



NUMBER: 23-046-07

GROUP: Body

DATE: October 30, 2007

This bulletin is supplied as technical information only and is not an authorization for repair. No part of this publication may be reproduced, stored in a retrieval system, or transmitted, in any form or by any means, electronic, mechanical, photocopying, or otherwise, without written permission of Chrysler LLC.

THIS BULLETIN SUPERSEDES TECHNICAL SERVICE BULLETIN 23-003-06, DATED JANUARY 19, 2006, WHICH SHOULD BE REMOVED FROM YOUR FILES. ALL REVISIONS ARE HIGHLIGHTED WITH **ASTERISKS**** AND INCLUDE ADDITIONAL YEARS AND MODELS.**

SUBJECT:

Paint Repair - Etching

OVERVIEW:

This bulletin involves evaluating the paint condition on all horizontal panels for etching and using the procedures listed in the Paint Condition Deck p/n 81-316-0507 or using the information listed in this bulletin

MODELS:

2006 - **2008**	(CS)	Pacifica
2006 - **2008**	(DR/D1/DC/DH)	Ram Truck
2006 - **2008**	(HB)	Durango
**2007 - 2008	(HG)	Aspen **
2006 **2007 - 2008	(JR)	Sebring Convertible/Sebring Sedan/Stratus Sedan
**2007 - 2008	(JS)	Sebring/Sebring Convertible/Avenger **
**2007 - 2008	(JK)	Wrangler **
**2007 - 2008	(KA)	Nitro **
2006 - **2007**	(KJ)	Liberty
**2008	(KK)	Liberty **
2006 - **2008**	(LX)	300/Magnum/ **Charger**
**2007 - 2008	(MK)	Compass/Patriot **
2006 - **2008**	(ND)	Dakota
**2007 - 2008	(PM)	Caliber **



Stick with the Specialists™

2006 - **2007**	(RS)	Town & Country/Caravan
2008	(RT)	Town & Country/Grand Caravan
2006	(TJ)	Wrangler
2005 - **2008**	(WK)	Grand Cherokee
2006 - **2008**	(XK)	Commander

DIAGNOSIS:

Inspect the vehicle horizontal panels for the appearance of an etched surface (picture available in "PAINT CONDITION DECK" - publication number 81-316-0507 - see "INSECT ETCH" graphic).

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 etch area.

PARTS REQUIRED:

Qty.	Part No.	Description
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
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)
-------------	--

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.

NOTE: No clear coat spot Repair should be performed on class “A” surfaces.

POLICY:

Reimbursable within the provisions of the warranty.

TIME ALLOWANCE:

Labor Operation No:	Description	Amount
Repair Procedure “A” Finesse:		
23-65-21-90	Panel, Hood - Perform Repair Procedure “A”	A/T
23-65-27-90	Panel, Cowl - Perform Repair Procedure “A”	A/T
23-65-31-90	Panel, Deck - Perform Repair Procedure “A”	A/T
23-65-41-90	Panel, Roof - Perform Repair Procedure “A”	A/T
23-65-42-90	Panel, Liftgate - Perform Repair Procedure “A”	A/T
23-65-49-90	Spoiler, Deck Lid / Liftgate - Perform Repair Procedure “A”	A/T
Repair Procedure “B” Refinish		
23-70-21-90 *	Panel, Hood - Perform Repair Procedure “B”	CS/RS/RT 2.6 Hrs. KJ/LX/ND/DR/DH/D1/DC 2.5 Hrs.

		HB/HG, 2.7 Hrs. JK 2.9 Hrs. JR41 2.8 Hrs. JR27/TJ/WK/XK 2.9 Hrs. JS 2.8 Hrs. KJ/KK/KA 2.5 Hrs. PM/MK 2.0 Hrs.
23-70-27-90 *	Panel, Cowl - Perform Repair Procedure "B"	TJ/JK 1.8 Hrs.
23-70-31-90 *	Panel, Deck Lid - Perform Repair Procedure "B"	LX 1.9 Hrs. JR41/JS 2.7 Hrs. JR27 2.5 Hrs.
23-70-49-90 *	Spoiler, Deck Lid / Liftgate - Perform Repair Procedure "B"	JR/LX/DR 1.0 Hrs.
23-72-42-90 *	Panel, Liftgate - Perform Repair Procedure "B"	CS/LX/ RS/RT/XK/WK 2.6 Hrs. KA/KK 2.5 Hrs. PM/MK 1.9 Hrs. HB/HG 3.2 Hrs.
23-70-41-90 *	Panel, Roof - Perform Repair Procedure "B"	CS 3.9 Hrs. DR/DH/D1/DC 3.1 Hrs. HB/HG 4.7 Hrs. JR41/JS 3.3 Hrs KJKA/KK/WK/XK 4.0 Hrs. LX 3.0 Hrs. ND 2.5 Hrs. RS/RT 3.9 Hrs.
23-70-41-91 *	Panel, Roof - 4DR/Club Cab - Perform Repair Procedure "B"	DR/DH/DC/D! 3.0 Hrs ND 3.0 Hrs
23-70-41-92 *	Panel, Roof - Mega Cab - Perform Repair Procedure "B"	DR/DH 3.4 Hrs

NOTE: * Refer to QuickLOP or appropriate LOTS for material allowance, optional equipment and related operations.

FAILURE CODE:

ZZ	Service Action
----	----------------