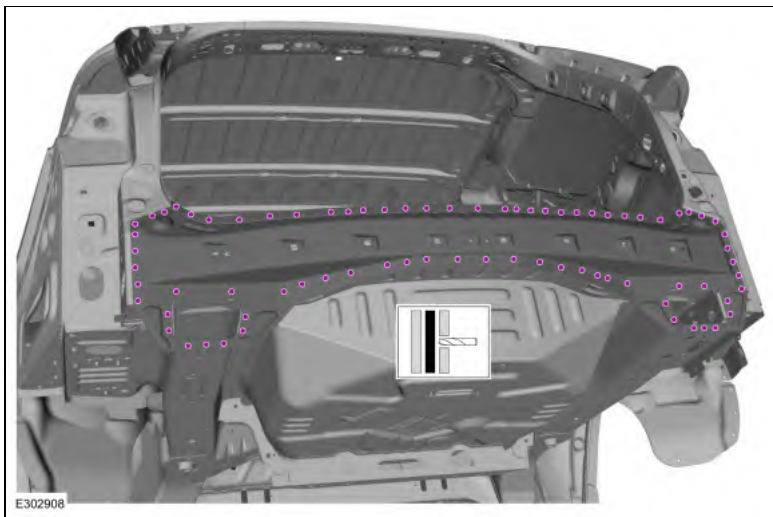
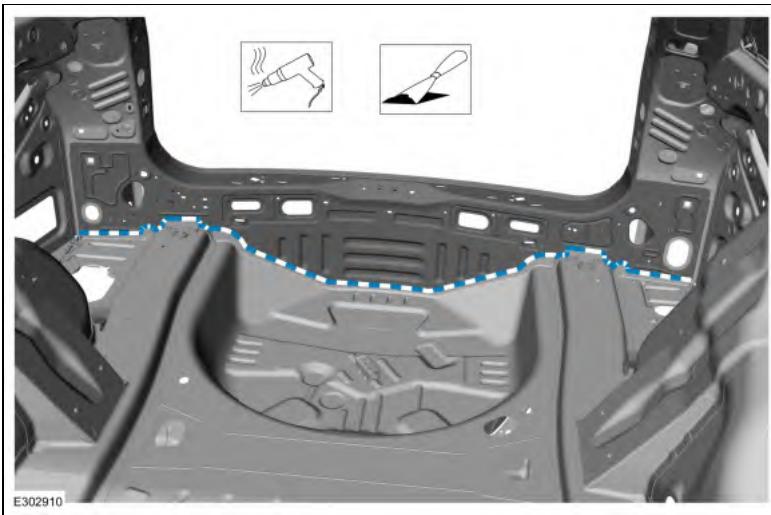




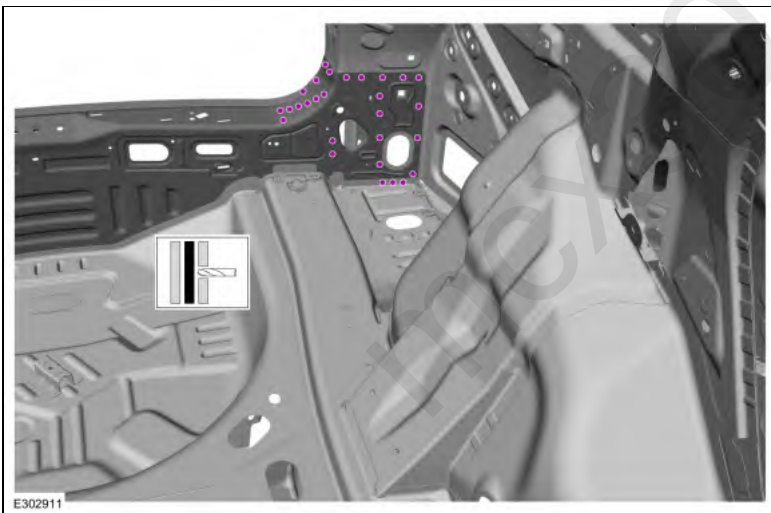
12. Remove the back panel.



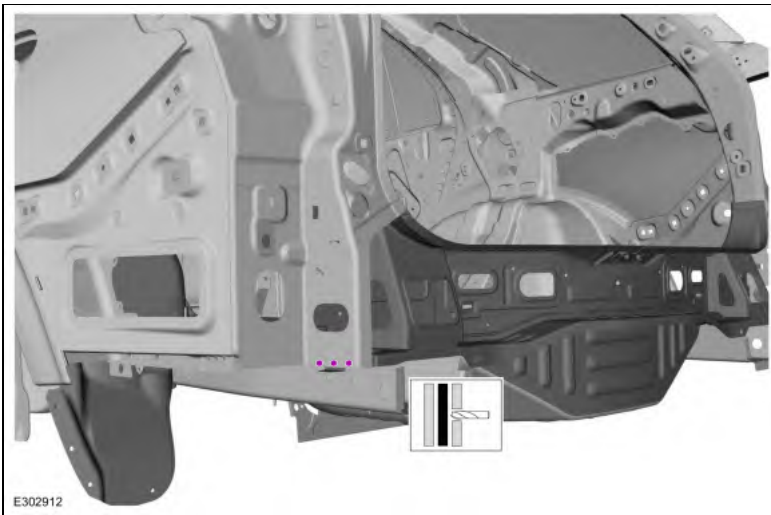
13. Remove the sealer and expandable foam.
 Use the General Equipment: Hot Air Gun
 Use the General Equipment: Scraper for Straight Edges



14. On Both Sides:
Remove the welds.
Use the General Equipment: Spot Weld Drill Bit



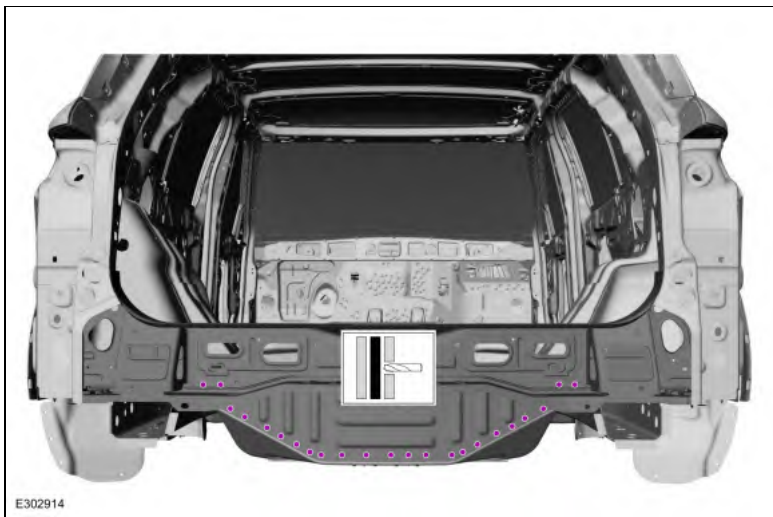
15. On Both Sides:
Remove the welds.
Use the General Equipment: Spot Weld Drill Bit



16. On Both Sides:
Remove the welds.
Use the General Equipment: Spot Weld Drill Bit



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



18. **NOTE:** Pay particular attention to location of sealers and foams used to aid in installation.

Remove the back panel reinforcement.



Installation

NOTICE: BEV, HEV and PHEV contain a HVTB (High Voltage Traction Battery). Before welding near the HVTB, the HVTB must be removed to avoid heat damage.

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

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

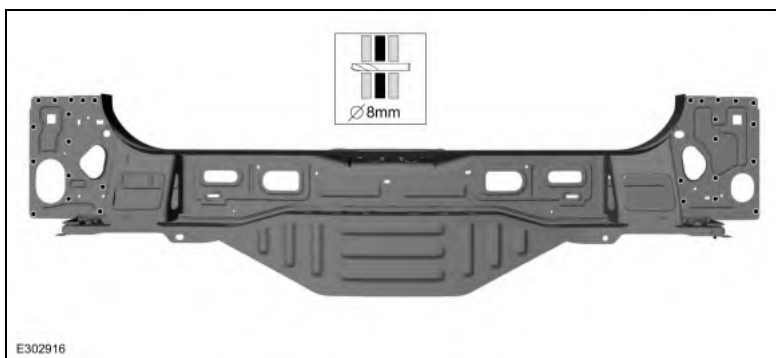
NOTE: Factory welds may be substituted with resistance spot welds or MIG plug welds. Resistance welds may not be placed directly over original weld location. They must be placed adjacent to original location and equal factory welds in quantity. MIG plug welds must equal factory welds in both location and quantity.

1. **WARNING:** Before beginning any service procedure in this manual, refer to health and safety warnings in section 100-00 General Information. Failure to follow this instruction may result in serious personal injury.

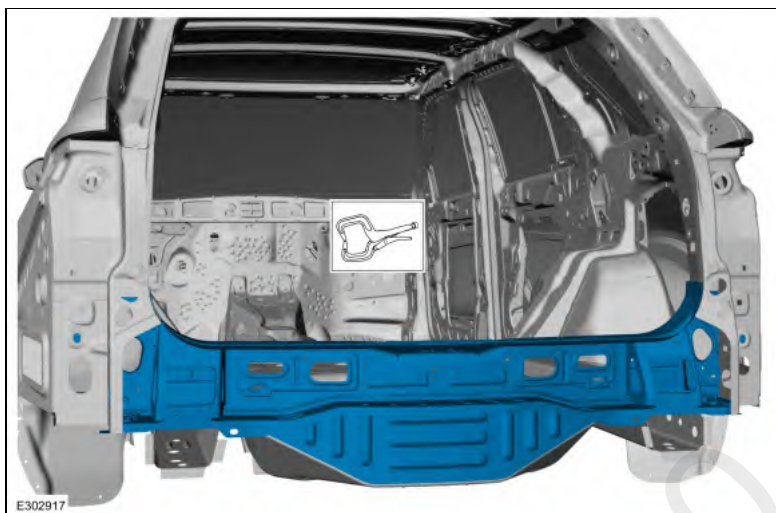
Refer to: Health and Safety Precautions (100-00 General Information, Description and Operation).

Refer to: High Voltage System Health and Safety Precautions - Overview (100-00 General Information, Description and Operation).

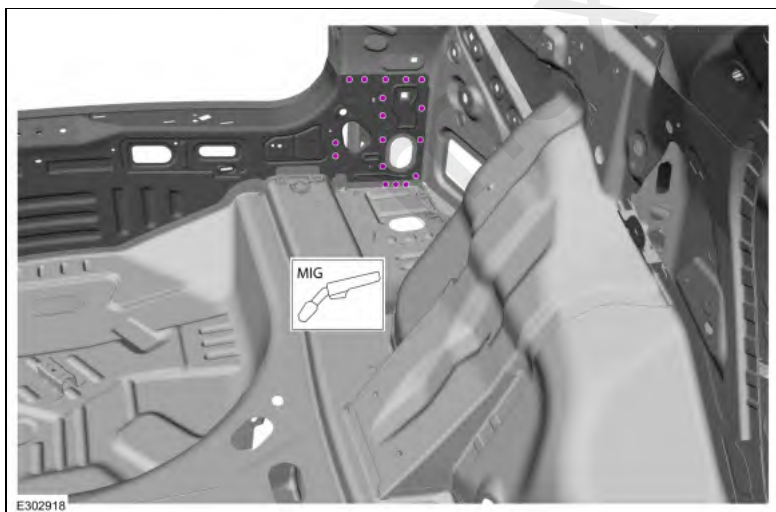
2. Drill plug weld holes.
Use the General Equipment: 8 mm Drill Bit



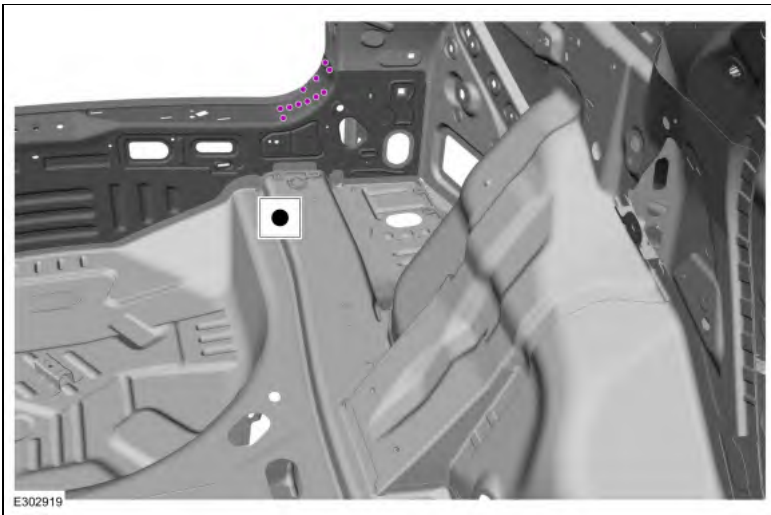
3. Install, properly position and clamp the back panel reinforcement.
Use the General Equipment: Locking Pliers



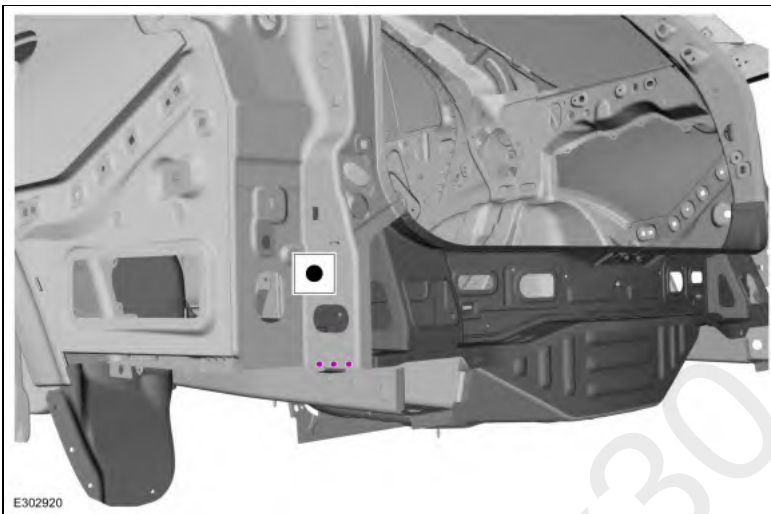
4. On Both Sides:
Install the welds.
Use the General Equipment: MIG/MAG Welding Equipment



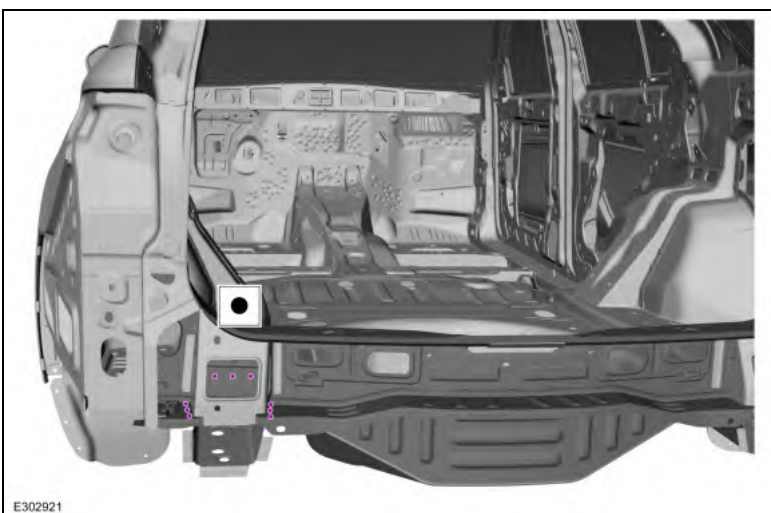
5. Install the welds.
Use the General Equipment: Resistance Spotwelding Equipment



6. Install the welds.
Use the General Equipment: Resistance Spotwelding Equipment



7. Install the welds.
Use the General Equipment: Resistance Spotwelding Equipment



8. Install the welds.

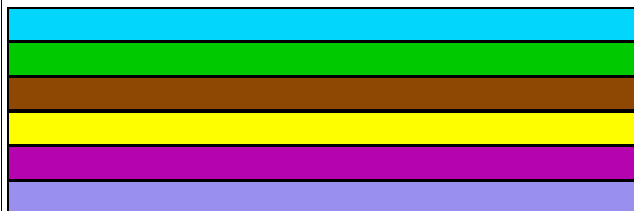
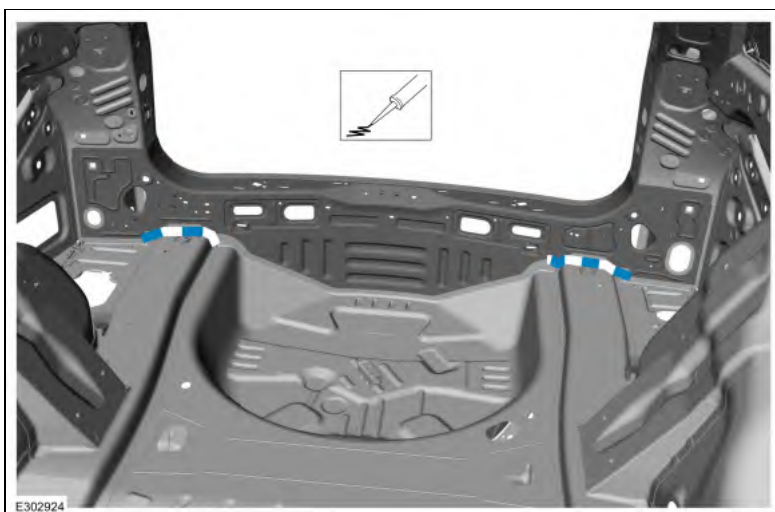
Use the General Equipment: Resistance Spotwelding Equipment



9. Metal finish all welds as necessary using typical metal finishing techniques and materials.

10. Apply NVH foam in areas noted during removal.

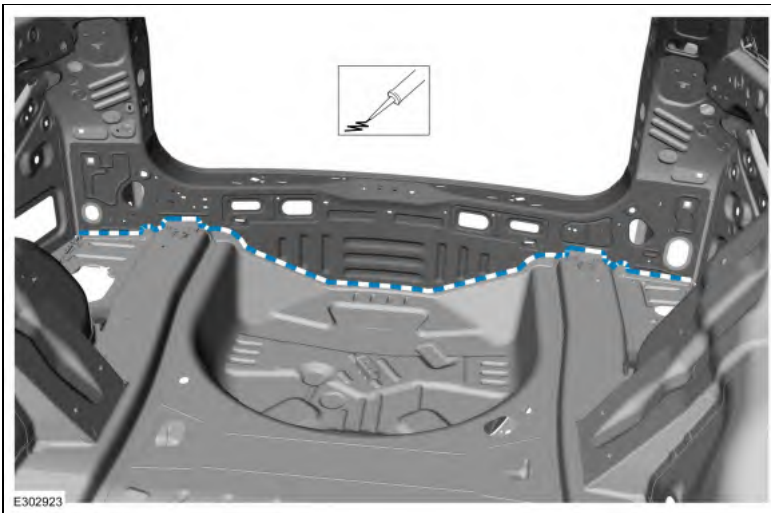
Material: Flexible Foam Repair / 3M[®], 08463, LORD Fusor[®] 121



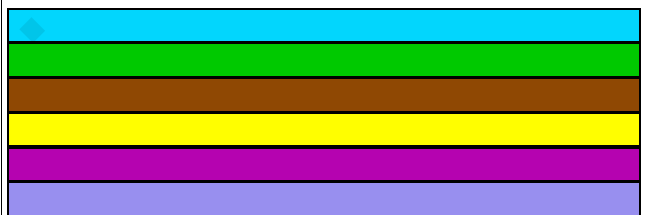
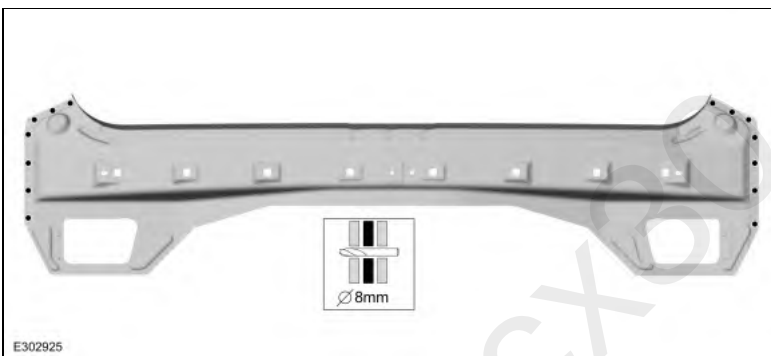
11. Seam Sealing:

All seams must be sealed to production level.

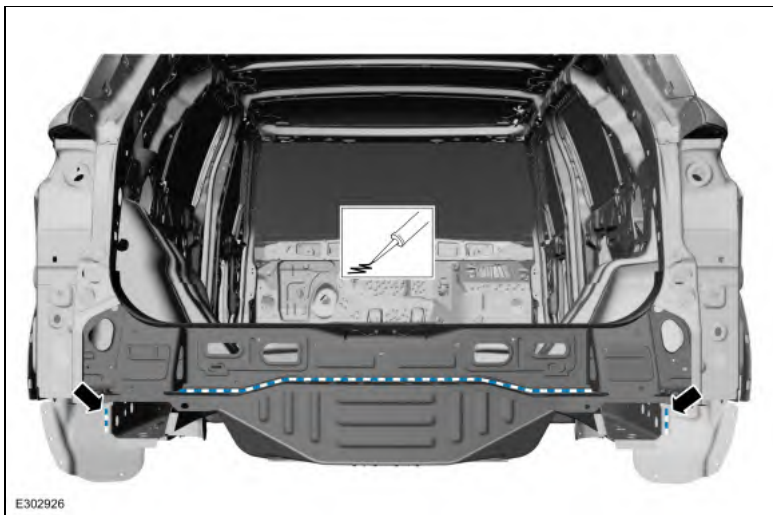
Material: Seam Sealer / TA-2-B, 3M[®], 08308, LORD Fusor[®] 805DTM



12. Drill plug weld holes.
Use the General Equipment: 8 mm Drill Bit



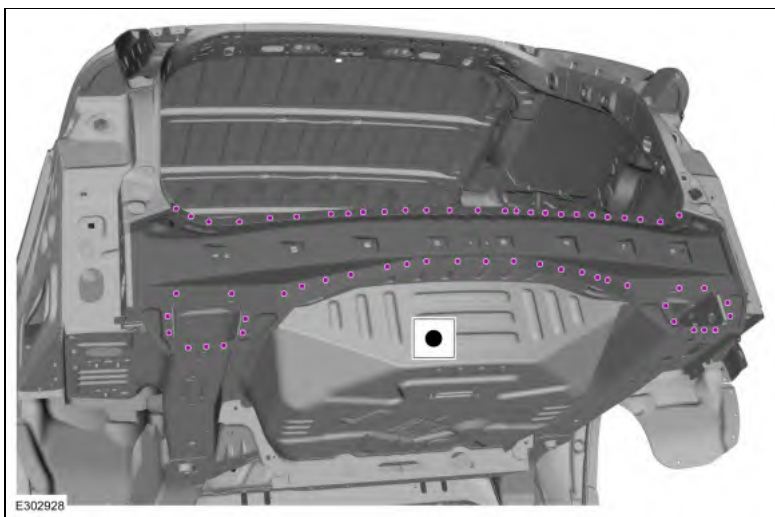
13. Apply adhesive.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3MÂ, 08115, LORD FusorÂ® 108B



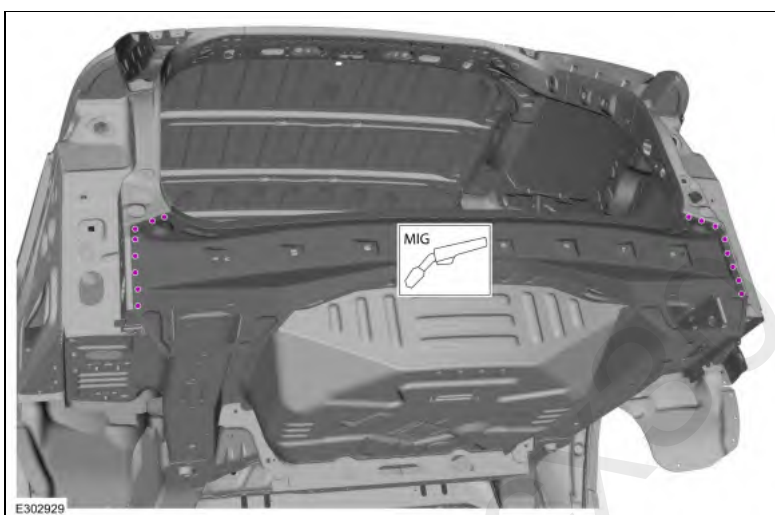
14. Install, properly position and clamp the back panel.
Use the General Equipment: Locking Pliers



15. Install the welds.
Use the General Equipment: Resistance Spotwelding Equipment



16. Install the welds.
Use the General Equipment: MIG/MAG Welding Equipment

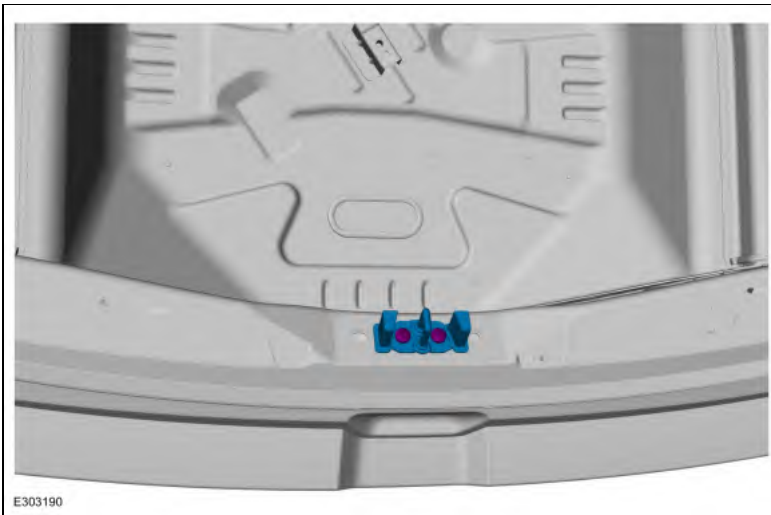


A horizontal bar chart consisting of six distinct, colored segments stacked vertically. From top to bottom, the colors are blue, green, brown, yellow, purple, and light blue. Each segment is separated by a thin black border. The segments are of varying heights, with the blue and green segments being the tallest, followed by the brown segment, and the yellow, purple, and light blue segments being progressively shorter.

17. Metal finish all welds as necessary using typical metal finishing techniques and materials.
18. Seam Sealing:
All seams must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M, # 08308, LORD Fusor® 805DTM



19. Refinish the repair using a Ford approved paint system.
20. Restore corrosion protection.
Refer to: Corrosion Prevention (501-25 Body Repairs - General Information, General Procedures).
21. If Equipped:
Install the HVTB (high-voltage traction battery).
Refer to: High Voltage Battery - Hybrid Electric Vehicle (HEV) (414-03 High Voltage Battery, Mounting and Cables, Removal and Installation).
22. Position all wiring harnesses back to original location.
23. On Both Sides:
Install the tail lamp assembly.
Refer to: Rear Lamp Assembly (417-01 Exterior Lighting, Removal and Installation).
24. Install the rear bumper and cover.
Refer to: Rear Bumper (501-19 Bumpers, Removal and Installation).
Refer to: Rear Bumper Cover (501-19 Bumpers, Disassembly and Assembly).
25. Install the liftgate striker.
Torque: 18 lb.ft (25 Nm)



26. Adjust the liftgate.
Refer to: Liftgate Alignment (501-03 Body Closures, General Procedures).
27. On Both Sides:
Install the quarter trim panel.
Refer to: Loadspace Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: Loadspace Trim Panel - Police (501-05 Interior Trim and Ornamentation, Removal and Installation).
28. Install the loadspace floor covering.

Inner Quarter Panel

Special Tool(s) / General Equipment

Resistance Spotwelding Equipment
Scraper for Straight Edges
Hot Air Gun
8 mm Drill Bit
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

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: Sectioning may not take place within 50 mm of restraints, door hinge, door striker or suspension mounting locations.

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

NOTE: The inner quarter panel may be sectioned providing restraints, door hinge and striker requirements are met. The following assumes full component replacement. Adjust procedure to meet repair needs.

1. **WARNING:** Before beginning any service procedure in this manual, refer to health and safety warnings in section 100-00 General Information. Failure to follow this instruction may result in serious personal injury.

Refer to: Health and Safety Precautions (100-00 General Information, Description and Operation).

Refer to: High Voltage System Health and Safety Precautions - Overview (100-00 General Information, Description and Operation).

2. Depower the SRS.

Refer to: Supplemental Restraint System (SRS) Depowering (501-20B Supplemental Restraint System, General Procedures).

3. Remove the side air curtain.

Refer to: Side Curtain Airbag (501-20B Supplemental Restraint System, Removal and Installation).

4. If Required:

Remove the hybrid auxiliary battery.

Refer to: Auxiliary Battery (414-01 Battery, Mounting and Cables, Removal and Installation).

5. If Required:

Dimensionally restore the vehicle to pre-damage condition.

Refer to: Body and Frame (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

6. If Required:

Remove the auxiliary A/C unit.

Refer to: Rear Climate Control Housing (412-02 Rear Climate Control, Removal and Installation).

7. If Required:

Remove the wi-fi modem.

Refer to: Telematics Control Unit (TCU) Module (415-00B Information and Entertainment System - General Information - Vehicles With: SYNC 3, Removal and Installation).

8. Remove the rear safety belt and retractor.

Refer to: Second Row Seatbelt Retractor and Pretensioner (501-20A Seatbelt Systems, Removal and Installation).

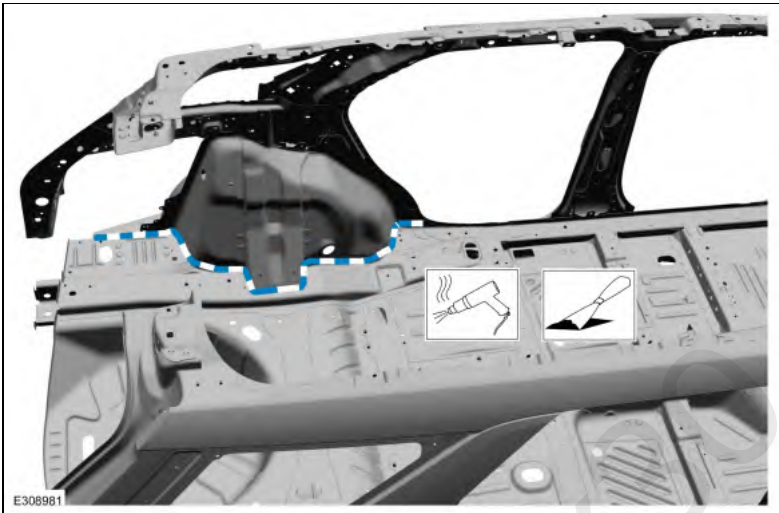
9. Position aside the carpeting and all wiring harnesses.

10. Remove the roof.

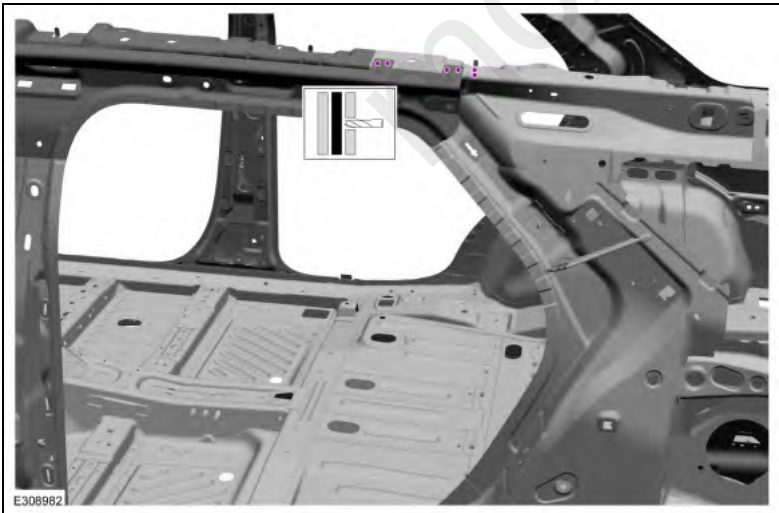
Refer to: Roof Panel (501-28 Roof Sheet Metal Repairs, Removal and Installation).

Refer to: RoofPanel - Vehicles With: Roof Opening Panel (501-28 Roof Sheet Metal Repairs, Removal and Installation).

- 11. If Equipped:
Remove the rear roof bows.
Refer to: Roof Reinforcement (501-28 Roof Sheet Metal Repairs, Removal and Installation).
- 12. Remove the rear roof header.
Refer to: Roof Rear Frame (501-28 Roof Sheet Metal Repairs, Removal and Installation).
- 13. Remove the back panel and reinforcement.
Refer to: Back Panel and Reinforcement (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
- 14. Remove the outer quarter panel.
Refer to: Quarter Panel (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
- 15. Remove the water drain panel.
Refer to: Water Drain Panel (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
- 16. Remove the rocker panel inner reinforcement.
Refer to: Rocker Panel Inner Reinforcement (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
- 17. Remove the seam sealer and NVH material.
Use the General Equipment: Hot Air Gun
Use the General Equipment: Scraper for Straight Edges



- 18. Remove the welds.
Use the General Equipment: Spot Weld Drill Bit



- 19. Remove the welds.
Use the General Equipment: Spot Weld Drill Bit