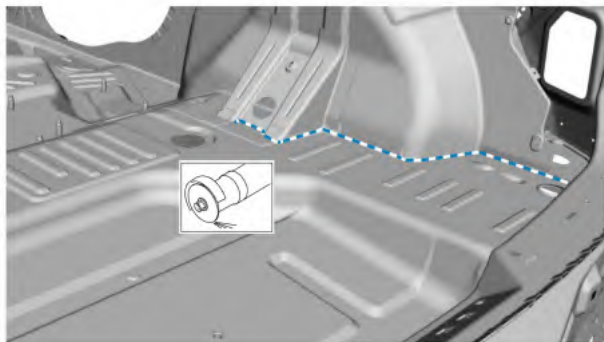




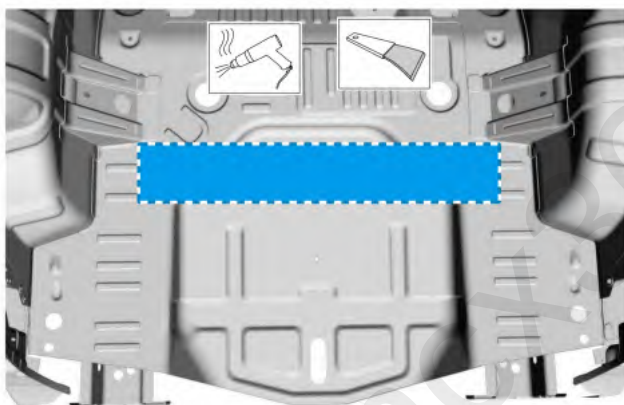
E203869



7. **NOTICE:** Use a heat gun to warm the mastic material, using caution not overheat, as the material is flammable.

NOTE:

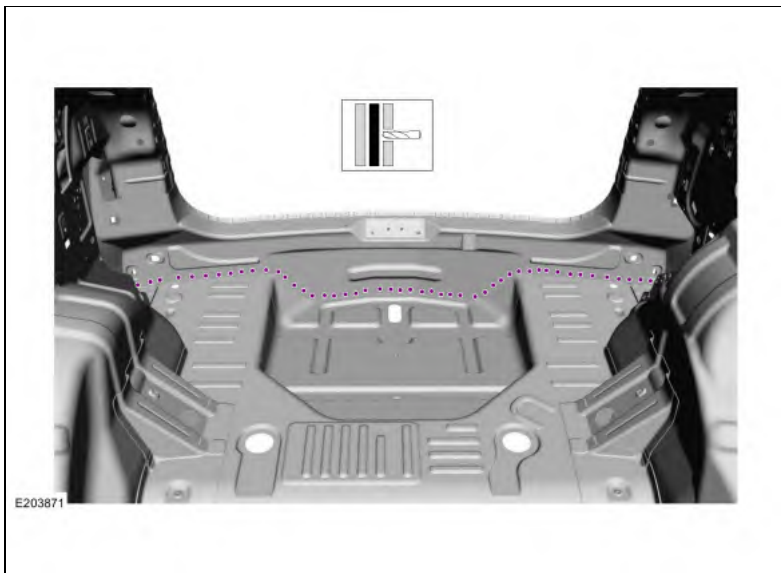
Remove the mastic material from the floor panel.
 Use the General Equipment: Hot Air Gun
 Use the General Equipment: Scraper for Straight Edges



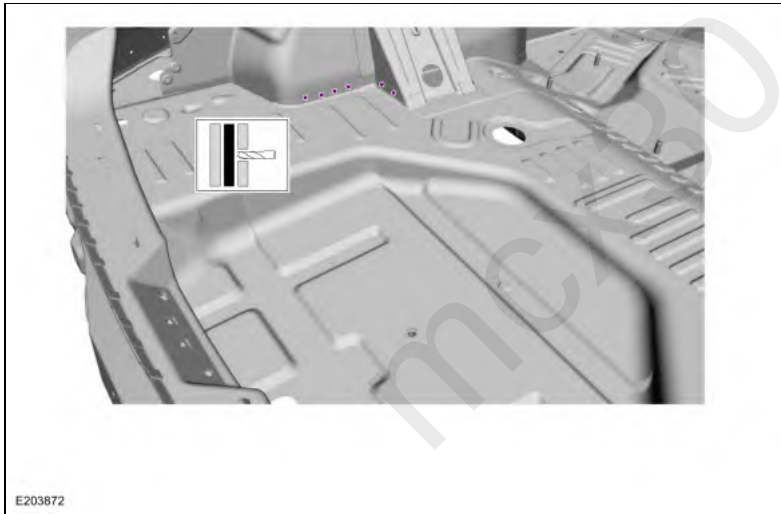
E203870



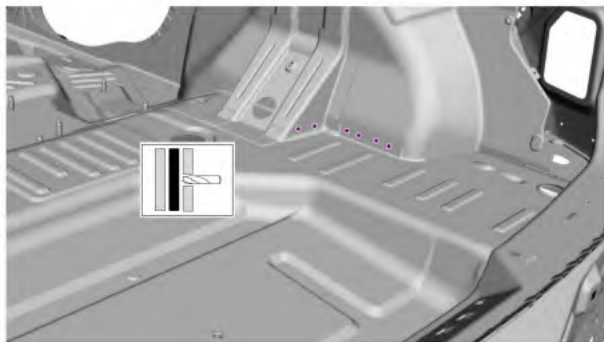
8. Remove the spot welds along the floor panel rear flange.
 Use the General Equipment: Spot Weld Drill Bit



9. Remove the spot welds along the floor panel wheelhouse flange, on the LH side.
Use the General Equipment: Spot Weld Drill Bit



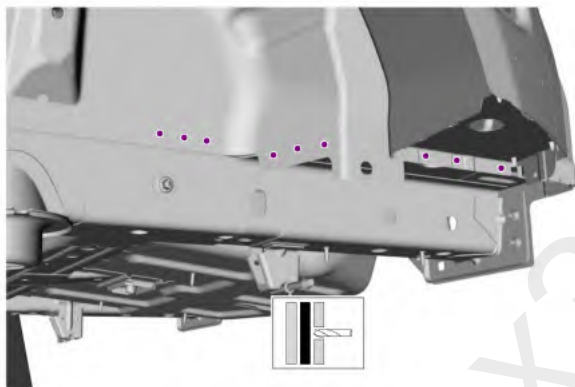
10. Remove the spot welds along the floor panel wheelhouse flange, on the RH side.
Use the General Equipment: Air Body Saw



E203873



11. Remove the spot welds along the floor panel lower wheelhouse flange, on both sides.
Use the General Equipment: Spot Weld Drill Bit

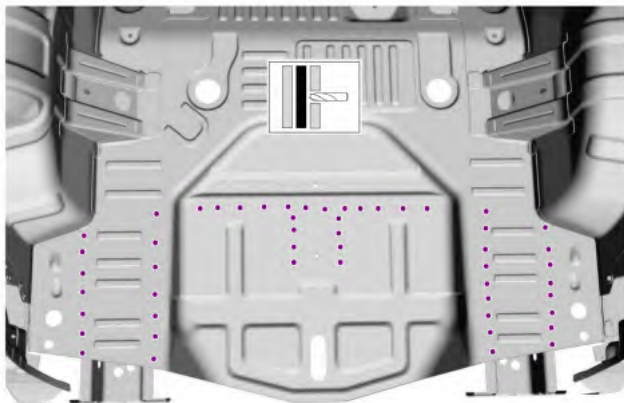


E203874



12. **NOTE:** Back panel removed from view for clarity.

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



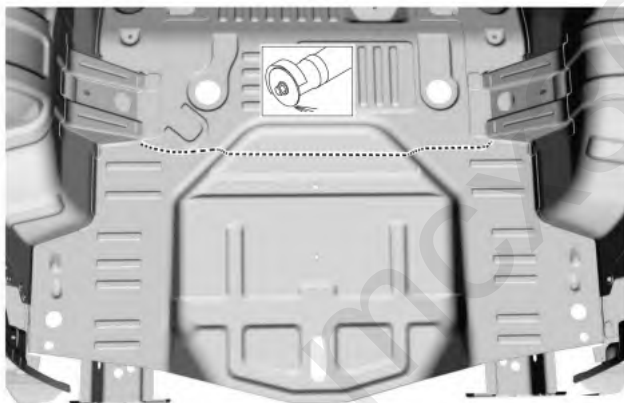
E203875



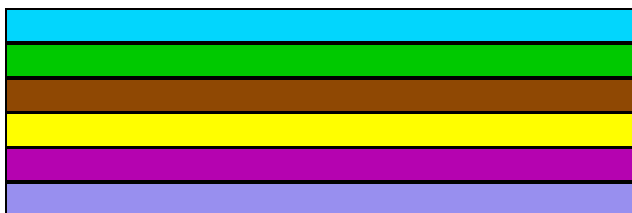
13. **NOTICE:** Cut through floor panel only, do not cut into reinforcements or crossmembers.

Cut the floor panel as indicated.

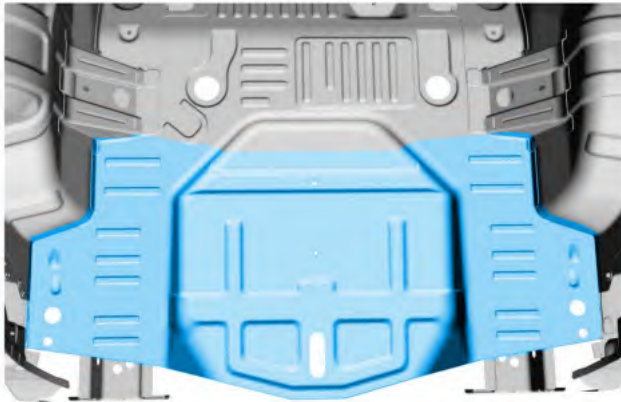
Use the General Equipment: Spot Weld Drill Bit



E203876



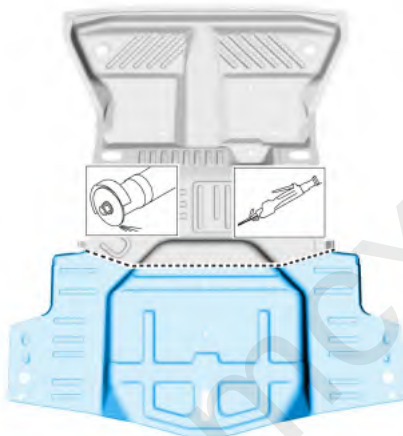
14. Remove the floor panel section.

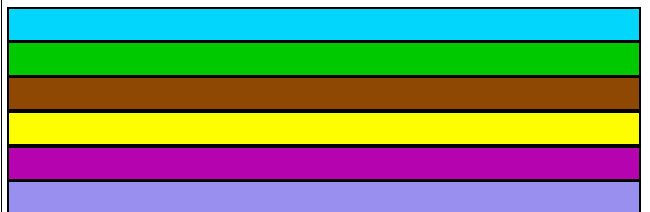




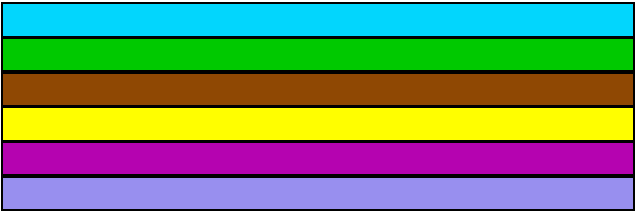
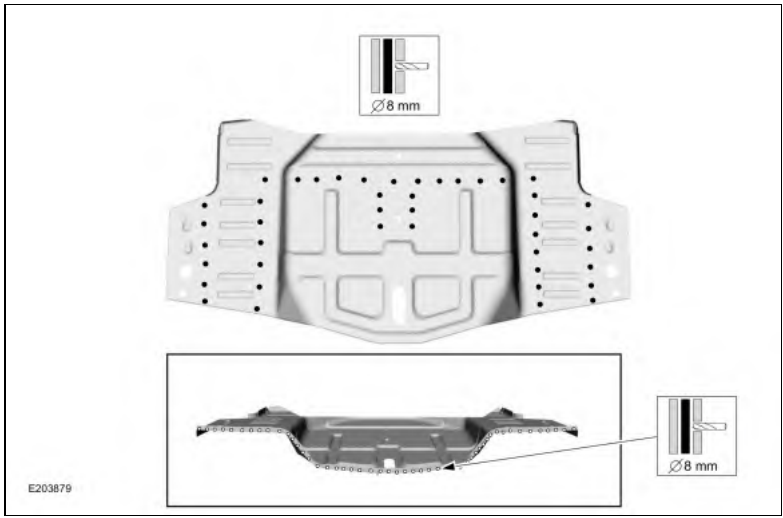
Installation

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



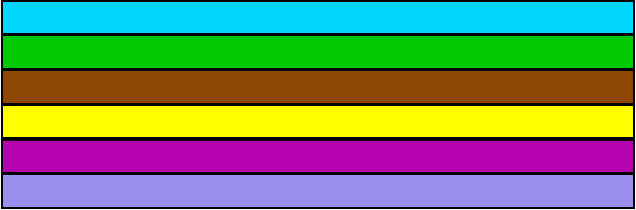
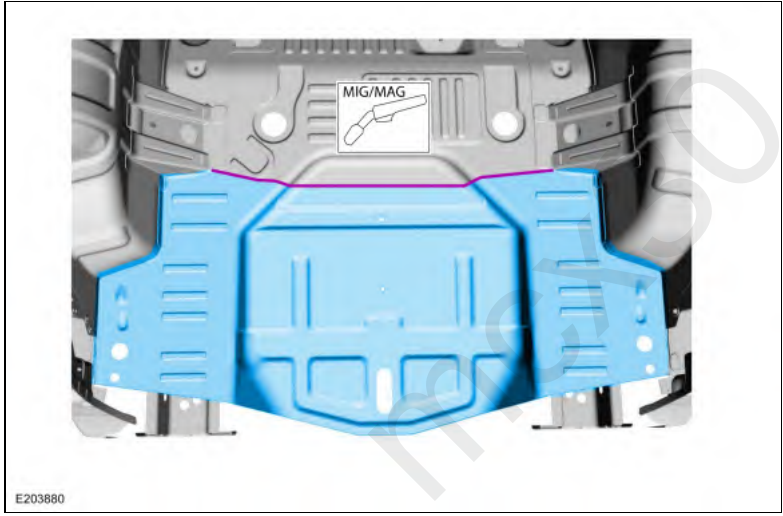


2. Drill holes for plug welding in the replacement section.
Use the General Equipment: 8 mm Drill Bit

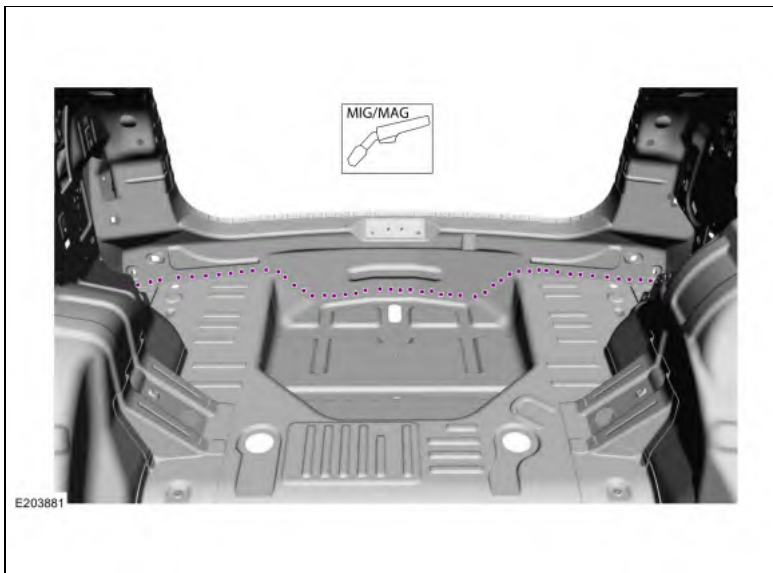


3. **NOTE:** Back panel removed for clarity.

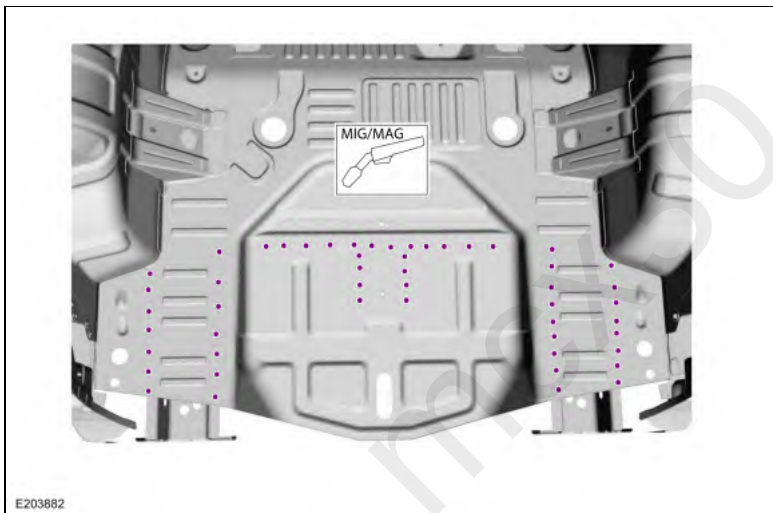
Install the replacement section and seam weld.
Use the General Equipment: MIG/MAG Welding Equipment



4. Weld the floor panel rear flange.
Use the General Equipment: MIG/MAG Welding Equipment



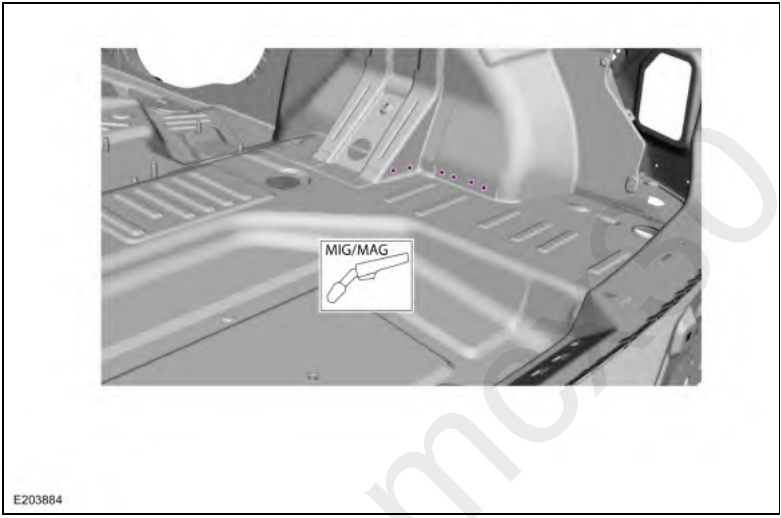
5. Weld the floor panel to side members and crossmember.
Use the General Equipment: Resistance Spotwelding Equipment



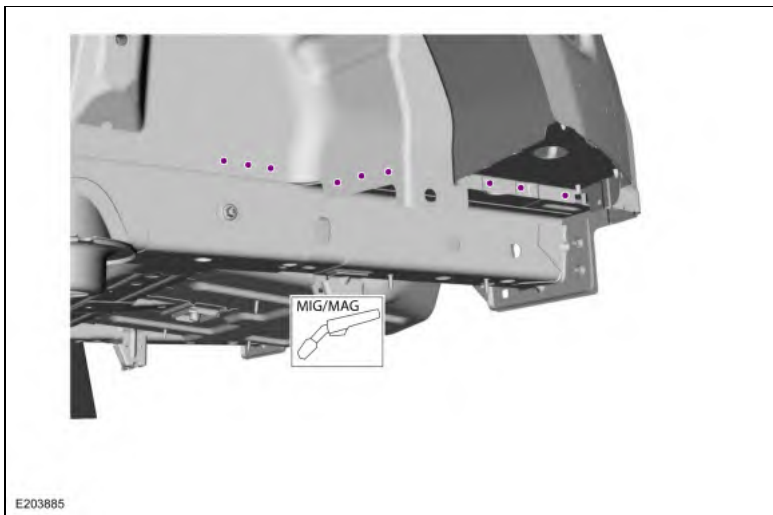
6. Weld the floor panel at the LH wheelhouse.
Use the General Equipment: Resistance Spotwelding Equipment



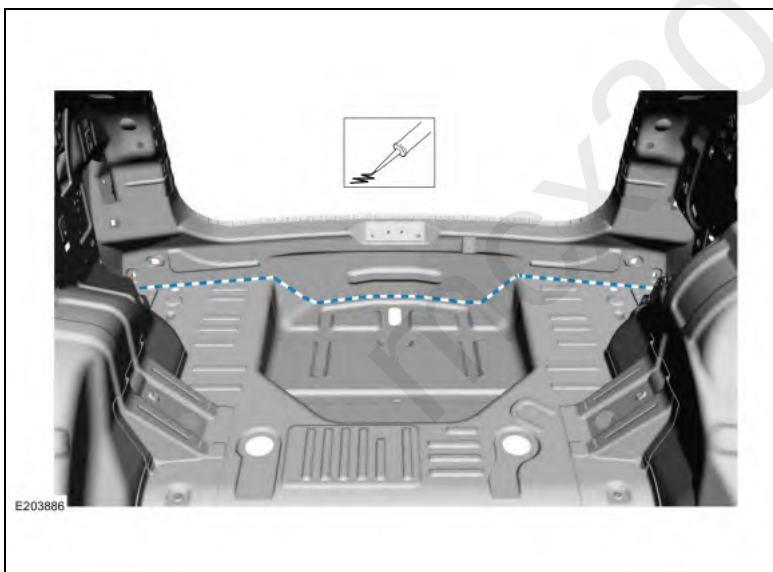
7. Weld the floor panel at the RH wheelhouse.
Use the General Equipment: Resistance Spotwelding Equipment



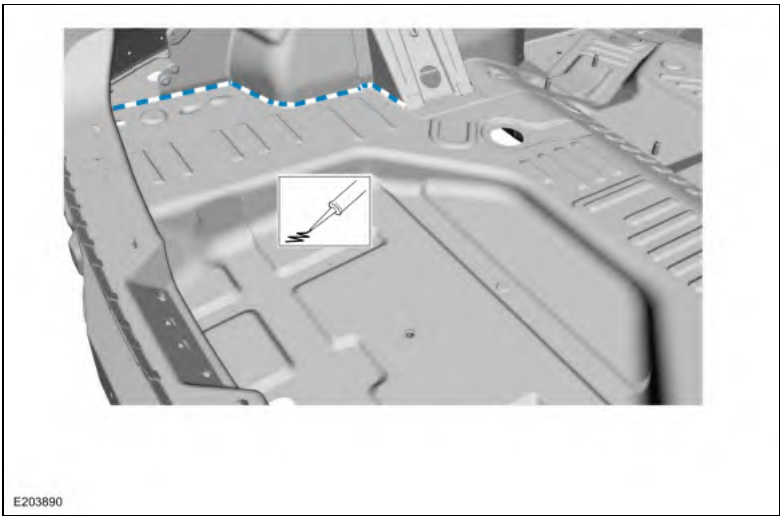
8. Weld the lower floor panel flange on both sides.



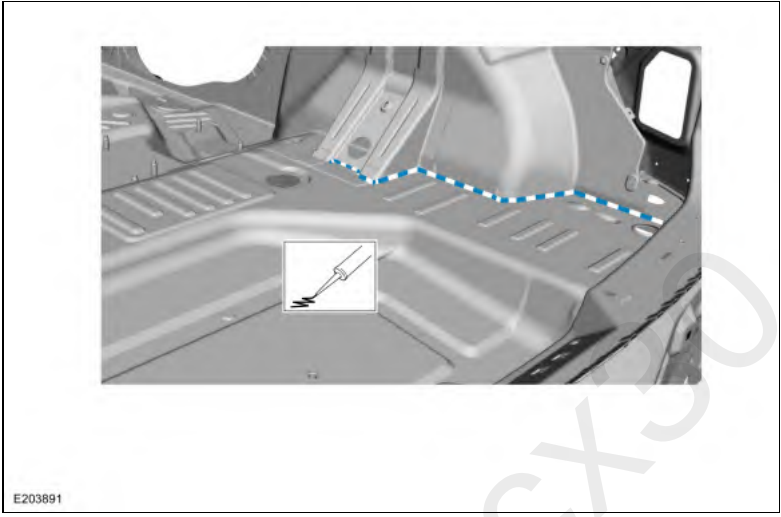
9. Finish the repair area using typical metal finishing techniques.
10. Refinish using a Ford approved paint system.
11. Apply sealer to the floor panel rear flange.



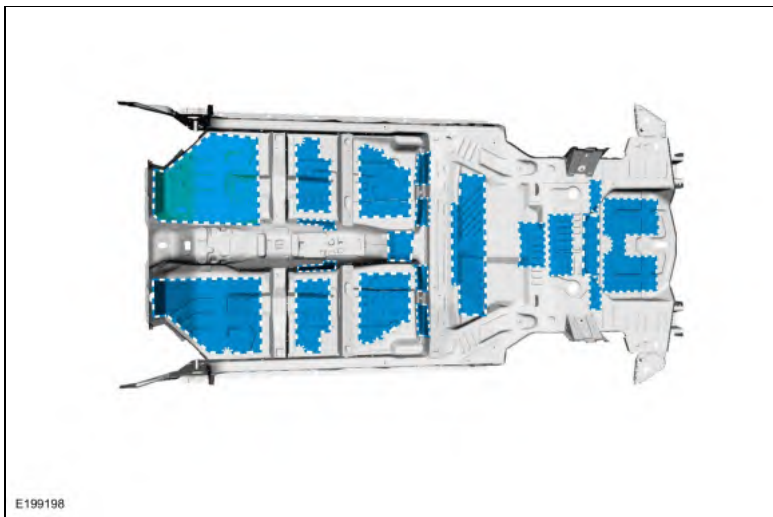
12. Apply sealer to the floor panel rear flange on the LH side.



13. Apply sealer to the floor panel rear flange on the RH side.
Material: Flange Sealant / CU7Z-19B508-A (WSS-M2G348-A11)



14. Apply NVH material (obtain locally) in original locations.



15. Sealing work: All areas must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M, 08308, LORD Fusor® 805DTM
16. Restore corrosion protection.
Refer to: Corrosion Prevention (501-25 Body Repairs - General Information, General Procedures).
17. Reposition the carpeting and the wiring harness.
18. Install the following items:
 1. Install the rear subframe (as equipped).
Refer to: Rear Subframe - AWD (502-00 Uni-Body, Subframe and Mounting System, Removal and Installation).
Refer to: Rear Subframe - FWD (502-00 Uni-Body, Subframe and Mounting System, Removal and Installation).
 2. Install the fuel tank (as equipped).
Refer to: Fuel Tank (310-01A Fuel Tank and Lines - 2.0L EcoBoost (184kW/250PS) MI4, Removal and Installation).
Refer to: Fuel Tank (310-01B Fuel Tank and Lines - 2.7L EcoBoost (238kW/324PS), Removal and Installation).
 3. Remove the rear bumper.
Refer to: Rear Bumper (501-19 Bumpers, Removal and Installation).
 4. Install the loadspace trim panel.
Refer to: Loadspace Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).

Rear Floor Panel Section

Special Tool(s) / General Equipment

Spherical Cutter
Grinder
Air Body Saw
MIG/MAG Welding Equipment
Spot Weld Drill Bit

Materials

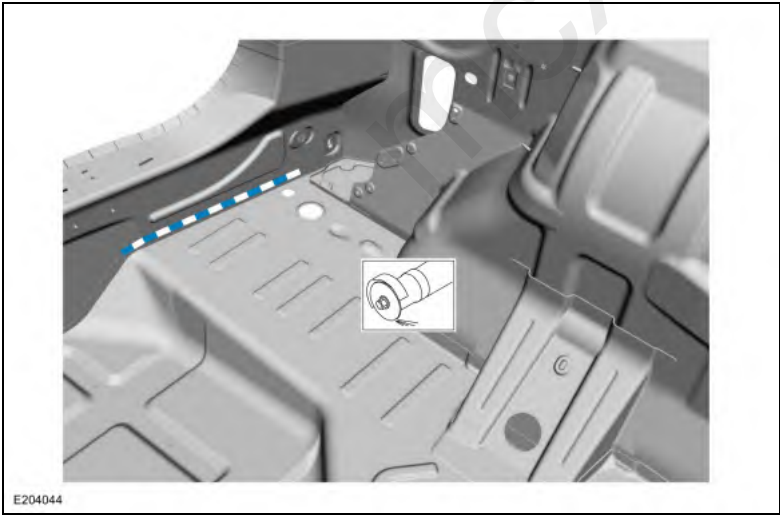
Name	Specification
Seam Sealer TA-2-B, 3M, 08308, LORD Fusor® 805DTM	-
Flange Sealant CU7Z-19B508-A	WSS-M2G348-A11

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. Reposition the carpeting and the wiring harness away from the working area.
3. Remove the following items:
 1. Remove the rear bumper.
Refer to: Rear Bumper (501-19 Bumpers, Removal and Installation).
 2. Remove the fuel tank (as equipped).
Refer to: Fuel Tank (310-01B Fuel Tank and Lines - 2.7L EcoBoost (238kW/324PS), Removal and Installation).
Refer to: Fuel Tank (310-01B Fuel Tank and Lines - 2.7L EcoBoost (238kW/324PS), Removal and Installation).
 3. Remove the loadspace trim panel.
Refer to: Loadspace Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).

NOTE: LH side shown, RH side similar.

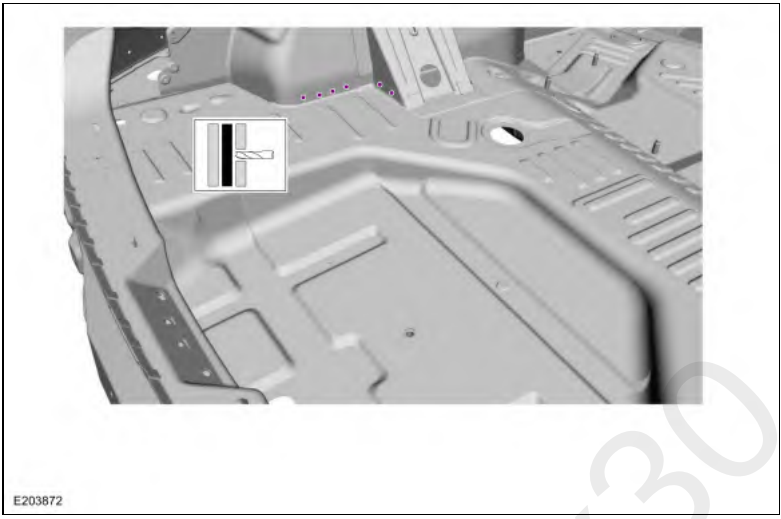
4. Using a grinder with an abrasive disc or equivalent, remove the sealer along the floor pan rear flange.
Use the General Equipment: Grinder



5. Using a grinder with an abrasive disc or equivalent, remove the sealer along the floor pan flange.
Use the General Equipment: Grinder



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



7. Remove the spot welds along the rear flange and frame rail area.
Use the General Equipment: Spot Weld Drill Bit