



## **Fitment Of Motorcraft Entrance Doors**

MC-TI-A4-01404

### **Technical Instruction**

Revision 1.0

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## 1. Revision History

This document will be updated, when necessary, by issue of the complete document. The amendments or additional parts will be marked by red text until the document is revised again.

Issue	Description	Prepared By	Approved By	Date
1.0	First Issue	T. Parkin-Coates	G. Shears	10/10/24

*Table 1*

## 2. Inventory

References.

Item	Document No. / URL	Title
1.	<a href="https://www.motorcraftoa.com/overland-vehicle-doors">https://www.motorcraftoa.com/overland-vehicle-doors</a>	Motorcraft OA Doors Webpage

*Table 2*

Ensure all parts and fixings listed in this document are obtained before starting the assembly. If anything is missing from the product, please contact Motorcraft Overland Accessories Ltd.

## 3. Introduction

This instruction defines the method to be followed in fitting Motorcraft Overland Accessories Ltd expedition doors. All types of doors fit the same way.

## 4. Responsibility

It is the responsibility of the Fitter that all documentation is followed.

**Motorcraft Overlander Accessories Ltd recommend that this product is installed by a trained professional.**

## 5. Items Required

Tool Description	Tool Size
Allen Key	4mm
Pozi Drive Screwdriver	
Sandpaper	180 Grit
Sealant Gun	
Jigsaw (Circular Saw recommended)	Blade / Cutting depth to get through panel
Panel Cleaner / Wipes	
Grinder	Cutting Disc
Telescopic Prop or 1m Lengths of Timber	x4
Packers	Various sizes
Warm soapy water	
Expanding Foam	

Table 3

## 6. Fixings Required

Fastener Description	Quantity	Recommended Tightening Torque
Solvent Free Polyurethane Adhesive such as Bostik Simson ISR 70-08 AP	2 x 600ml Tubes	N/A

Table 4

## 7. Advised Personal Protection Equipment

- Protective Work Glasses
- Rubberised Work Gloves
- Cut resistant Gloves
- Steel Toe Cap Boots
- Ear Defenders
- Respiratory Dust Mask

HAVING A WORK PARTNER IS ADVISED WHEN  
CONDUCTING THIS INSTALLATION

For any questions regarding the assembly of this product, please contact Motorcraft Overland Accessories Ltd.

## 8. Measuring Up

- 8.1. Obtain your Motorcraft door and place it face down on your work surface. Ensure a clean cloth is placed first to reduce the chance of scratching the door and GRP frame.
- 8.2. Using a tape measure, measure the GRP frame to determine the size of the cut you will need to make from the outside of your panel. The measurements required is shown in Figure 1.

*Note: Although this information may be available on the website, it is essential to check the physical product sizes due to Fibreglass thickness tolerances.*

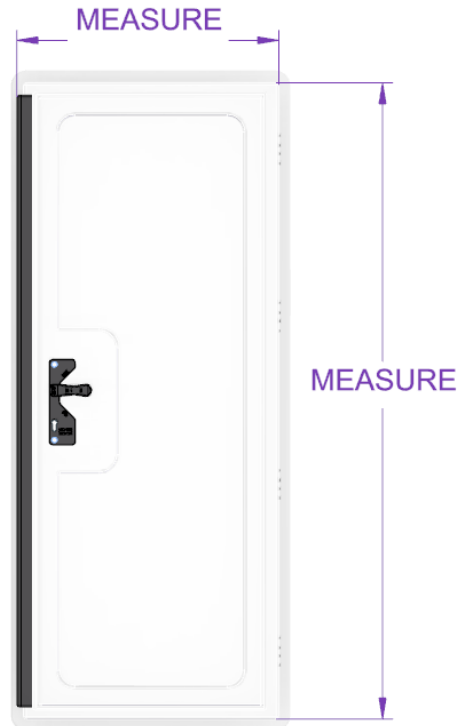


Figure 1: Inside Door Measurement

## 9. Panel Prep for Cutting

- 9.1. Wash the Panel thoroughly with soapy warm water and a sponge and then dry with a clean cloth.
- 9.2. Using a vibrant Marker Pen and a straight edge, mark on the panel the measurements taken from point 8.2. (Figure 1) in the desired location on the panel.

*Note: The Door must be fitted to a flat surface.*

- 9.3. Ensure the door location is correct on the inside and the outside before cutting the panel. This can be checked by drilling a small pilot hole in the corner of the proposed cut-out. Then go around to the other side of the panel and see where the pilot hole is located.
- 9.4. Ensure you are happy with the door location BEFORE continuing.

## 10. Making The Cut-out

- 10.1. Using a Drill create a hole, all the way through, inside the drawn cut-out area. Ensure the drill bit is big enough to allow a jigsaw blade to get through the hole. This point can be skipped if a Circular Saw is being used.
- 10.2. Using a Jigsaw, with a 100mm blade, or better still a Circular Saw (either wood or metal blade based on your panel spec), cut out the centre of the door hole following the drawn lines made in point 9.2. Now, your panel should look like Figure 2.

*Note: Ensure suitable PPE is worn whilst making the cuts through the panel and handling the cut piece.*

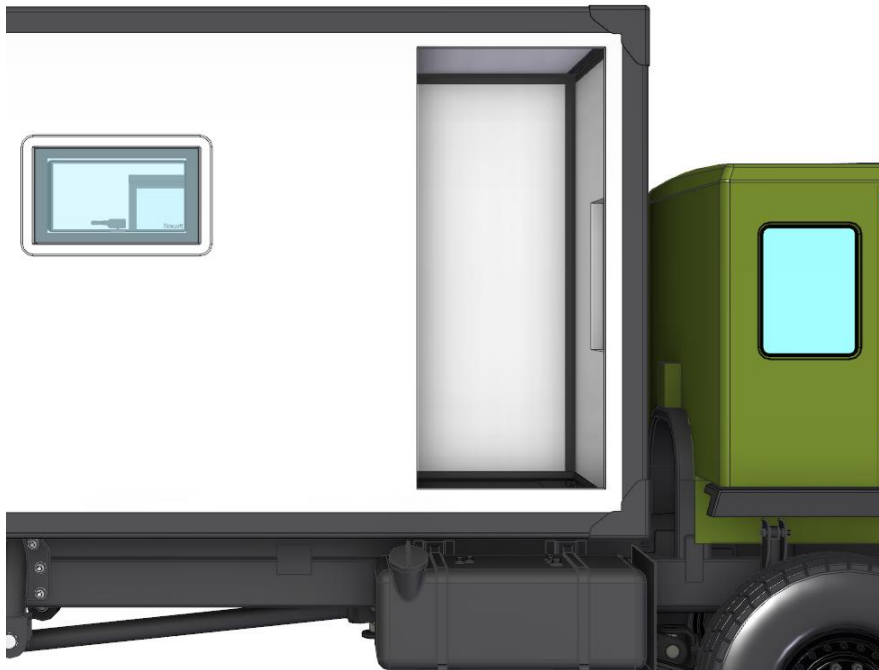


Figure 2: Cut Door Hole

## 11. Panel Prep for Bonding

- 11.1. For installations on Aluminium Panels, obtain a Bastard File and file the edges around the cuts to remove sharp burrs. Ensure suitable PPE is worn such as cut resistant gloves.
- 11.2. Obtain Sandpaper and begin to sand around the door cut-out where the Motorcraft door flange will meet the panel surface, such as Figure 3 (Area shown in Yellow). This creates a coarse bonding surface for the adhesive.



*Figure 3: Bonding Surface Area*

- 11.3. Using a Panel Cleaner / Wipe, clean the area which has just been sanded in order to clean the bonding surface and remove dust and remaining deposits.



## 12. Dry Fit & Trimming

- 12.1. With the help of an assistant, dry fit the door and prop in place to ensure the cutout is big enough. Ensure the door is comfortably in its final position.
- 12.2. On the inside of the body with a marker pen, draw around the inside of the door frame to cut off the excess door frame. Ensure not to trim the door too small and cut through the locking mechanism.
- 12.3. If the panels are less than 60mm or you have purchased a door that isn't from the Motorcraft '65' or '75' range, internal trims will need to be installed to fetch the panel out to the door frame.
- 12.4. Once the door is marked, take the door out and place face down on a soft work surface.
- 12.5. Using a Grinder with a cutting disc, cut off the excess GRP from the door frame to get the door trimmed down to suit the panel. Again, ensure not to cut through any of the ironmongery of the door.

*Note: Depending on which door you have purchased, will affect how much you can trim the inside of your door.*

## 13. Bonding in the Motorcraft Door

**MOTORCRAFT OVERLAND ACCESSORIES LTD  
RECOMMEND YOU GET A SECOND PERSON TO HELP  
YOU FIT OUR PRODUCTS**

- 13.1. Prior to bonding the door in place, dry fit the door and check the fitment and that it is correct. Make sure the Door is being fitted in a dry environment and will not get wet or rained on.
- 13.2. Using a Solvent Free Polyurethane Adhesive, such as Bostik Simson ISR 70-08 AP, apply adhesive around the GRP frame, around the back side of the flange where the door contacts the panel. See figure 4.



*Figure 4: Bonding Surface Area*

- 13.3. Additionally, apply more adhesive around the door frame where the GRP will contact the cut faces of the panels all the way around, shown in Yellow in Figure 5.

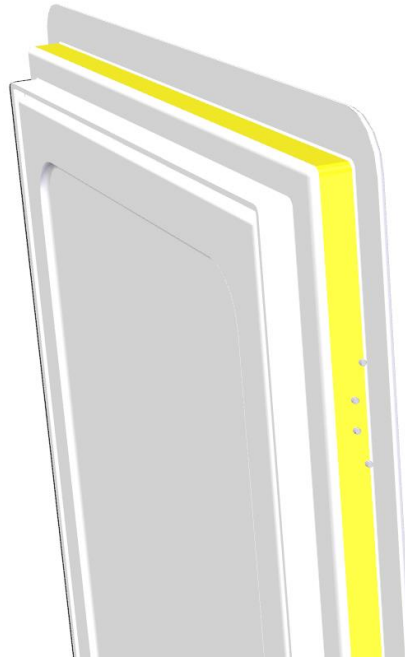


Figure 5: Bonding Surface Area

*Tip: Ensure to apply a generous amount of glue. Cut the Glue nozzle down and create a 'V' shape cut to allow for a tall bead.*

- 13.4. With the assistance, install the door. Ensure the door is level and in the correct place. If possible, get inside the body and fit plastic packers between the door and the panel to align if required.
- 13.5. Obtain props and apply force onto the door in four places shown in Figure 6. Do not fit the props at the top of the door as the door must set straight and not to the contour of your panel to ensure it operates correctly.

If you don't have any props, two lengths of timber can be used along with screws. Ensure the screws go into the panel as close to the GRP door frame as possible. Therefore, when you seal around the door frame, the screw holes will be sealed also.

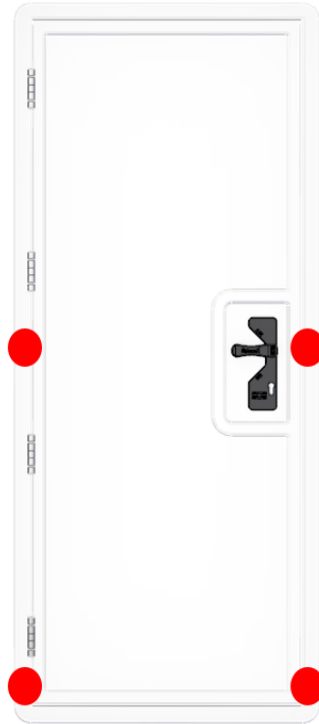


Figure 5: Prop Placement

- 13.6. While the glue is still wet, use a plastic scraper to scrape off the excess glue. Use a damp cloth to wipe around the door. Otherwise, once the door is set, use a Stanley Knife or scraper to get the excess glue off.
- 13.7. Leave the door to set. Read the advice on the back of the glue tube for drying times. However, Motorcraft recommend **24 hours at 16+°C** or **48 hours below 16°C** drying time.

*Tip: Lay a bead of adhesive on a different surface. After 24 hours, cut the bead in half to see the inside of the glue to see if it has fully cured as a guide for the door.*

## **14. Internal Finishing**

- 14.1. On the inside of the door, there is a gap between the door frame and the panel. Obtain expanding foam and fill around the door to ensure insulation properties remain intact.
- 14.2. Once the expanding foam has set, cut the excess foam off the door so the door frame is now flush with the inside face of the panel.
- 14.3. Now, the door is ready to be trimmed on the inside as per the interior design.

## **15. Fine Adjustment**

- 15.1. Once the quoted time has passed, it is safe to remove all props from the door. The adhesive should be set, and the door fixed into the panel.
- 15.2. Ensure to clean the door inside and out to remove any dust or debris and the door seal.
- 15.3. Operate the door. Ensure the door opens correctly and locks and unlocks correctly.
- 15.4. If required, using a 4mm Allen Key and a Pozi Drive Screwdriver, rotate the screw heads (Shown in Figure 6) circled in red to either bring the keeps forward or backwards depending on what your door requires. Ensure the door is still making contact with the seal all the way around once the door has been adjusted.



Figure 2: Door Adjustment

END

If technical assistance is required contact Motorcraft Overlander  
Accessories Ltd via email. [Contact@motorcraftoa.com](mailto:Contact@motorcraftoa.com)