

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

6.5 mm Drill Bit
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Knife
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	-
Flexible Foam Repair 3M™ 08463, LORD Fusor® 121	-

Removal

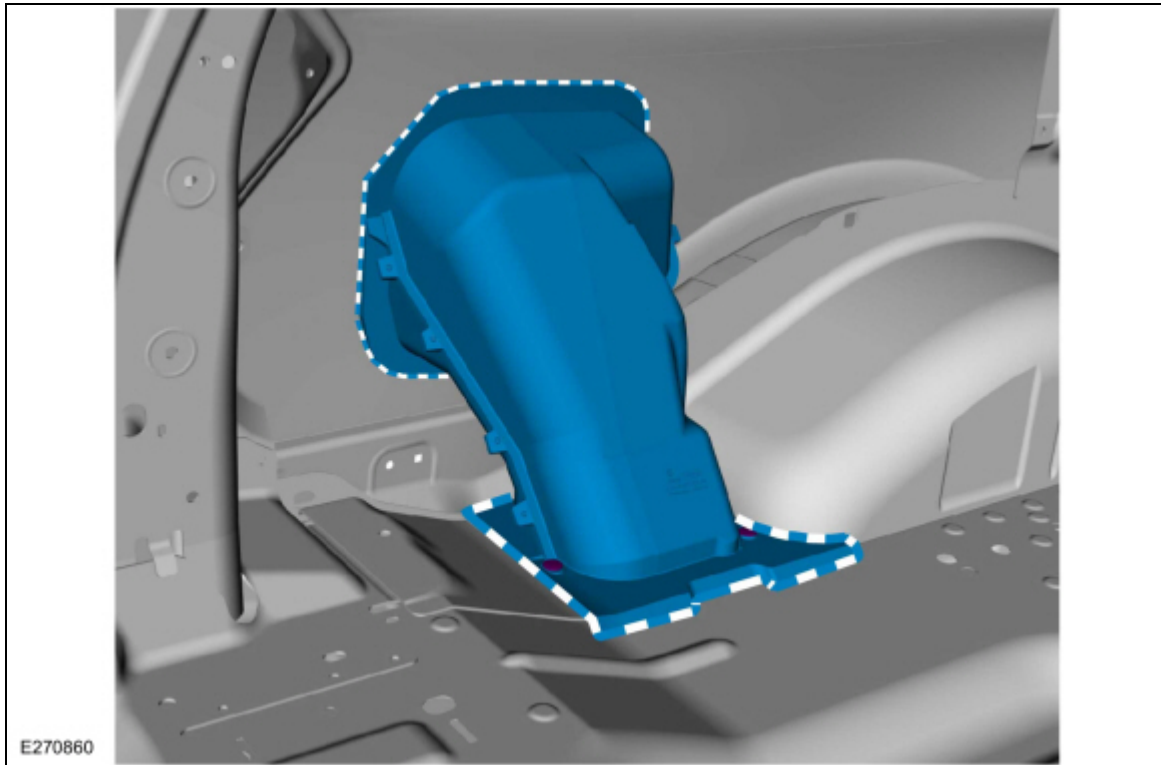
NOTE: SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

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 repairs areas that utilize structural adhesive 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.

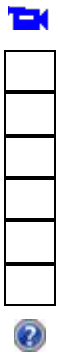
NOTE: Short wheelbase (SWB) shown, long wheelbase (LWB) similar.

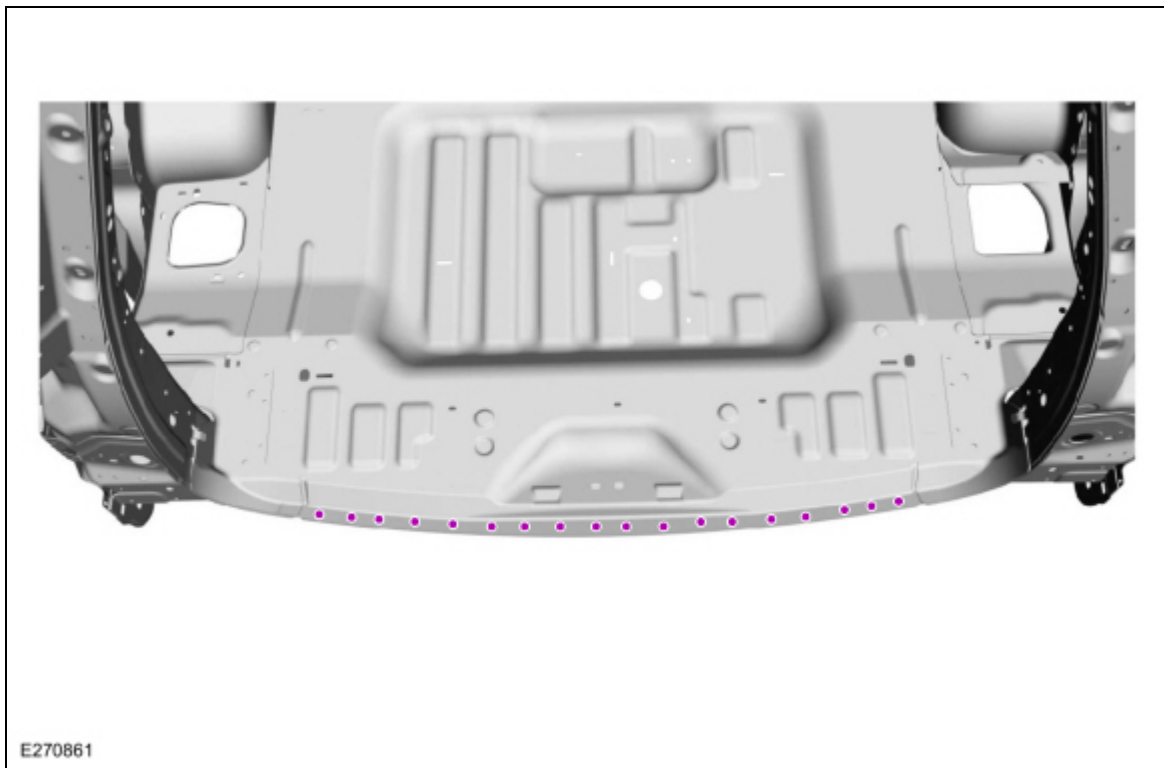
1. Verify the vehicle is dimensionally correct.
Refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).
2. Remove the D-pillar trim.
Refer to: [D-Pillar Trim Panel - Short Wheelbase](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: [D-Pillar Trim Panel - Long Wheelbase](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
3. Remove the loadspace trim panels.
Refer to: [Loadspace Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
4. Remove the subwoofer speaker.
Refer to: [Subwoofer Speaker](#) (415-00 Information and Entertainment System - General Information, Removal and Installation).

5. Remove the fuel tank filler pipe LH side only.
Refer to: [Fuel Tank Filler Pipe](#) (310-01 Fuel Tank and Lines - 3.5L EcoBoost (272kW/370PS), Removal and Installation).
6. Position aside the carpeting and wiring harness.
7. Cut the NVH foam attaching the fuel pipe housing and remove.
Use the General Equipment: Knife

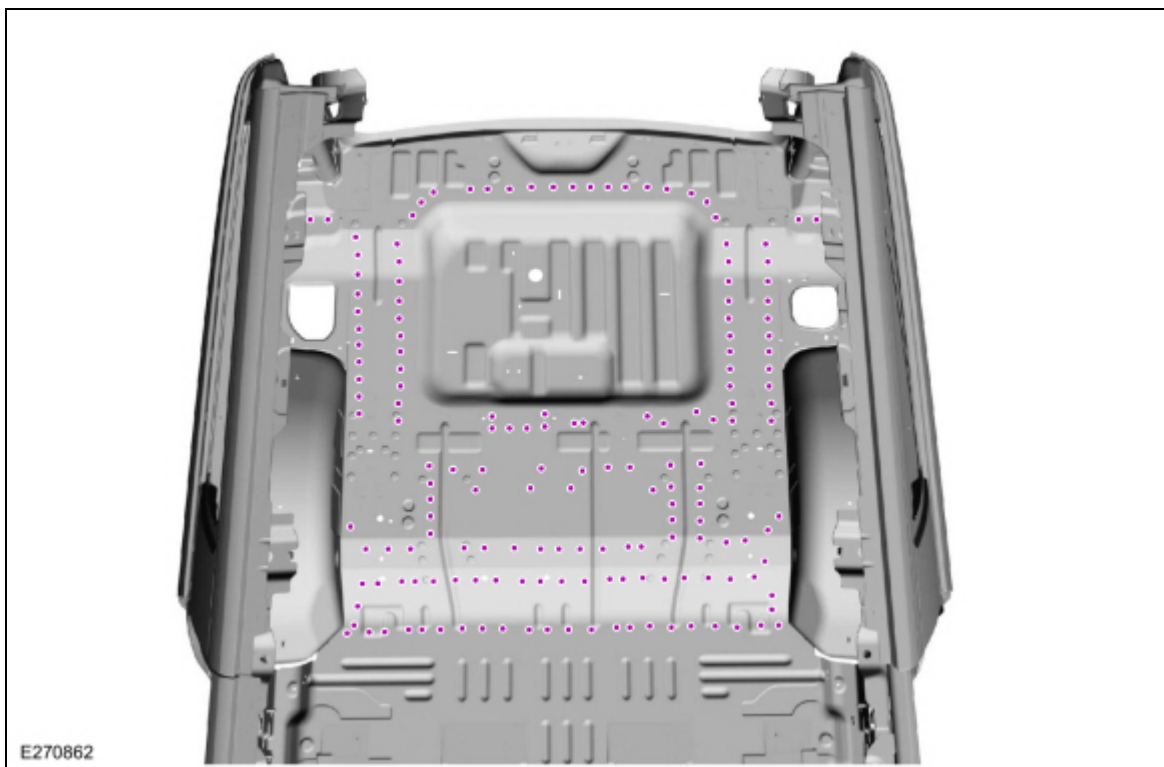


8. Remove the rivet fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander

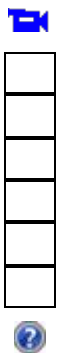


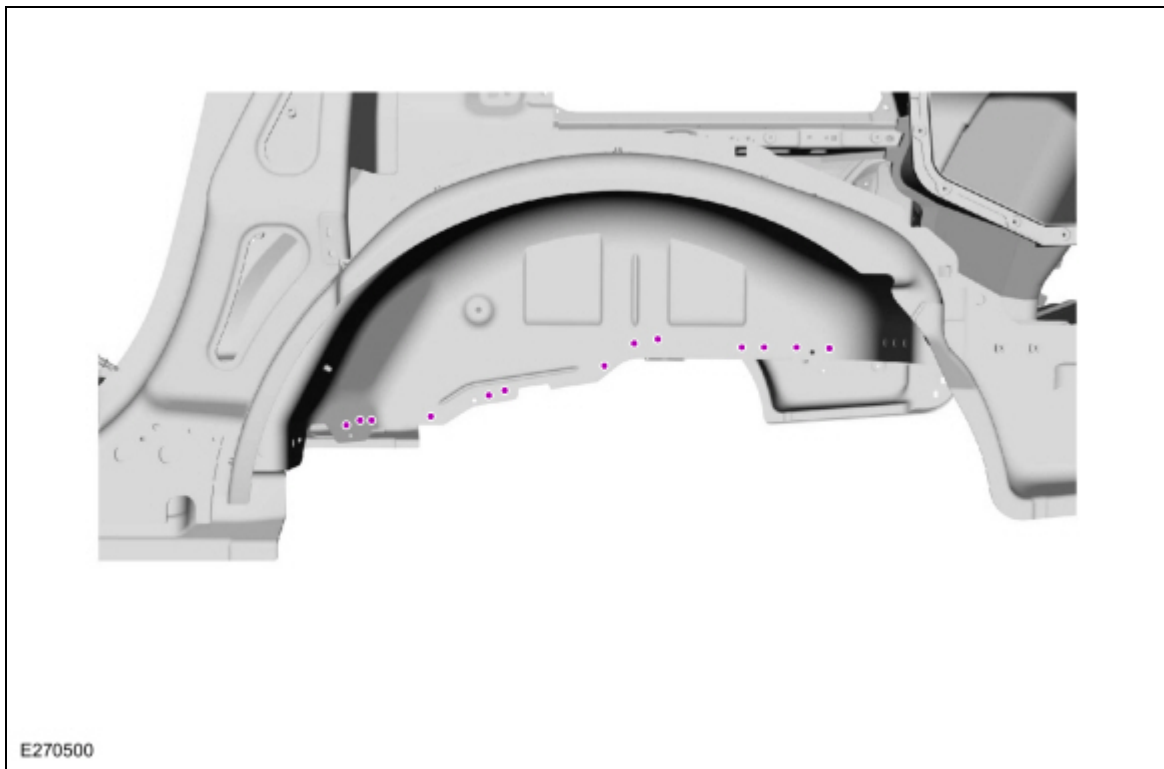


9. Remove the rivet fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander

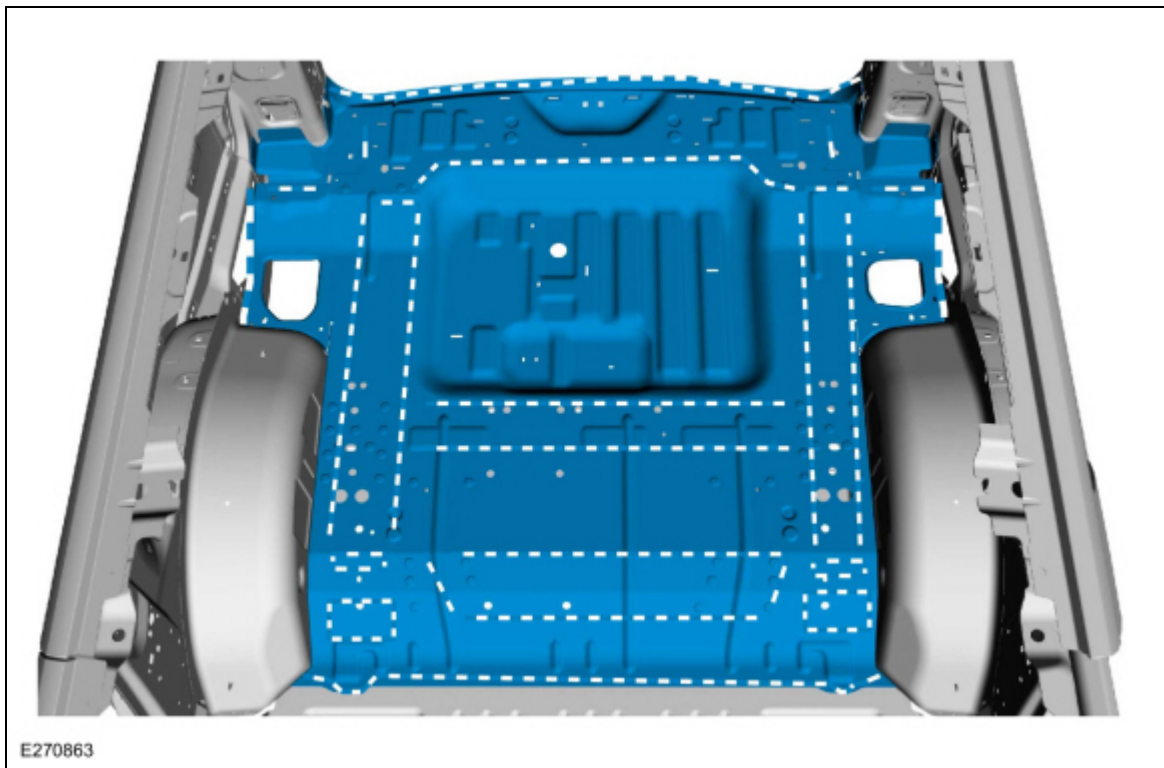


10. Remove the rivet fasteners on both sides.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander





11. Break the adhesive bond and remove the rear floor panel.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander

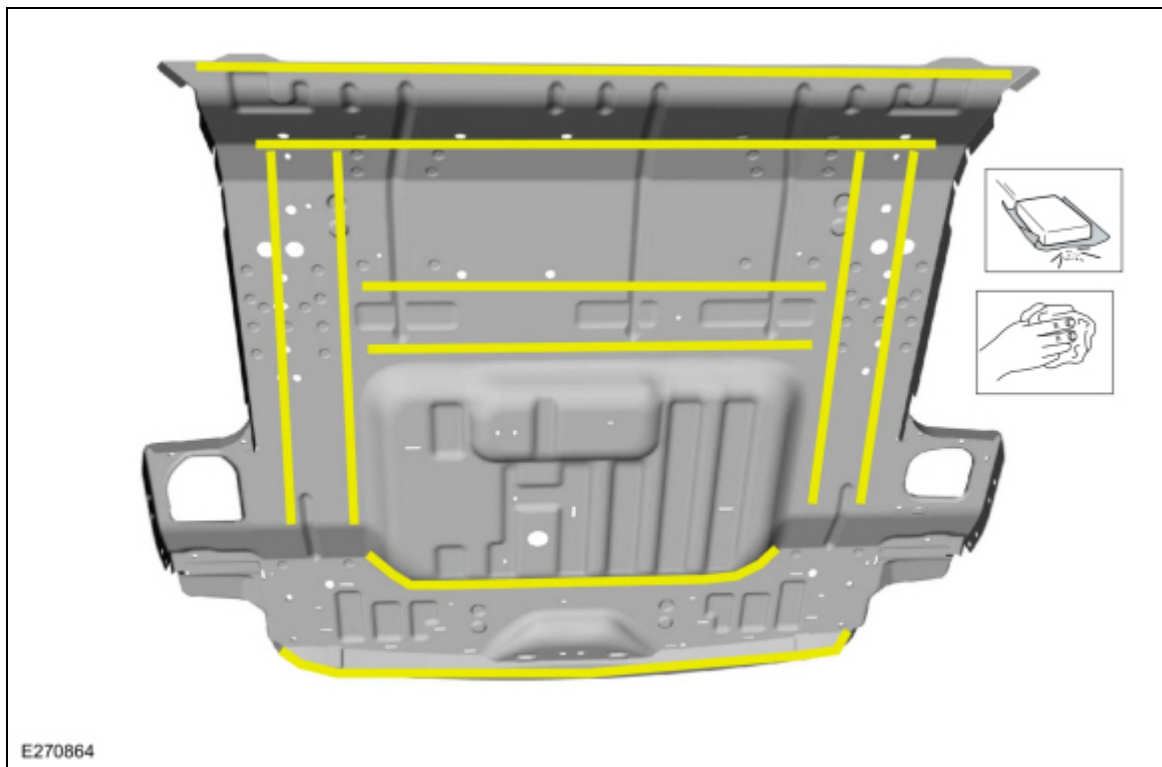


Installation

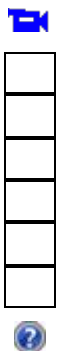
NOTE: Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs areas that utilize structural adhesive 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.

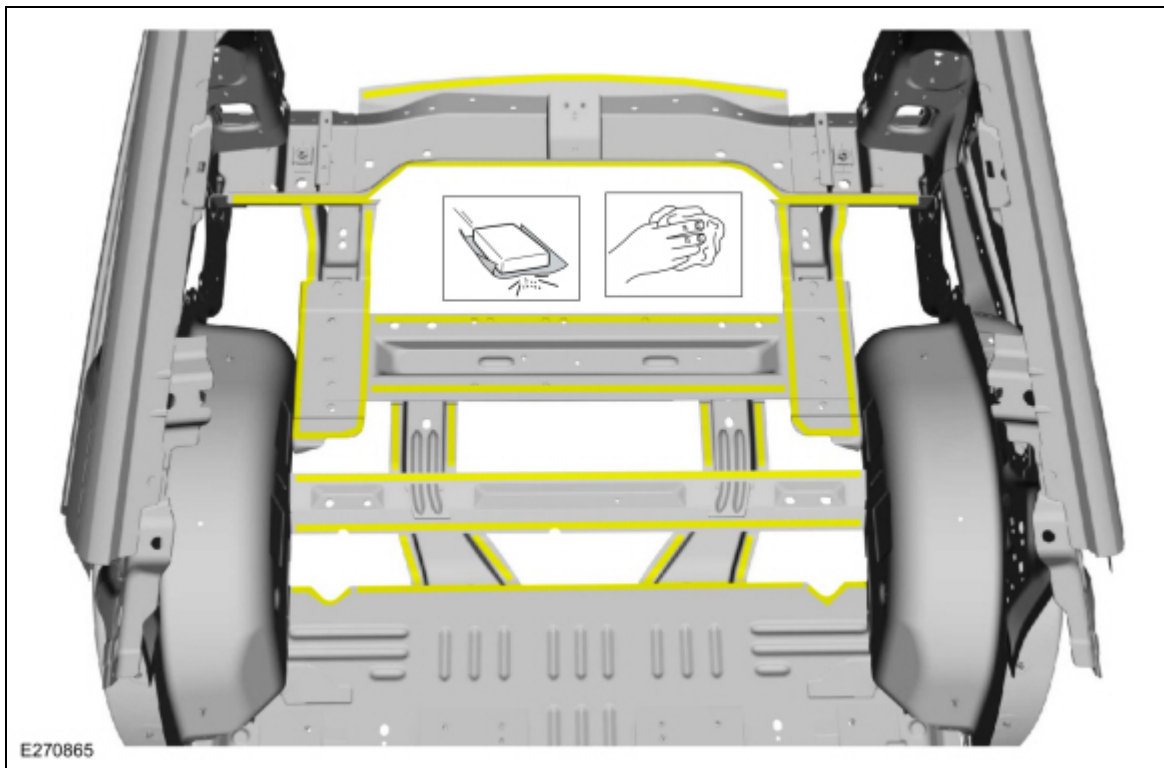
NOTE: Blind or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm and must equal original quantity.

1. Use a hammer and dolly dedicated to aluminum repair to repair any damage to the flange mating surfaces.
Refer to: [Special Repair Considerations for Aluminum Repairs](#) (501-25 Body Repairs - General Information, Description and Operation).
2. Sand and clean the replacement floor panel mating surfaces using 80-120 grit sandpaper.

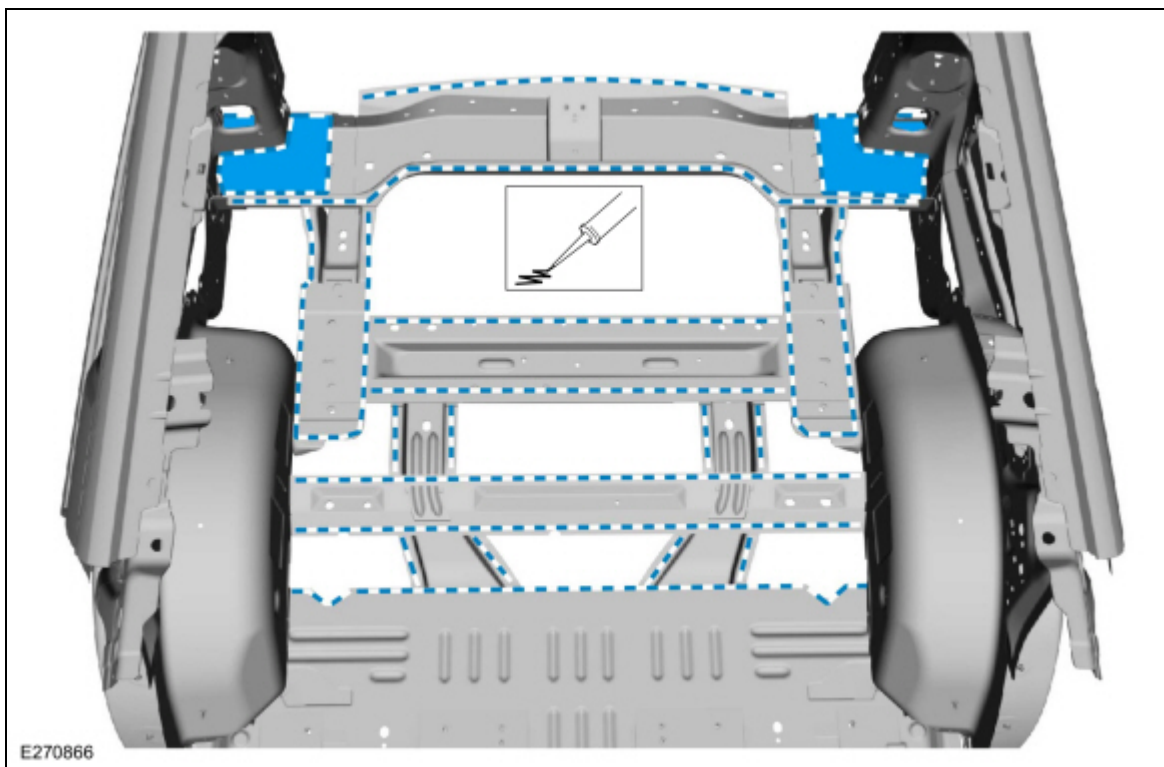


3. Sand and clean the underbody mating surfaces using 80-120 grit sandpaper.

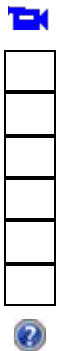


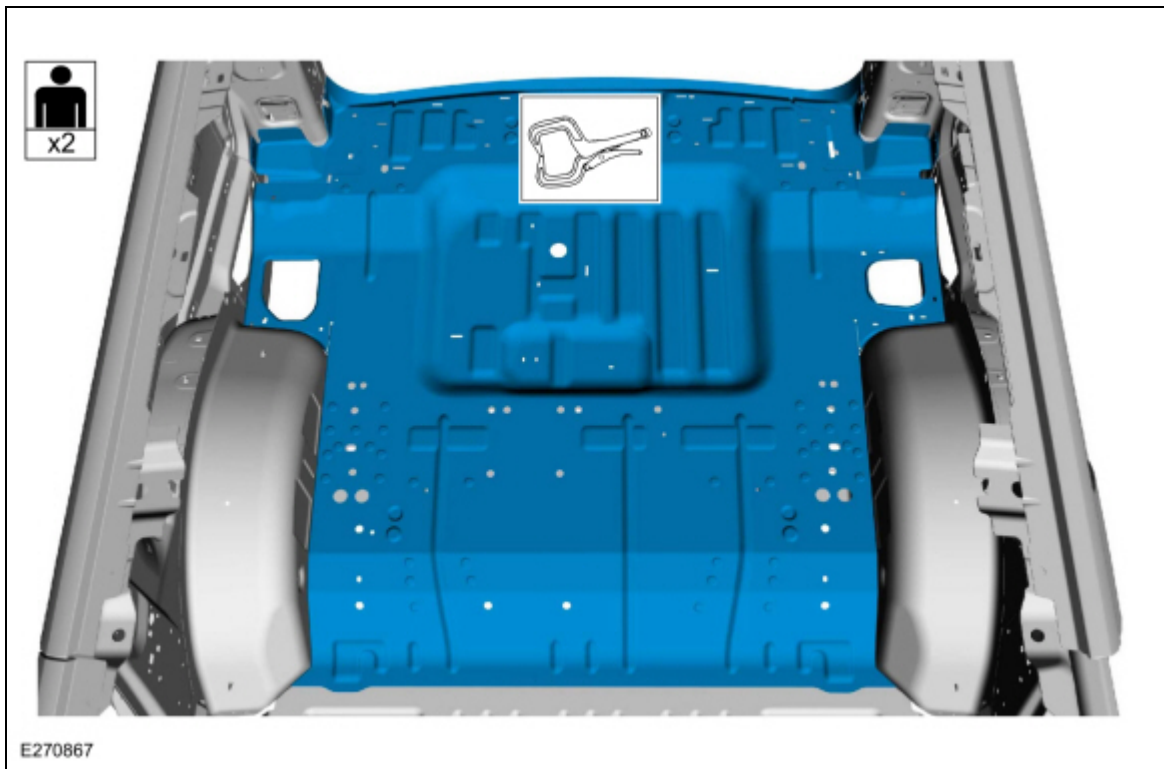


4. Apply adhesive to the mating surfaces, and NVH foam to D-pillar corners as noted during removal.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B
Material: Flexible Foam Repair / 3M™ 08463, LORD Fusor® 121

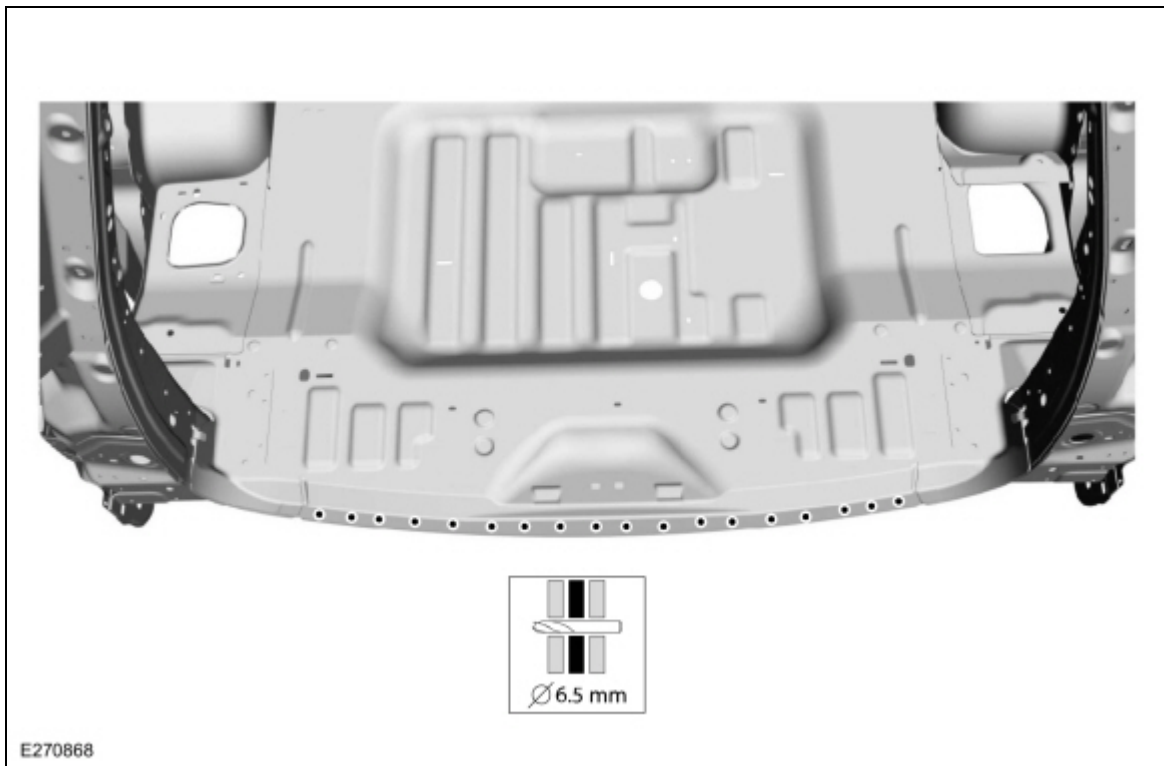


5. With the aid of an assistant, position and install the floor panel.
 Refer to: [Joining Techniques](#) (501-25 Body Repairs - General Information, General Procedures).
 Use the General Equipment: Locking Pliers

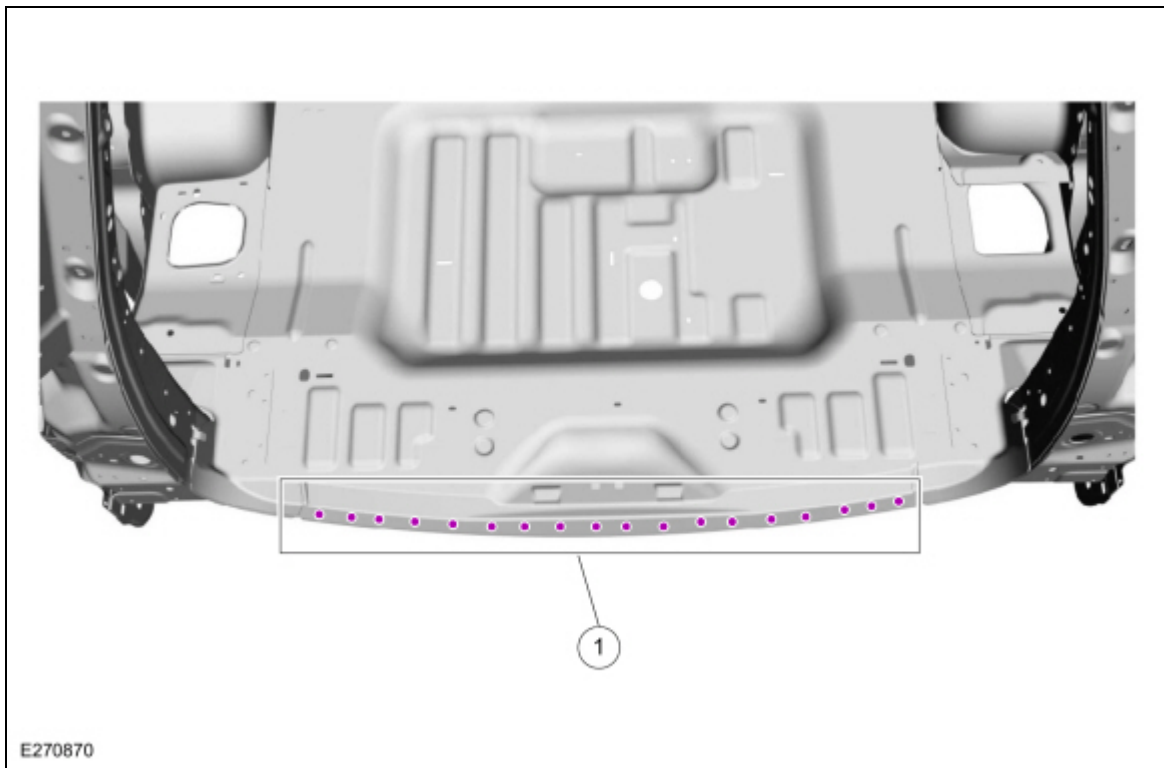




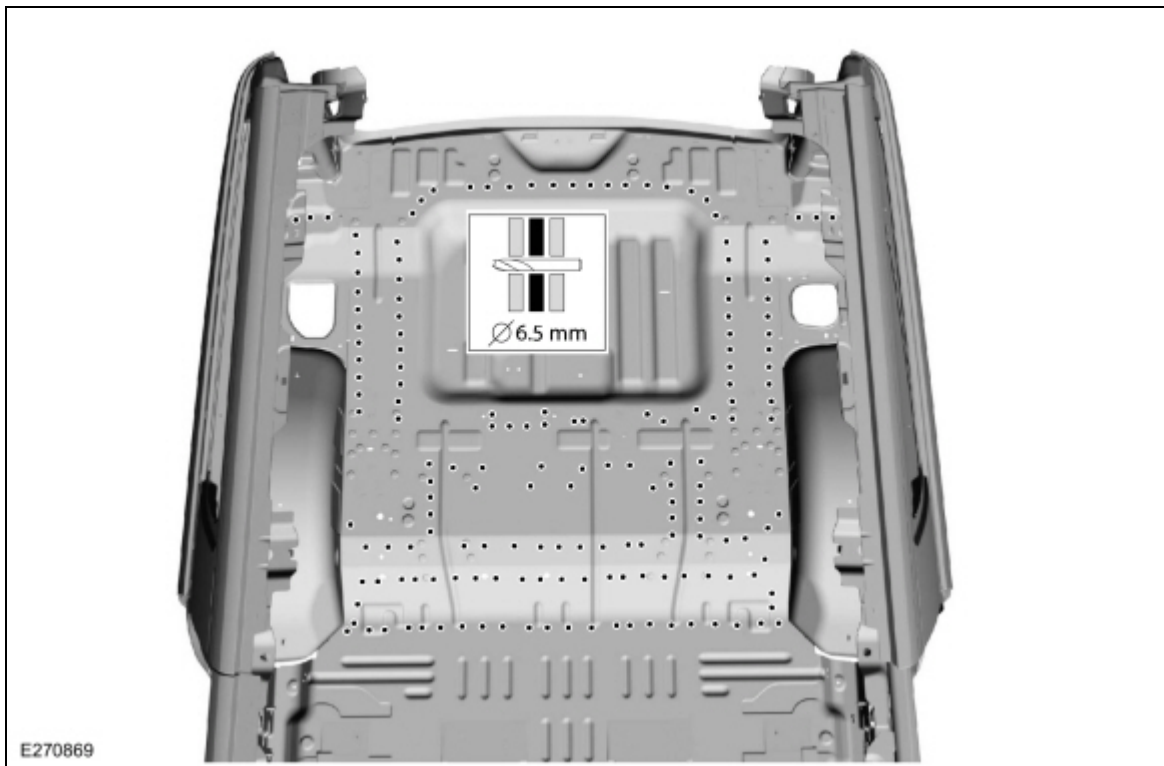
- 6. Drill for blind rivet fasteners.
Use the General Equipment: 6.5 mm Drill Bit



- 7. Install blind rivet fasteners.
Use the General Equipment: Blind Rivet Gun



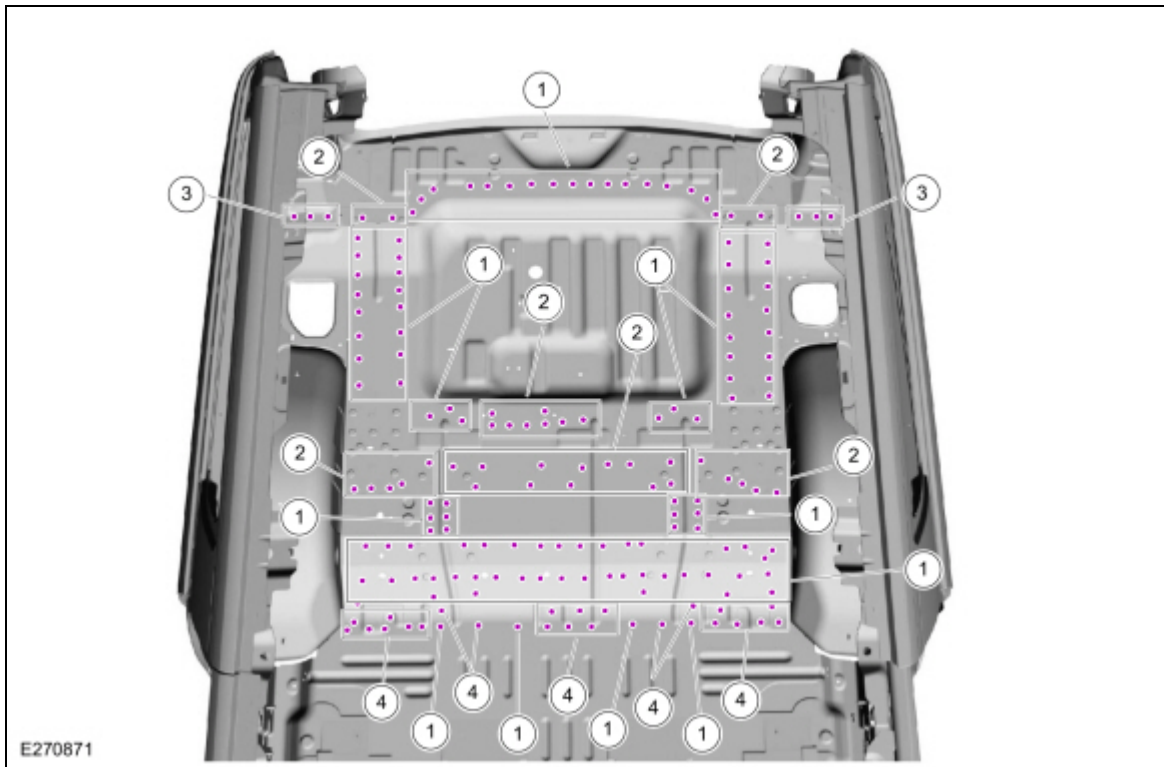
- 8. Drill for blind rivet fasteners.
Use the General Equipment: 6.5 mm Drill Bit



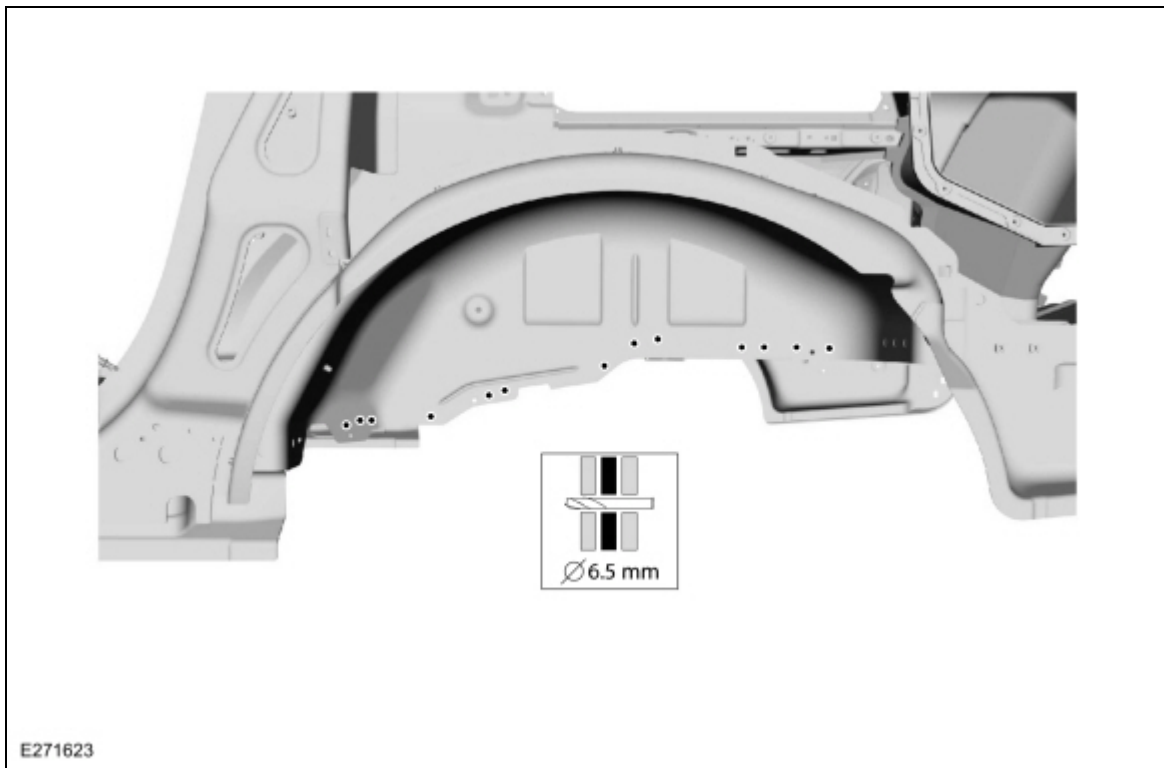
- 9. Install blind rivet fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W702512-S900C	-	-
2	-	-	-	-	W708777-S900C	-	-
3	-	-	-	-	W708778-S900C	-	-
4	-	-	-	-	W707638-S900C	-	-

Use the General Equipment: Blind Rivet Gun



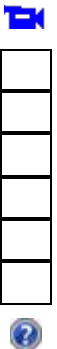
10. Drill for blind rivet fasteners.
Use the General Equipment: 6.5 mm Drill Bit

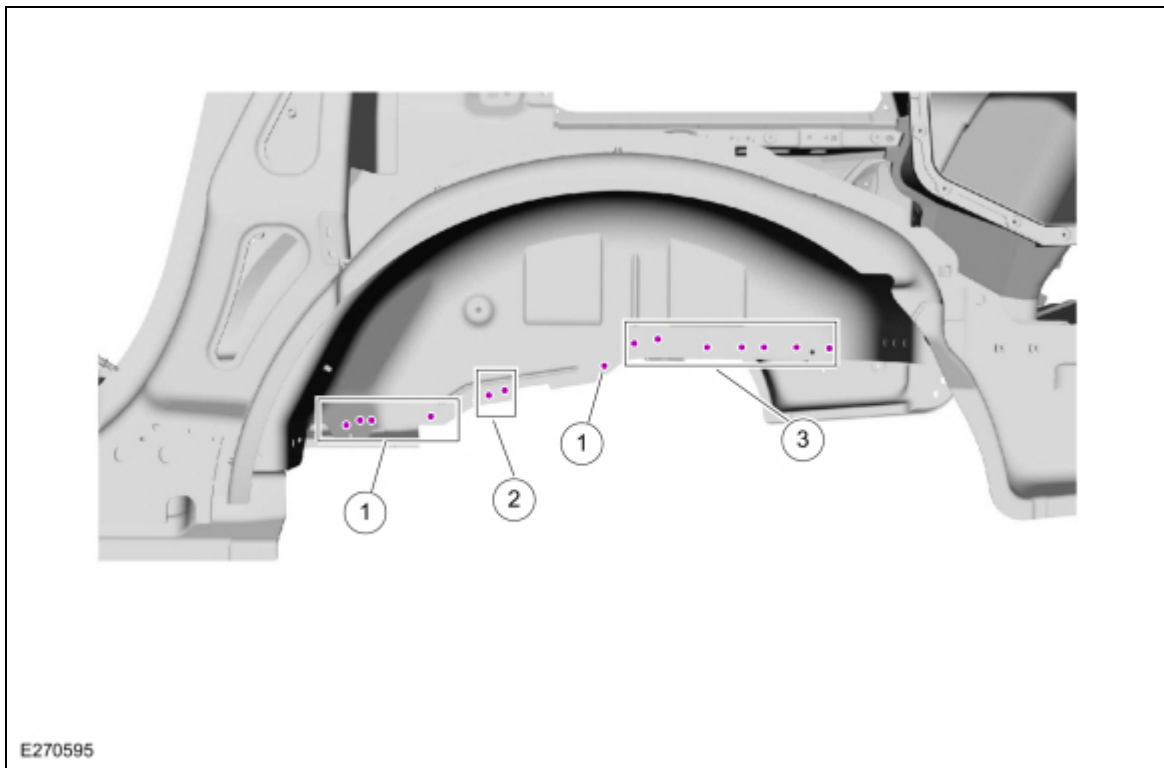


11. Install rivet fasteners on both sides.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	W790377-S900	-
2	-	-	-	-	W708777-S900C	W790377-S900	-
3	-	-	-	-	W702512-S900C	W790376-S900	-

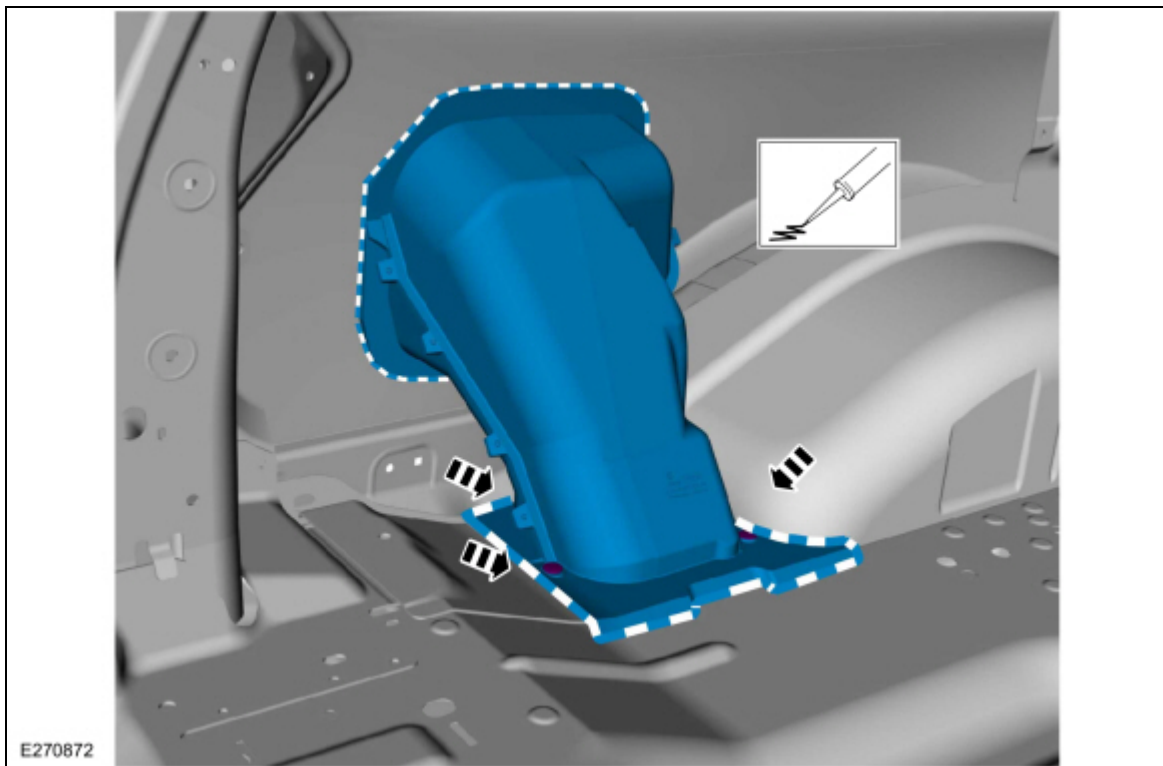
Use the General Equipment: Blind Rivet Gun





12. Metal finish the repair using typical aluminum metal finishing techniques and a fiber-based body filler. Refer to: [Special Repair Considerations for Aluminum Repairs](#) (501-25 Body Repairs - General Information, Description and Operation).
13. **Seam Sealing:**
All areas must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M™ 08308, LORD Fusor® 803DTM
14. Refinish the repair area using a Ford approved paint system and typical refinishing techniques.
15. Apply flexible foam to fuel pipe housing flanges, install push clips and clamp in position.
Material: Flexible Foam Repair / 3M™ 08463, LORD Fusor® 121





16. Install the fuel tank filler pipe LH side only.
Refer to: [Fuel Tank Filler Pipe](#) (310-01 Fuel Tank and Lines - 3.5L EcoBoost (272kW/370PS), Removal and Installation).
17. Install the subwoofer speaker.
Refer to: [Subwoofer Speaker](#) (415-00 Information and Entertainment System - General Information, Removal and Installation).
18. Reposition the carpeting and wiring harness.
19. Install the D-pillar trim.
Refer to: [D-Pillar Trim Panel - Short Wheelbase](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: [D-Pillar Trim Panel - Long Wheelbase](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
20. Install the loadspace trim panels.
Refer to: [Loadspace Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).

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