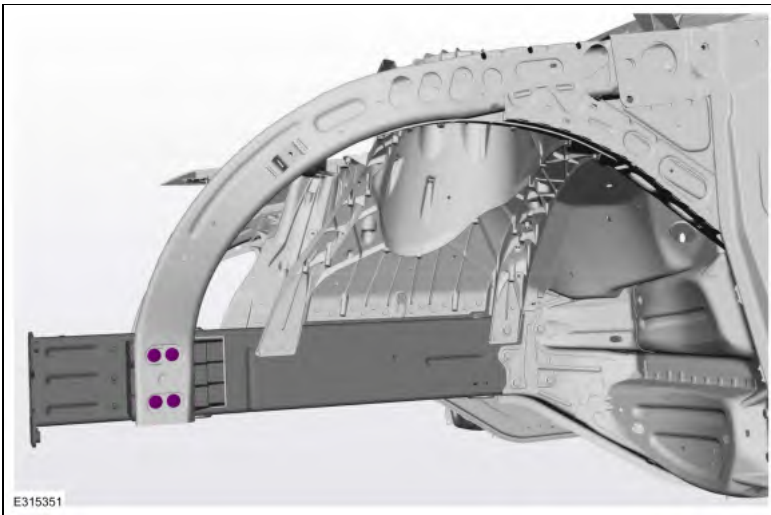
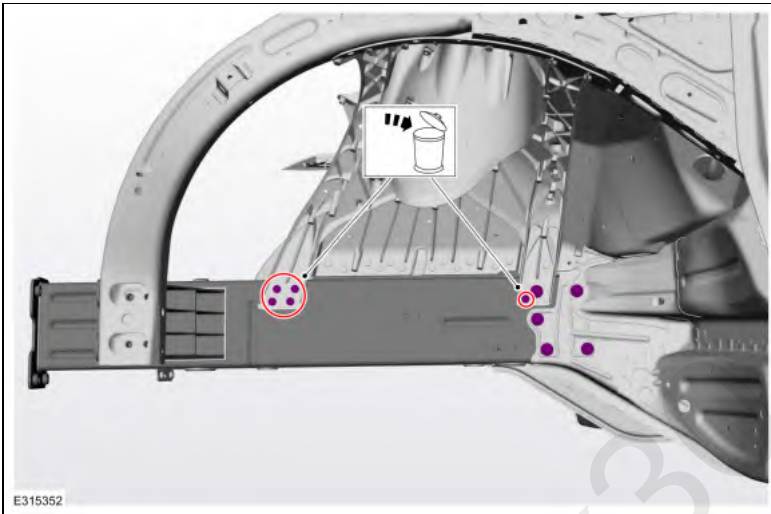
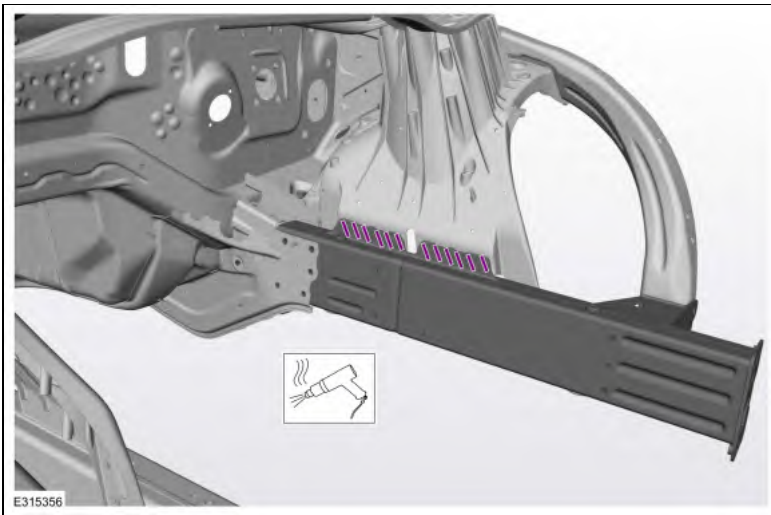




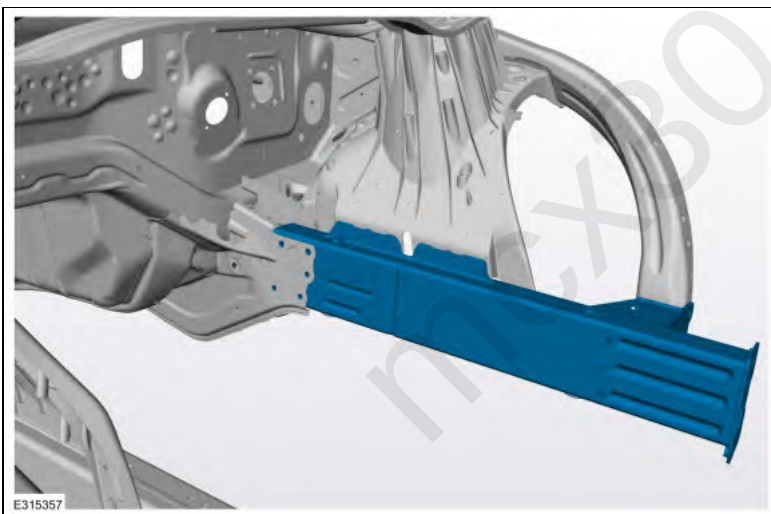
12. Remove the bolts and remove and discard the FDS.
Use the General Equipment: Torx Bit Socket



13. Remove the bolts and remove and discard the FDS.
Use the General Equipment: Torx Bit Socket



17. Remove the front side member.



Installation

WARNING: Electric vehicles damaged by a crash may have compromised high voltage safety systems and present a potential high voltage electrical shock hazard. Exercise caution and wear appropriate Personal Protective Equipment (PPE) safety gear, including high voltage safety gloves and boots. Remove all metallic jewelry, including watches and rings. Isolate the HV system as directed by the Ford Emergency Response Guide for the vehicle. Failure to follow these instructions may result in serious personal injury or death.

NOTICE: Battery electric vehicle (BEV), hybrid electric vehicle (HEV) and plug-in hybrid electric vehicle (PHEV) contain a high-voltage battery. Before cutting or welding near the high-voltage battery it must be removed to avoid damage.

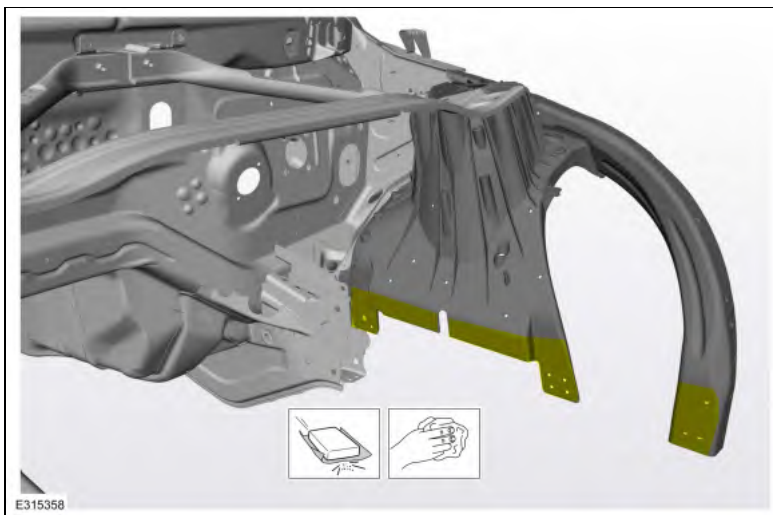
NOTICE: The high-voltage battery in a battery electric vehicle (BEV), hybrid electric vehicle (HEV) or plug-in hybrid electric vehicle (PHEV) can be affected and damaged by excessively high temperatures. The temperature in some body shop paint booths can exceed 60°C (140°F). Therefore, during refinishing operations, the paint booth temperature must set at or below 60°C (140°F) with a bake time of 45 minutes or less. Temperatures in excess of 60°C (140°F) or bake durations longer than 45 minutes will require the high-voltage battery be removed from the vehicle prior to placing in the paint booth.

NOTICE: If refinishing cure temperatures exceed 60°C (140°F), the charge port light ring on plug-in vehicles must be removed.

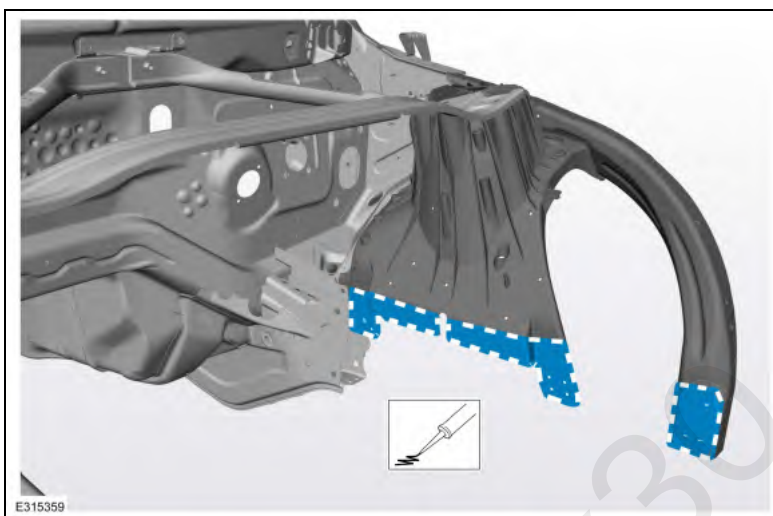
NOTE: Blind or solid rivets may be used in place of self piercing rivet (SPR) fasteners in the original self piercing rivet (SPR) fastener location after enlarging hole to 6.5 mm.

NOTE: Left hand (LH) side shown, right hand (RH) side similar.

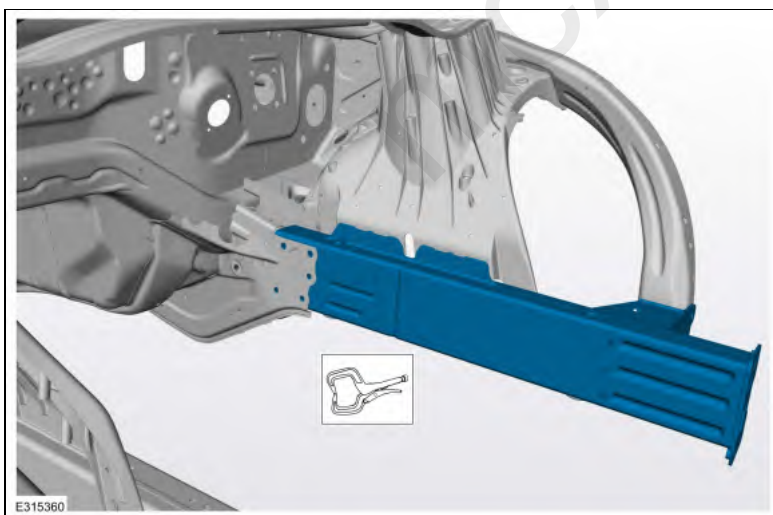
1. Sand to remove old adhesive, sealer and clean.



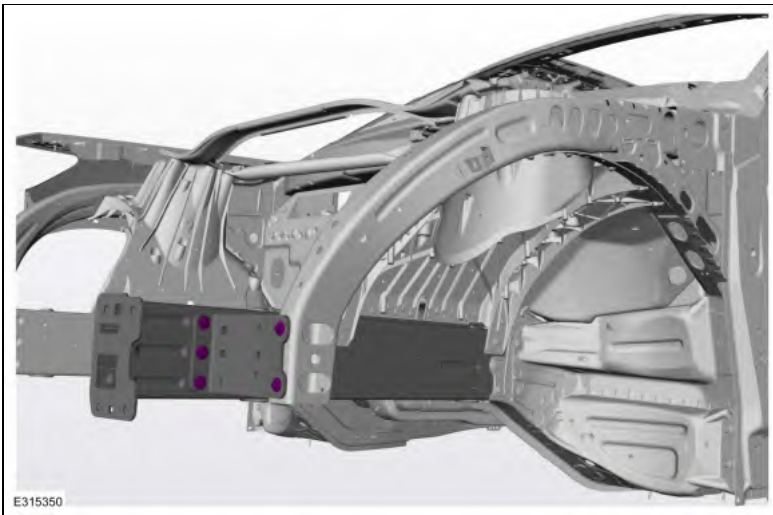
2. Apply adhesive.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M[®], 08115, LORD Fusor[®] 108B



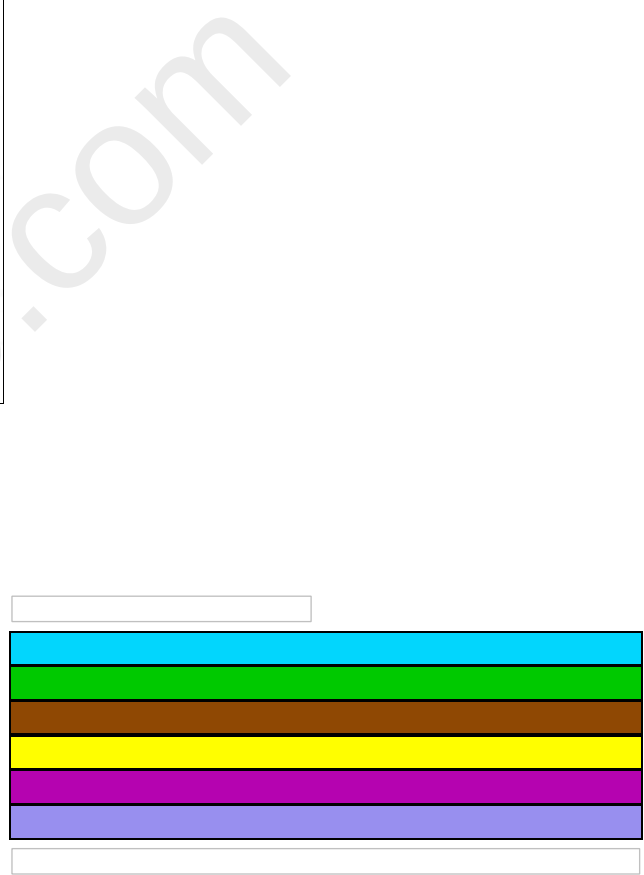
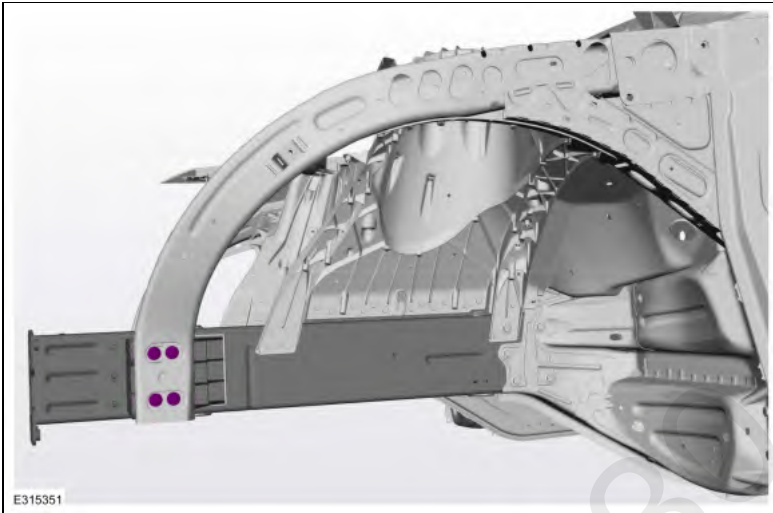
3. Install, properly position and clamp the front side member.
Use the General Equipment: Locking Pliers



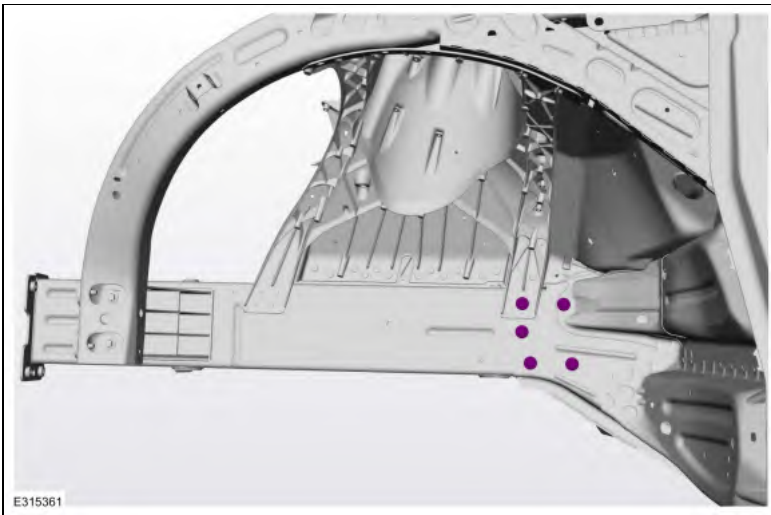
4. Loosely install the bolts.



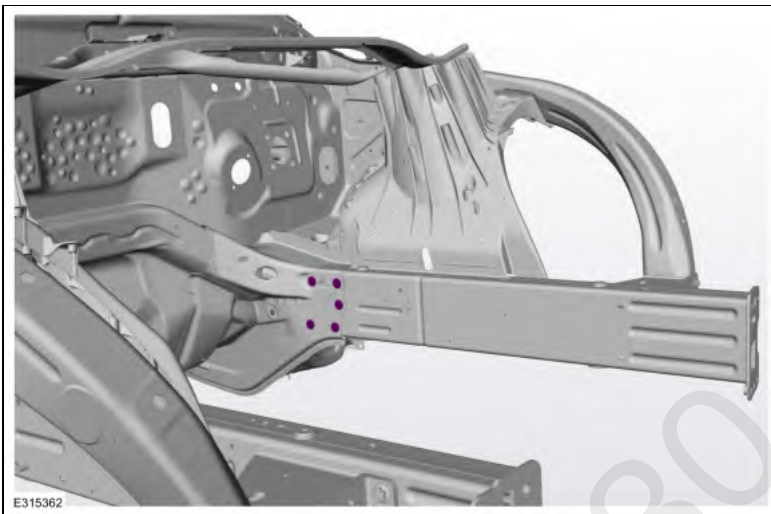
5. Loosely install the bolts.



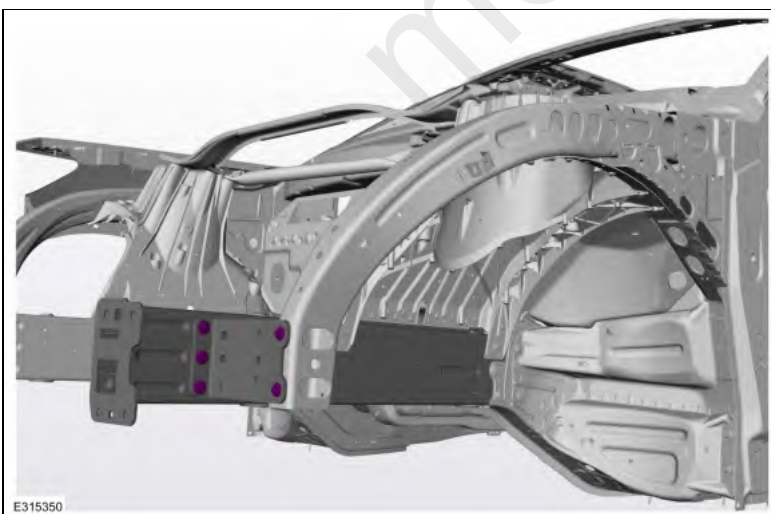
6. Loosely install the bolts.



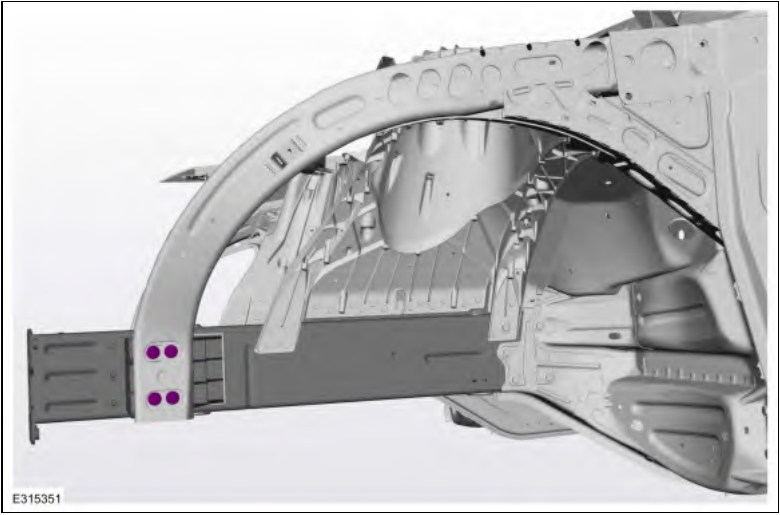
7. Loosely install the bolts.



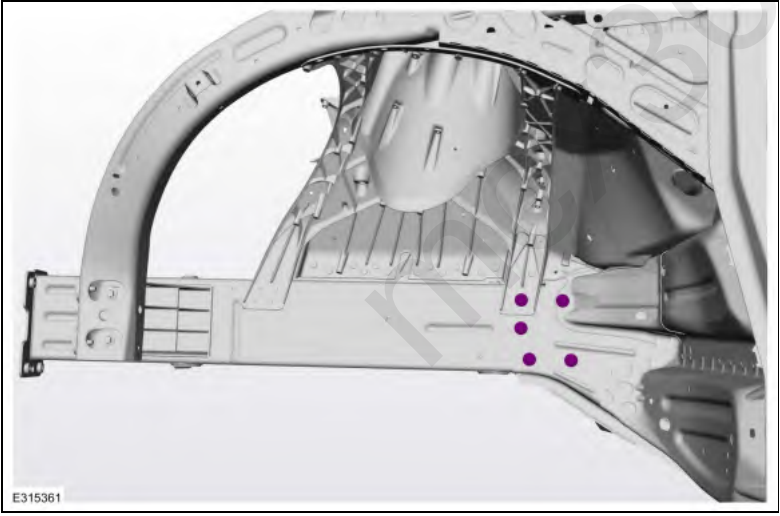
8. Tighten the bolts.
Torque: 35 lb.ft (47 Nm)



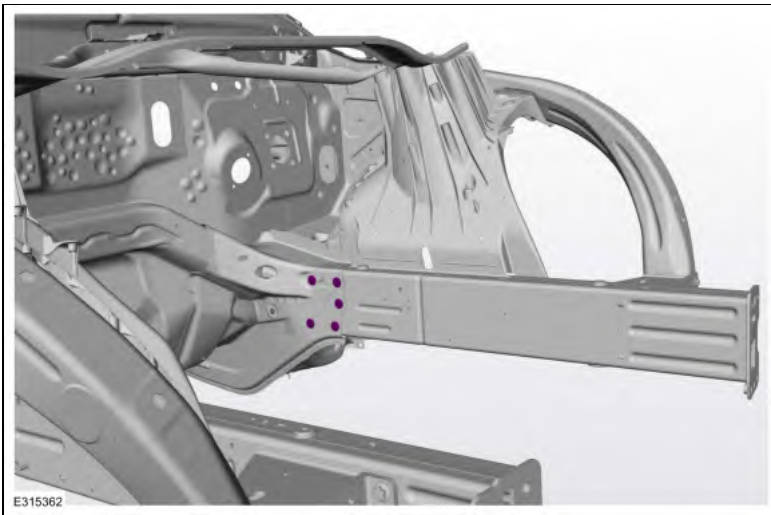
9. Tighten the bolts.
Torque: 35 lb.ft (47 Nm)



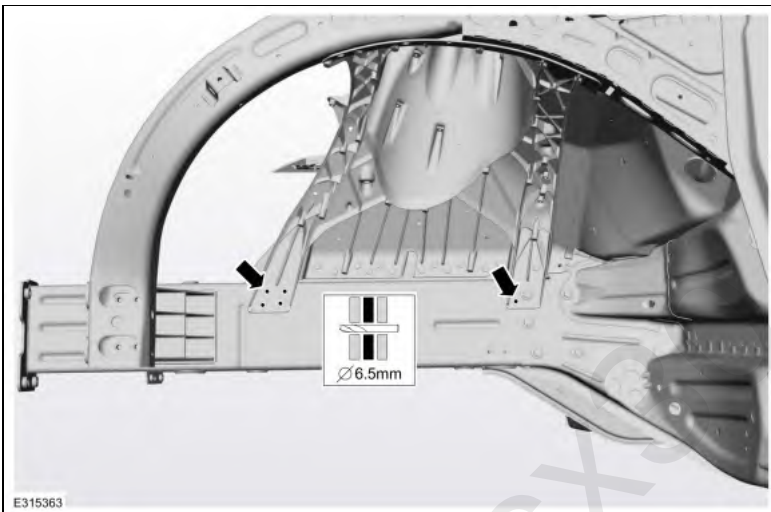
10. Tighten the bolts.
Torque: 35 lb.ft (47 Nm)



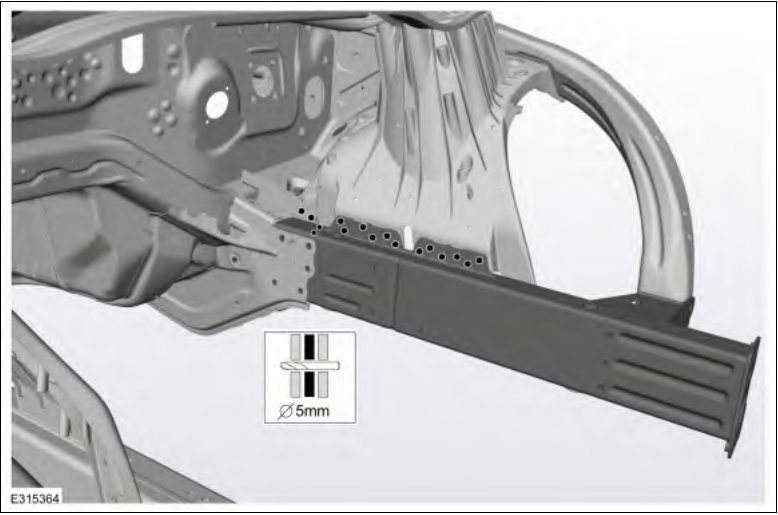
11. Tighten the bolts.
Torque: 35 lb.ft (47 Nm)



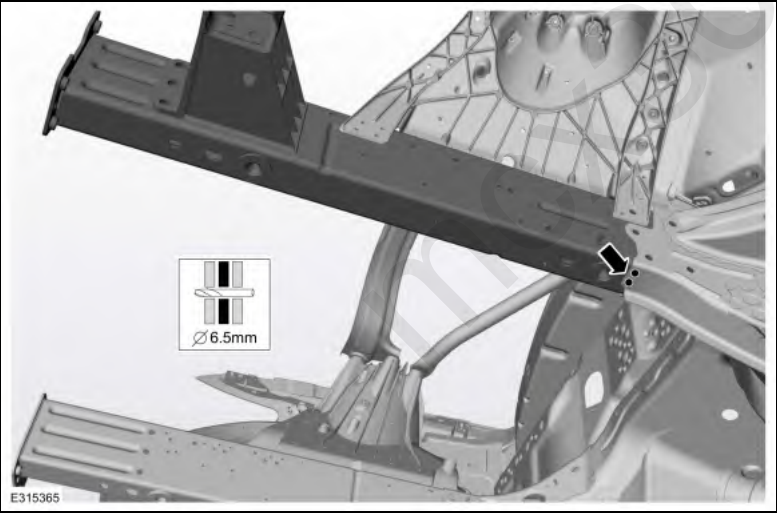
12. Drill for blind rivet fasteners.
Use the General Equipment: 6.5 mm Drill Bit



13. Drill for blind rivet fasteners.
Use the General Equipment: 6.5 mm Drill Bit



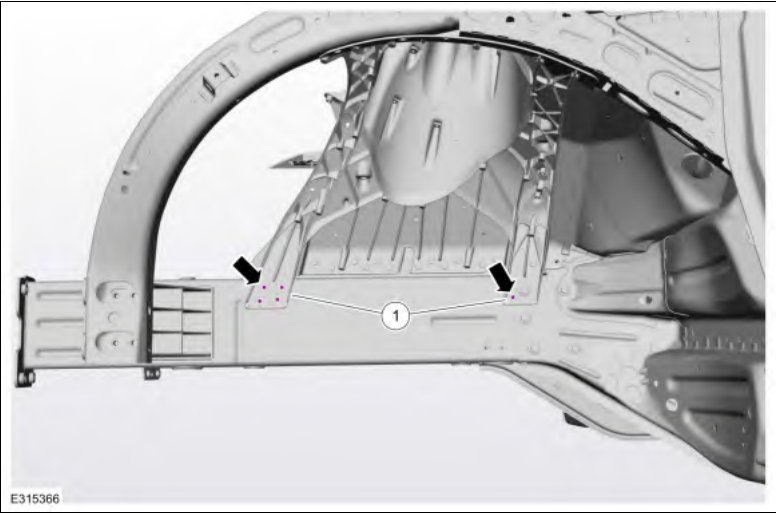
14. Drill for blind rivet fasteners.
Use the General Equipment: 6.5 mm Drill Bit



15. Install fasteners.

Item	SPR Number	SPR Code	Henrob®, Car-O-Liner®, CMO®, Chief®, Spanesi®, Wielander and Schill® Mandrel	Pro-Spot® Mandrel	Quantity	Blind Rivet	Solid Rivet
1	-	-	-	-	5	W708777-S900C	-

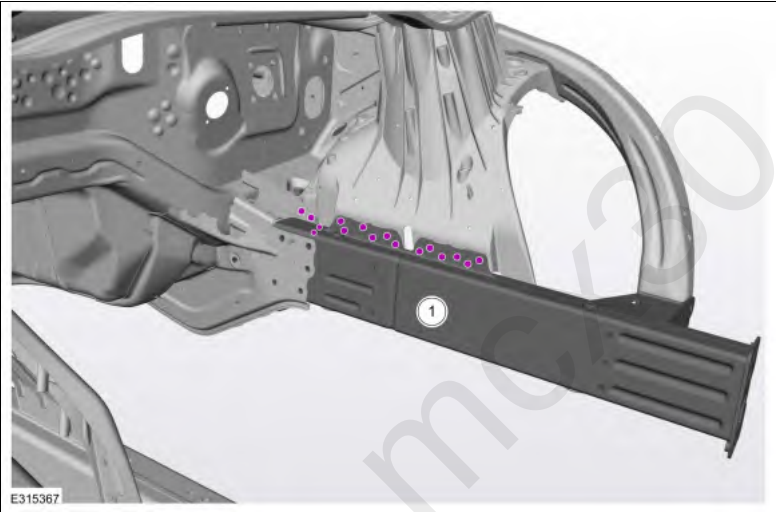
Use the General Equipment: Blind Rivet Gun



16. Install fasteners.

Item	SPR Number	SPR Code	Henrob®, Car-O-Liner Â®, CMO®, Chief®, Spanesi®, Wielander and Schill® Mandrel	Pro-Spot® Mandrel	Quantity	Blind Rivet	Solid Rivet
1	-	-	-	-	5	W702512-S900C	-

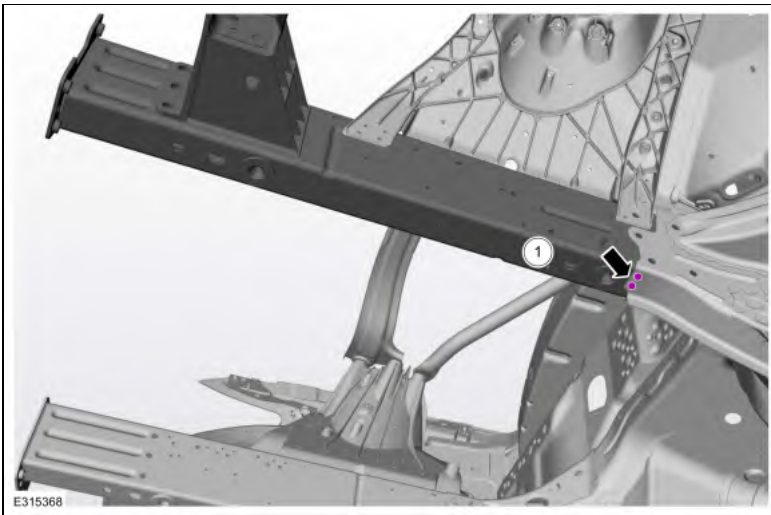
Use the General Equipment: Blind Rivet Gun



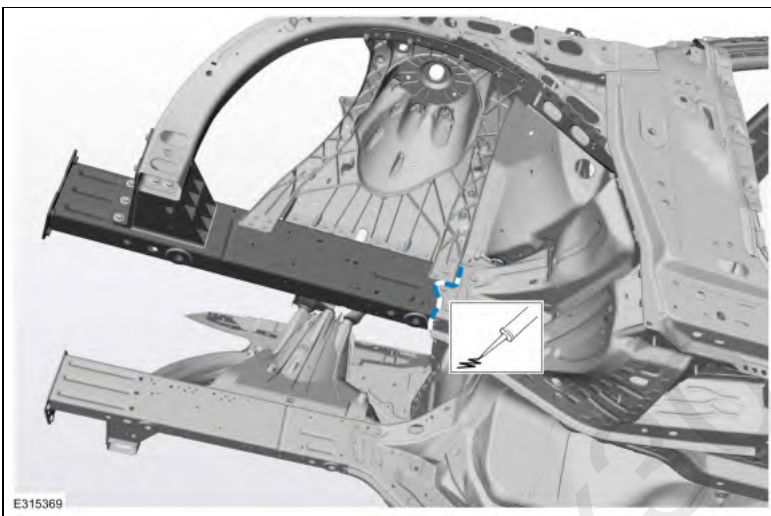
17. Install fasteners.

Item	SPR Number	SPR Code	Henrob®, Car-O-Liner Â®, CMO®, Chief®, Spanesi®, Wielander and Schill® Mandrel	Pro-Spot® Mandrel	Quantity	Blind Rivet	Solid Rivet
1	-	-	-	-	5	W702512-S900C	-

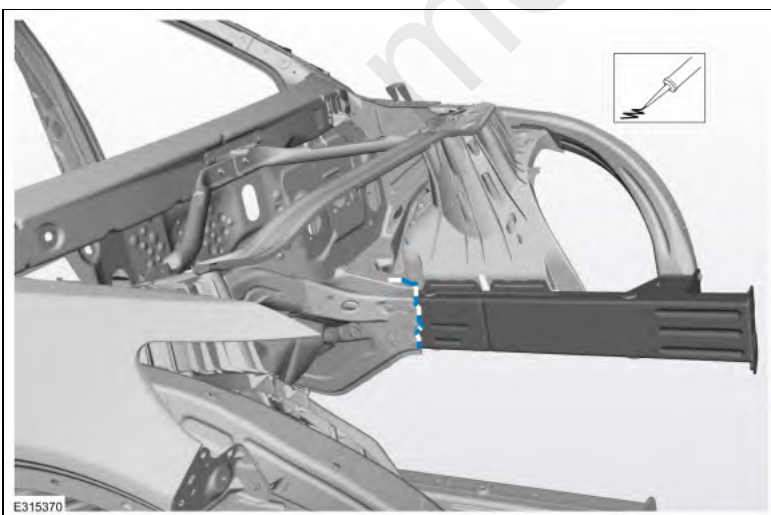
Use the General Equipment: Blind Rivet Gun



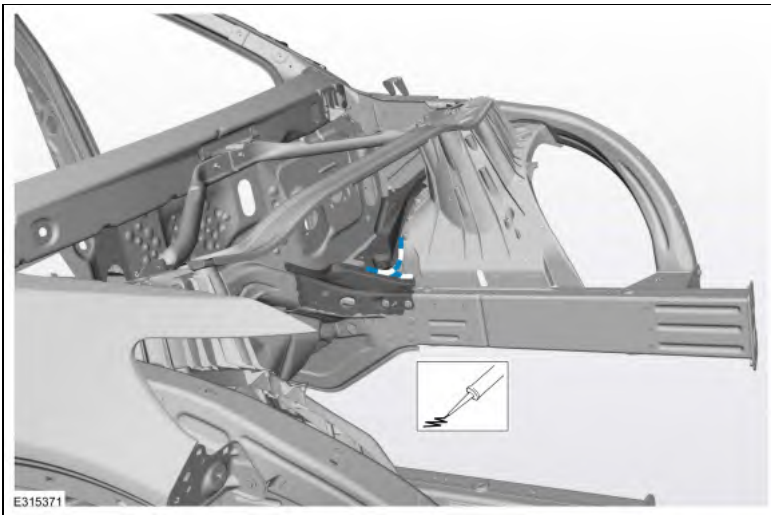
18. Seam Sealing:
All seams must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M, 08308, LORD Fusor® 805DTM



19. Seam Sealing:
All seams must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M, 08308, LORD Fusor® 805DTM



20. Apply NVH foam sealant.
Material: Flexible Foam Repair / 3M, 08463, LORD Fusor® 121



21. Refinish the entire repair using a Ford approved paint system.
22. Install the engine.
Refer to: Engine (303-01A Engine - 2.3L EcoBoost (201kW/273PS), Installation).
Refer to: Engine (303-01B Engine - 3.0L EcoBoost, Installation).
Refer to: Engine (303-01C Engine - 3.3L Duratec-V6, Installation).
Refer to: Engine (303-01D Engine - 3.3L Duratec-V6 â€“ Hybrid (BP), Installation).
Refer to: Hybrid Drive Unit (303-01E Electric Motor, Removal and Installation).
23. Reposition all hoses and wiring harnesses to original location.
24. Install the cooling module.
Refer to: Cooling Module (303-03A Engine Cooling - 2.3L EcoBoost (201kW/273PS), Removal and Installation).
Refer to: Cooling Module (303-03B Engine Cooling - 3.0L EcoBoost, Removal and Installation).
Refer to: Cooling Module (303-03C Engine Cooling - 3.3L Duratec-V6, Removal and Installation).
Refer to: Cooling Module (303-03D Engine Cooling - 3.3L Duratec-V6 â€“ Hybrid (BP), Removal and Installation).
25. Install the fender and front splash shield.
Refer to: Fender (501-02 Front End Body Panels, Removal and Installation).
Refer to: Fender Splash Shield (501-02 Front End Body Panels, Removal and Installation).
26. Install the front bumper.
Refer to: Front Bumper (501-19 Bumpers, Removal and Installation).
Refer to: Front Bumper Cover (501-19 Bumpers, Removal and Installation).
27. Install the grille opening panel.
Refer to: Radiator Grille Opening Panel (501-02 Front End Body Panels, Removal and Installation).
28. Restore corrosion protection.
Refer to: Corrosion Prevention (501-25 Body Repairs - General Information, General Procedures).

Information not available at this time.

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501-28 Roof Sheet Metal Repairs