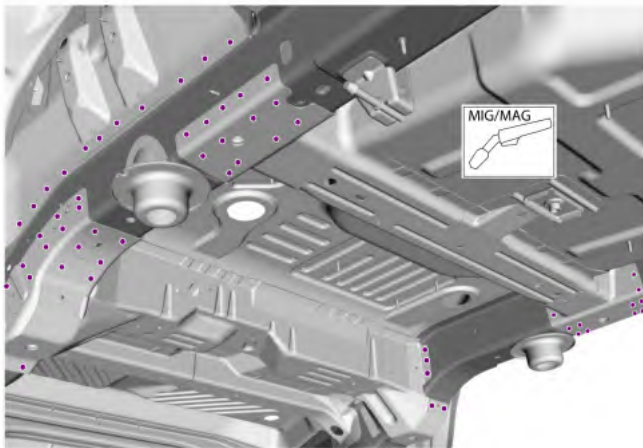




E203781



3. Metal finish as required using typical metal finishing techniques.
4. Sealing work: All areas must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M[®], 08308, LORD Fusor[®] 805DTM
5. Refinish using a Ford approved paint system.
6. Restore corrosion protection.
Refer to: Corrosion Prevention (501-25 Body Repairs - General Information, General Procedures).
7. Install the following items:
 1. Install the back panel.
Refer to: Back Panel and Reinforcement (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
 2. 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).
 3. 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).
8. Reposition the carpeting and wiring harness.

Rear Wheelhouse Outer

Special Tool(s) / General Equipment

Resistance Spotwelding Equipment
Spherical Cutter
Plasma Cutter
Air Body Saw
MIG/MAG Welding Equipment
Locking Pliers

Materials

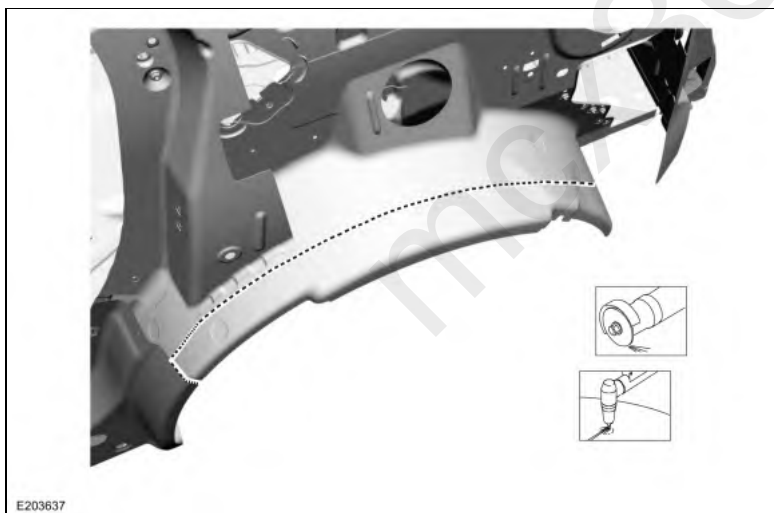
Name	Specification
Seam Sealer TA-2-B, 3M®, 08308, LORD Fusor® 805DTM	-

Removal

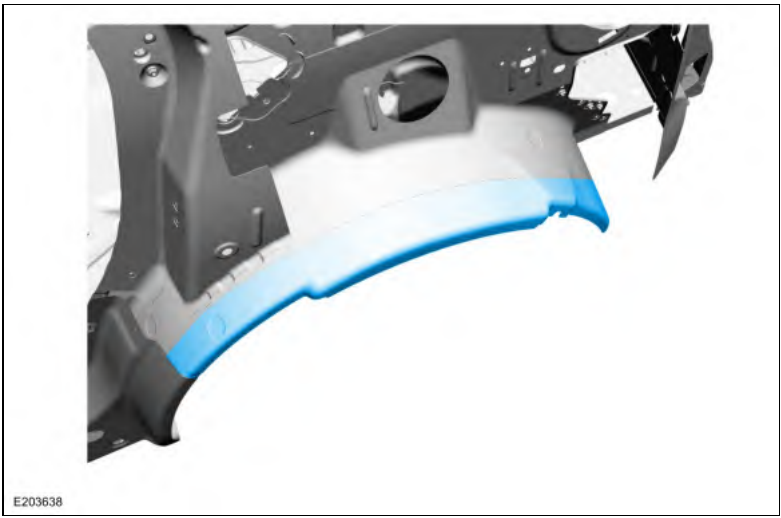
1. Restore vehicle to pre-accident dimensions, if required.
Refer to: Body and Frame (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).
2. Remove the following items:
 1. Remove the quarter panel.
Refer to: Quarter Panel LH (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
3. **NOTE:** Cutline shown as a general guideline for minor damage. Complete wheelhouse panel may be required depending on extent of damage.

LH side shown, RH side similar.

Cut the wheelhouse panel.
Use the General Equipment: Air Body Saw
Use the General Equipment: Plasma Cutter



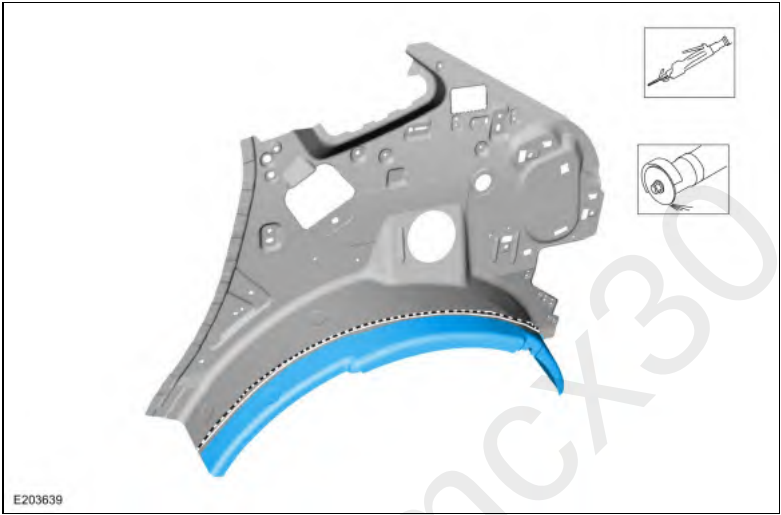
4. Remove the panel section.



Installation

1. **NOTE:** *LH side shown, RH side similar.*

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



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