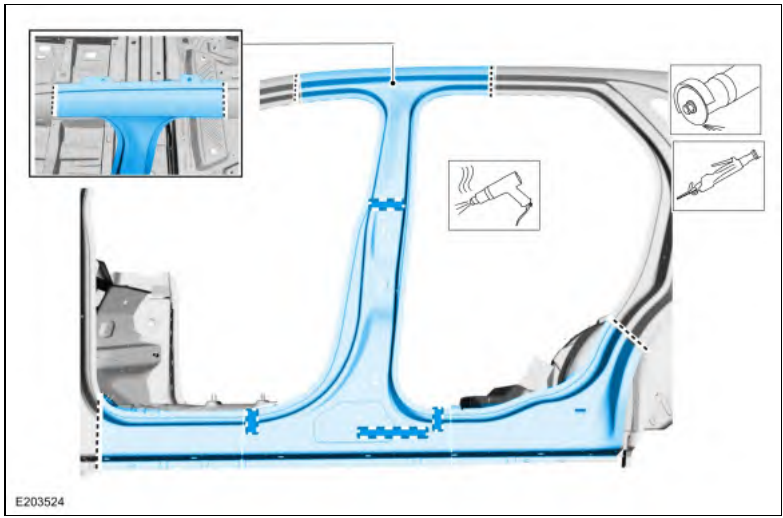
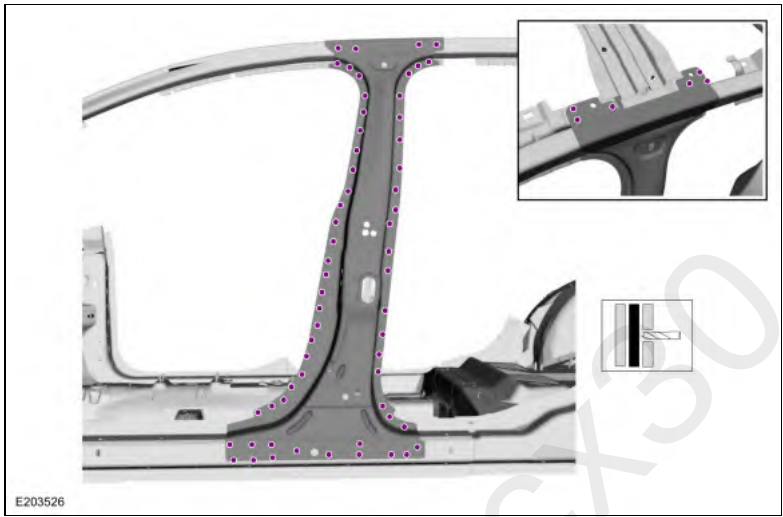
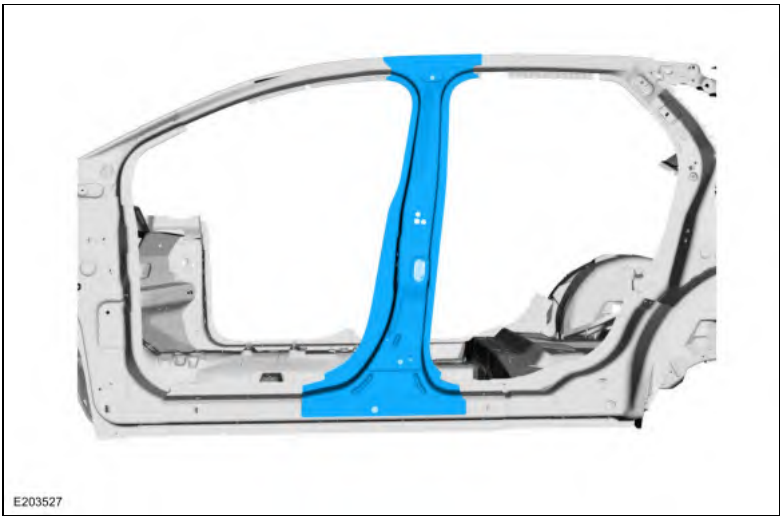




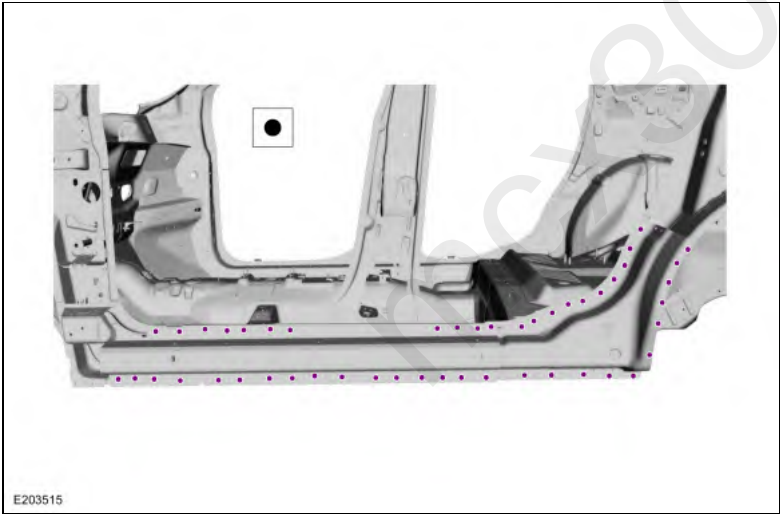
8. Remove the spot welds from the B-pillar inner panel.
Use the General Equipment: Spot Weld Drill Bit



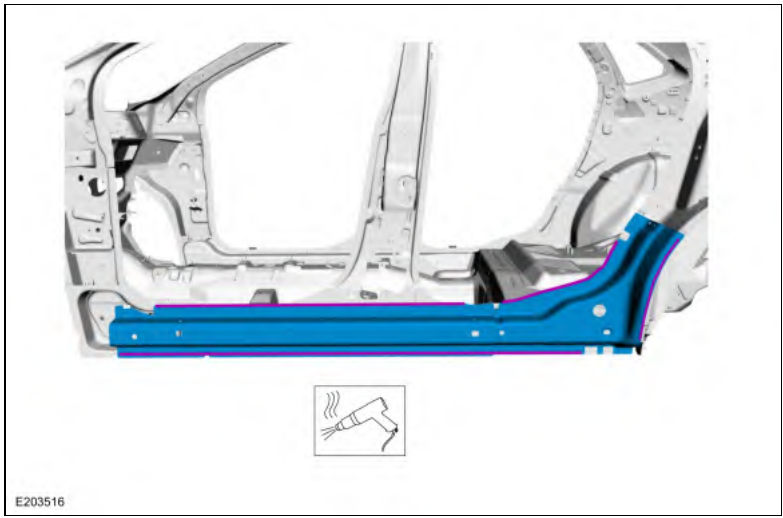
9. Remove the B-pillar inner panel.



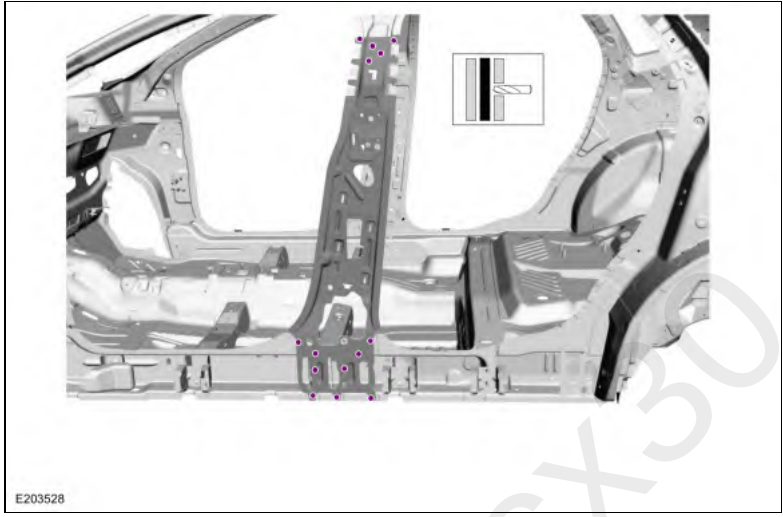
10. Remove the spot welds from the rocker panel.



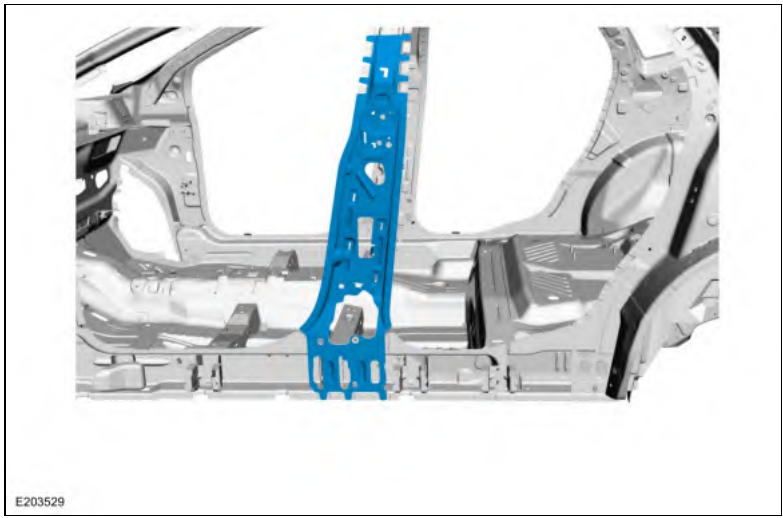
11. **NOTE:** Use of a heat gun may aid in softening the adhesive.
Remove the rocker panel.



12. Remove the spot welds from the inner reinforcement.
Use the General Equipment: Spot Weld Drill Bit



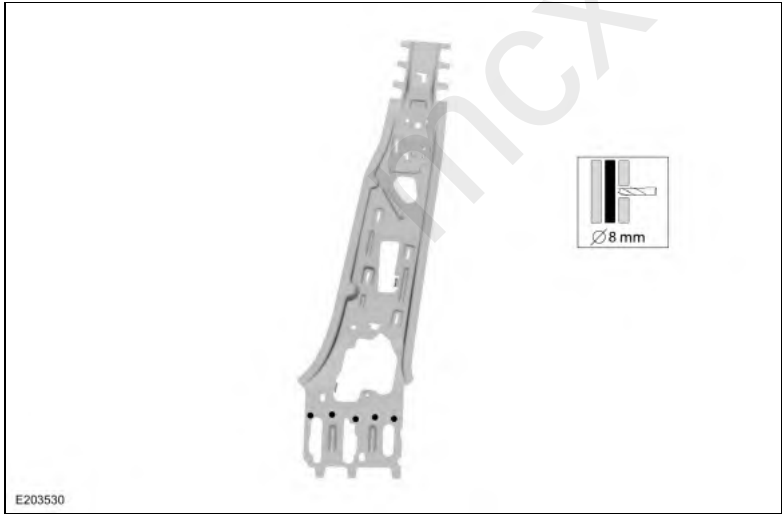
13. Remove the inner reinforcement panel.



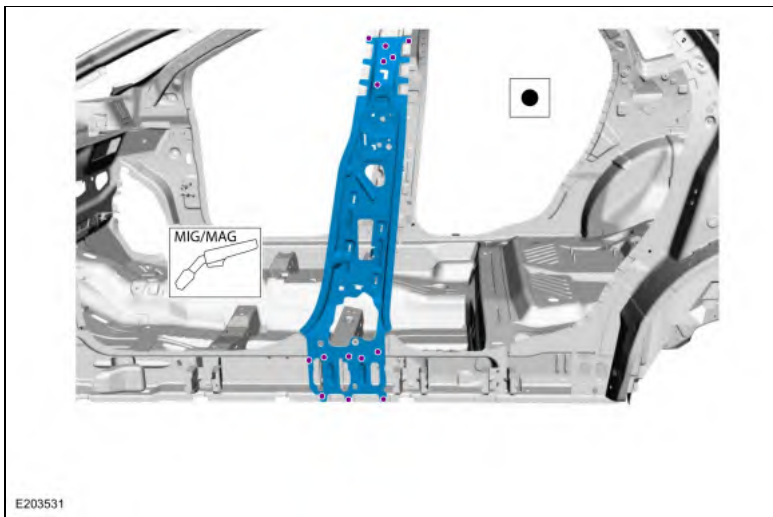
Installation

NOTE: The B-pillar inner panel and reinforcement are made of boron and cannot be sectioned. Components must be replaced at factory seams.

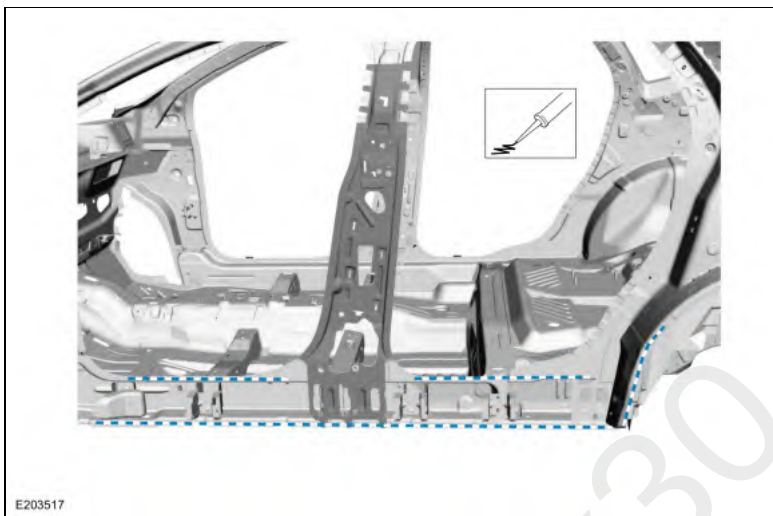
1. Drill the holes for plug welds in the replacement panel.
Use the General Equipment: 8 mm Drill Bit



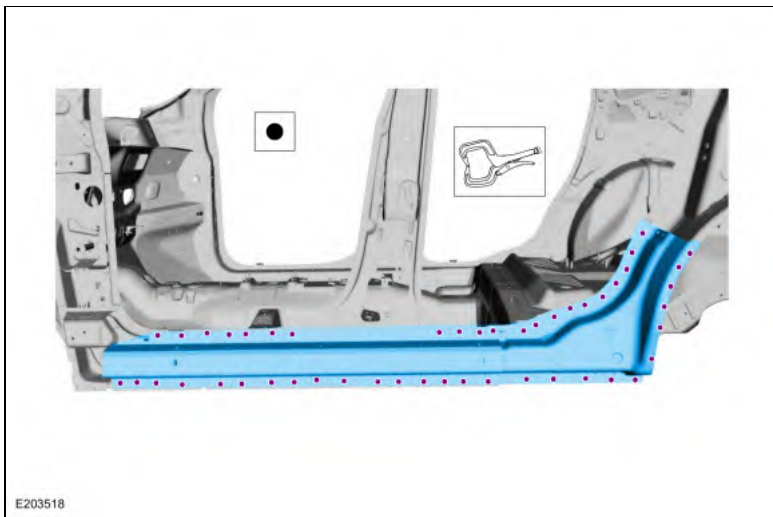
2. Install and weld the inner reinforcement panel.
Use the General Equipment: Locking Pliers
Use the General Equipment: Resistance Spotwelding Equipment



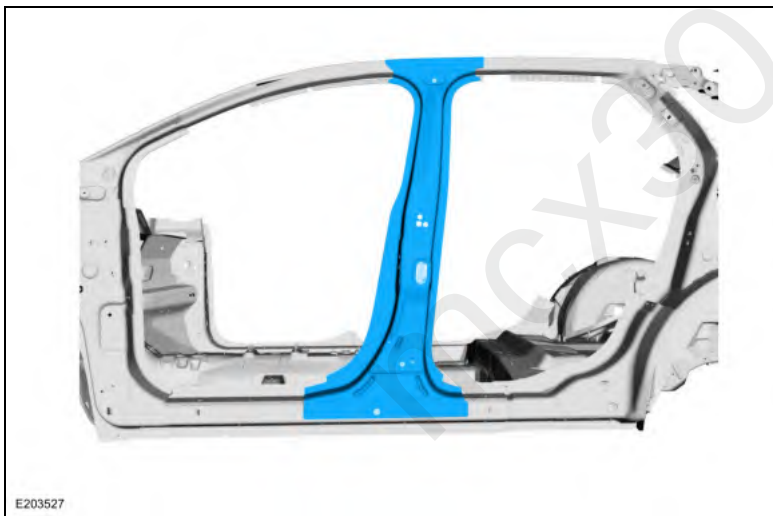
3. Apply adhesive as indicated.
 Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M, 08115, LORD Fusor® 108B



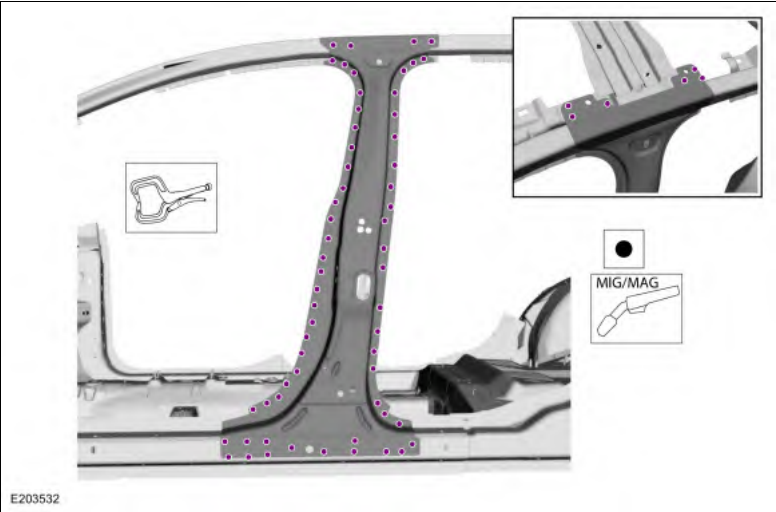
4. Install the rocker panel and resistance spot weld.
 Use the General Equipment: Resistance Spotwelding Equipment
 Use the General Equipment: Locking Pliers



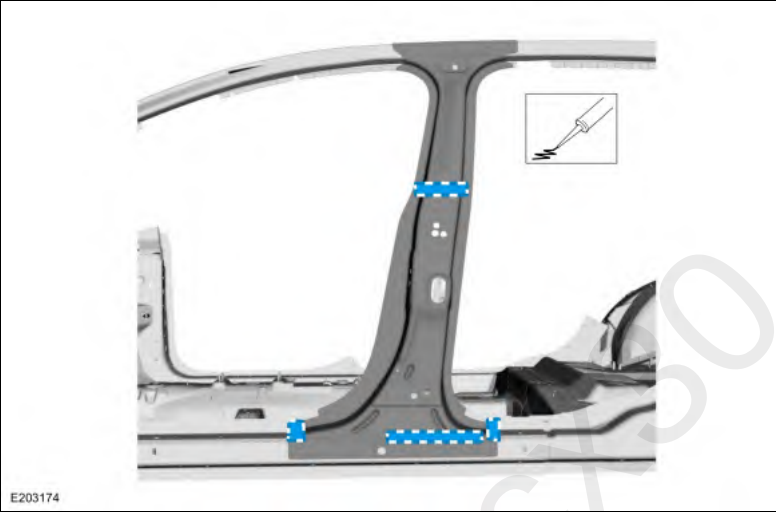
5. Install the inner B-pillar panel.



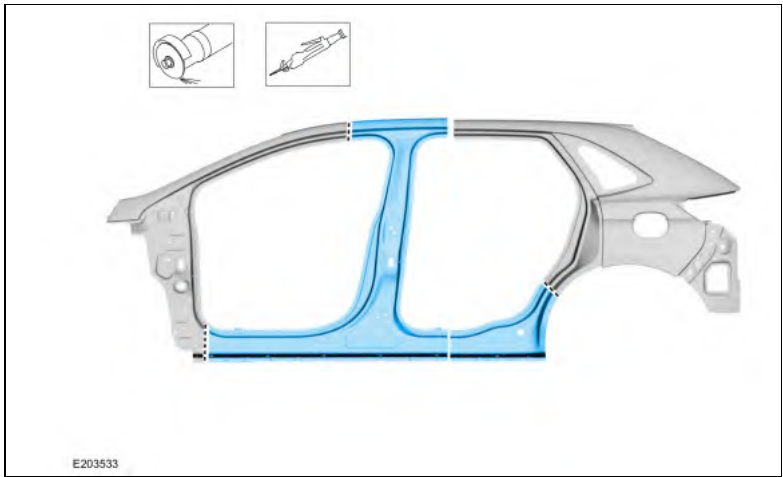
6. Weld the panel.
- Use the General Equipment: Resistance Spotwelding Equipment
 - Use the General Equipment: MIG/MAG Welding Equipment
 - Use the General Equipment: Locking Pliers



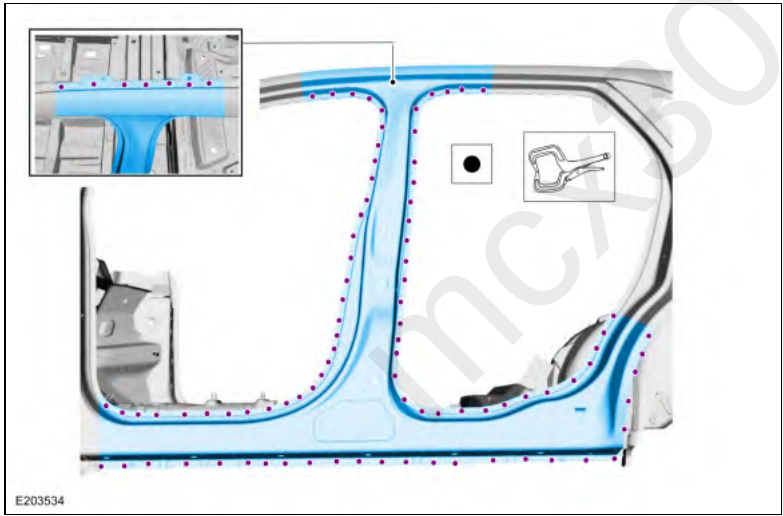
7. Apply flexible foam at the indicated locations.
Material: Flexible Foam Repair / 3M, 08463, LORD Fusor® 121



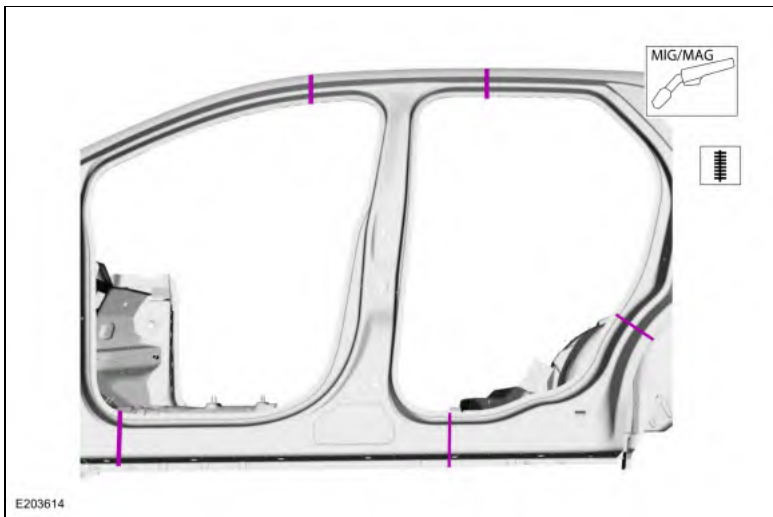
8. Cut section from replacement panels.
Use the General Equipment: Spherical Cutter
Use the General Equipment: Air Body Saw



9. Install the outer panels and resistance spot weld.
Use the General Equipment: Resistance Spotwelding Equipment
Use the General Equipment: Locking Pliers



10. Seam weld the outer panel.



11. Metal finish using typical metal finishing techniques.
12. Sealing work: All areas must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M, 08308, LORD Fusor® 805DTM
13. Restore corrosion protection.
Refer to: Corrosion Prevention (501-25 Body Repairs - General Information, General Procedures).
14. Refinish using a Ford approved paint system.
15. Install the front door striker and rear door hinge at the B-pillar.
16. Install the following items:
 1. Install the roof panel.
Refer to: Roof Panel (501-28 Roof Sheet Metal Repairs, Removal and Installation).
 2. Install the B-pillar trim panel.
Refer to: B-Pillar Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
 3. Install the front door
Refer to: Front Door (501-03 Body Closures) .
 4. Install the rear door
Refer to: Rear Door (501-03 Body Closures) .
17. Reposition the wiring harness and carpet to original position.

B-Pillar Outer Panel

Special Tool(s) / General Equipment

Resistance Spotwelding Equipment
Spherical Cutter
Hot Air Gun
MIG/MAG Welding Equipment
Spot Weld Drill Bit
Locking Pliers

Materials

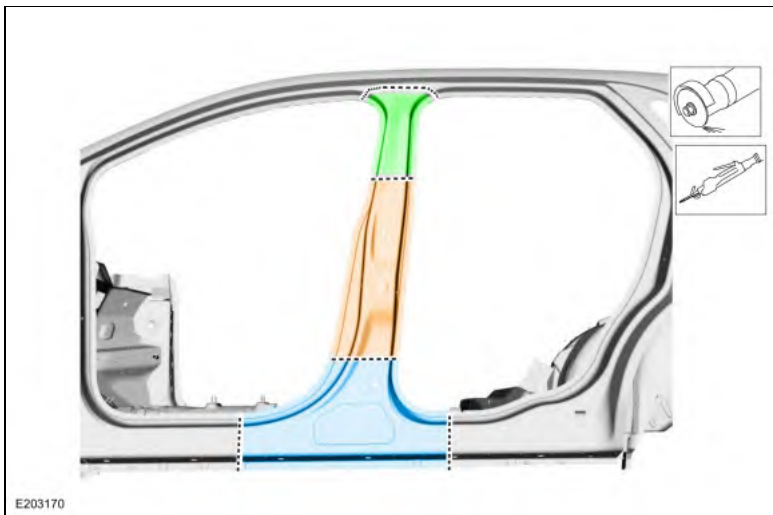
Name	Specification
Seam Sealer TA-2-B, 3M [®] , 08308, LORD Fusor [®] 805DTM	-
Flexible Foam Repair 3M [®] , 08463, LORD Fusor [®] 121	-

Removal

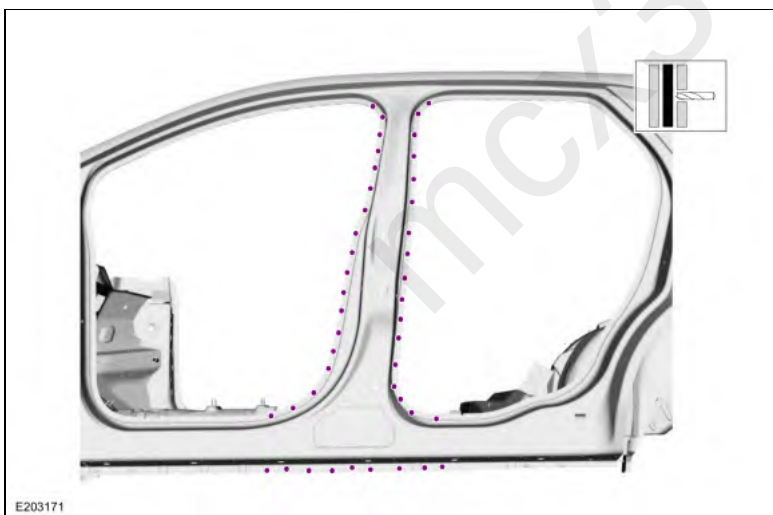
1. If required, restore the vehicle to pre-accident dimensions.
Refer to: Body and Frame (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).
2. Remove the following items:
 1. Remove the B-pillar trim panel.
Refer to: B-Pillar Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
3. Remove the front door striker and rear door hinge at the B-pillar.
4. Position aside the carpeting and wiring harness in the repair area.
5. If damage extends into the roof rail area, the roof panel must be removed.
Refer to: Roof Panel (501-28 Roof Sheet Metal Repairs, Removal and Installation).
6. **NOTICE: Carefully cut the outer panel only.**

NOTE: *Partial replacement due to damage is possible and reasonable on the outer panel only*

Possible cutlines depending on damage.



7. Remove the spot welds.
Use the General Equipment: Spot Weld Drill Bit



8. **NOTE:** The use of a heat gun may aid in softening the NVH foam.

Remove the B-pillar outer panel.
Use the General Equipment: Hot Air Gun