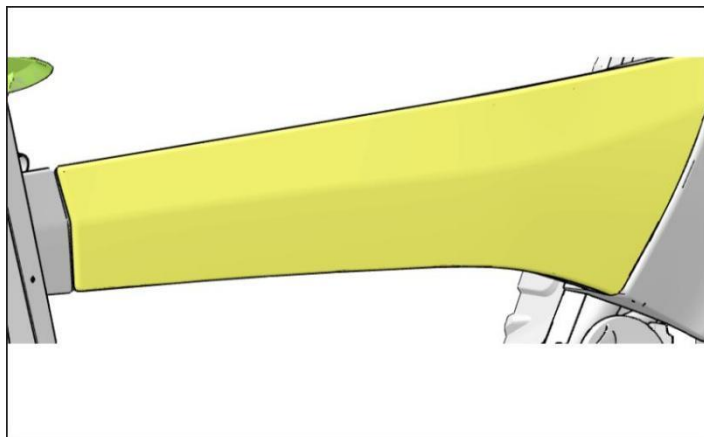
Half Door Assembly-Villain

Assembly of half-door components

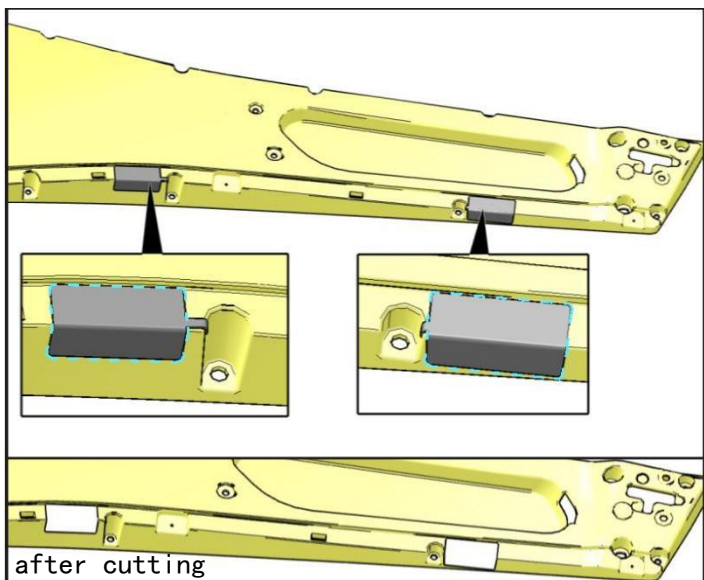
1. Remove the fasteners from the left (right) door liner.



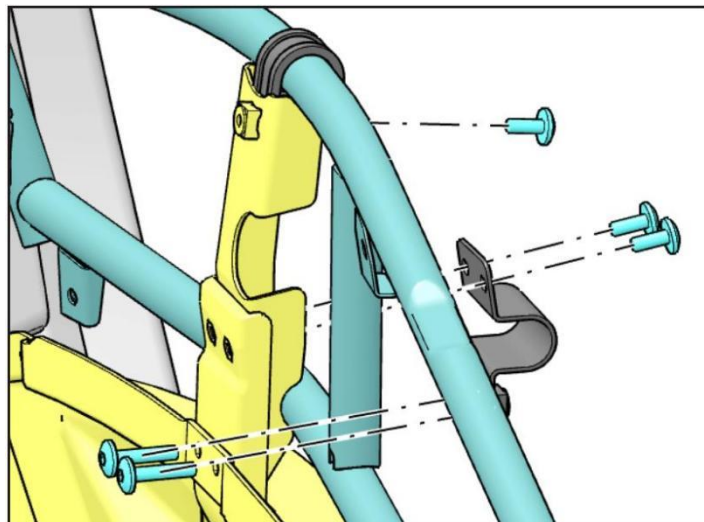
2. Remove the door panels and door liners.



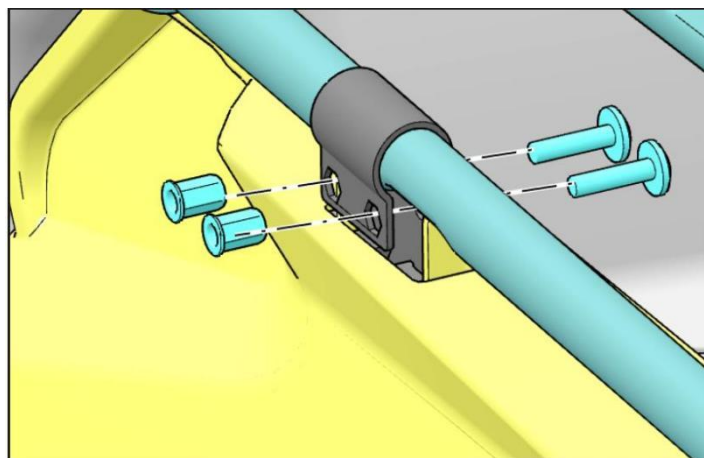
3. Place the left (right) door cutting tool on the door liner at a suitable position (the position shown in the figure below), draw the outline of the tooling on the liner and cut the liner here with the tool.



4. Secure the rear of the half door to the door bracket with a 25 Clamp and hoop bracket and bolts



4. Secure the front of the half-door ASSY with the lower half-door adapter bracket , using the bolt and flat head hexagonal rivet nuts to the door bracket.



5. After installing the door panels and reattaching the door liners with fasteners for fastening.

