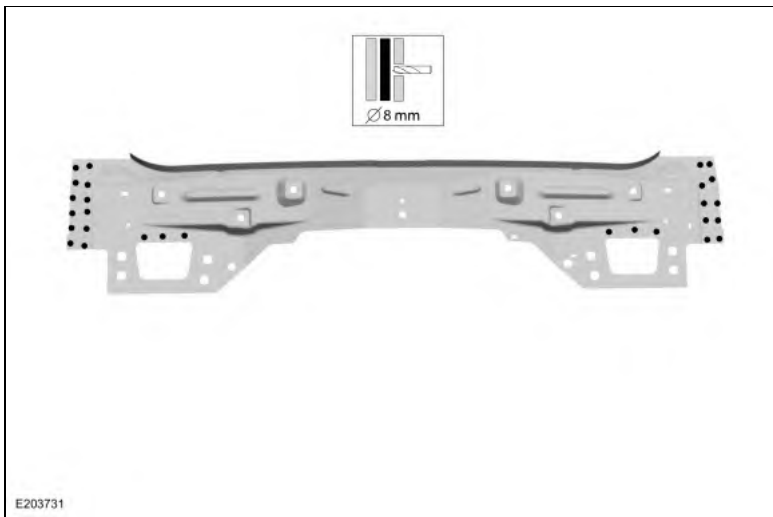
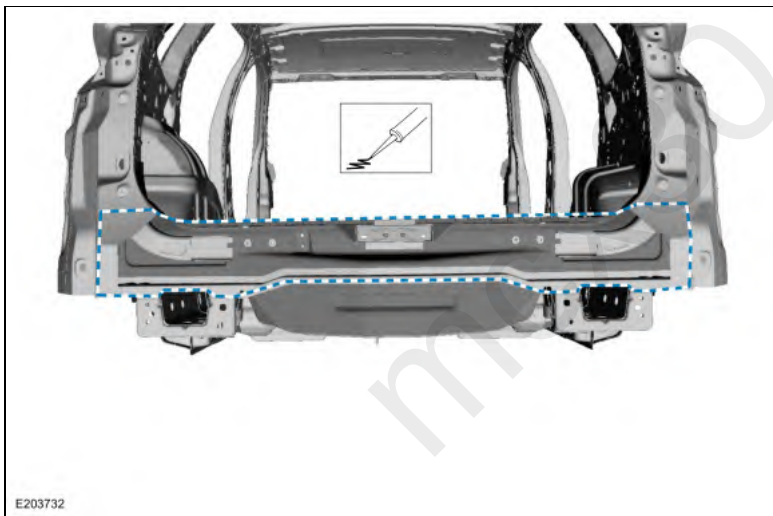




2. Apply adhesive as indicated.

Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M[®], 08115, LORD Fusor[®] 108B

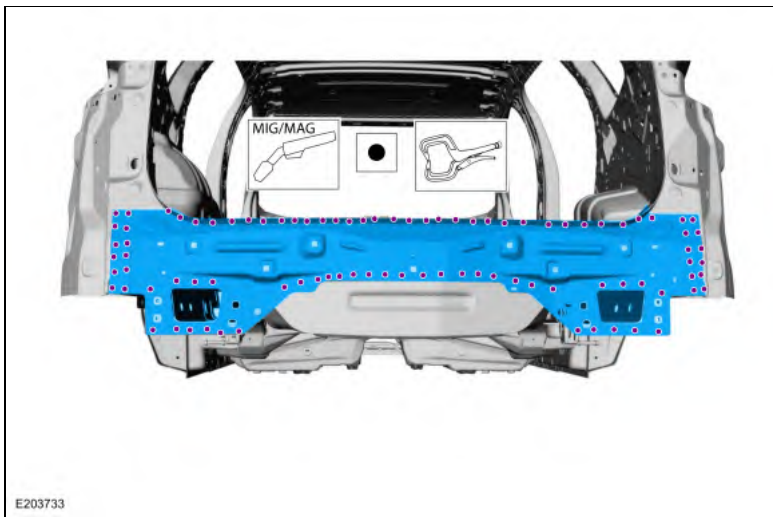


3. Install the back panel reinforcement and weld.

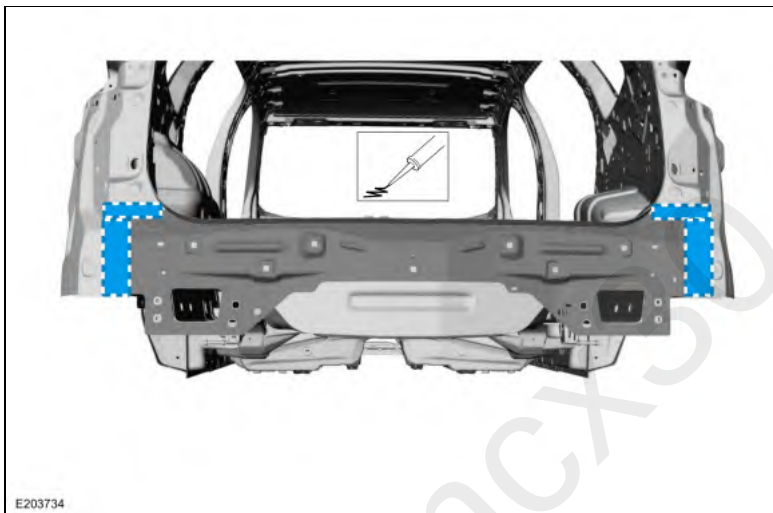
Use the General Equipment: Resistance Spotwelding Equipment

Use the General Equipment: MIG/MAG Welding Equipment

Use the General Equipment: Locking Pliers



4. Finish the repair area using typical metal finishing procedures.
5. Apply sealer at the seams.
Material: Seam Sealer / TA-2-B, 3M[®], 08308, LORD Fusor[®] 805DTM



6. Sealing work: All areas must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M[®], 08308, LORD Fusor[®] 805DTM
7. Restore corrosion protection.
Refer to: Corrosion Prevention (501-25 Body Repairs - General Information, General Procedures).
8. Refinish using a Ford approved paint system.
9. Reposition the wiring harness and carpeting.
10. Install the following items:
 1. Install the rear bumper.
Refer to: Rear Bumper (501-19 Bumpers, Removal and Installation).
 2. Install the rear lamp assembly.
Refer to: Rear Lamp Assembly (417-01 Exterior Lighting, Removal and Installation).
 3. Install the loadspace trim panel.
Refer to: Loadspace Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).

Quarter Panel LH

Special Tool(s) / General Equipment

Resistance Spotwelding Equipment
Spherical Cutter
Air Body Saw
8 mm Drill Bit
MIG/MAG Welding Equipment
Spot Weld Drill Bit
Locking Pliers

Materials

Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M [®] , 08115, LORD Fusor [®] 108B	-
Seam Sealer TA-2-B, 3M [®] , 08308, LORD Fusor [®] 805DTM	-
Flexible Foam Repair 3M [®] , 08463, LORD Fusor [®] 121	-

Removal

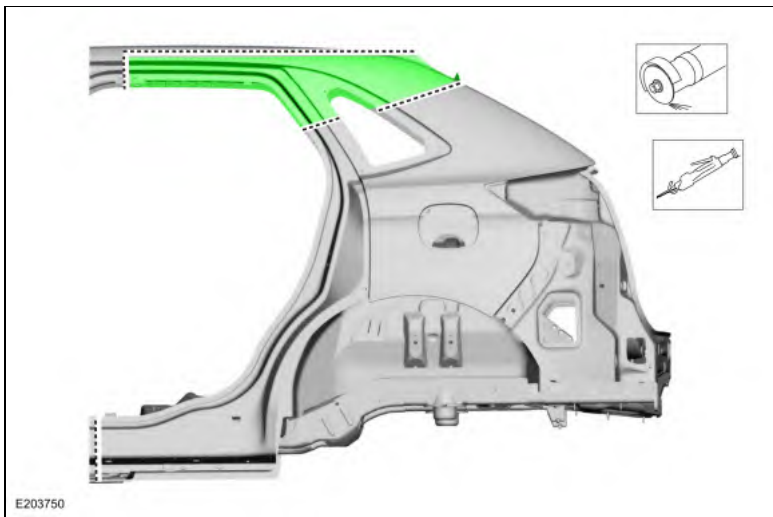
1. Restore vehicle to pre-accident dimensions, if required.
Refer to: Body and Frame (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).
2. Remove the following items:
 1. If required, remove the roof panel.
Refer to: Roof Panel (501-28 Roof Sheet Metal Repairs, Removal and Installation).
 2. Remove the liftgate.
Refer to: Liftgate (501-03 Body Closures, Removal and Installation).
 3. Remove the fuel filler door, LH side only.
Refer to: Fuel Filler Door Assembly (501-03 Body Closures, Removal and Installation).
 4. Remove the rear bumper cover.
Refer to: Rear Bumper Cover (501-19 Bumpers, Removal and Installation).
 5. Remove the side curtain airbag.
Refer to: Side Curtain Airbag (501-20B Supplemental Restraint System, Removal and Installation).
 6. Remove the rear quarter glass.
Refer to: Fixed Glass (501-11 Glass, Frames and Mechanisms, General Procedures).
 7. Remove the C-pillar trim panel.
Refer to: C-Pillar Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
 8. Remove the B-pillar trim panel.
Refer to: B-Pillar Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
 9. Remove the rear door.
Refer to: Rear Door (501-03 Body Closures, Removal and Installation).
3. Position aside the carpeting and wiring harness.
4. **NOTE:** If damage to the quarter panel extends above the roof side rail area, the roof panel must be removed.

Cut through the **outer** panel only.

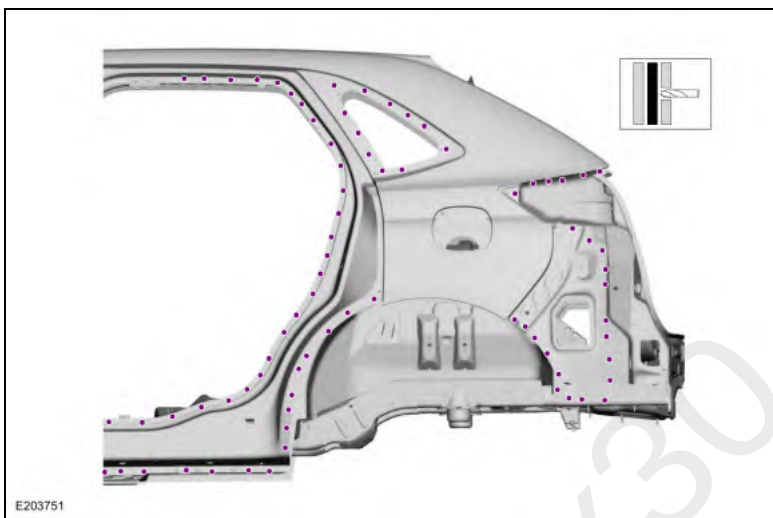
Possible cutlines.

Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter



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



6. Remove the spot welds along upper flange.
Use the General Equipment: Spot Weld Drill Bit