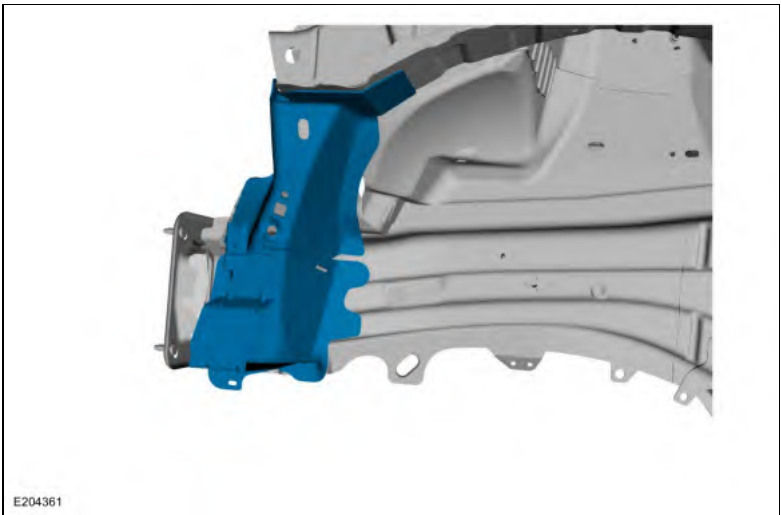
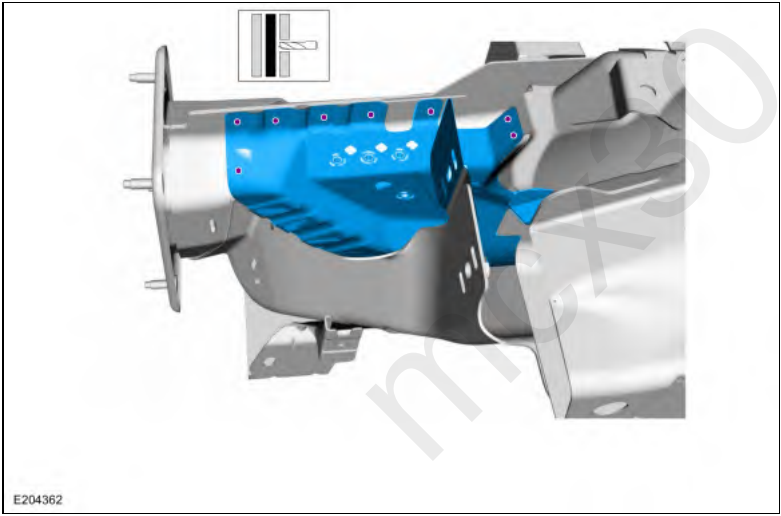
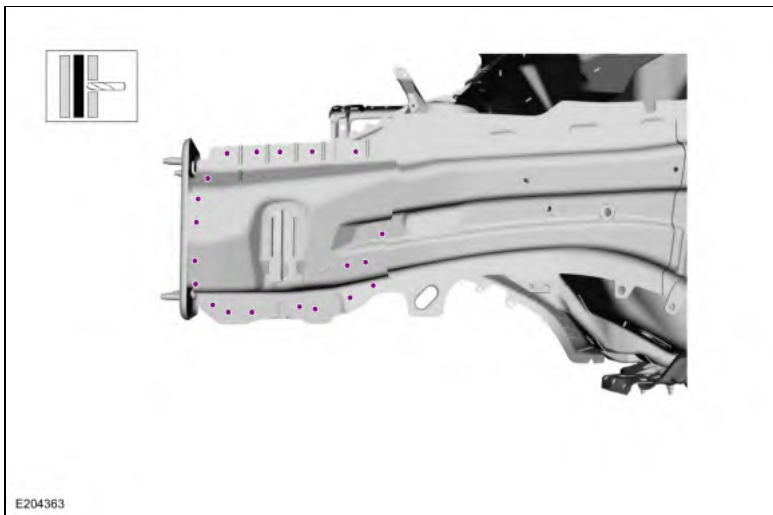




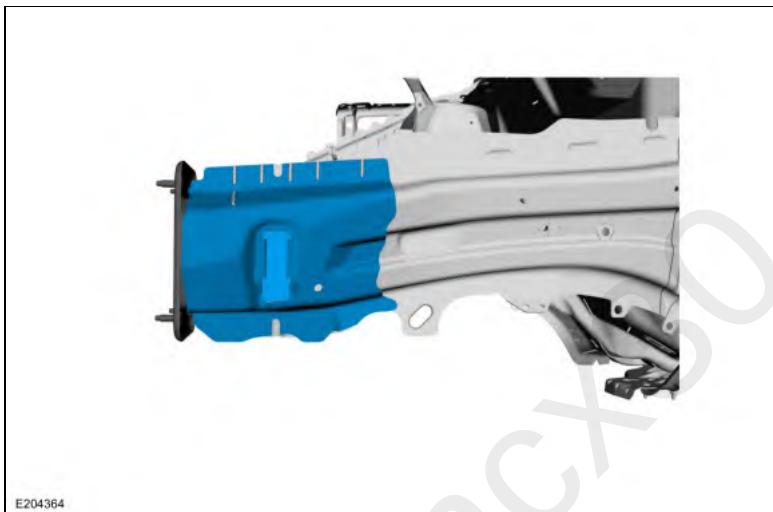
7. Remove the spot welds and remove the panel from the fender apron assembly.
Use the General Equipment: Spot Weld Drill Bit



8. Remove the spot welds on the outer side member.
Use the General Equipment: Spot Weld Drill Bit

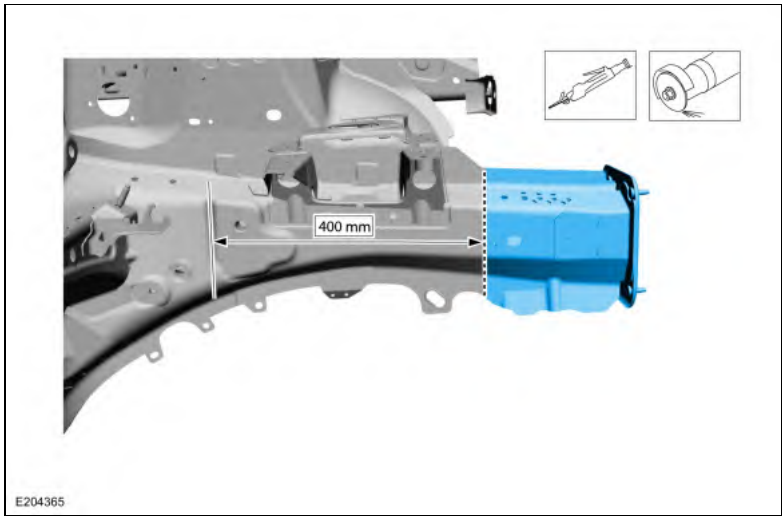


9. Remove the section on the outer member.

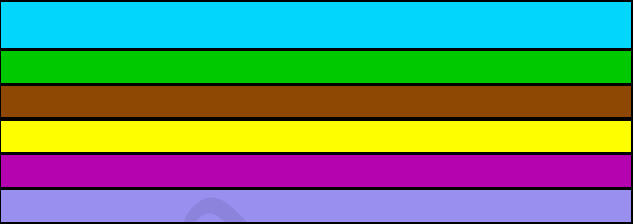


10. **NOTICE:** Cut through the inner side member only.

Measure and cut the inner side member and remove.
 Use the General Equipment: Spherical Cutter
 Use the General Equipment: Air Body Saw

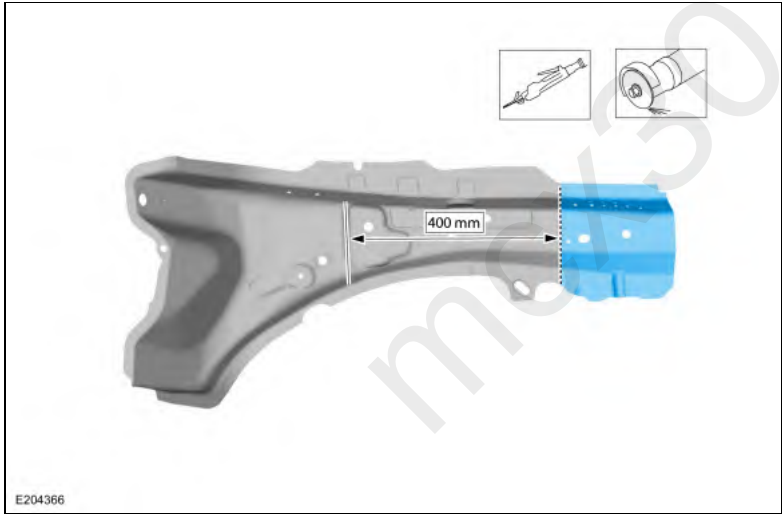


E204365



Installation

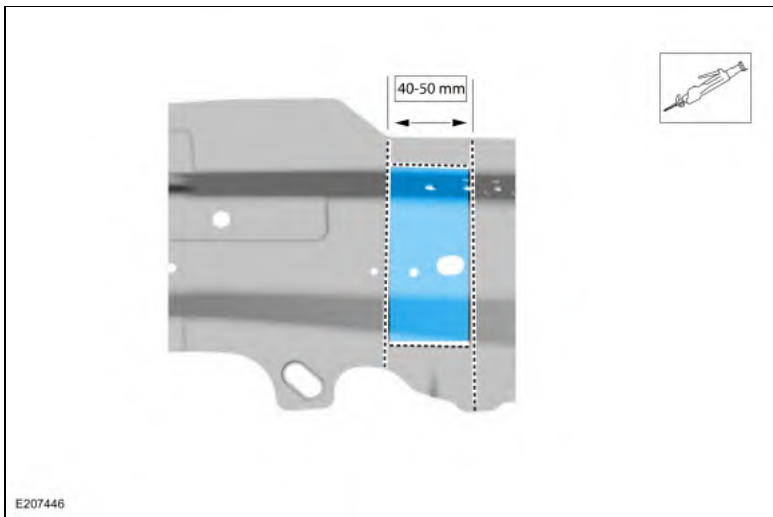
1. Measure and cut section from the replacement part.
Use the General Equipment: Spherical Cutter
Use the General Equipment: Air Body Saw



E204366



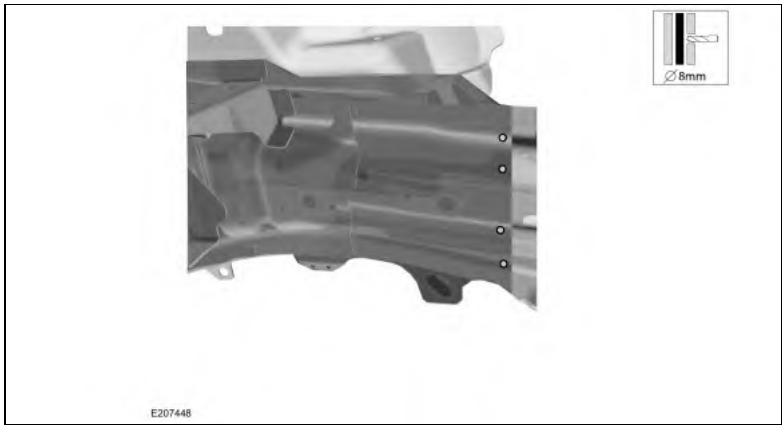
2. Create a backer piece from a suitable piece of the inner frame rail material.



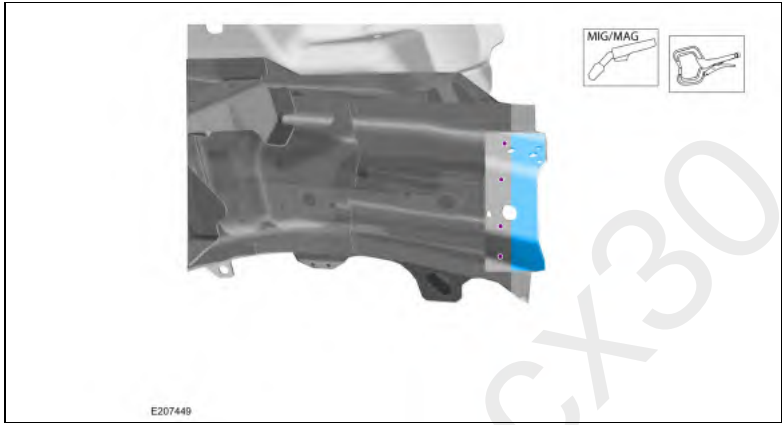
3. Drill holes for plug welding the replacement inner frame rail section.
Use the General Equipment: 8 mm Drill Bit



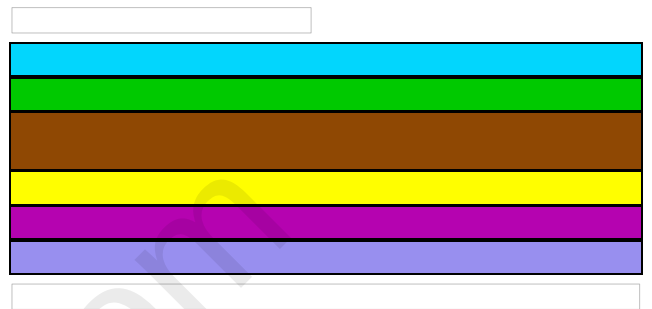
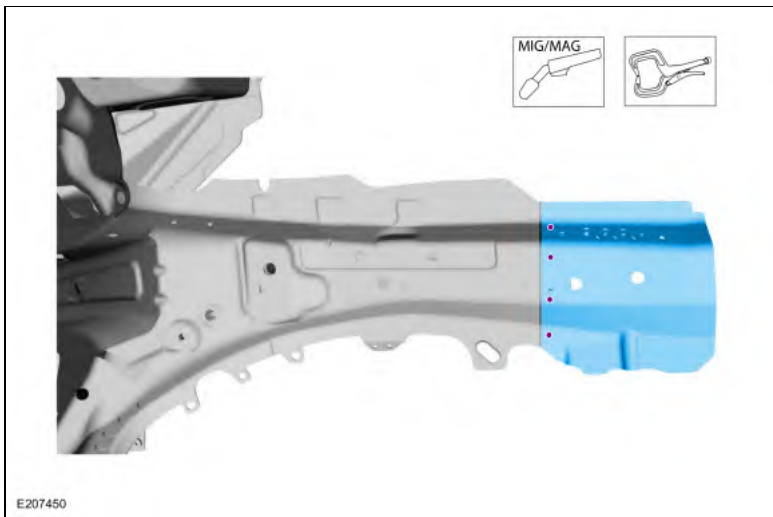
4. **NOTE:** Fender apron panel and engine mounting brackets removed from view for clarity.
Drill holes for plug welding in the inner frame rail section.
Use the General Equipment: 8 mm Drill Bit



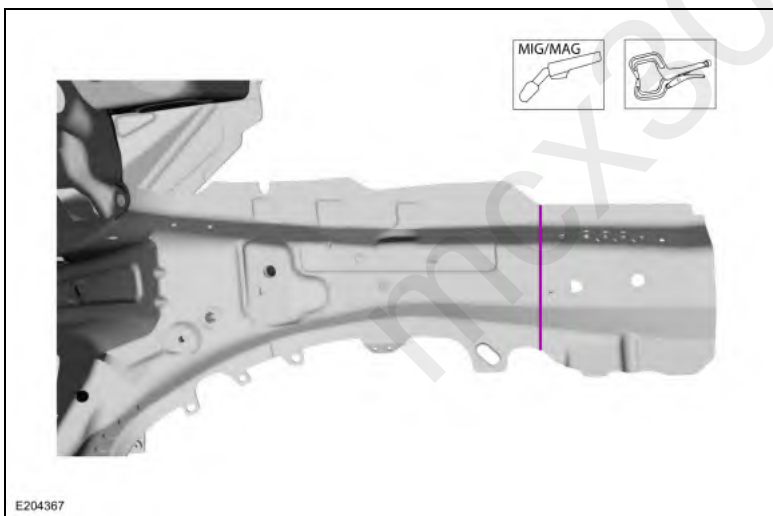
5. Install the backer reinforcement and weld to the inner frame rail.
Use the General Equipment: Locking Pliers
Use the General Equipment: MIG/MAG Welding Equipment



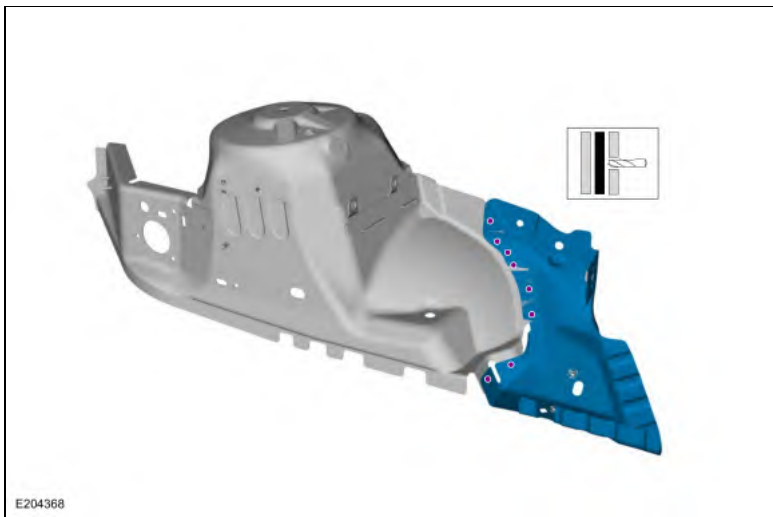
6. **NOTE:** Check for dimensional accuracy *before* welding.
Install the frame rail replacement section and weld.



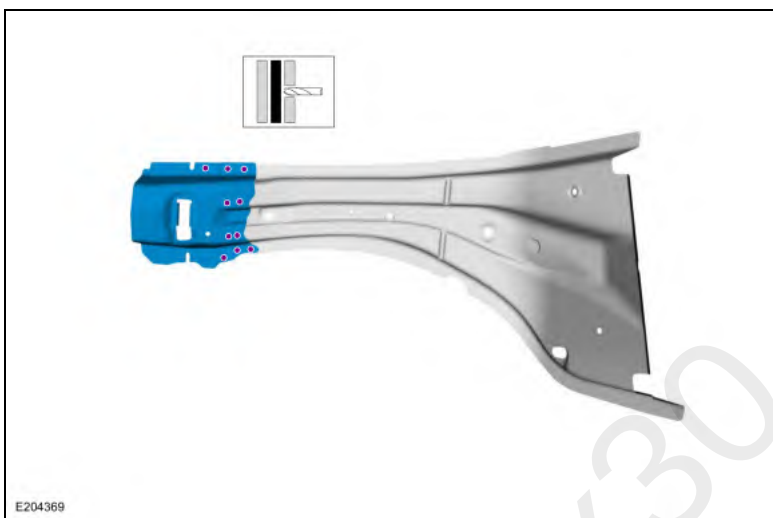
7. Seam weld the replacement section.
 Refer to: Body and Frame (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).
 Use the General Equipment: MIG/MAG Welding Equipment
 Use the General Equipment: Locking Pliers



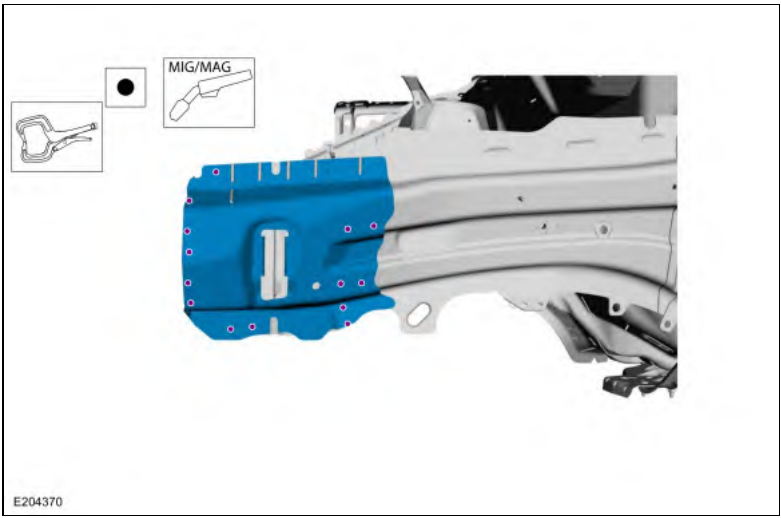
8. **NOTE:** Original panel may be reused if undamaged, otherwise replacement panel will need to be removed from a new fender apron assembly and installed.
 Remove the panel from the fender apron assembly.
 Use the General Equipment: Spot Weld Drill Bit



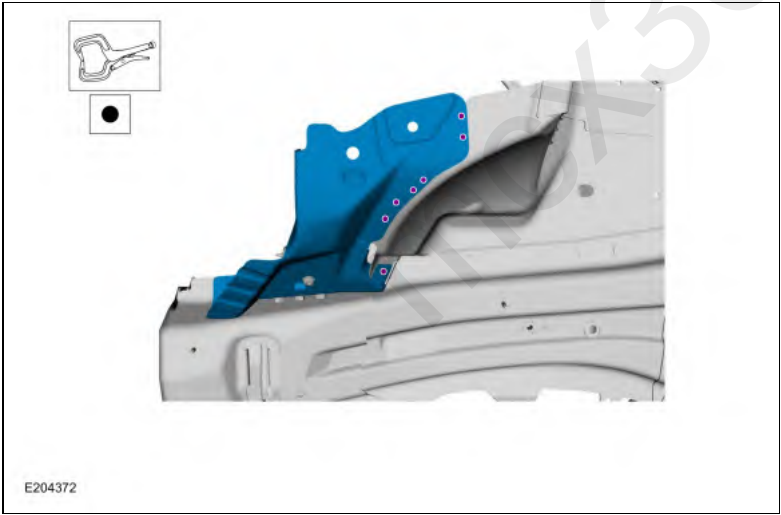
9. Remove section from the replacement part.
Use the General Equipment: Spot Weld Drill Bit



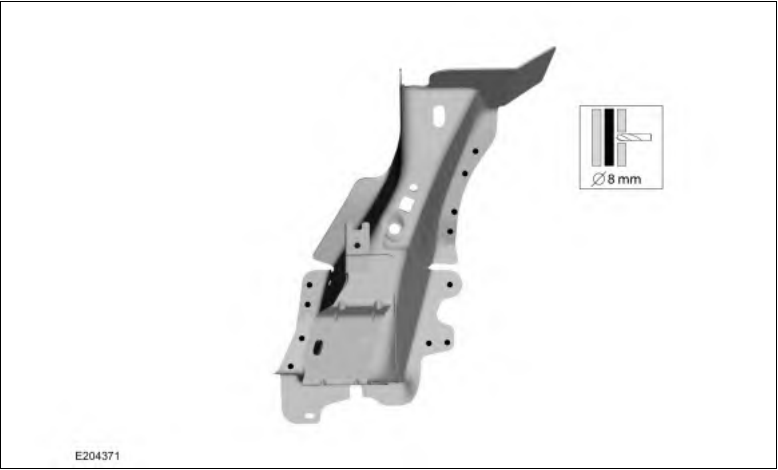
10. Install the replacement section and weld.
Use the General Equipment: MIG/MAG Welding Equipment
Use the General Equipment: Resistance Spotwelding Equipment
Use the General Equipment: Locking Pliers



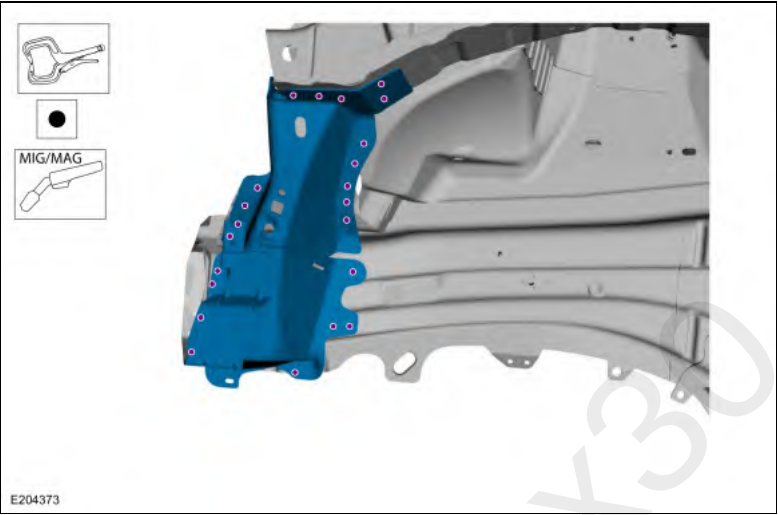
11. Install the panel to the fender apron assembly and resistance spot weld.
Use the General Equipment: Locking Pliers
Use the General Equipment: Resistance Spotwelding Equipment



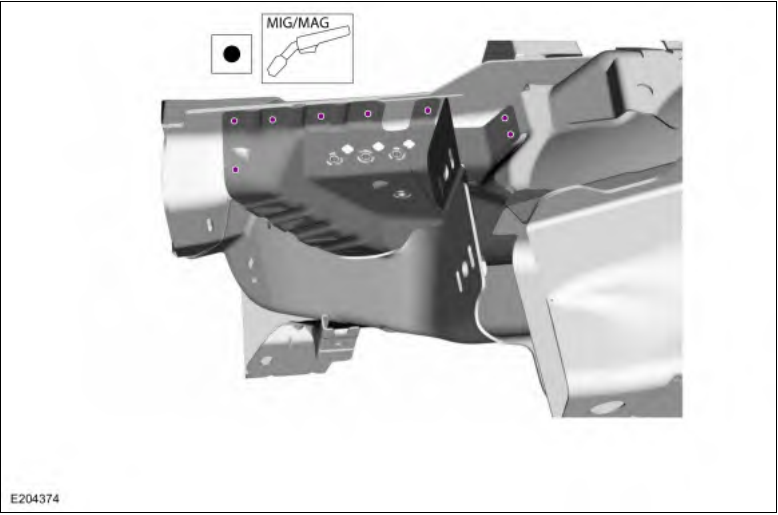
12. Drill holes in the replacement fender mounting bracket for plug welding.
Use the General Equipment: 8 mm Drill Bit



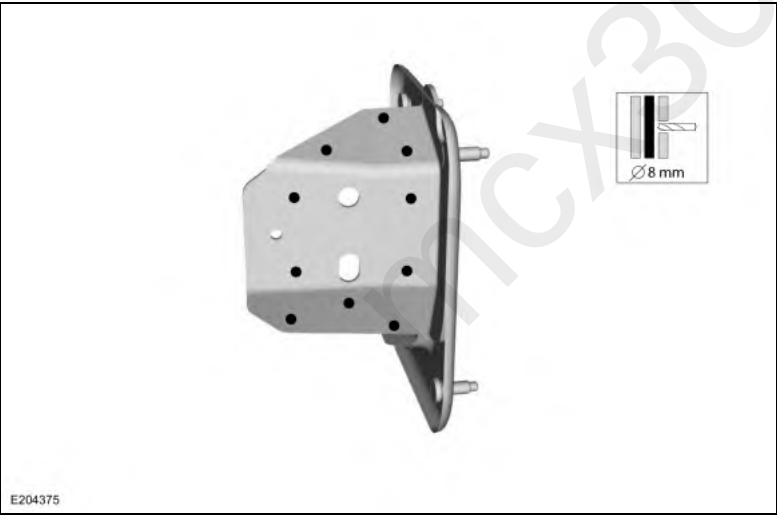
13. Install the fender mounting bracket and weld.
Use the General Equipment: MIG/MAG Welding Equipment
Use the General Equipment: Resistance Spotwelding Equipment
Use the General Equipment: Locking Pliers



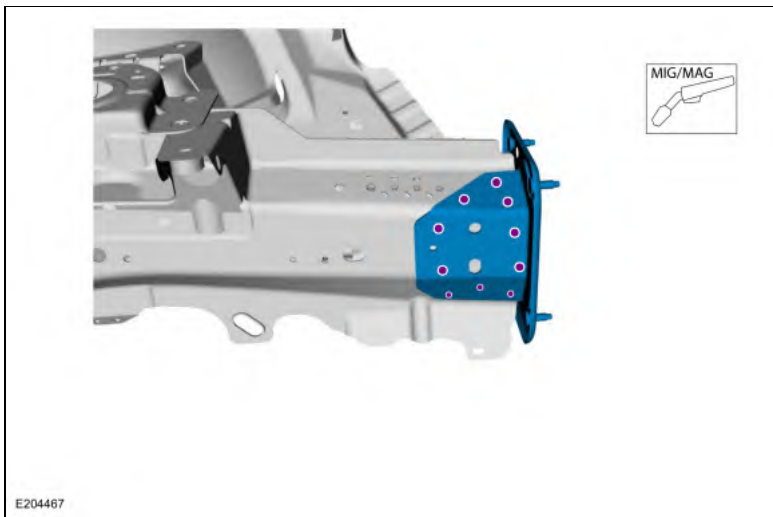
14. Weld the panel flanges.
Use the General Equipment: MIG/MAG Welding Equipment
Use the General Equipment: Resistance Spotwelding Equipment



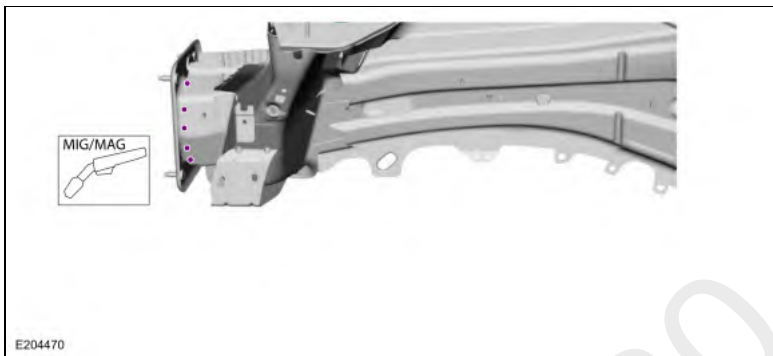
15. Drill holes in the bumper mount bracket replacement part for plug welding.
Use the General Equipment: 8 mm Drill Bit



16. Install the bumper mounting bracket and weld to the inner side member.
Use the General Equipment: MIG/MAG Welding Equipment



17. Complete welding the bumper mounting bracket on the outer side member.
Use the General Equipment: MIG/MAG Welding Equipment



18. Complete all panel sectioning seams using typical metal finishing techniques.
19. Prime the entire repair using a Ford approved paint system
20. Sealing work: All areas must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M[®], 08308, LORD Fusor[®] 805DTM
21. Refinish using a Ford approved paint system.
22. Restore corrosion protection.
Refer to: Corrosion Prevention (501-25 Body Repairs - General Information, General Procedures).
23. Install the radiator grille opening panel.
24. Install the following items:
 1. Install the subframe.
Refer to: Front Subframe (502-00 Uni-Body, Subframe and Mounting System, Removal and Installation).
 2. Install the cooling module (as equipped).
Refer to: Cooling Module (303-03A Engine Cooling - 2.0L EcoBoost (184kW/250PS) 4-cyl MI4, Removal and Installation).
Refer to: Cooling Module (303-03B Engine Cooling - 2.7L EcoBoost (238kW/324PS), Removal and Installation).
 3. Install the bumper.
Refer to: Front Bumper (501-19 Bumpers, Removal and Installation).
 4. Install the headlamp assembly.
Refer to: Headlamp Assembly (417-01 Exterior Lighting, Removal and Installation).
 5. Install the fender.
Refer to: Fender (501-02 Front End Body Panels, Removal and Installation).
 6. Install the fender splash shield.
Refer to: Fender Splash Shield (501-02 Front End Body Panels, Removal and Installation).
 7. Install the hood.
Refer to: Hood (501-02 Front End Body Panels, Removal and Installation).
 8. Install the battery, LH side only.
Refer to: Battery (414-01 Battery, Mounting and Cables, Removal and Installation).

501-28 Roof Sheet Metal Repairs

Removal and Installation

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