

Floor Panel Reinforcement**Special Tool(s) / General Equipment**

6.5 mm Drill Bit
Scraper for Straight Edges
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Hot Air Gun
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® 803DTM	-

Removal

NOTICE: Panel sectioning is prohibited within 50 mm of door hinge, door striker, restraints and suspension anchoring points.

NOTE: Self-piercing rivet (SPR) fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

NOTE: Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repair areas that utilize structural adhesives may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425° F to loosen a bonded panel should only be done when all panels in the joint will be replaced and new adhesive applied.

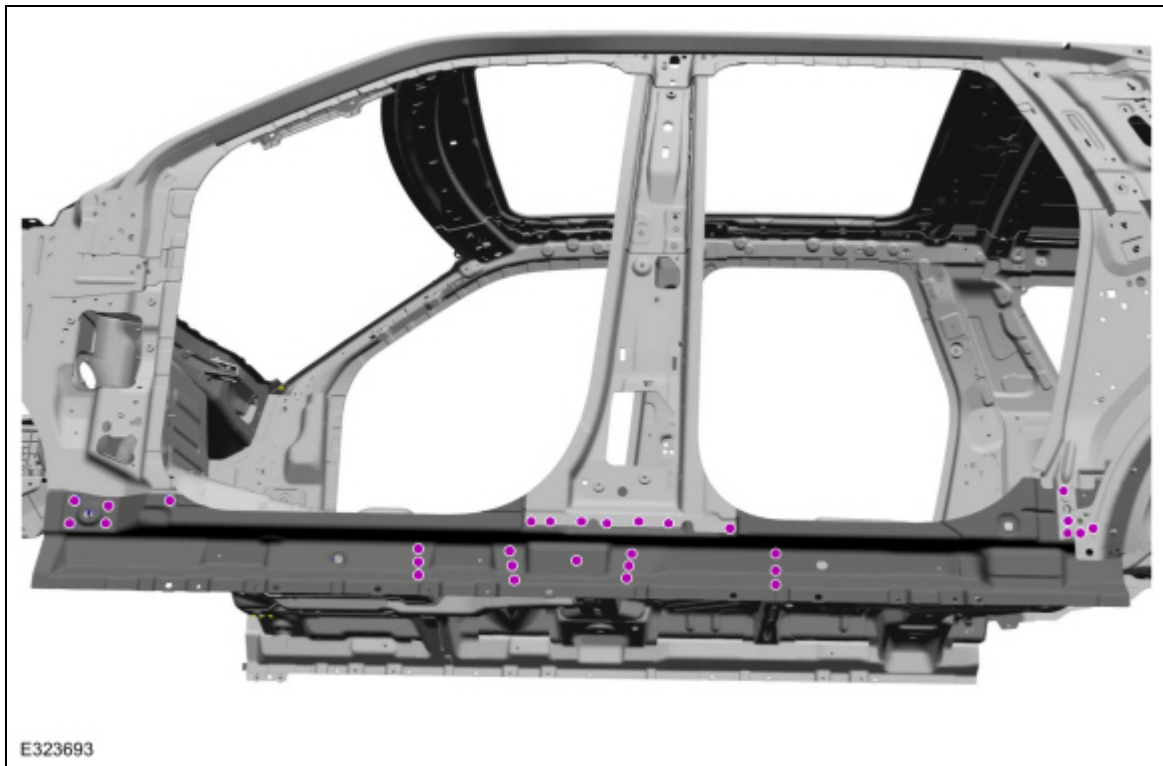
NOTE: The floor panel reinforcement may be sectioned providing the sectioning guidelines are adhered to. The following procedure assumes full component replacement. Adjust to meet repair needs.

NOTE: LH side shown, RH side similar.

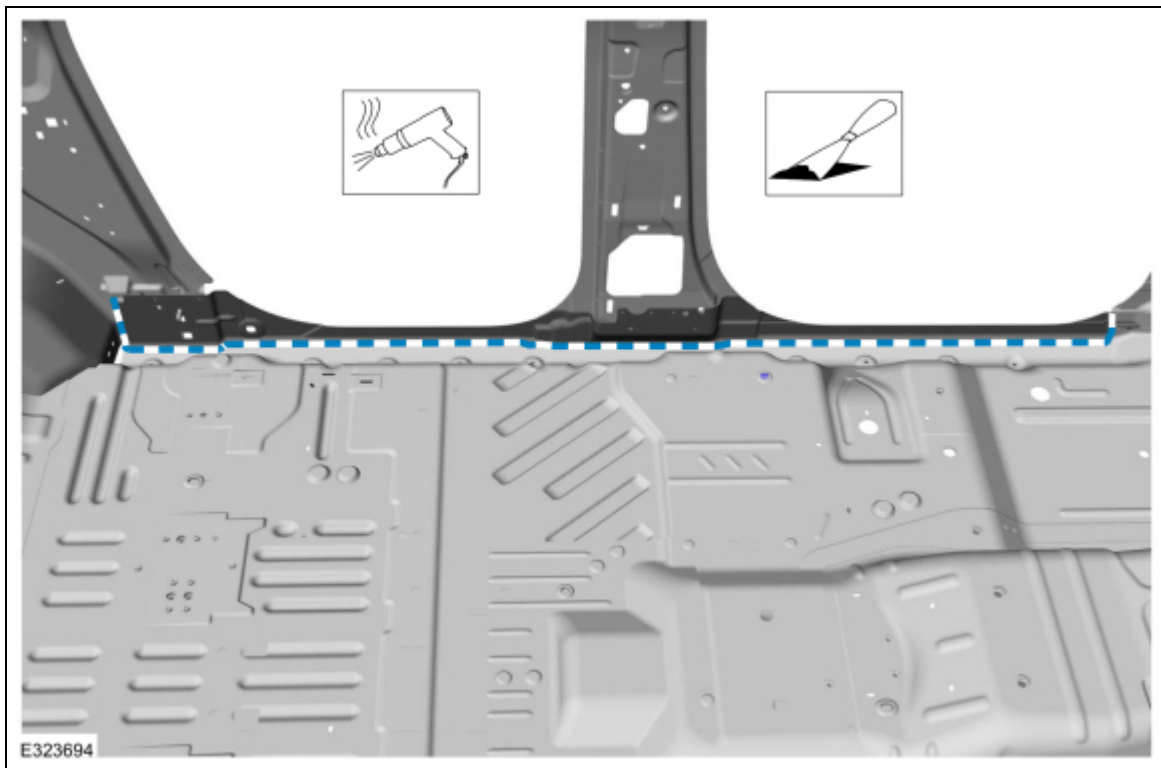
NOTE: Long wheelbase shown, short wheelbase similar.

1. Depower the SRS.
Refer to: [Supplemental Restraint System \(SRS\) Depowering](#) (501-20B Supplemental Restraint System, General Procedures).
2. 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).

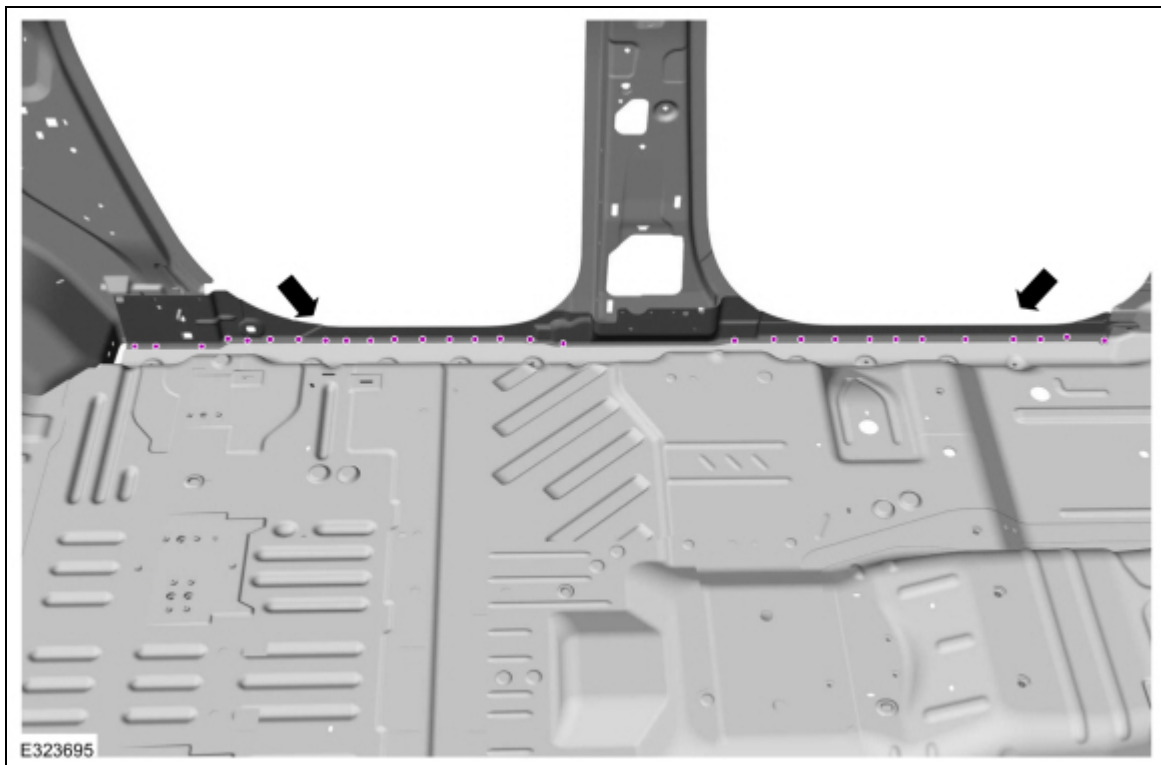
3. Remove the A, B and C-pillar trim.
 Refer to: [A-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
 Refer to: [B-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
 Refer to: [C-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
4. Remove the front and second row seats.
 Refer to: [Front Seat](#) (501-10A Front Seats, Removal and Installation).
 Refer to: [Second Row Seat](#) (501-10B Second Row Seats, Removal and Installation).
5. Position the carpet and all wiring harnesses away from the working area.
6. Remove the A-pillar reinforcement.
 Refer to: [A-Pillar Outer Panel Section and Reinforcement](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
7. Remove the rocker panel reinforcement.
 Refer to: [Rocker Panel Inner Reinforcement](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
8. Remove the fasteners.
 Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Belt Sander



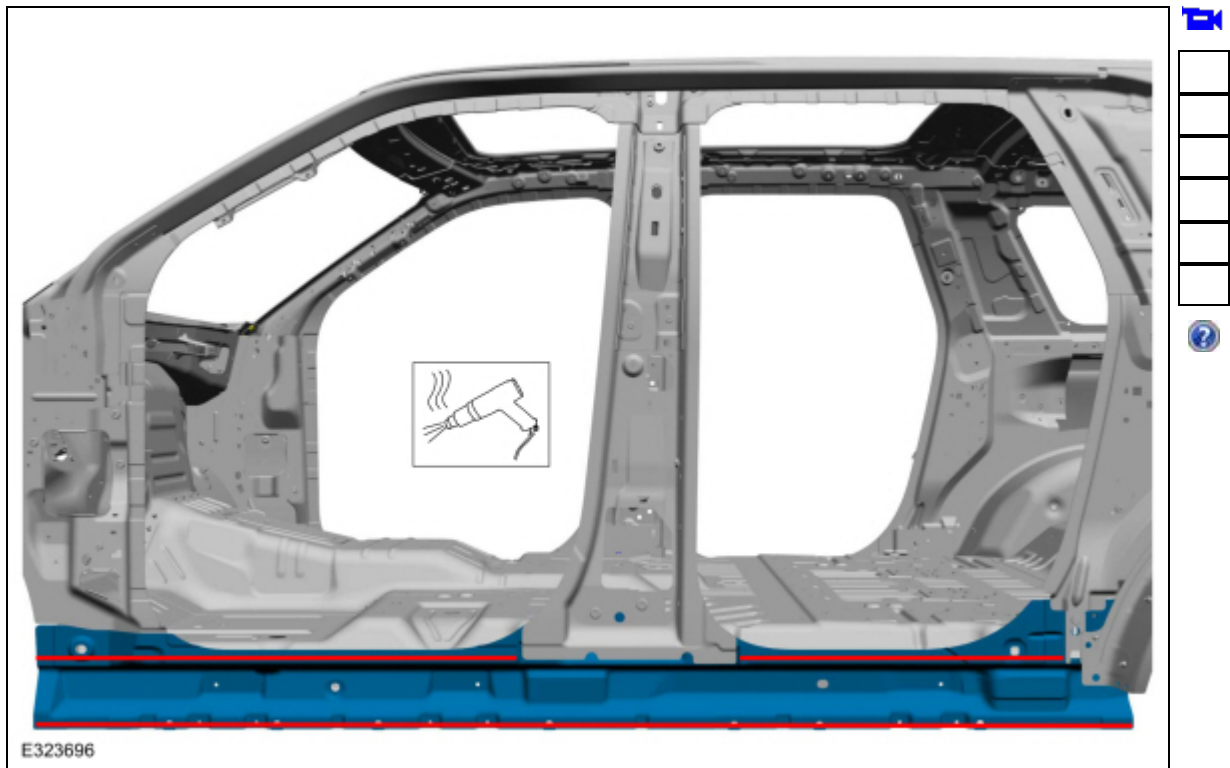
9. Remove the seam sealer.
 Use the General Equipment: Hot Air Gun
 Use the General Equipment: Scraper for Straight Edges



10. Remove the fasteners.
 Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Belt Sander



11. Break the adhesive bond and remove the floor side reinforcement.
 Use the General Equipment: Hot Air Gun



Installation

NOTICE: Body side sectioning is prohibited within 50 mm of door hinge, door striker, restraints and suspension anchoring points.

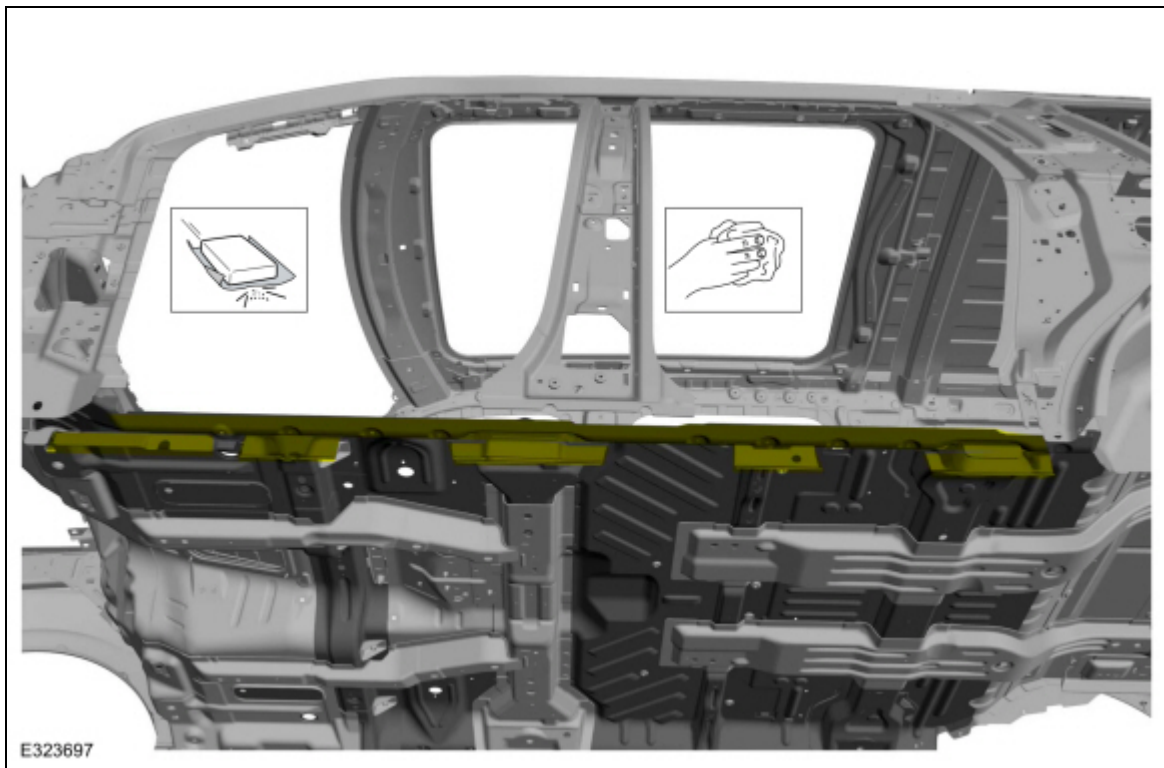
NOTE: Self-piercing rivet (SPR) fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

NOTE: Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repair areas that utilize structural adhesives may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425° F to loosen a bonded panel should only be done when all panels in the joint will be replaced and new adhesive applied.

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

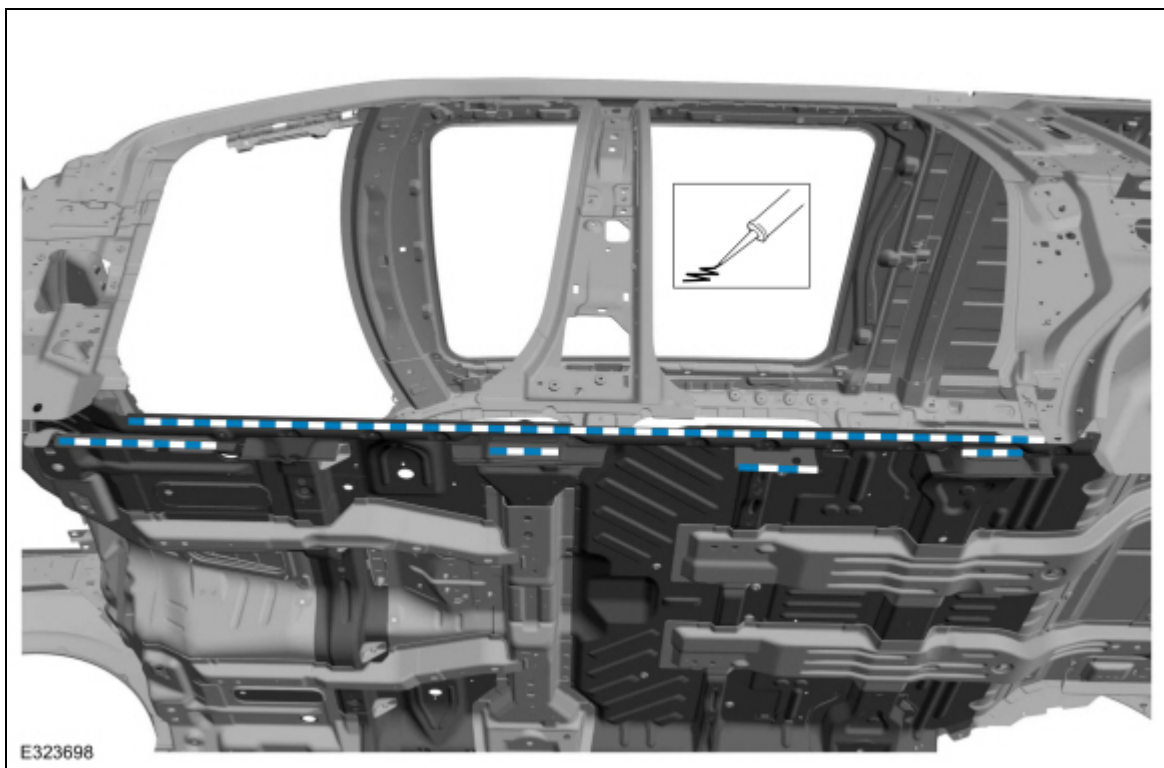
NOTE: Long wheelbase shown, short wheelbase similar.

1. Sand using 80-150 grit sand paper to remove old adhesive, e-coat and clean.

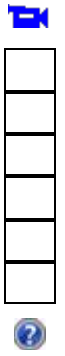
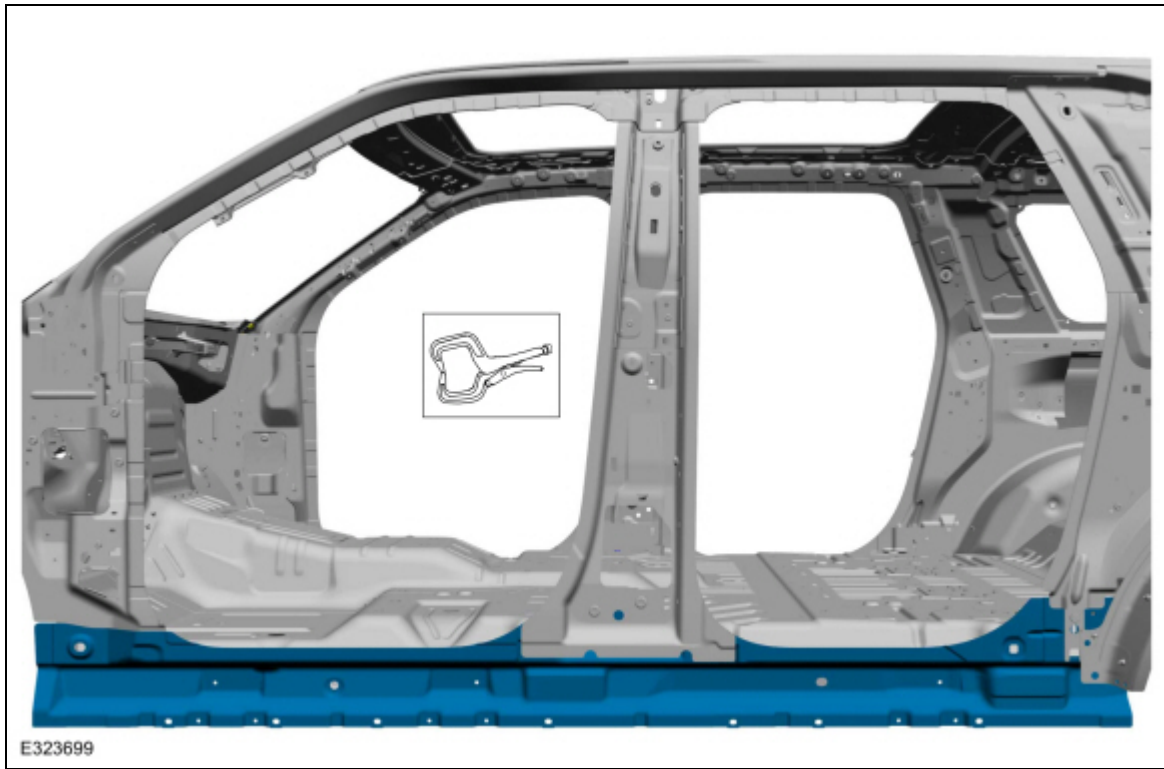


2. Apply adhesive.

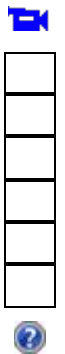
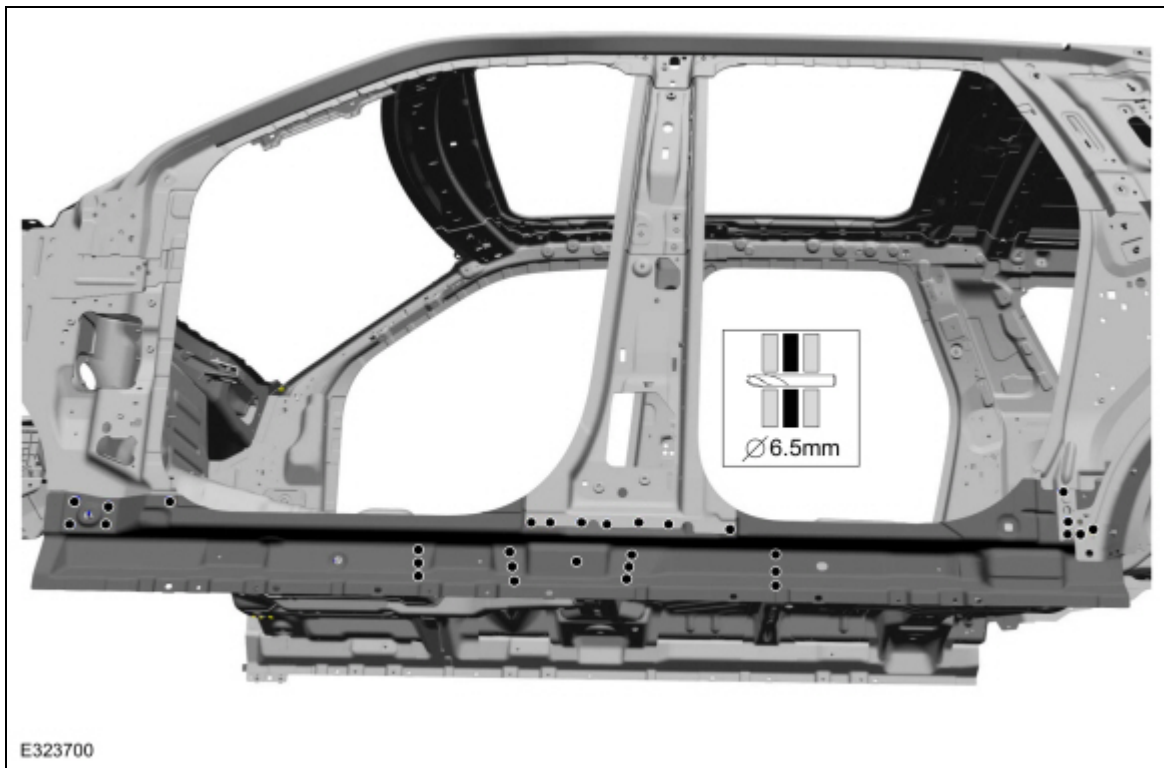
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B



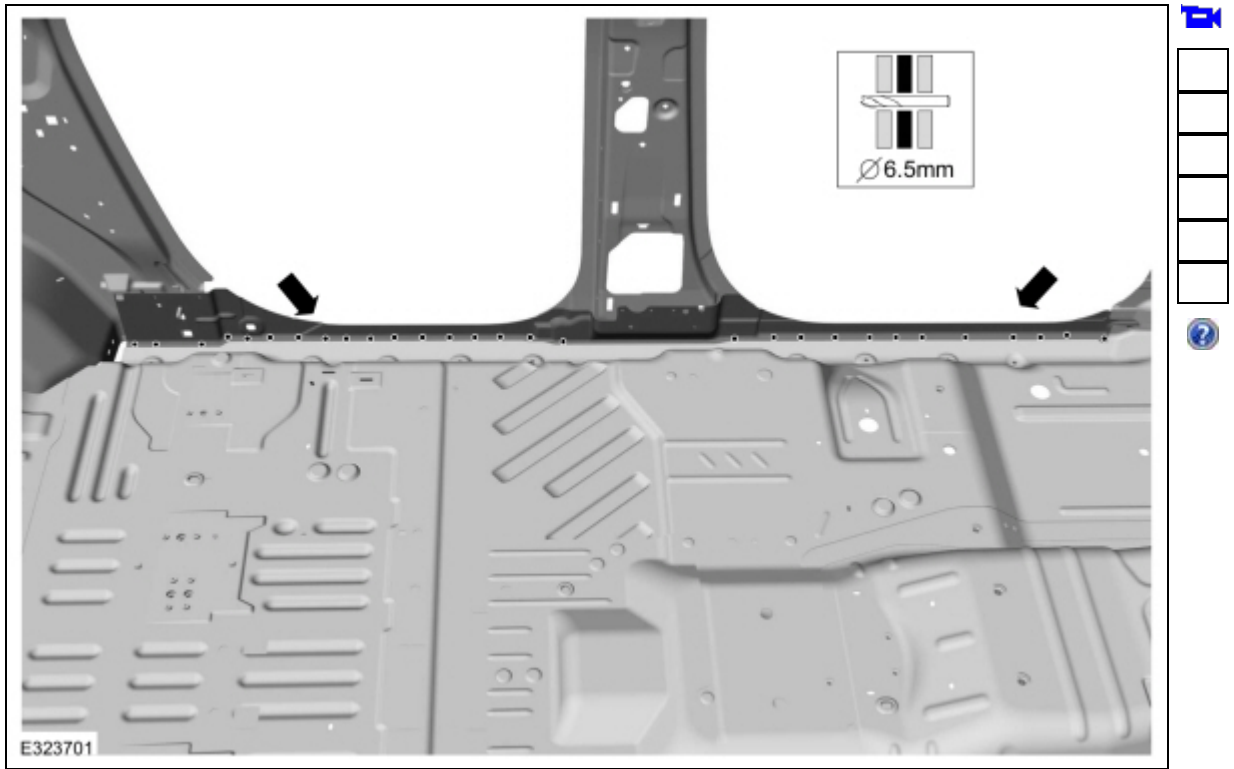
3. Install, properly position and clamp the floor panel reinforcement.
Use the General Equipment: Locking Pliers



- 4. Drill for fasteners.
Use the General Equipment: 6.5 mm Drill Bit



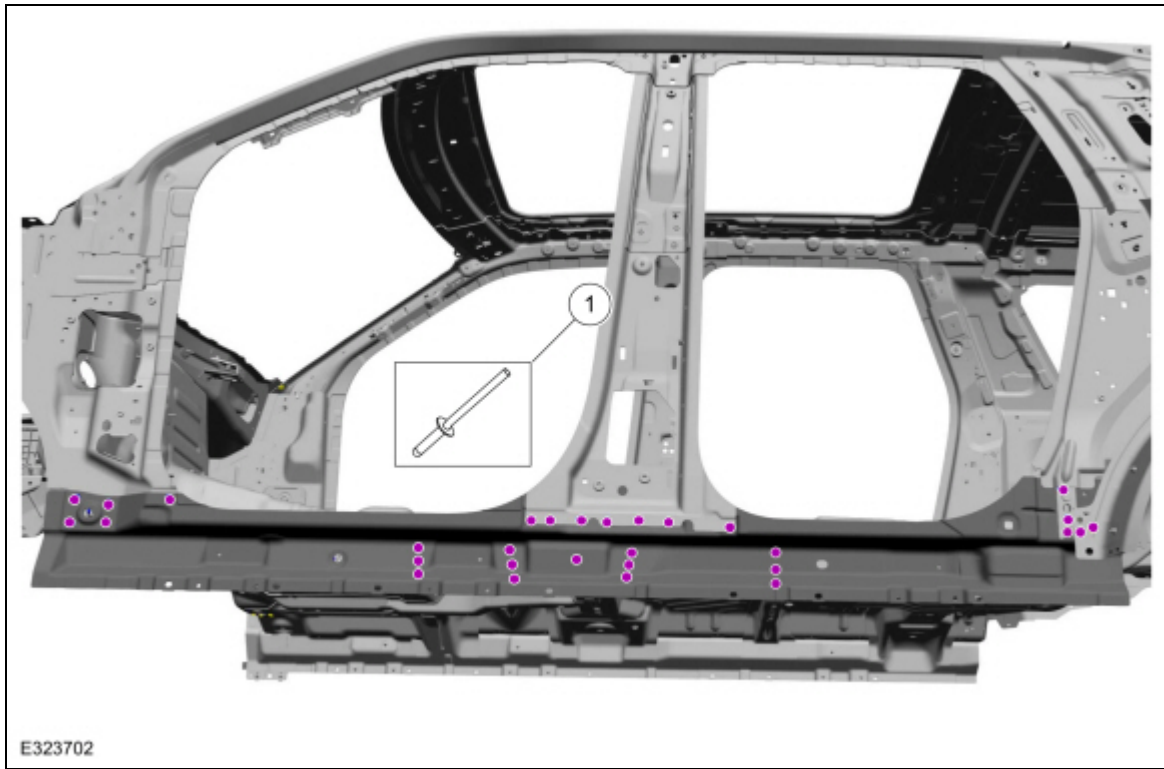
- 5. Drill for fasteners.
Use the General Equipment: 6.5 mm Drill Bit



6. Install the fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Riv-Nut®
1	-	-	-	-	W708777-S900C	-	-

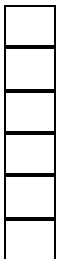
Use the General Equipment: Blind Rivet Gun

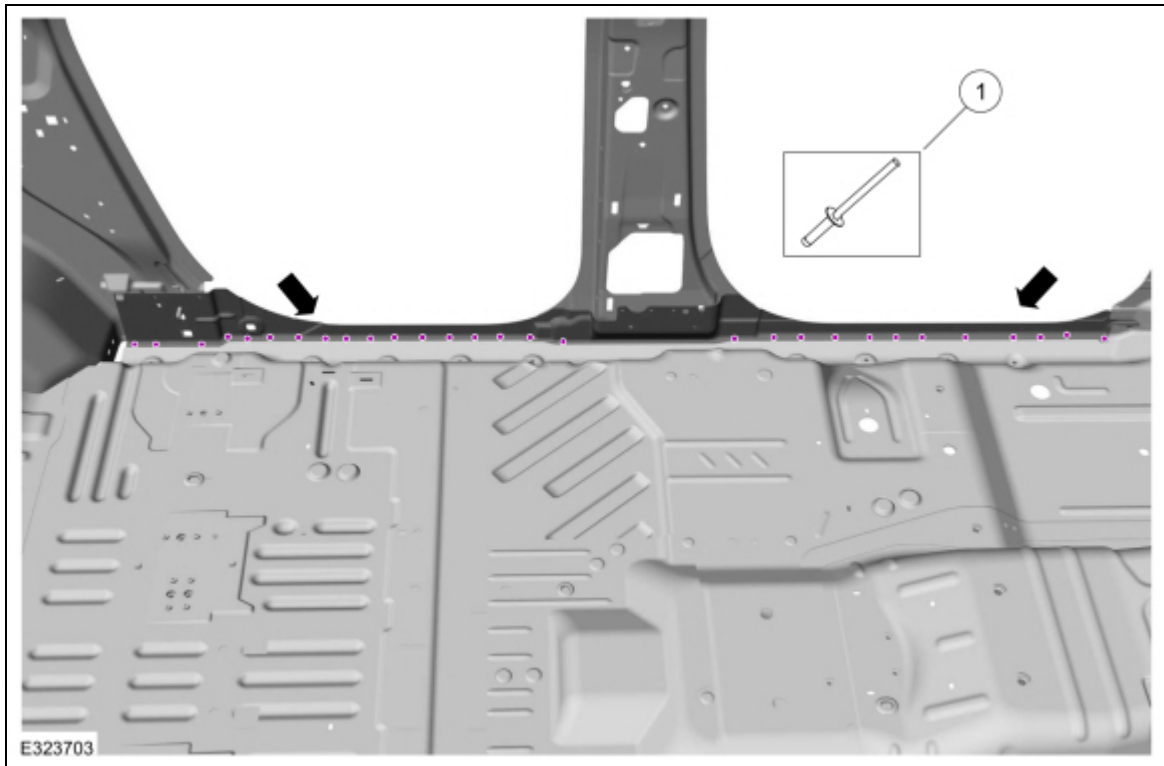


7. Install the fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Riv-Nut®
1	-	-	-	-	W702512-S900C	-	-

Use the General Equipment: Blind Rivet Gun

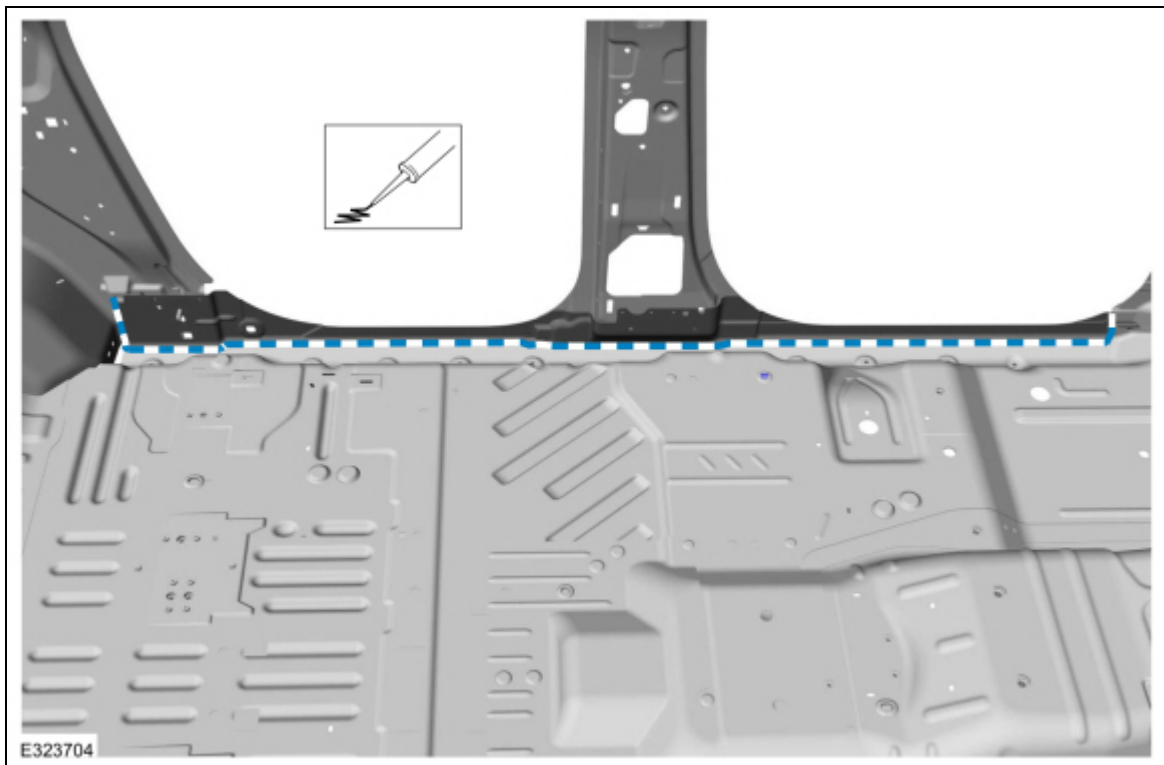




8. Seam Sealing:

All seams must be sealed to production level.

Material: Seam Sealer / TA-2-B, 3M™ 08308, LORD Fusor® 803DTM



9. Install the rocker reinforcement.

Refer to: [Rocker Panel Inner Reinforcement](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

10. Install the A-pillar reinforcement.
Refer to: [A-Pillar Outer Panel Section and Reinforcement](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
11. Refinish the entire repair using a Ford approved paint system.
12. Restore corrosion protection.
Refer to: [Corrosion Prevention](#) (501-25 Body Repairs - General Information, General Procedures).
13. Position all wiring harnesses and the carpet to original location.
14. Install the front and second row seats.
Refer to: [Second Row Seat](#) (501-10B Second Row Seats, Removal and Installation).
Refer to: [Front Seat](#) (501-10A Front Seats, Removal and Installation).
15. Install the A, B and C-pillar trim.
Refer to: [C-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: [B-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: [A-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
16. Repower the SRS.
Refer to: [Supplemental Restraint System \(SRS\) Repowering](#) (501-20B Supplemental Restraint System, General Procedures).

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