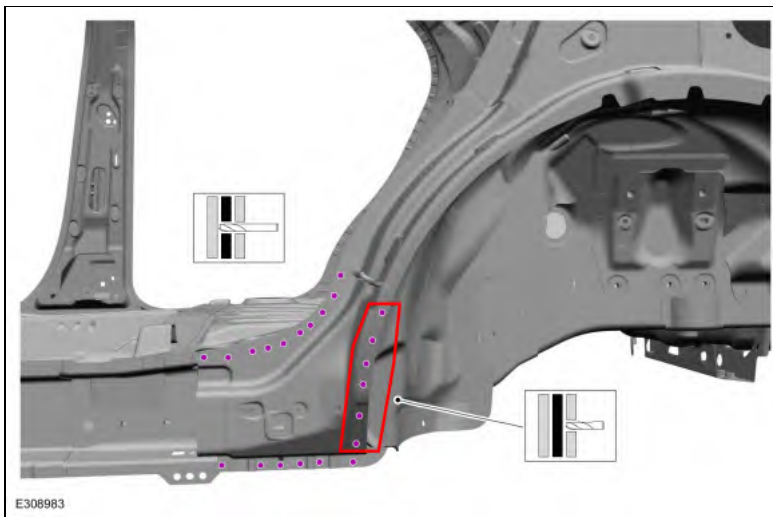
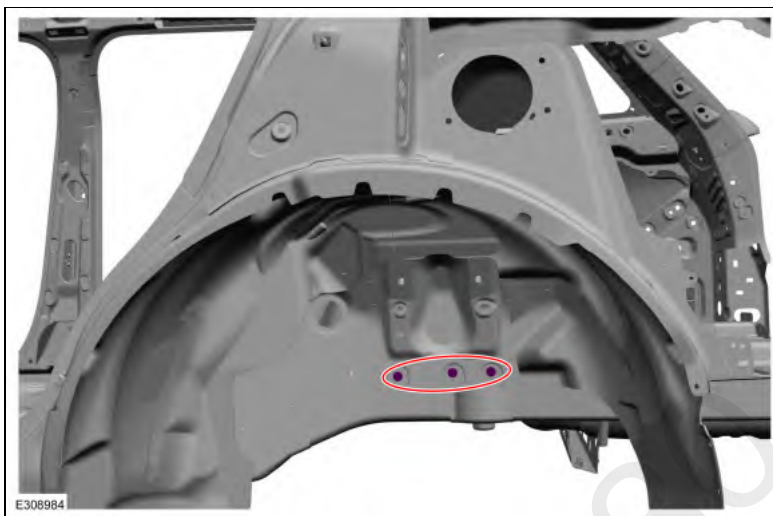




20. Remove the bolts.



21. Remove the seam sealer.
 Use the General Equipment: Hot Air Gun
 Use the General Equipment: Scraper for Straight Edges



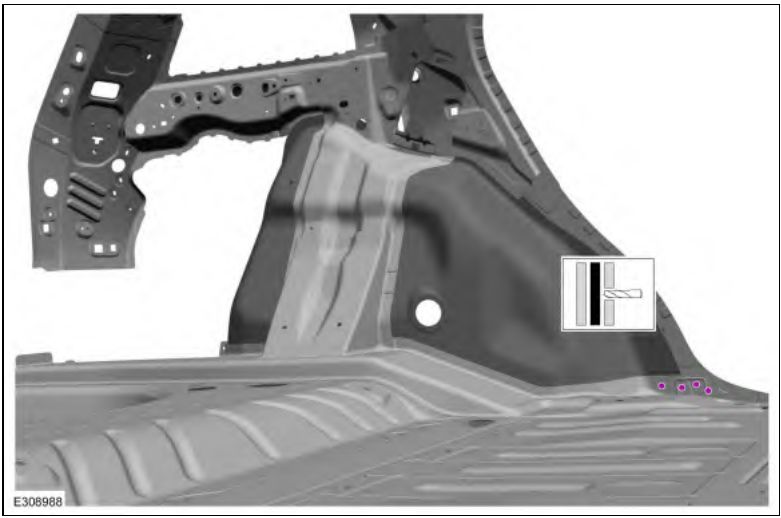
A diagram showing a stack of six horizontal bars of different colors (cyan, green, brown, yellow, purple, and light blue) and a white bar above them, all within a black rectangular frame. The bars are stacked vertically, with the white bar at the top and the light blue bar at the bottom. The colors of the bars from top to bottom are white, cyan, green, brown, yellow, purple, and light blue. The entire stack is enclosed in a black rectangular frame.



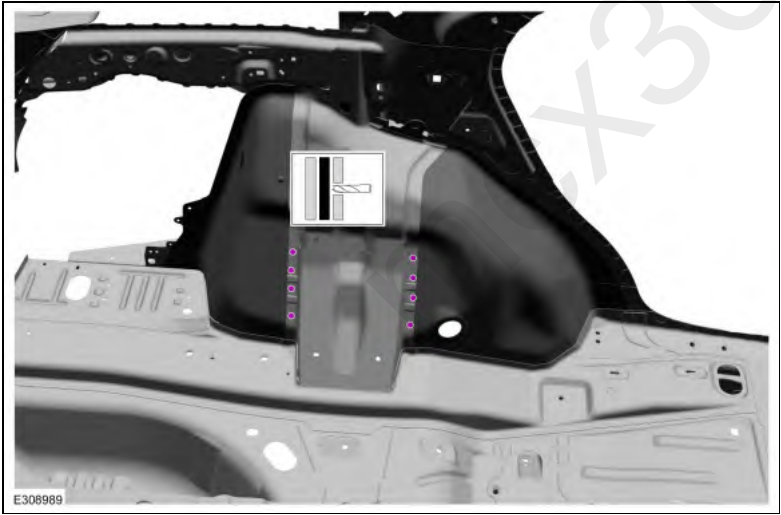
A diagram illustrating a horizontal stack of colored rectangles. The stack consists of seven rectangles of equal height and width, arranged vertically. The colors from top to bottom are: white, light blue, green, brown, yellow, purple, and light purple. A small white rectangle is positioned above the stack, and a larger white rectangle is positioned below the stack.



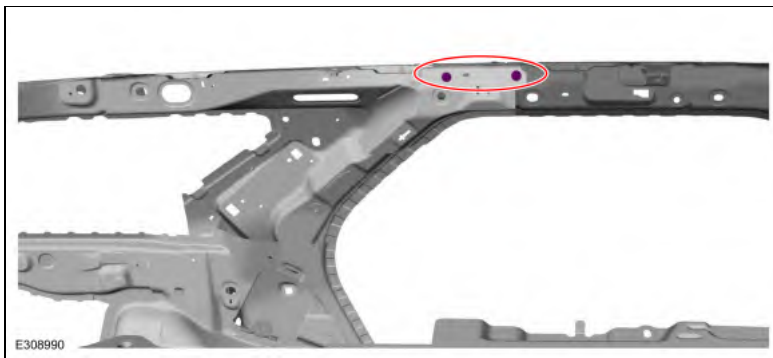
24. Remove the welds.
Use the General Equipment: Spot Weld Drill Bit



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

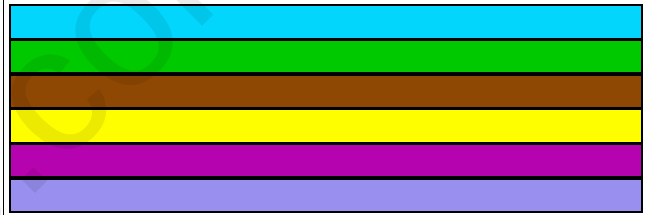
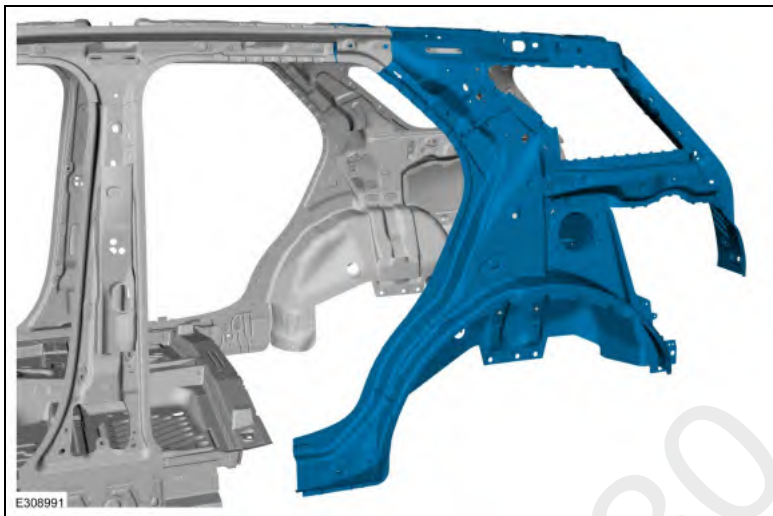


26. Remove the bolts.



27. **NOTE:** Pay particular attention to location of adhesives and sealers to aid in installation.

Remove the inner quarter panel.



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

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: 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.

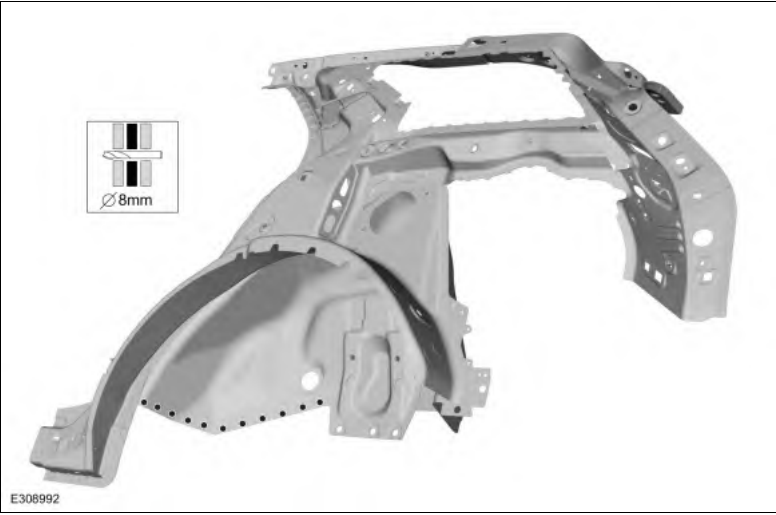
NOTE: Factory welds may be substituted with resistance spot welds or metal inert gas (MIG) plug welds. Resistance spot welds may not be placed directly over original location. They must be placed adjacent to original location and equal factory welds in quantity. Metal inert gas (MIG) plug welds must 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.

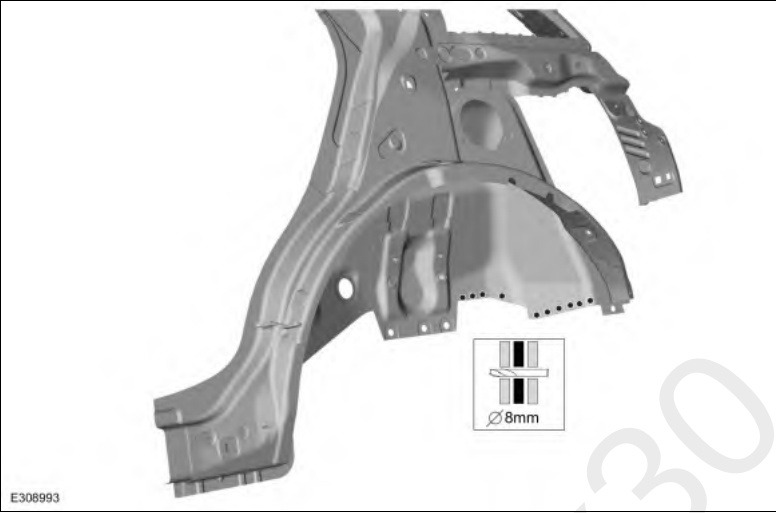
Refer to: Health and Safety Precautions (100-00 General Information, Description and Operation).

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

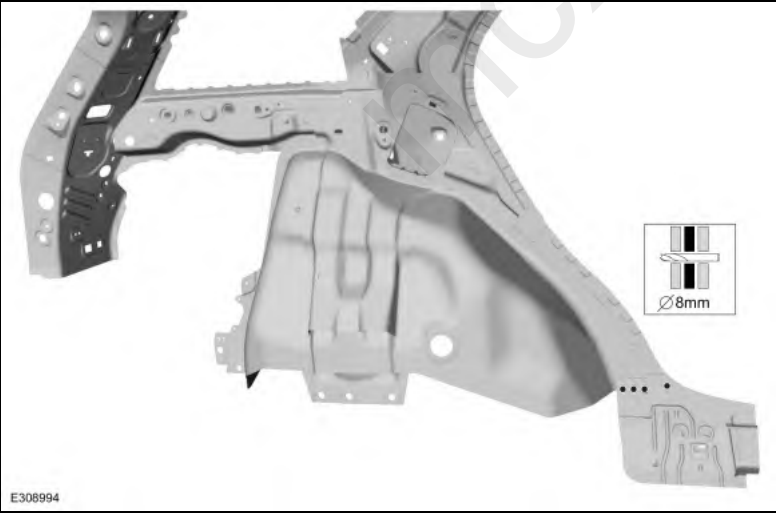
2. Drill plug weld holes.
Use the General Equipment: 8 mm Drill Bit



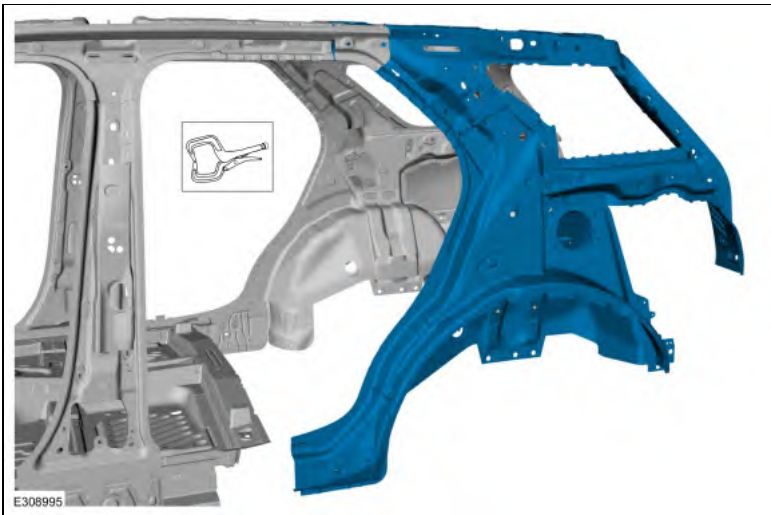
3. Drill plug weld holes.
Use the General Equipment: 8 mm Drill Bit



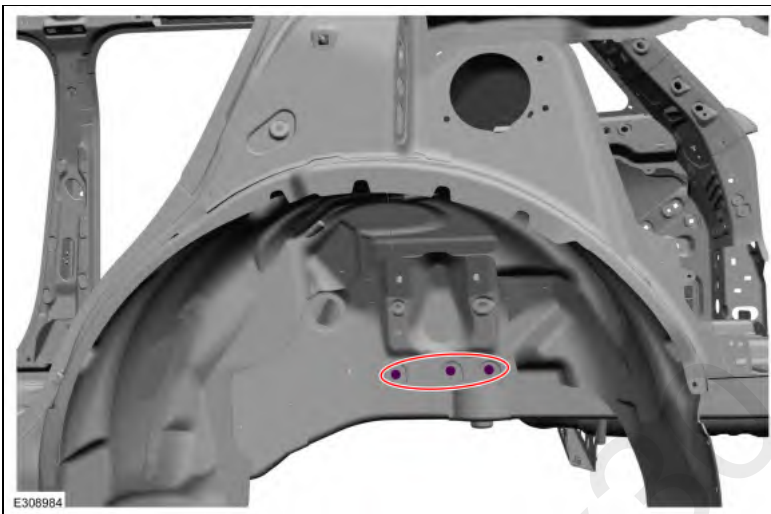
4. Drill plug weld holes.
Use the General Equipment: 8 mm Drill Bit



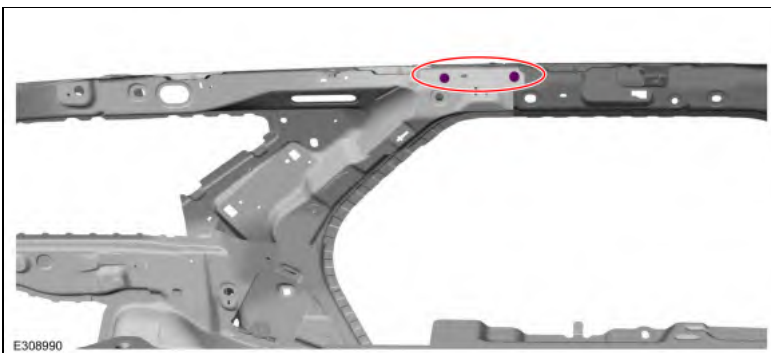
5. Install, properly position and clamp the inner quarter panel.
Use the General Equipment: Locking Pliers



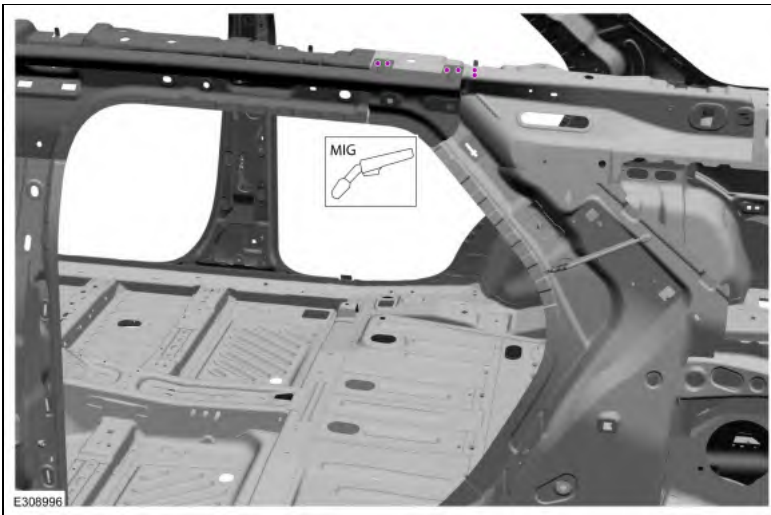
6. Install the bolts.
Torque: 35 lb.ft (47 Nm)



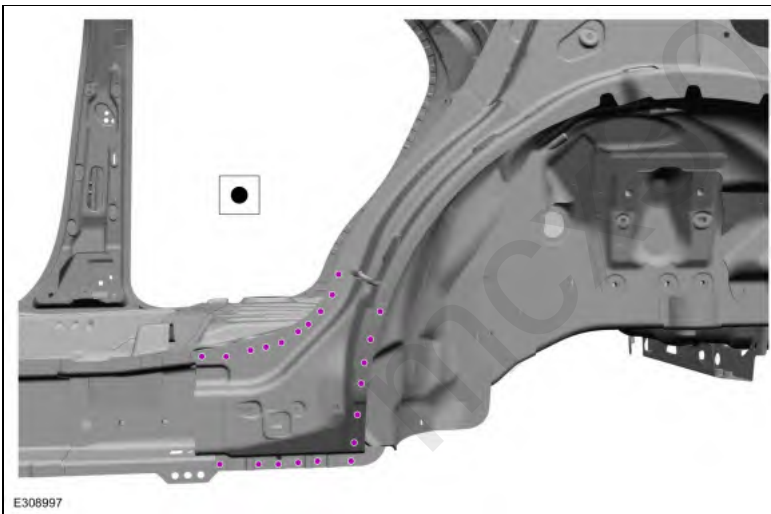
7. Install the bolts.
Torque: 80 lb.in (9 Nm)



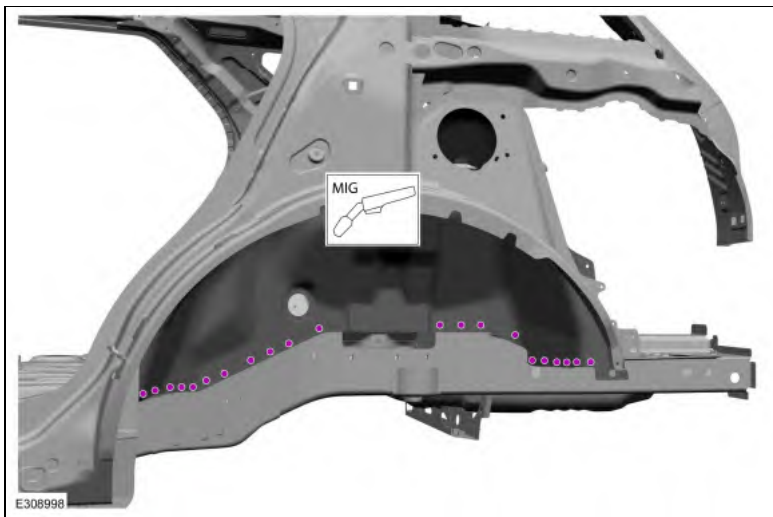
8. Install the welds.
Use the General Equipment: MIG/MAG Welding Equipment



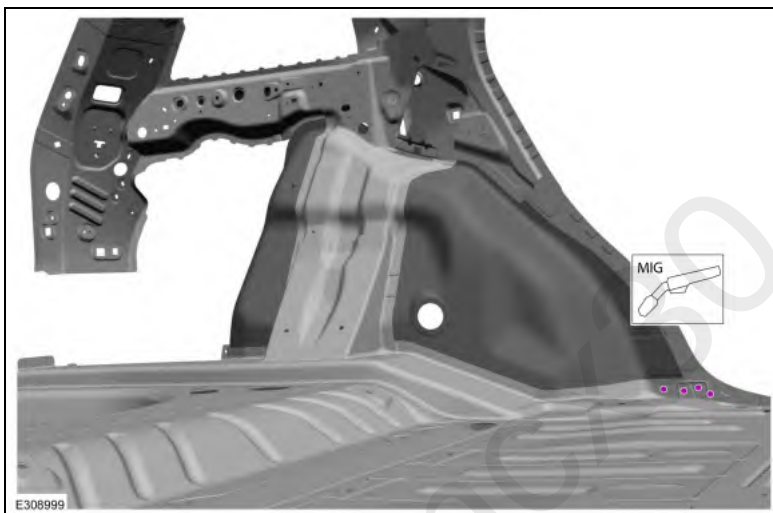
9. Install the welds.
Use the General Equipment: Resistance Spotwelding Equipment



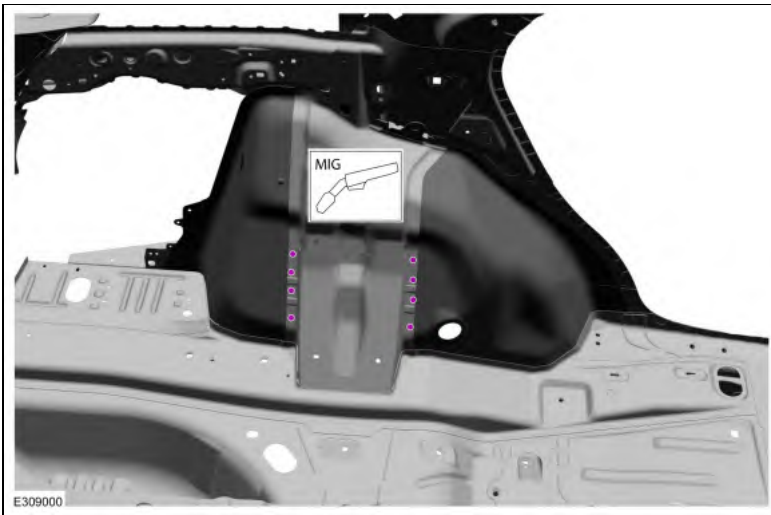
10. Install the welds.
Use the General Equipment: MIG/MAG Welding Equipment



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



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

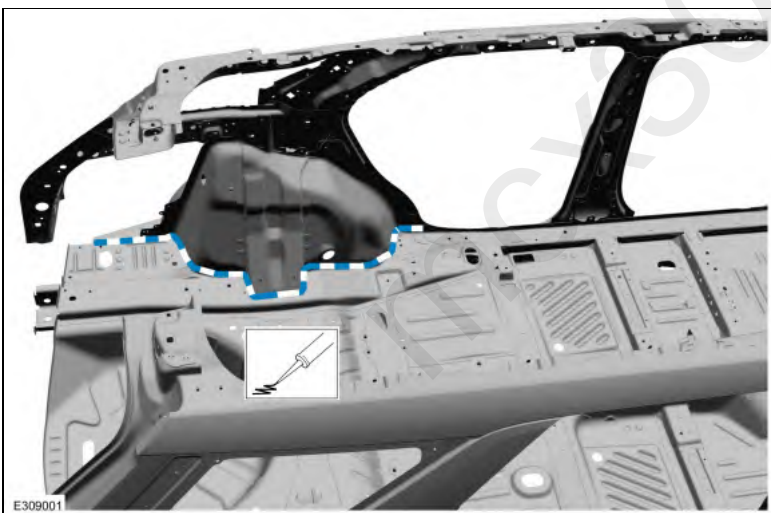


13. Metal finish all welds as necessary.

14. Seam Sealing:

All seams must be sealed to production level.

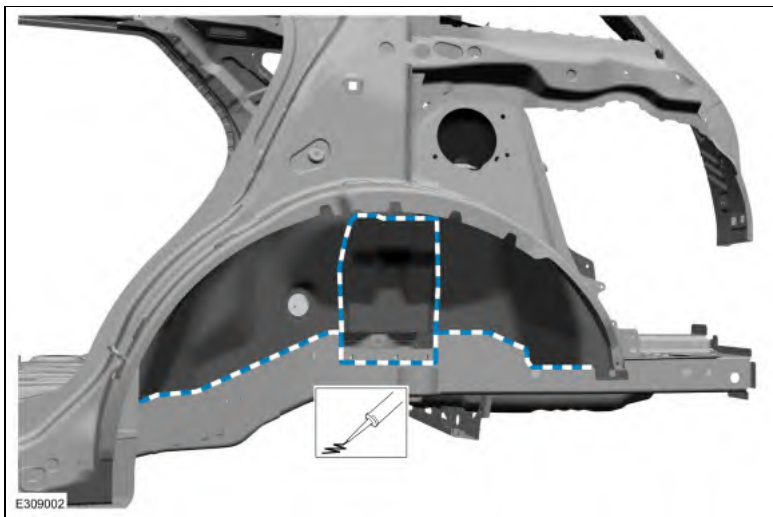
Material: Seam Sealer / TA-2-B, 3M, 08308, LORD Fusor® 805DTM



15. Seam Sealing:

All seams must be sealed to production level.

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



16. Apply NVH foam sealant to all areas noted during removal.
Material: Flexible Foam Repair / 3MÂ, 08463, LORD FusorÂ® 121
17. Install the rocker panel inner reinforcement.
Refer to: Rocker Panel Inner Reinforcement (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
18. Install the water drain panel.
Refer to: Water Drain Panel (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
19. Install the outer quarter panel.
Refer to: Quarter Panel (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
20. Install the back panel and reinforcement.
Refer to: Back Panel and Reinforcement (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
21. If Equipped:
Install the rear roof bows.
Refer to: Roof Reinforcement (501-28 Roof Sheet Metal Repairs, Removal and Installation).
22. Install the rear roof header.
Refer to: Roof Rear Frame (501-28 Roof Sheet Metal Repairs, Removal and Installation).
23. Install the roof panel.
Refer to: Roof Panel (501-28 Roof Sheet Metal Repairs, Removal and Installation).
Refer to: Roof Panel - Vehicles With: Roof Opening Panel (501-28 Roof Sheet Metal Repairs, Removal and Installation).
24. Refinish the entire repair using a Ford approved paint system.
25. If Required:
Install the hybrid auxiliary battery.
Refer to: Auxiliary Battery (414-01 Battery, Mounting and Cables, Removal and Installation).
26. If Required:
Install the auxiliary A/C unit.
Refer to: Rear Climate Control Housing (412-02 Rear Climate Control, Removal and Installation).
27. If Required:
Install 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).
28. Install the rear safety belt and retractor.
Refer to: Second Row Seatbelt Retractor and Pretensioner (501-20A Seatbelt Systems, Removal and Installation).
29. Install the side air curtain.
Refer to: Side Curtain Airbag (501-20B Supplemental Restraint System, Removal and Installation).
30. Restore corrosion protection.
Refer to: Corrosion Prevention (501-25 Body Repairs - General Information, General Procedures).
31. Repower the SRS
Refer to: Supplemental Restraint System (SRS) Repowering (501-20B Supplemental Restraint System, General Procedures).

Quarter Panel

Special Tool(s) / General Equipment

Resistance Spotwelding Equipment
Scraper for Straight Edges
Spherical Cutter
Hot Air Gun
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

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.

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

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

NOTE: The outer quarter panel may be section at any point providing restraints, hinge and striker mounting precautions are met. The following assumes full component replacement. Adjust procedure to meet repair needs.

- 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).

- Quarter panel service part.

Refer to: Body Panel Sectioning (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, General Procedures).



3. Partial quarter panel service part.

Refer to: Body Panel Sectioning (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, General Procedures).



4. If Required:

Remove the hybrid auxiliary battery.

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

5. Depower the SRS.

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

6. Remove the side air curtain.

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

7. If Necessary:

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).

8. Remove the rear door.

Refer to: Rear Door (501-03 Body Closures, Removal and Installation).

9. Remove the rear door opening tread plate.

10. Remove the rear door opening weatherstrip.