

## GROUP

# BODY 01

(70000)

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## SECTION 01-00 Body—Service

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### VEHICLE APPLICATION

Taurus / Sable.

## DESCRIPTION

**Body Sealer Types****Caulking Cord D6AZ-19560-A (ESB-M4G32-A)**

This sealer, or equivalent, is commonly known as permagum. It is used on spot weld holes, around moulding clips or between two surfaces not properly sealed by a gasket. Apply with a putty knife.

**Weatherstrip Adhesive E8AZ-19552-A (ESB-M2G14-A)**

This material or equivalent, is designed to hold weatherstripping on doors, bodies, deck lids, cowl ventilators and the surrounding metal. Windows and windshields which are set in rubber can be sealed effectively against leakage by flowing cement into the affected areas.

Clean all grease, dirt and old sealer from the surfaces to be cemented, and apply a medium coat of cement to both surfaces. Immediately press both surfaces firmly together.

**Silicone Lubricant C0AZ-19553-AA (Jelly) (ESR-M13P4-A)**

This lubricant or equivalent, is to be used on the door and window weatherstrips. It is recommended that silicone lubricant be applied to the weatherstrips at every lubrication period. Its use makes the doors easier to close, avoids weatherstrip squeaks, retards weatherstrip wear from chafing between the door glass upper frame and the weatherstrip, and helps to retain door window alignment by reducing friction between the glass frame and rubber weatherstrip.

**Towing**

Refer to Section 00-02.

## DIAGNOSIS AND TESTING

**Dust and Water Leaks**

Sealer locations should be considered when checking for dust or water leaks. The forward motion of the vehicle causes any unsealed, small opening in the lower section of the body to permit air and dust to be drawn into the body. Opening the ventilator air ducts will equalize these pressures. Dust accumulates in the rocker panel and may move into the luggage compartment.

To eliminate dust leakage, determine the exact point at which the dust enters.

Under certain conditions, water can enter the body at any point where dust can enter.

To determine the exact location of a dust leak, it may be necessary to remove the following trim from the vehicle:

- Cowl trim panel. Refer to Section 01-05.
- Quarter trim panel. Refer to Section 01-05.
- Rear seat back and seat cushion. Refer to Section 01-10A.

- Luggage compartment floor mats and side trim panel. Refer to Section 01-05.
- Spare wheel. Refer to Section 00-02.
- Center pillar trim. Refer to Section 01-05.
- Scuff plates. Refer to Section 01-05.

After removing the trim, the location of most leaks will be evident. The entrance of dust is usually indicated by a pointed shaft of dust or silt. Seal these leaks, then road test the vehicle on a dusty road to ensure all leaks are sealed.

After the road test, check for indications of a dust pattern around the door openings, cowl panel, lower part of the quarter panel and in the luggage compartment.

Sometimes leaks can be located by putting bright lights under the vehicle, with the above components removed, and checking the interior of the body joints and weld lines. A light will show through where leaks exist. The Rotunda Vacuum / Air / Water Leak Detector 055-00103 or equivalent, can locate dust leaks, wind and water leaks.

## PAINT REPAIR

**Complete Panel Service or Spot Repair**

Use a commercial refinishing system and follow the manufacturer's instructions.

**Soft Fascia Service**

Use a commercial elastomeric repair system with Acrylic Repair Lacquer according to repair procedures outlined in Section 01-02.

## LOWER BODY SIDE STONE PROTECTION VINYL SERVICE

**Tools Required:**

- Rotunda Heat Gun 107-00300

A large area resulting from peeling or damage will necessitate removal of the factory sprayed-on vinyl coating. The following procedure is suggested:

NOTE: Where sheet metal is damaged to the extent that fender, door or quarter panel replacement is required (or in an initial installation), disregard Steps 1 and 2.

1. Using Rotunda Heat Gun 107-00300 or equivalent, or lamp, soften vinyl coating until it is pliable. Scrape off softened vinyl with putty knife or similar tool. If necessary, sand off any hard to remove vinyl coating, using an orbital disc sander (No. 80 disc). (The Vinyl Abrasion Resistant Coating is not suitable for "spot" corrections.)

## LOWER BODY SIDE STONE PROTECTION VINYL SERVICE (Continued)

2. Perform necessary repairs to correct sheet metal damage.

Abrasion Resistant Coating D9AZ-19515-A (ESB-M4G221-A) or equivalent is available in 0.947L (1 quart) cans. Approximately 1.89L (2 quarts) is required for an initial installation on a vehicle similar to a factory-applied system. The specified dry film thickness of 15 to 20 mils (0.015 to 0.020 inch) requires at least three, or possibly four, applications of coating material, with flash-off time allowed between coats. As with painting, spray coat the complete lower panel.

As the adherence of this coating to properly prepared sheet metal is excellent, the necessity of prime painting the sheet metal prior to protective coating is eliminated, saving both time and money.

NOTE: Adhesion will be adversely affected unless the sheet metal area to be covered (either repaired or new) is prepared in accordance with the following procedure.

### Coating Preparation

#### Masking Vehicle

Suitable covers should be installed over the wheels. Mask off all upper exterior body sheet metal. Remove wheel opening stone shields and mask mouldings.

NOTE: If the vehicle has lower body side mouldings 305-355mm (12-14 inches) above the "turn under" of the rocker panel, the moulding can serve as the upper margin of the area to be coated. If the vehicle does not have suitable mouldings, a sculpture or break line in the sheet metal can be used. However, the method used in masking off the upper coating margin line will depend on the presence or absence of mouldings in this area.

Masking tape should be positioned so that the moulding lower side is also covered. Do not cover the sheet metal immediately below the moulding.

It is not necessary to mask off body door openings in the coating area as they will be uniformly coated where the door margins allow the coating to enter. However, these door opening areas should be cleaned to ensure coating adherence.

### Sheet Metal

#### Serviced Sheet Metal

1. Scuff sand (No. 180-grit paper) to remove all of the glossy surface appearance of dry painted areas to be coated.
2. Remove sanding dust using a lint-free tack cloth and compressed air.
3. Using a clean, lint-free cloth, solvent wipe area to be coated with Multi-Purpose Paint Precleaner VC-542-A or equivalent, and allow to flash-off.

### New Sheet Metal

1. Scuff sand (No. 180-grit paper) any prime paint in area to be coated.

NOTE: Do not sand through the primer.

2. Remove sanding dust using a lint-free tack cloth and compressed air.
3. Using a clean, lint-free cloth, solvent wipe area to be coated with Multi-Purpose Paint Precleaner VC-542-A or equivalent, and allow to flash-off.

### Initial Installation

#### Tools Required:

- Rotunda Dual Action Air Sander 107-01619

NOTE: Do not sand through primer.

1. The glossy surface of paint in coating area may be scuff sanded with a D/A sander such as Rotunda Dual Action Air Sander 107-01619 or equivalent. A 220/240-Grit Disc does a good, fast job.
2. Remove sanding dust using a lint-free tack cloth and compressed air.
3. Using a clean, lint-free cloth, solvent wipe area to be coated with Multi-Purpose Paint Precleaner VC-542-A or equivalent.

### Application

Coating must be applied with commercial equipment (appropriate equipment listed in this Section) by an experienced automotive painter. Coating must be thoroughly agitated and used without thinning. Since the material is reasonably heavy bodied, a pressure cup equipped spray gun is recommended. Satisfactory coating appearance (minimal orange peel and sagging) will result with gun air pressures of approximately 207 kPa (30 psi) and cup pressures of approximately 103 kPa (15 psi).

### Coating Spray Procedure

To protect the lower exposed painted fender, rocker, and quarter panel down flanges, the vehicle must be elevated high enough so that the painter can spray areas effectively. When an initial installation is made, a remote 1.89L (2 quart) capacity pressure cup makes a much more efficient tool, as the spray gun can be used closer to the floor. The spray gun, fluid hose and/or cup must be cleaned immediately after use. While lacquer thinner can be used when the suggested clean-up material is unavailable, Multi-Purpose Paint Precleaner, VC-542-A or equivalent, is quicker and much more efficient. With Rotunda Spray Gun 085-01626 or an equivalent set at 207 kPa (30 psi) and Rotunda Detached Pressure Cup 085-01617 or an equivalent set at 103 kPa (15 psi), follow this procedure:

1. Apply a wet, sag-free coat. Allow 3-5 minutes flash-off time.

## LOWER BODY SIDE STONE PROTECTION VINYL SERVICE (Continued)

2. Apply second wet, sag-free coat. Allow 3-5 minutes flash-off time.
3. Apply third wet, sag-free coat. Allow 3-5 minutes flash-off time.
4. Apply final wet, sag-free coat. Allow 3-5 minutes flash-off time and pull off Fine Line Tape, exposing raw upper edge of the coating.
5. Immediately clean spray equipment using Multi-Purpose Paint Precleaner VC-542-A or equivalent.
6. Allow at least two hours drying time at approximately 21°C (70°F).

### Color Coat

As the complete coated area, as well as the upper raw edge, must be covered with color coat, mask off upper margin line with Fine Line Tape positioned 1.59mm (1/16-inch) above coating edge. Using appropriate repair paint and application procedures, including both prime and color coat, finish paint the protective coating.

NOTE: If damaged sheet metal extends above the protective coating area, normal prime / color paint procedures should be followed.

### Materials Required

- Abrasion Resistant Coating D9AZ-19515-A (ESB-M4G221-A)
- Color Coat Paint System
- Silicone and Wax Remover
- Multi-Purpose Paint Precleaner (Spray Gun Clean-Up) VC-542-A

### Suggested Equipment

- Rotunda Spray Gun 085-01626 (No. 63 Air Cap, No. SS Fluid Tip, No. 363 AN needle) or equivalent.
- Rotunda Detached Pressure Cup 085-01617, 0.946L (1 quart) (with Air Adjusting Gauge) or equivalent.
- Rotunda Dual Action Air Sander 107-01619 or equivalent.
- Rotunda Heat Gun 107-00300 or equivalent.
- No. 180-Grit Paper.
- Lint-Free Cloth.
- Tack Cloth.
- Regular Masking Tape.
- No. 80 Disc for Disc Sander.
- No. 220/240 Disc.

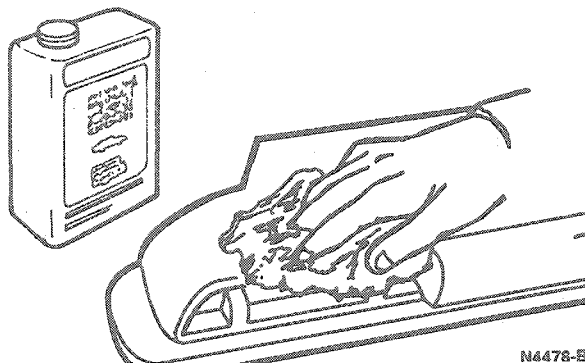
## REPAIR

### Tools Required:

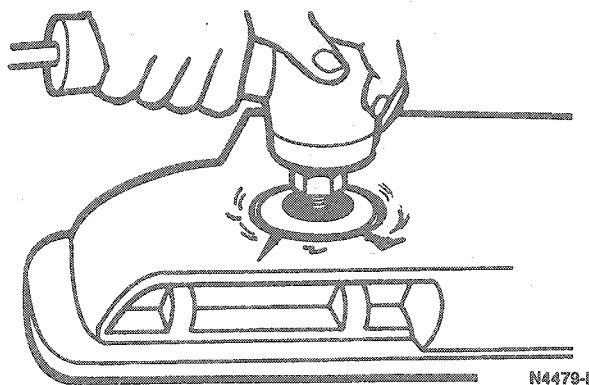
- Rotunda Dual Action Air Sander 107-01619

### Procedure For Repairing Surface Damage

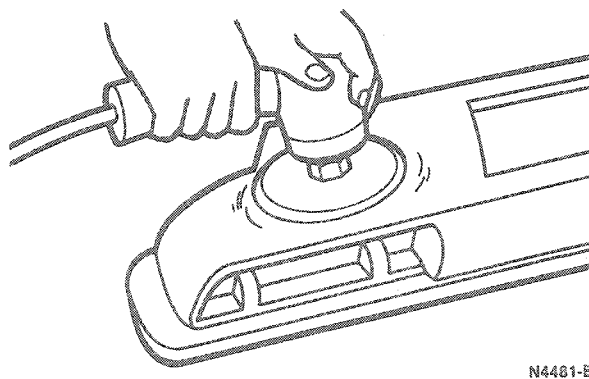
1. Clean the surface area with soap and water and wipe with silicone and wax remover to ensure clean surfaces.



2. Using a sander, such as Rotunda Dual Action Air Sander 107-01619 or equivalent, or sanding block with No. 36 Disc or Coarse Abrasive Paper, grind or abrade away sufficient substrate material 1-1-1/2 inches around damaged area to maximize adhesion of repair material.

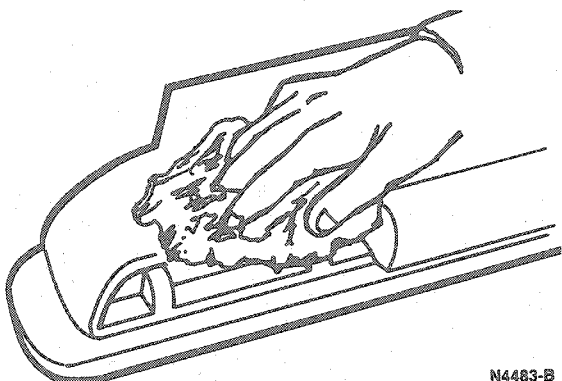


3. Feather edge the paint around repair area with No. 180-grit paper.



## REPAIR (Continued)

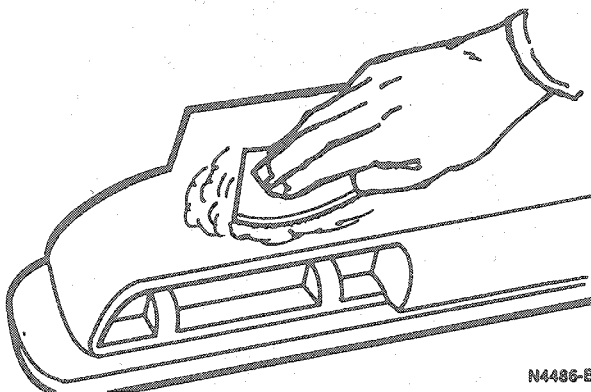
4. Wipe off or clean repair area with clean, dry cloth and blow off dust with an air gun.



N4483-B

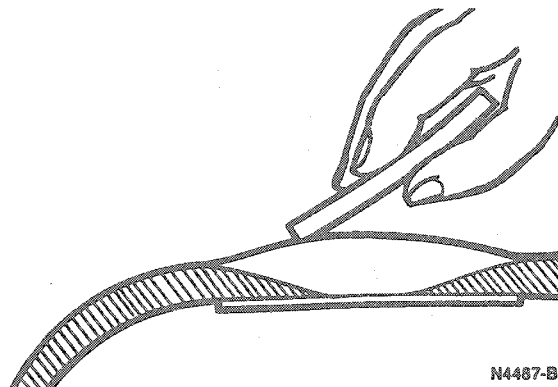
5. Using the 3M® Flexible Parts Repair Material part No. 05900 or equivalent, mix repair filler material. Carefully follow instructions on tubes and on kit container to ensure correct mixing and applications of repair material.

NOTE: To prevent air bubbles during mixing, the components should be scraped together with downward pressure and spread thinly on mixing board. Adhesive must be used within two minutes after mixing. Observe safety precautions when handling adhesive.



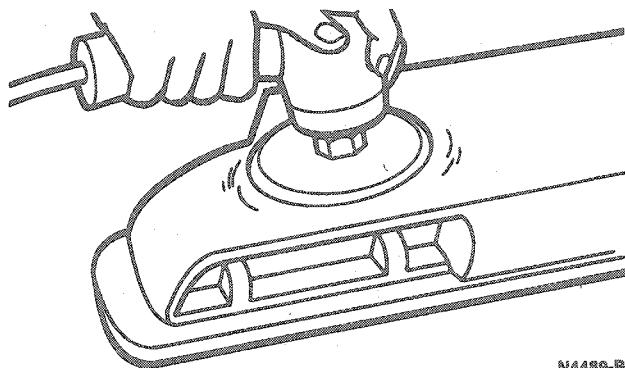
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6. When restoring contour, apply sufficient material to overfill the area. Refer to package instruction if necessary. If voids, bubbles or low areas occur, mix more adhesive and apply to repair.



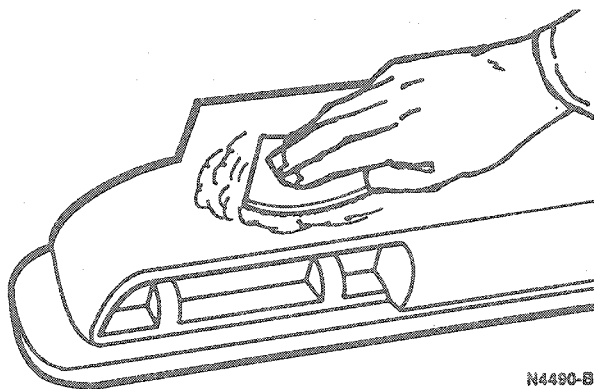
N4487-B

7. Allow the material to dry for 20-30 minutes at 60°-80° F. Check for low spots and apply additional filler, if needed.
8. When properly cured, sand repair area down to correct contour. Start with a No. 180-grit disc followed by a No. 240-grit paper disc.



N4489-B

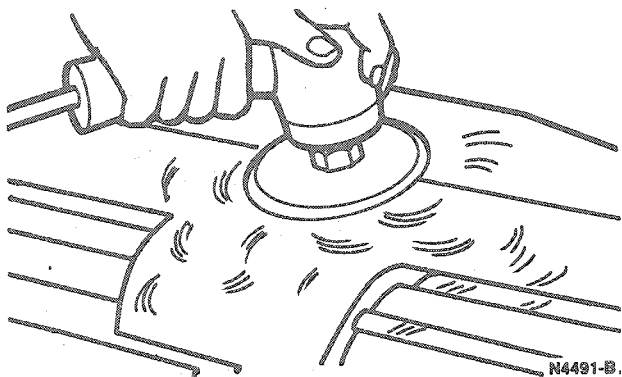
9. Examine finished sanded repair and fill any bubbles, holes or low spots with additional adhesive.



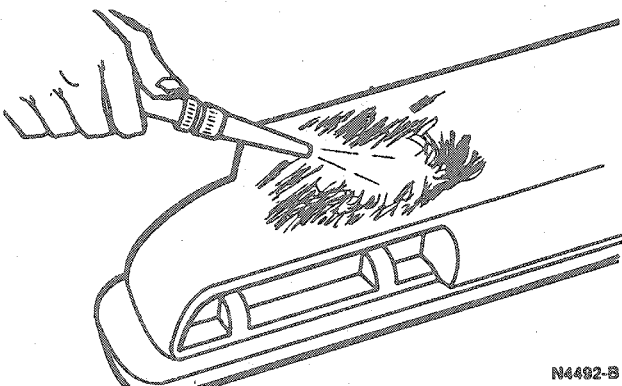
N4490-B

## REPAIR (Continued)

10. The entire panel surface must be scuff sanded (orbital-type disc or block) with No. 320 disc or paper.



11. Clean area by blowing off dust and tack wipe. Wash with a silicone and wax remover.



12. For refinishing, follow paint manufacturer's instructions.

### Exterior Parts, Flexible—Refinishing

Elastomeric additive is intended for use with Acrylic Air Dry service paints or suitable equivalents to refinish flexible parts, and is not suitable for use on metal.

This material adds flexibility to air dry repair paints so that the same paint with additive can also be used for repair of soft, non-metallic parts. The use of standard service automotive finishes on flexible parts is impractical as these finishes form a rigid coating when paint cures. This additive allows paint coating to adhere to the part when flexed or compressed and return to normal appearance as the part returns or recovers to its original shape.

**WARNING: THE ADDITIVE MUST BE HANDLED WITH CAUTION. IT IS INTENDED FOR INDUSTRIAL USE ONLY BY QUALIFIED PERSONNEL AND IS NOT INTENDED FOR THE GENERAL PUBLIC. THE PRODUCT LABEL PROVIDES INFORMATION ON RECOMMENDED SAFETY PRECAUTIONS AND PROPER APPLICATION. THE ELASTOMERIC ADDITIVE SHOULD NOT BE USED UNTIL THIS INFORMATION IS READ AND UNDERSTOOD. OBSERVE ALL APPLICABLE PRECAUTIONS.**

**THE VAPOR AND MIST SPRAY CAN BE HARMFUL. WHEN MIXED, IT SHOULD BE, IF POSSIBLE, USED IN A SPRAY BOOTH WITH ADEQUATE RESPIRATOR PROTECTION. THE RECOMMENDED PROTECTION IS A NIOSH-APPROVED POSITIVE PRESSURE AIR-SUPPLIED RESPIRATOR. IF THIS IS NOT AVAILABLE, USE A VAPOR/PARTICLE RESPIRATOR SUCH AS 3M® MODEL NO. 6984 OR ITS EQUIVALENT, RECOMMENDED BY THE MANUFACTURER AS EFFECTIVE FOR ISOCYANATE VAPORS AND MIST. RESPIRATOR PROTECTION IS RECOMMENDED FOR USE DURING THE WHOLE TIME OF SPRAYING AND UNTIL ALL VAPOR AND MIST IS GONE. THE 3M® RESPIRATOR PACKAGE HAS SPECIFIC FITTING AND USAGE INSTRUCTIONS THAT MUST BE FOLLOWED TO ENSURE MAXIMUM PROTECTION FROM THE RESPIRATOR.**

The additive should be kept away from water or moist air because it may react with water and form a gel-like material which can make the product useless. The flexibility of the coating may be adversely affected if relative humidity of air is high during application. The container must be kept closed when not in use.

The useable "pot" life of a mixed color is approximately one hour, after which the mixture will have poor drying characteristics. To avoid waste of material, mix only the quantity required. Clean all spray equipment with solvent immediately after use. Allow part to cure two to four hours after final coat before handling. After curing for 24 hours, the coating can be rubbed out by hand to improve the finish. Do not use a machine for rubbing; it may cause burring.

### Surface Preparation

If the flexible part has a coating that completely covers the substrate, no special priming is required. It only requires cleaning with a Silicone and Wax Remover and scuff sanding with 400-grit paper to remove gloss. The high bake elastomeric coating applied in the factory requires sanding to promote adhesion of the air dry service paints.



## REPAIR (Continued)

If the coating does not cover the substrate, Ford Elastomeric Primer EBP-M18P5-A and Ford Elastomeric Thinner EBP-1618-B or equivalent must be used prior to applying the color coat. Follow label instructions for each product.

### Mixing and Application

The additive is highly recommended for use with Acrylic enamel. It may also be used with Acrylic Lacquer for colors that are not available in enamel.

Apply full wet coats with 10 to 15 minutes flash time between coats.

**Enamel:** Requires three full wet coats.

- 1 part Elastomeric Additive (EBP-652-A), 118ml (4 oz)
- 4 parts Acrylic Enamel, 473ml (16 oz)

**Lacquer:** Requires six full wet coats.

- One-half part Elastomeric Additive (EBP-652-A), 59ml (2 oz)
- 2 parts Acrylic Lacquer, 236ml (8 oz)

## CLEANING AND INSPECTION

### Floorpan Plugs and Grommets

Many plugs and grommets are used in the floorpan and instrument panel. The floorpan plugs seal the various access holes. If any plugs are missing or improperly installed, a dust or water leak may result. This also applies to the grommets used on the instrument panel. When dust or water leaks are evident, these plugs and grommets should be checked for proper installation.

### Rattle Elimination

Foreign objects such as nuts, bolts or small pieces of body deadener in the door wells, pillars and quarter panels are often the source of rattles. Door wells can be checked by carefully striking the underside of the door with a rubber mallet.

All bolts and screws should be inspected periodically. In the event that tightening the bolts and screws located on such assemblies as the doors, hood, and deck lid does not eliminate the rattles, the trouble is probably caused by misalignment. If this is the case, follow the adjustment and alignment procedures for these assemblies.

Rattles and squeaks are sometimes caused by weatherstripping and anti-squeak material that has slipped out of position. Apply additional cement or other adhesive.

### Trim

Bright metals should be periodically cleaned with a soft, clean cloth or sponge and clear water. For excessively dirty parts, use Multi-Purpose Cleaner Concentrate B8A-19523-AA (ESR-M14P4-A) or equivalent diluted to proper concentration. Wash, rinse and wipe the parts dry. To remove rust or salt corrosion from chrome-plated parts, sparingly use Custom Bright Metal Cleaner 8A-19522-A (ESR-M5B194-B) or equivalent. On aluminum or chrome finished parts, avoid scouring with steel wool and polishing with products containing abrasives. Use Custom Silicone Gloss Polish B7AZ-19530-AA (ESR-M11B26-A) or equivalent, for excellent protection of all bright metal parts.

### Vinyl Insert Moulding Care

Rinse the vinyl to remove dirt and grime. Exceptionally dirty areas should be precleaned with Triple Clean E0AZ-19526-AA (ESR-M14P4-A) or Multi-Purpose Cleaner Concentrate B8A-19523-AA (ESR-M14P4-A) or equivalent diluted per label instructions or mild soap solution. Next, apply Vinyl Hardtop Cleaner and Reconditioner E3AZ-19F535-A (ESR-M14P6-A) or equivalent following directions.

**NOTE:** Commercial hot waxes applied at automatic car washes have been known to affect cleanability of vinyl material.

**CAUTION:** To avoid damage to the vinyl insert mouldings, use only an approved Ford cleaner. The use of stiff bristle brushes or abrasive material or cleaners must be avoided.

### Body Maintenance

Regular body maintenance preserves the vehicle's appearance during the life of the vehicle. The following steps are suggested as a guide for regular body maintenance.

1. Vacuum the interior thoroughly and wash the vehicle.
2. Check all openings for water leaks and seal where necessary.
3. Cement all useable loose weatherstrips, using Weatherstrip Adhesive E8AZ-19552-A (ESB-M2G14-A) or equivalent.
4. Replace all door and deck lid weatherstrips that are damaged or worn.
5. Apply Silicone Lubricant C0AZ-19553-AA (ESR-M13P4-A) or equivalent, to the weatherstripping.
6. Replace all cracked, fogged or chipped glass.
7. Align the hood, doors and deck lid if necessary.
8. Inspect the windshield wiper blades and replace them if necessary.

**CLEANING AND INSPECTION (Continued)**

9. Tighten scuff plate and garnish moulding screws. Refer to Section 01-05.
10. Clean the seats, door trim panels and headlining.
11. Apply touch-up paint to chipped or scratched areas.
12. Drain holes (located on the underside of each rocker panel, quarter panel and door) should be cleared periodically.

**Appearance Protection**

Proper maintenance will help keep the vehicle looking factory new for several years. The following cleaning and care recommendations will provide the vehicle with necessary appearance protection.

Proper exterior appearance protection includes proper and frequent washing (including underside areas), polishing to shield paint and bright metal surfaces, touching up nicks and scratches with proper paint, and keeping body drain holes unplugged.

**NOTE:** It is very important to remember when using any chemical cleaner or polish to always follow label directions. Read all warning and caution statements which appear on label.

**Washing**

Use One Step Wash and Wax Concentrate D6AZ-19523-AA (ESR-M14P12-A) or equivalent diluted to the proper concentration, followed by a rinse with clear, cold water. Do not wash vehicle with hot water, in the direct rays of the sun or while sheet metal is hot.

**Polishing**

Use Custom Silicone Gloss Polish B7AZ-19530-AA (ESR-M11B26-A), Custom Paste Wax B4A-19534-AA (ESR-M11B23-A), Custom Cream Wax E4AZ-19534-AA (ESR-M11B26-A) or equivalent to remove harmful deposits and provide added protection on body surfaces.

**Underbody**

In geographic areas using a heavy concentration of road salt or other corrosive materials for snow removal or road dust control, flush and inspect the complete underside of the vehicle at least twice a year.

Particular attention should be given to cleaning out underbody members and drain holes where dirt and other foreign materials may have collected.

**Rustproofing**

**CAUTION:** The flexible plastic and/or rubber-like parts such as front and rear polycarbonate bumpers, plastic claddings and fairings, and urethane rear sight shields, if so equipped, may be damaged by aftermarket rustproofing compounds. If rustproofing overspray, drips or runs are allowed to remain on the front or back side of the noted plastic parts, they may swell or distort. To prevent this, if the vehicle has been aftermarket rustproofed, inspect and clean with Extra Strength Tar and Road Oil Remover B7A-19520-AA (ESR-M5B106-A) or equivalent, or a naphtha-wetted cloth. Wipe completely dry. Inspect frequently, as rustproofing may run or drip for some time after installation, especially in hot weather.

**Chrome and Bright Metal Care**

Frequent washing and the use of Custom Bright Metal Cleaner 8A-19522-A (ESR-M5B194-B) or equivalent, are recommended for body hardware, chrome-plated materials and aluminum components.

**CAUTION:** Plastic wheelcovers should always be washed with mild detergent and water immediately after using any commercial-type cleaner to prevent any possible damage to wheelcover.

**CAUTION:** Do not use steel wool, abrasive - type cleaner or strong detergents containing highly alkaline or caustic agents on chrome-plated materials, aluminum wheels or anodized aluminum parts as damage to the protective coating, and discoloration may result. Clean with One Step Wash and Wax Concentrate D6AZ-19523-AA (ESR-M14P12-A) or equivalent, diluted per label directions.

**Multi-Purpose Cleaner Concentrate**  
B8A-19523-AA (ESR-M14P4-A)

**Custom Bright Metal Cleaner 8A-19522-A**  
(ESR-M5B194-B)

**WARNING: READ THE WARNING INFORMATION ON THE PRODUCT LABEL**

1. Pour some cleaner concentrate onto a clean, damp cloth and wipe wax from the bumper. A second application with vigorous rubbing may be necessary for hard wax areas.
2. For severe wax buildup, pour some metal cleaner onto a clean, damp cloth and wipe wax from the bumper. Minimal effort should be required to remove wax. Continue this process until entire bumper is wax-free.
3. To provide a bright, glossy appearance to bumper, apply metal cleaner after removing wax coating. A separate clean, damp cloth should be used for this procedure.



## CLEANING AND INSPECTION (Continued)

### Paint

The outside finish should be washed frequently. Never wipe the painted surface with a dry cloth. Dusting the finish when it is dry tends to rub dust and dirt into the paint, causing scratches on the surface. To keep the finish bright and attractive, wash the vehicle whenever it is dirty.

Protect the exterior with frequent washing, including underside areas. Use One Step Wash and Wax Concentrate D6AZ-19523-AA (ESR-M14P12-A) or equivalent, diluted to proper concentration, followed by a rinse with clear, cold water. Do not wash vehicle with hot water, in direct sunlight, or while sheet metal is hot.

Polish paint and bright metal with Custom Silicone Gloss Polish B7AZ-19530-AA (ESR-M11B26-A), Custom Paste Wax B4A-19534-AA (ESR-M11B23-A), Custom Cream Wax E4AZ-19534-AA (ESR-M11B26-A) or equivalent, to remove harmful deposits and provide added protection to body surfaces, body hardware, and chrome and aluminum parts. Touch up nicks and scratches with proper paint.

**CAUTION:** Do not use steel wool, abrasive-type cleaner, gasoline or strong detergents containing highly alkaline or caustic agents on chrome-plated materials, aluminum wheels, headlamps, bumpers or anodized aluminum parts, as damage to the protective coating and discoloration or paint deterioration may occur.

**NOTE:** Vehicles subjected to airborne pollen, insect droppings, bird droppings and other organic matter, especially vehicles subjected to this matter that are exposed to high temperatures and sunshine, should be washed as often as necessary to keep them free of this organic matter. Similar precautions should be taken where a vehicle may be exposed to chemical industrial fallout. Failure to do so may result in damage to the exterior surfaces.

### Glass

Glass should be cleaned with Ultra Clear Spray Glass Cleaner E4AZ-19C507-AA (ESR-M14P5-A) or equivalent, using a clean, soft, lint-free cloth. Follow directions on the container.

## ADJUSTMENTS

**CAUTION:** Never apply heat to the bumper energy absorber. Heat could cause the material inside the absorbers to expand and flow out of the absorbers or crack the metal housing. Always remove the absorbers before performing body frame service near them.

**CAUTION:** Never apply excessive heat to bumper surface. Heat could cause the bumper to distort.

**CAUTION:** When collecting exhaust fumes in service area, never attach a metal collector to the exhaust tail pipe as the heat could damage the bumper.

### Body Alignment, Unitized

**NOTE:** Heat and the use of heavy-duty jacks must be carefully controlled because of the difference in the gauge of the metal in the side rails of a unitized body and the stress points in a unitized body. It is possible to pull damaged areas back into alignment with the use of lightweight jacks and hydraulic equipment, without heating the metal.

Rough-out badly damaged areas before taking measurements for squaring up a body. If necessary, remove the glass from the damaged area to prevent breakage. In severe cases, reinforcement brackets and other inner construction may have to be removed or cut to permit restoration of the outer shell and pillars, without excessive strain on the parts. Straighten, install and secure all such parts in place before attempting to align the body.

**CAUTION:** In cases of severe or sharp bends, it may be necessary to use heat. Any attempt to cold-straighten a severely bent bracket may cause ruptures of the welds and may also cause cracks in the bent part. Never heat the area to more than a dull red.

All welding should be done with a Rotunda MIG Welder 066-01210 or equivalent, with welding wire meeting AWS-E-70S Specifications.

**CAUTION:** Disconnect the negative battery cable before using any electric welding equipment.

### Underbody Misalignment Check

The dimensions of the underbody must be restored in repairing major body damage to provide correct front and rear wheel geometry. Refer to illustration for the underbody dimensions. All the dimensions are detailed to the centerline of existing holes in the underbody assembly. Once the frame and suspension members are aligned, other operations in this Section can be performed.

### Body Misalignment Check

**CAUTION:** Do not attempt to correct any serious misalignment with one jacking operation.

To align or square up a body, take two opposite diagonal measurements between the front, center or rear pillars. Take the measurements between reference points, such as crease lines or weld joints which are diagonally opposite each other on the two pillars being measured. Since all measurements should be made from the bare metal, remove all interior trim from the checking points.

**ADJUSTMENTS (Continued)**

Align each section proportionately, until the proper dimensions are obtained. If body alignment is questionable, refer to illustration for underbody dimensions.

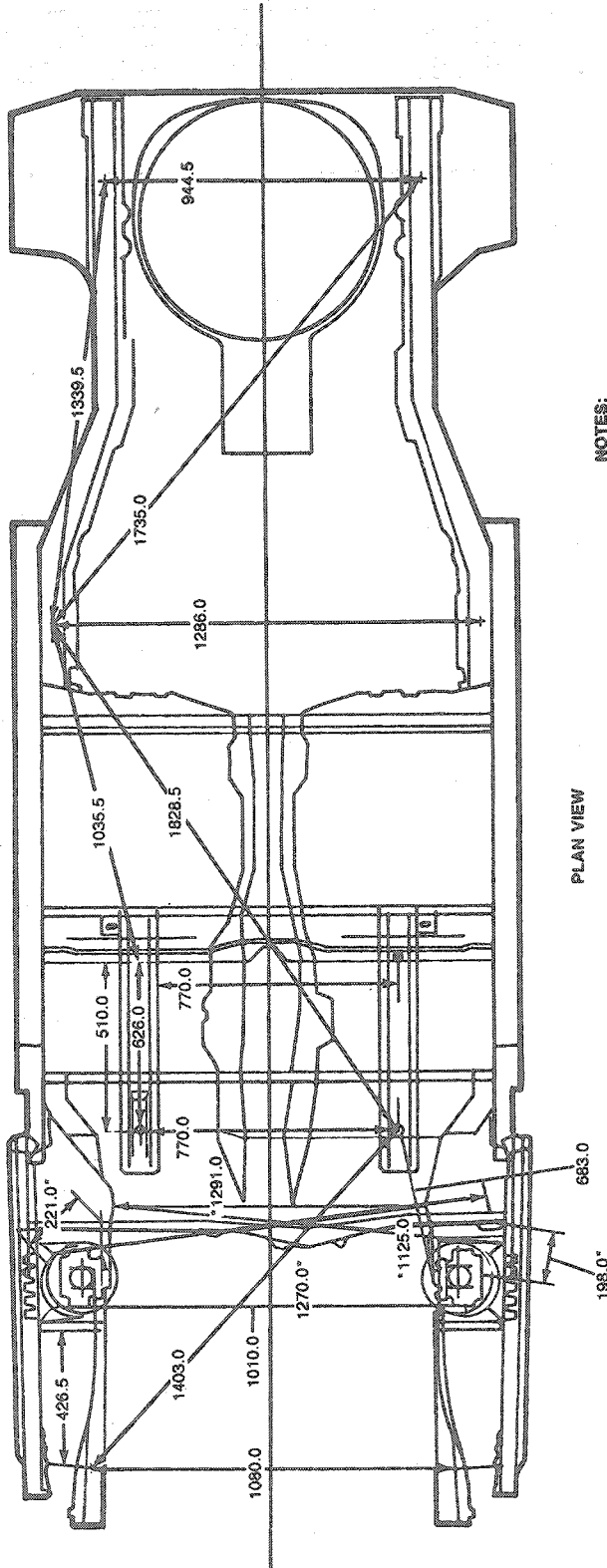
**Underbody Dimensions****Tools Required:**

- Rotunda Complete Laser Measuring System  
073-00450

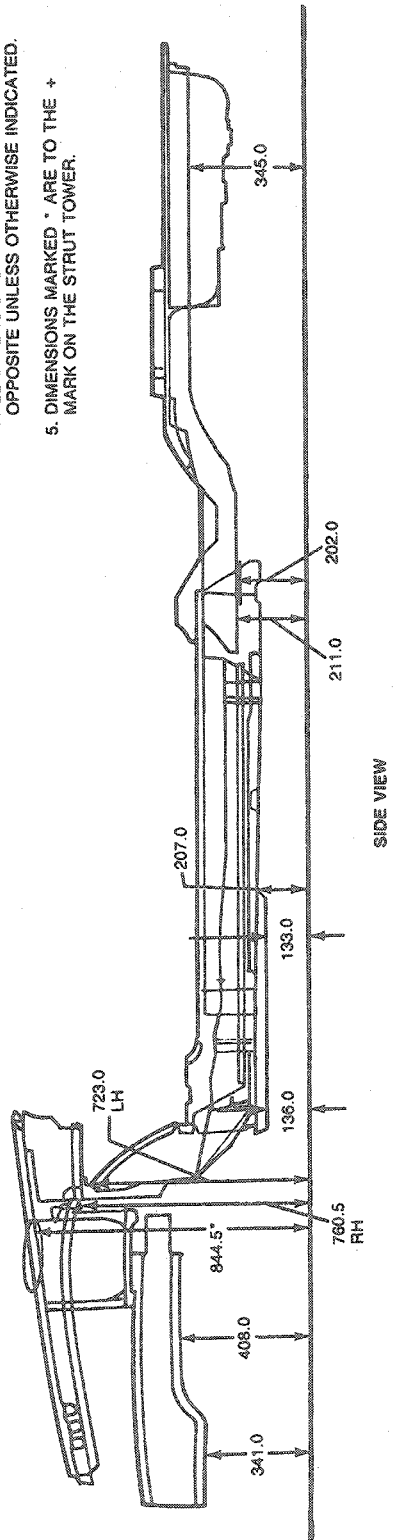
Underbody dimensions are shown in the following illustration. Dimensions can be measured using Rotunda Complete Laser Measuring System 073-00450 or equivalent.

# ADJUSTMENTS (Continued)

## Underbody Dimensions



PLAN VIEW



SIDE VIEW

IN6980-A

- NOTES:
1. ALL DIMENSIONS ARE IN mm.
  2. TOLERANCE IS  $\pm 3$ mm.
  3. ALL DIMENSIONS ARE TRUE TO LENGTH, CENTER TO CENTER.
  4. ALL DIMENSIONS ARE SYMMETRICALLY OPPOSITE UNLESS OTHERWISE INDICATED.
  5. DIMENSIONS MARKED \* ARE TO THE + MARK ON THE STRUT TOWER.

**SPECIAL SERVICE TOOLS****ROTUNDA EQUIPMENT**

Model	Description
085-01626	Spray Gun
085-01617	Detached Pressure Cup
107-00300	Heat Gun
107-01619	Dual Action Air Sander

(Continued)

**ROTUNDA EQUIPMENT (Cont'd)**

Model	Description
066-01210	MIG Welder
073-00450	Complete Laser Measuring System
055-00103	Vacuum / Air / Water Leak Detector

# SECTION 01-02 Body Panels, Front End

SUBJECT	PAGE	SUBJECT	PAGE
<b>ADJUSTMENTS</b>		<b>REMOVAL AND INSTALLATION (Cont'd.)</b>	
Hood Alignment.....	01-02-8	Hood Lift Assist and Support (Gas Cylinder).....	01-02-1
Hood Bumpers.....	01-02-9	Radiator Grille.....	01-02-2
<b>REMOVAL AND INSTALLATION</b>		Splash Shield and Insulator.....	01-02-4
Hood Hinge.....	01-02-1	Stone Deflector, Front.....	01-02-2
Battery Tray.....	01-02-7	<b>SPECIFICATIONS</b> .....	01-02-9
Cowl Vent Screen.....	01-02-6	<b>VEHICLE APPLICATION</b> .....	01-02-1
Fender, Front.....	01-02-5		
Hood.....	01-02-1		

## VEHICLE APPLICATION

Taurus / Sable.

## REMOVAL AND INSTALLATION

### Hood

#### Removal

1. Open and support hood. Mark hood hinge locations on hood.
2. Protect body with covers to prevent damage to paint.
3. Disconnect gas cylinders from hood as outlined.
4. Remove two bolts retaining each hinge to hood, taking care not to let hood slip when bolts are removed.
5. Remove hood from vehicle.

### Installation

1. Position hood to hood hinges. Tighten retaining bolts, hood-to-hinge to 22-34 N·m (17-25 lb-ft) and hinge-to-body to 22-34 N·m (17-25 lb-ft). Remove body covers.
2. Adjust hood for even fit between fenders and for flush fit with front of fenders.
3. Attach gas cylinders to hood as outlined.
4. Adjust hood for flush fit with rear of fenders.
5. Adjust hood latch, if necessary.

### Hood Hinge

#### Removal

1. Open and support hood. Mark hood hinge locations on hood.
2. Protect body with covers to prevent damage to paint.
3. Disconnect gas cylinders from hood as outlined.
4. Remove two bolts retaining hinge to hood, taking care not to let hood slip when bolts are removed and support rear of hood.

5. Remove two bolts retaining hinge to body. Remove hinge.

#### Installation

1. Position hinge to body. Install two retaining bolts and tighten to 22-34 N·m (17-25 lb-ft).
2. Position hinge to hood. Install two retaining bolts and tighten to 22-34 N·m (17-25 lb-ft).
3. Connect gas lift cylinders to hood as outlined.
4. Adjust hood as outlined.

### Hood Lift Assist and Support (Gas Cylinder)

#### Removal

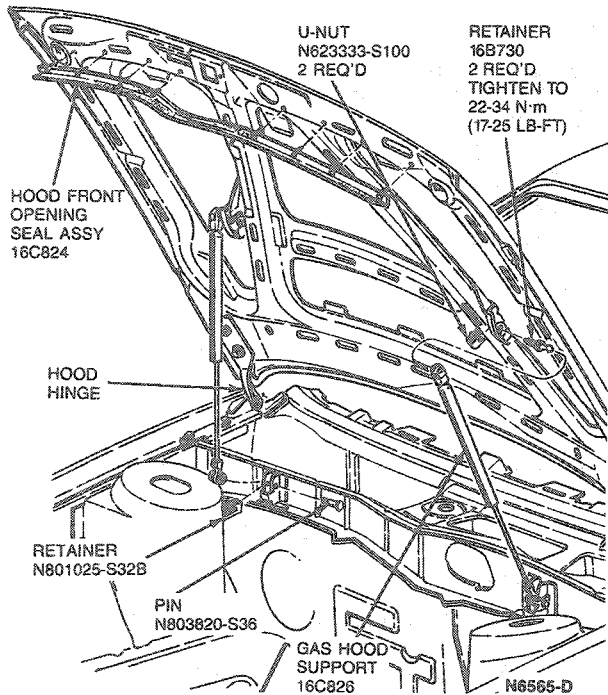
1. Open hood and temporarily support it.
2. Disconnect gas cylinder from hood.
3. Disconnect gas cylinder from cowl. Remove gas cylinder.

#### Installation

1. Position hole at end of gas cylinder in the retaining bracket on cowl.
2. Insert retaining pin and install lock clip on end of pin.
3. Connect opposite end of gas cylinder to ball stud on hood. Ensure lock clip is in place on gas cylinder.

## REMOVAL AND INSTALLATION (Continued)

## 4. Remove temporary support and close hood.



## Radiator Grille

## Taurus

Taurus does not have a conventional grille. It is part of the front stone deflector.

## Sable

Sable vehicles do not have a conventional grille, they have a lighted panel. Refer to Section 17-01 for headlamp information.

## Stone Deflector, Front

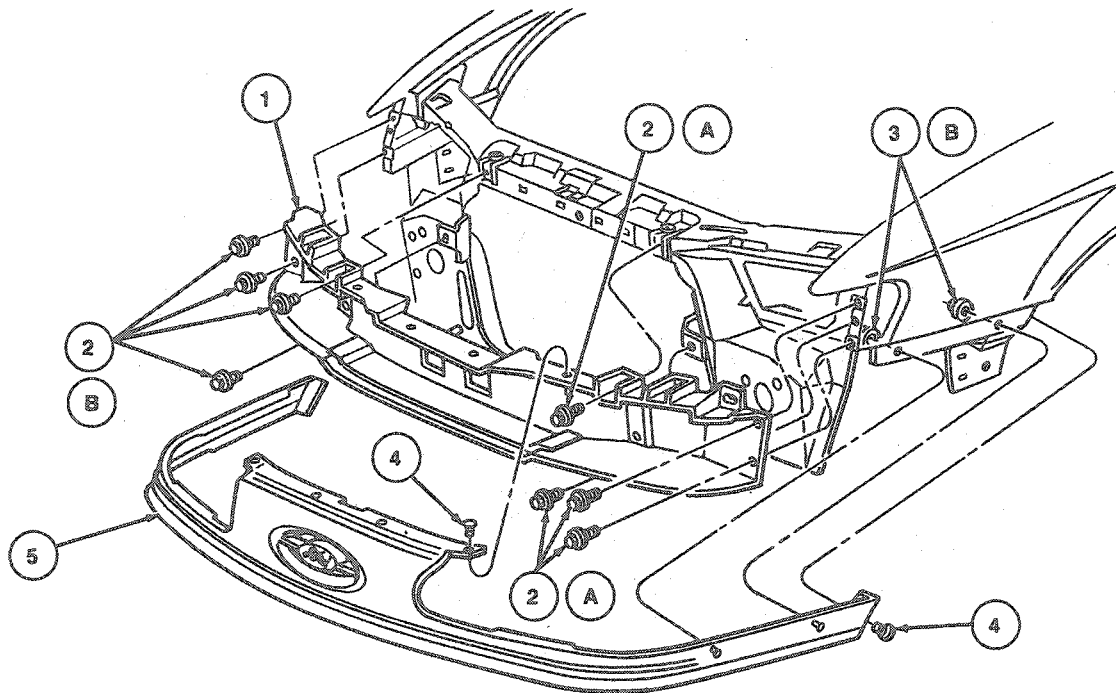
## Taurus

## Removal and Installation

1. Remove four push pins retaining stone deflector to grille opening reinforcement panel.
2. Fold back front half of RH and LH fender splash shields.
3. Remove four nuts (two each side) attaching deflector to fender.
4. Remove stone deflector.
5. To install, reverse Removal procedure.



## REMOVAL AND INSTALLATION (Continued)



N9625-A

Item	Part Number	Description
1	8A164	Grille Opening Panel Reinforcement
2A	N606676-S55	Screw and Washer Assy (8 Req'd)
3B	N621906-S36	Nut and Washer Assy (2 Req'd Each Side)
4	388577-S	Push Pin (1 Req'd Each Side)

(Continued)

Item	Part Number	Description
5	17A878	Front Bumper Stone Deflector Assy
A		Tighten to 5.3-7.1 N·m (4-5 Lb-Ft)
B		Tighten to 4.5-6.9 N·m (3-5 Lb-Ft)

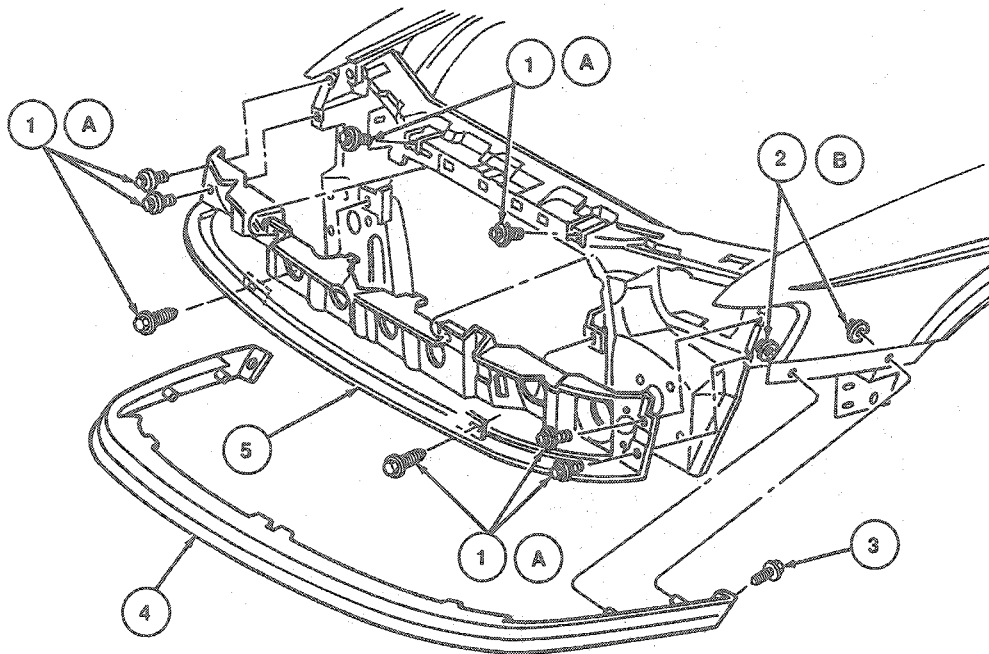
TN9625A

**Sable****Removal and Installation**

1. Remove two push pins (one each side) retaining deflector to front fenders.
2. Fold back front half of RH and LH fender splash shield.

3. Remove four nuts (two each side) retaining stone deflector ends to front fender.
4. Remove stone deflector.
5. To install, reverse Removal procedure.

## REMOVAL AND INSTALLATION (Continued)



N9626-A

Item	Part Number	Description
1A	N606676-S55	Screw and Washer Assy (8 Req'd)
2B	621906-S36	Nut and Washer (2 Req'd Each Side)
3	388577-S	Push Pin (1 Req'd Each Side)
4	17A878	Front Bumper Stone Deflector Assy

Item	Part Number	Description
5	8A164	Grille Opening Panel Reinforcement
A		Tighten to 5.3-7.1 N-m (4-5 Lb-Ft)
B		Tighten to 4.5-6.9 N-m (3-5 Lb-Ft)

TN9626A

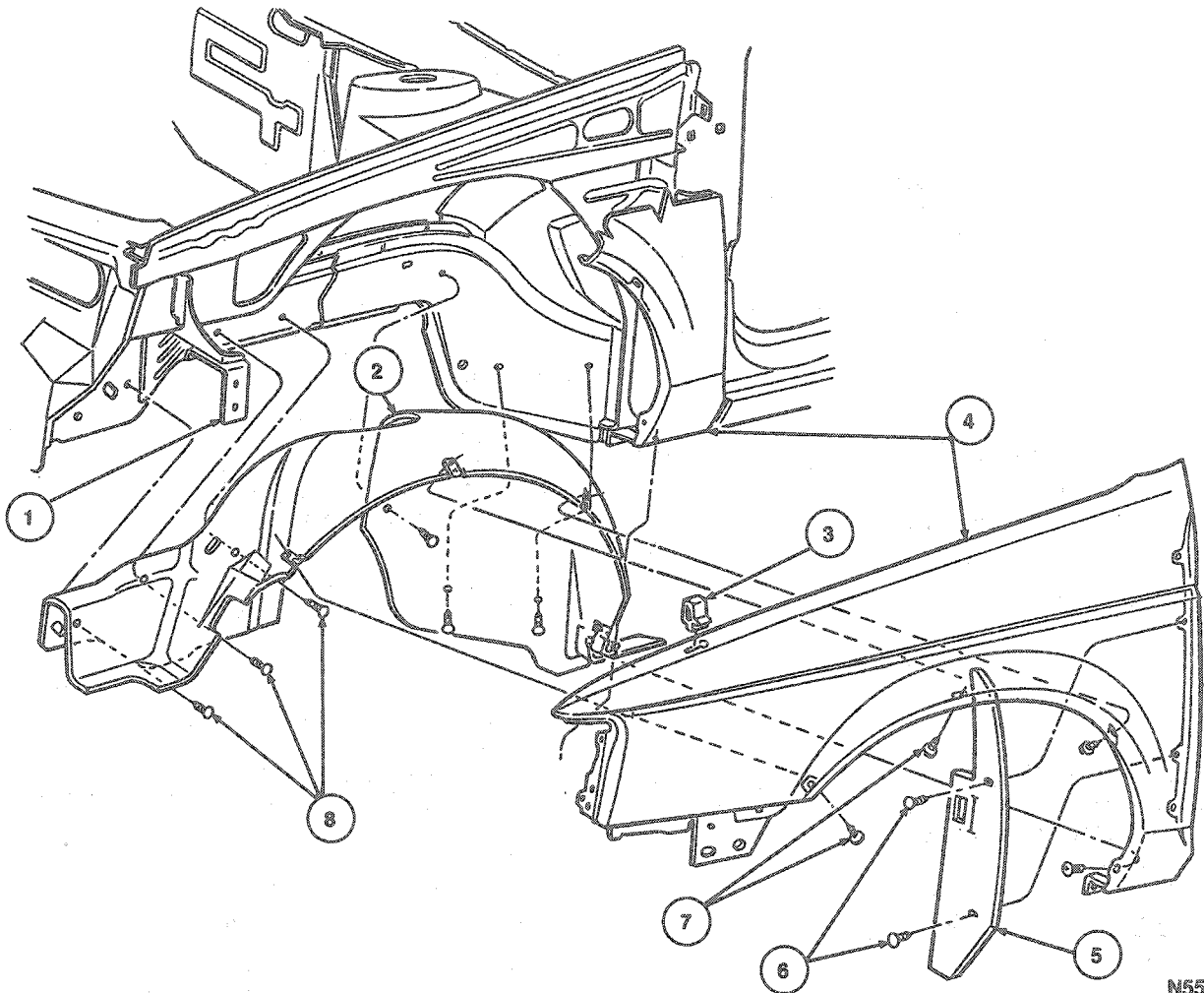
(Continued)

**Splash Shield and Insulator****Removal and Installation**

1. Remove pins securing splash shield to body.
2. Remove screws securing splash shield to fender and lower rear attachment to body side. Remove splash shield.

3. Remove insulator assembly from fender by removing retaining pins. Remove insulator.
4. To install, reverse Removal procedure.

## REMOVAL AND INSTALLATION (Continued)



N5509-D

Item	Part Number	Description
1	—	Bracket
2	16034	Shield Assy
3	N802726-S	Bumper

(Continued)

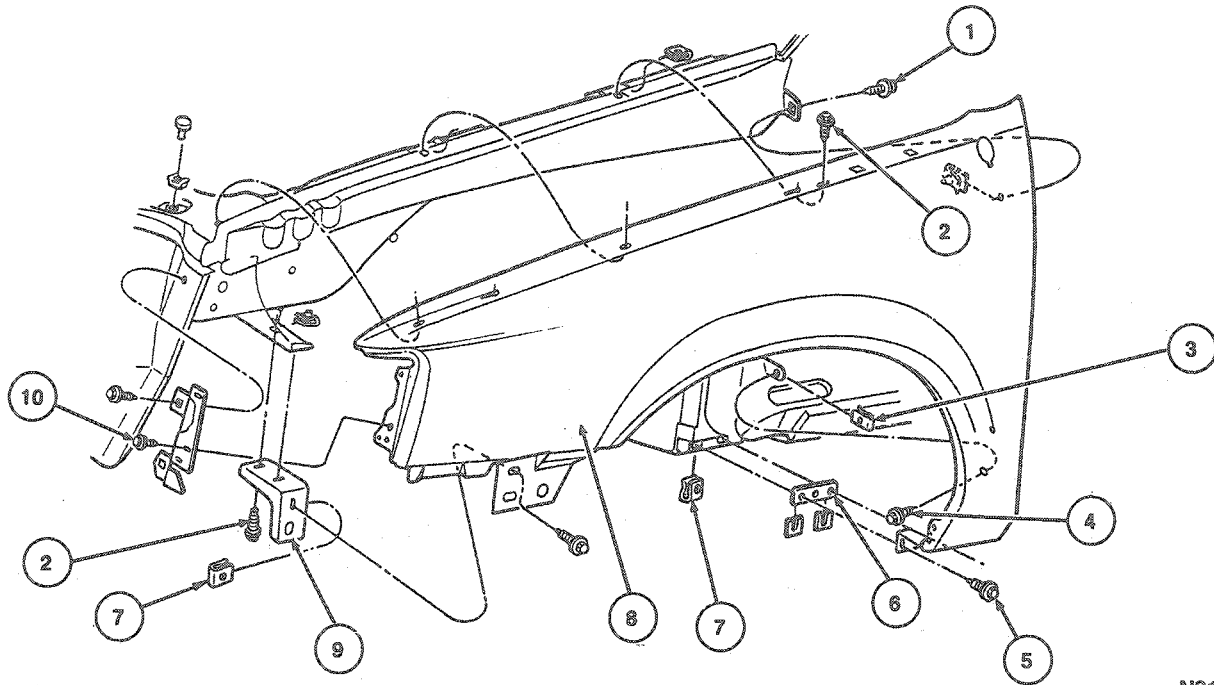
Item	Part Number	Description
4	16006	Front Fender
5	6E560	Insulator
6	388577-S	Push Pin
7	56912-S55X	Screw (4 Req'd Each Side)
8	N802781-S	Pin (6 Req'd Each Side)

**Fender, Front****Removal and Installation**

1. Remove the front bumper. Refer to Section 01-19.
2. Remove two screws retaining grille opening reinforcement panel to fender.
3. Remove one screw retaining upper front fender mounting bracket to fender.
4. Remove one screw retaining front fender mounting bracket to fender.

5. Remove two screws retaining lower rear fender to body side.
6. Remove two bolts retaining upper and lower front fender (rear).
7. Remove three retaining bolts from "catwalk" area of fender to apron. Remove fender.
8. To install, reverse Removal procedure.

## REMOVAL AND INSTALLATION (Continued)



N8176-B

Item	Part Number	Description
1	N80947-S2	Screw and Washer Assy
2	N606676-S36	Bolt
3	N623332-S100	U-Nut
4	N606675-S36	Bolt
5	N606677-S2	Bolt

(Continued)

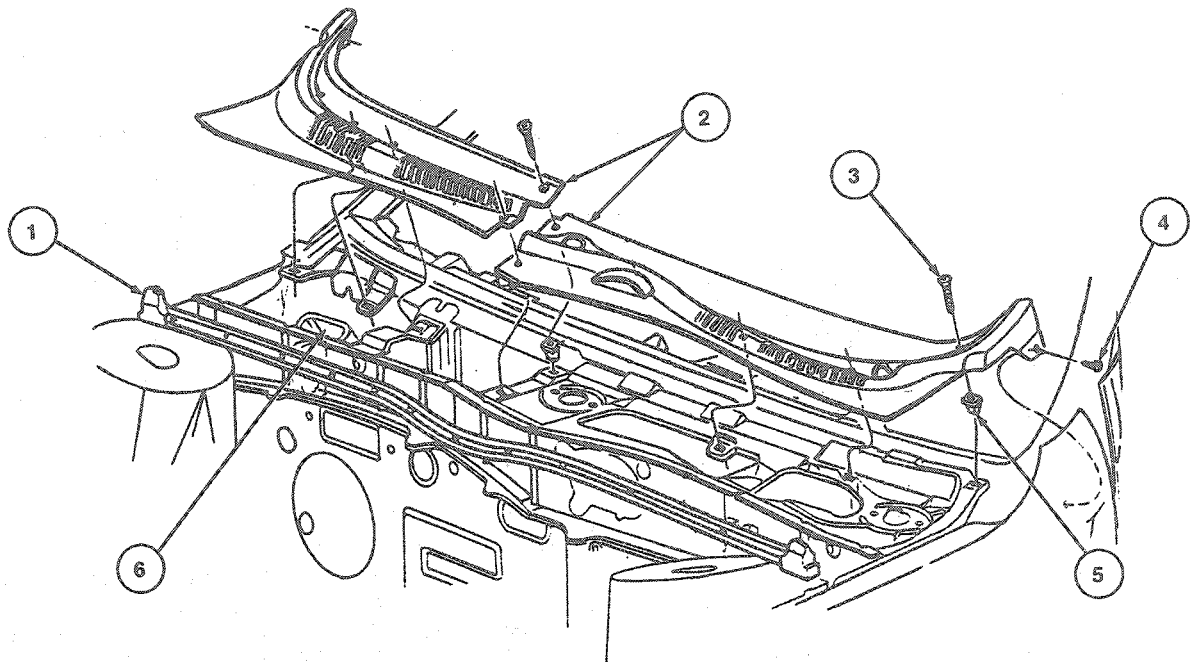
Item	Part Number	Description
6	N804532(RH) N804533 (LH)	Spacer
7	N801839-S53	U-Nut
8	16015	Fender
9	—	Front Fender Mounting Bracket
10	N610958-S2	Screw

**Cowl Vent Screen****Removal and Installation**

1. Remove both windshield wiper arms from vehicle. Refer to Section 01-16.
2. Remove two side screws and eight top screws securing cowl vent screen to body.

3. Remove screen from vehicle. LH half of screen must be removed before RH half of screen.
4. To install, reverse Removal procedure.

## REMOVAL AND INSTALLATION (Continued)



N7048-C

Item	Part Number	Description
1	16A942	Pad Assy
2	018A14/5	Cowl Vent Screen Assy
3	N610131-S55	Screw (8 Req'd)
4	382413-S55X	Screw (1 Req'd Each Side)
5	02316-A	Retainer (8 Req'd)
6	20B02	Cowl Vent Water Deflector

TN7048C

**Battery Tray**

**WARNING: BATTERIES NORMALLY PRODUCE EXPLOSIVE GASES WHICH CAN CAUSE PERSONAL INJURY. THEREFORE, DO NOT ALLOW FLAMES, SPARKS OR LIGHTED TOBACCO TO COME NEAR THE BATTERY. WHEN CHARGING OR WORKING NEAR A BATTERY, ALWAYS SHIELD YOUR FACE AND PROTECT YOUR EYES. ALWAYS PROVIDE VENTILATION.**

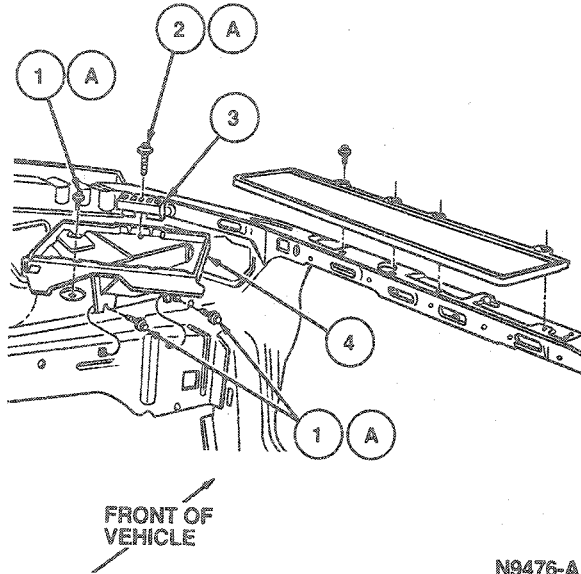
**WHEN LIFTING A PLASTIC-CASED BATTERY, EXCESSIVE PRESSURE ON THE END WALLS COULD CAUSE ACID TO SPEW THROUGH THE VENT CAPS, RESULTING IN PERSONAL INJURY. LIFT WITH A BATTERY CARRIER OR WITH YOUR HANDS ON OPPOSITE CORNERS.**

**Removal and Installation**

1. Open hood.
2. Disconnect negative battery cable.
3. Disconnect positive battery cable.
4. Remove battery hold-down bolt and spacer.
5. Remove battery.
6. Remove three battery tray retaining bolts.
7. Remove battery tray.
8. To install, reverse Removal procedure.

REMOVAL AND INSTALLATION (Continued)

Taurus/Sable

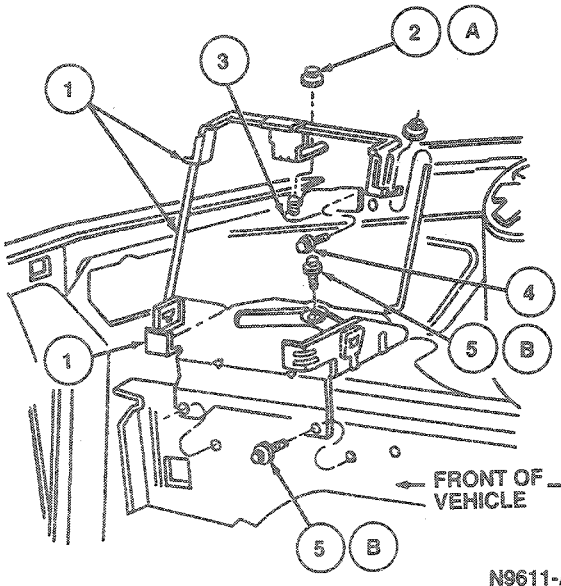


N9476-A

Item	Part Number	Description
1A	N800932-S55	Screw and Washer Assy (3 Req'd)
2A	N803471-S55	Screw and Washer Assy (1 Req'd)
3	10747	Battery Hold Down Spacer
4	10723	Battery Tray Assy
A		Tighten to 8-12 N·m (6-9 Lb·Ft)

TN9476A

SHO



N9611-A

Item	Part Number	Description
1	10723	Battery Tray Assy
2A	N620481-S2	Nut
3	10727	Battery Hold Down Clamp Brace
4	N803991-S2	Screw (2 Req'd)
5B	N800935-S36	Screw and Washer (3 Req'd)
A		Tighten to 10-16 N·m (7-12 Lb·Ft)
B		Tighten to 8-12 N·m (6-9 Lb·Ft)

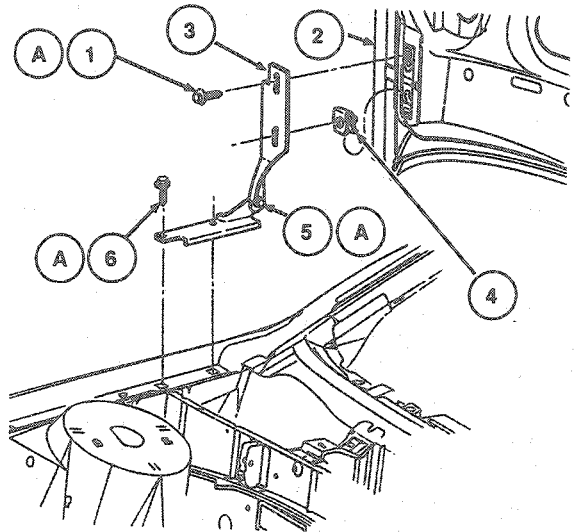
TN9611A

ADJUSTMENTS

Hood Alignment

The hood can be adjusted fore-and-aft and side-to-side by loosening two hood-to-hinge retaining bolts at each hinge. Reposition hood as required and tighten the hood-to-hinge retaining bolts. A 4.0mm ± 1.5mm margin should be maintained between the hood and fenders.

To raise or lower the rear of the hood, loosen the hood hinge pivot nut. The pivot can now move up or down. Raise or lower hood as necessary to obtain a flush condition at the rear of the hood with the fenders. Tighten the hood hinge pivot nut to 22-34 N·m (17-25 lb-ft).



N6596-F

Item	Part Number	Description
1A	N606677-S36	Screw and Washer Assy (2 Req'd Each Hinge)
2	16612	Hood Assy
3	16800-1	Hood Hinge Assy

(Continued)



**ADJUSTMENTS (Continued)**

Item	Part Number	Description
4	N8D1839-S53	Nut
5A	16797	Hinge Pivot Nut
6A	N606689-S36	Screw and Washer Assy (2 Req'd Each Hinge)
A		Tighten to 22-34 N·m (17-25 Lb-Ft)

**Hood Bumpers**

Hood bumpers, located on the top RH and top LH surfaces of the radiator support, can be adjusted up and down to provide a flush surface alignment of the hood panel with the front fenders as follows:

1. Loosen hood bumper locknut.

2. Screw hood bumper in or out, as necessary.
3. Install bumper locknut.

**SPECIFICATIONS****TORQUE SPECIFICATIONS**

Description	N·m	Lb-Ft
Hood Pivot Nut	22-34	17-25
Hinge-to-Body Retaining Bolts	22-34	17-25
Hinge-to-Hood Retaining Bolts	22-34	17-25
Battery Tray Screws	8-12	6-9
Battery Hold Down Brace Nut	10-16	7-12
Stone Deflector Screws	5.3-7.1	4-5
Stone Deflector Nuts	4.5-6.9	3-5

# SECTION 01-03 Doors, Deck Lid and Liftgate

SUBJECT	PAGE	SUBJECT	PAGE
<b>ADJUSTMENTS</b>		<b>REMOVAL AND INSTALLATION (Cont'd.)</b>	
Door Alignment.....	01-03-8	Doors.....	01-03-2
Hinge, Liftgate.....	01-03-9	Hinge.....	01-03-2
Luggage Compartment Deck Lid.....	01-03-8	Hinge, Liftgate.....	01-03-6
Torsion Bar Loading.....	01-03-9	Liftgate.....	01-03-6
Torsion Bar, Deck Lid Hinge.....	01-03-8	Luggage Compartment Deck Lid.....	01-03-6
<b>DESCRIPTION</b>		Luggage Compartment Deck Lid Weatherstrip.....	01-03-6 01-03-6
Deck Lid Hinges—Lubricant.....	01-03-1	Weatherstrips.....	01-03-4
Door and Roof Rail Weatherstrip Lubricant.....	01-03-1	<b>SPECIAL SERVICE TOOLS</b> .....	01-03-9
Door Hinge.....	01-03-1	<b>SPECIFICATIONS</b> .....	01-03-9
<b>REMOVAL AND INSTALLATION</b>		<b>VEHICLE APPLICATION</b> .....	01-03-1
Door Hinge Check.....	01-03-4		

## VEHICLE APPLICATION

Taurus / Sable.

## DESCRIPTION

### Door and Roof Rail Weatherstrip Lubricant

Silicone Lubricant C0AZ-19553-AA (Jelly) and D7AZ-19553-AA (Spray) (ESR-M13P4-A)

Use this lubricant on the door and window weatherstrips. It is recommended that silicone lubricant be applied to the weatherstrips whenever necessary. Silicone lubricant helps avoid weatherstrip squeaks and retards excess weatherstrip wear from chafing between the door glass upper frame and the weatherstrip. It also helps to retain door window alignment by reducing friction between the glass frame and the rubber weatherstrip.

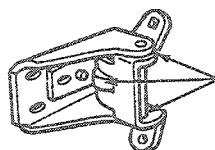
### Deck Lid Hinges—Lubricant

Multi-Purpose Grease Spray D7AZ-19584-AA (ESR-M1C159-A and ESB-M1C93-A)

Use this lubricant on deck lid hinges. Apply evenly to all movable hinge surfaces when a binding condition occurs.

### Door Hinge

Use Multi-Purpose Grease Spray D7AZ-19584-AA (ESR-M1C159-A and ESB-M1C93-A) or equivalent to lubricate door hinges.



LUBRICATE  
BUSHINGS  
AND ROLLER  
PIN

N6585-B

## REMOVAL AND INSTALLATION

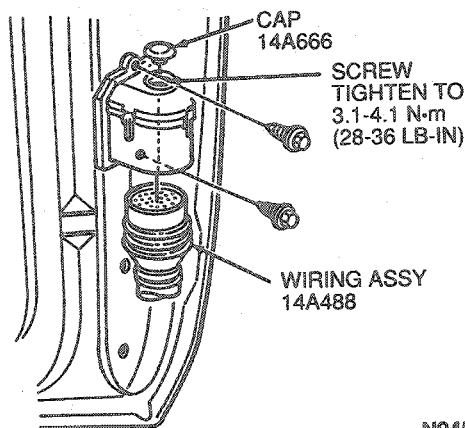
### Doors

#### Tools Required:

- Rotunda Door Rack 103-00027

#### Removal

1. Support door using Rotunda Door Rack 103-00027 or equivalent for door service.
2. Remove hinge retaining bolts and nuts from door and remove door.
3. Disconnect wiring harness connector to door, if so equipped by removing trim cap, loosening screw and separating connector halves.
4. If door is to be replaced, transfer the following components to the new door if in usable condition: trim panel, watershield, outside mouldings, clips, window regulators and door latch components.



N9458-A

#### Installation

1. Position door hinges and partially tighten bolts.
2. Align door and tighten bolts to 25-35 N·m (18-26 lb-ft).
3. If disconnected, connect electrical connector. Tighten screw to 3.1-4.1 N·m (28-36 lb-in). Install trim cap.

### Hinge

#### Door, Front

#### Removal

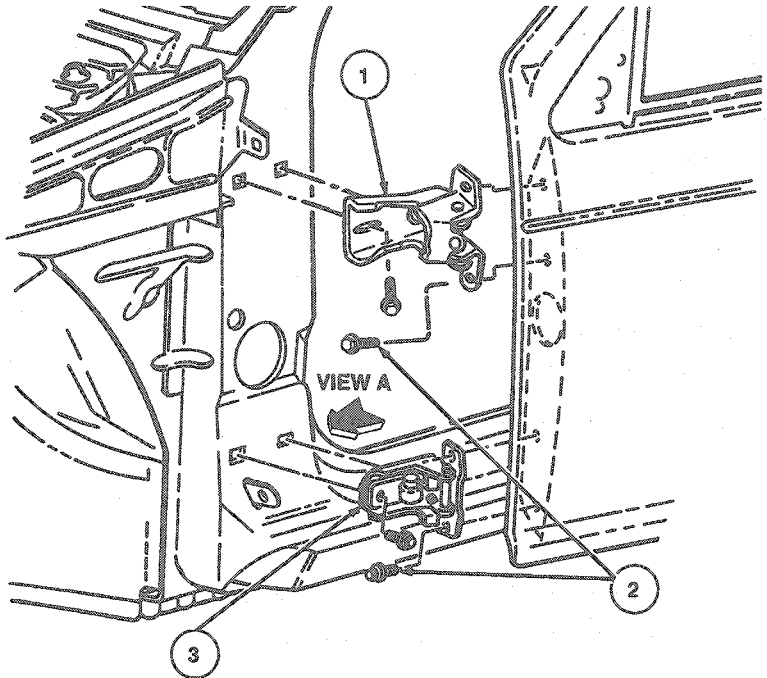
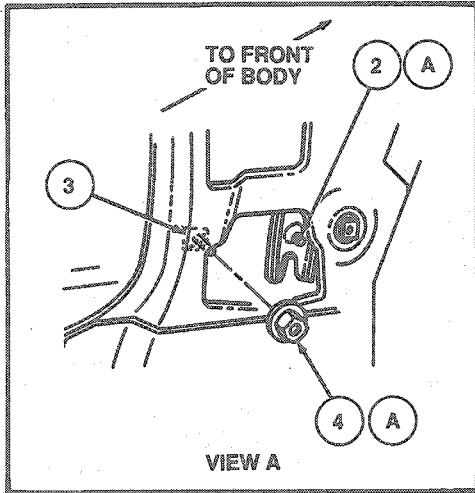
1. Open door and support it with Rotunda Door Rack 103-00027 or equivalent for door service.

2. Scribe hinge location to door.
3. Remove two washer head bolts retaining hinge to door.
4. Move door stand so that door is far enough away from body to allow access to hinge bolts on pillar.
5. Remove cowl side trim panel. Refer to Section 01-05.
6. **RH Door and LH Door, Lower:** Push insulator aside and remove lower nut and washer.
7. **RH Door, Upper:** Open glove compartment. Press sides of glove compartment bin to clear instrument panel stops and lower glove compartment door and bin. Reaching through glove compartment opening, bend sound absorber down from 8mm hinge nut and washer and remove nut and washer.
8. **LH Door, Upper:** Remove steering column opening cover. Refer to Section 01-12. Reaching through cover opening, bend sound absorber down from pillar access hole. Use ratchet extension and 8mm universal socket to loosen hinge nut and washer and remove nut and washer.
9. From outside vehicle, remove upper and lower hinge-to-body retaining screws. Remove hinges.  
**CAUTION: Take care not to damage painted surface when removing and installing hinge-to-body retaining screws.**

#### Installation

1. Install upper and lower hinge-to-body retaining bolts. Tighten to 25-35 N·m (18-26 lb-ft).
2. Install upper and lower hinge nuts and washers. Tighten to 25-35 N·m (18-26 lb-ft). Install sound absorbers.
3. Position door to hinges and install four washer head screws retaining hinges to door. Tighten to 25-35 N·m (18-26 lb-ft).
4. **LH Door:** Install steering column opening cover. Refer to Section 01-12.
5. **RH Door:** Install glove compartment.
6. Install cowl side trim panel. Refer to Section 01-05.

REMOVAL AND INSTALLATION (Continued)



N6617-F

Item	Part Number	Description
1	22800	Upper Hinge Assy
2A	N8034 17-S2	Screw (3 Req'd Per Hinge)
3	22806	Lower Hinge Assy
4A	N801193-S2	Nut
A		Tighten to 25-35 N·m (18-26 Lb·Ft)

Door, Rear

Tools Required:

- Rotunda Door Rack 103-00027.

Removal

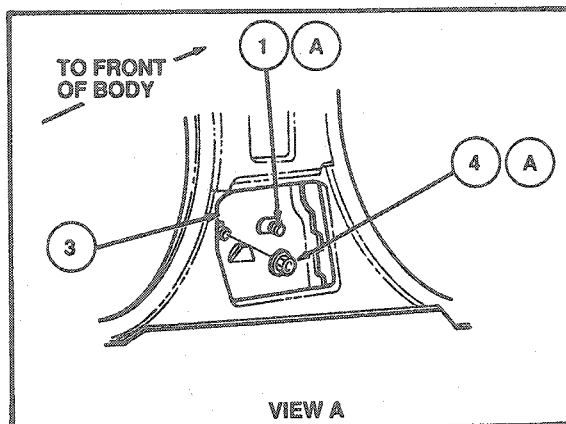
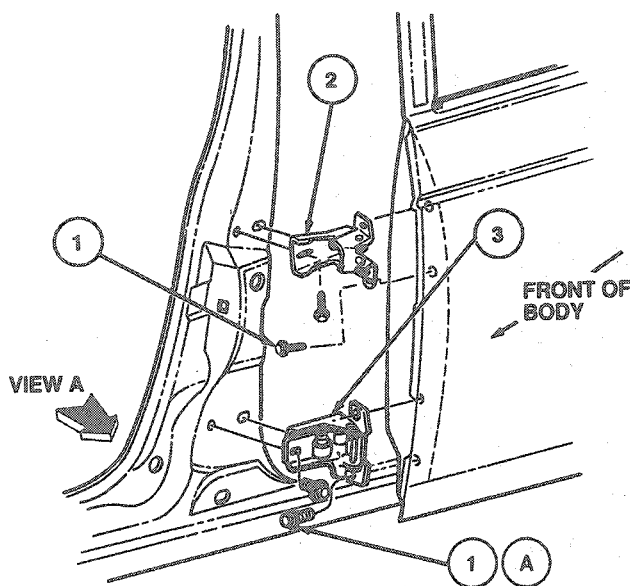
1. Remove scuff plate. Refer to Section 01-05.
2. Remove center pillar trim panel. Refer to Section 01-05.
3. Remove safety belt assembly. Refer to Section 01-20A.
4. Open door and support with Rotunda Door Rack 103-00027 or equivalent for door service.
5. Scribe hinge location to door.
6. Remove upper and lower hinge-to-door hinge retaining washer head bolts.
7. Remove upper and lower hinge-to-body retaining bolts.

8. Remove upper and lower hinge-to-body bolt and washer assemblies. Remove hinges.

Installation

1. Install upper and lower hinge-to-body retaining bolts. Tighten to 25-35 N·m (18-26 lb-ft).
2. Install upper and lower hinge-to-body retaining bolts. Tighten to 25-35 N·m (18-26 lb-ft).
3. Position door to hinges and install upper and lower retaining washer head bolts. Tighten to 25-35 N·m (18-26 lb-ft).
4. Install safety belt assembly. Refer to Section 01-20A.
5. Install center pillar trim panel. Refer to Section 01-05.
6. Install scuff plate. Refer to Section 01-05.

## REMOVAL AND INSTALLATION (Continued)



N6618-E

Item	Part Number	Description
1A	N803417-S2	Bolt
2	26800	Upper Hinge Assy
3	26866	Lower Hinge Assy
4A	N801193-S2	Nut
A		Tighten to 25-35 N-m (18-26 Lb-Ft)

**Door Hinge Check**

**NOTE:** The front door hinge check can be serviced without removing the complete hinge assembly. Perform the following procedure:

**Removal**

1. Open front door with broken hinge check.
2. Remove exposed hinge-to-body retaining bolt and retain.
3. Insert a chisel, 267mm (10-1/2 inches) long with a 19mm (3/4 inch) cutting blade, between hinge half on body and back side of hinge check. Hammer until chisel unseats rivet securing hinge check-to-body side hinge.
4. Remove broken hinge check and discard.

**Installation**

1. Loosely place new door check and elastomer reinforcement into body door hinge.
2. Install hinge-to-body retaining bolt to secure new hinge check and reinforcement-to-body side hinge. Tighten bolt to 25-35 N-m (18-26 lb-ft).

**Weatherstrips****Removal**

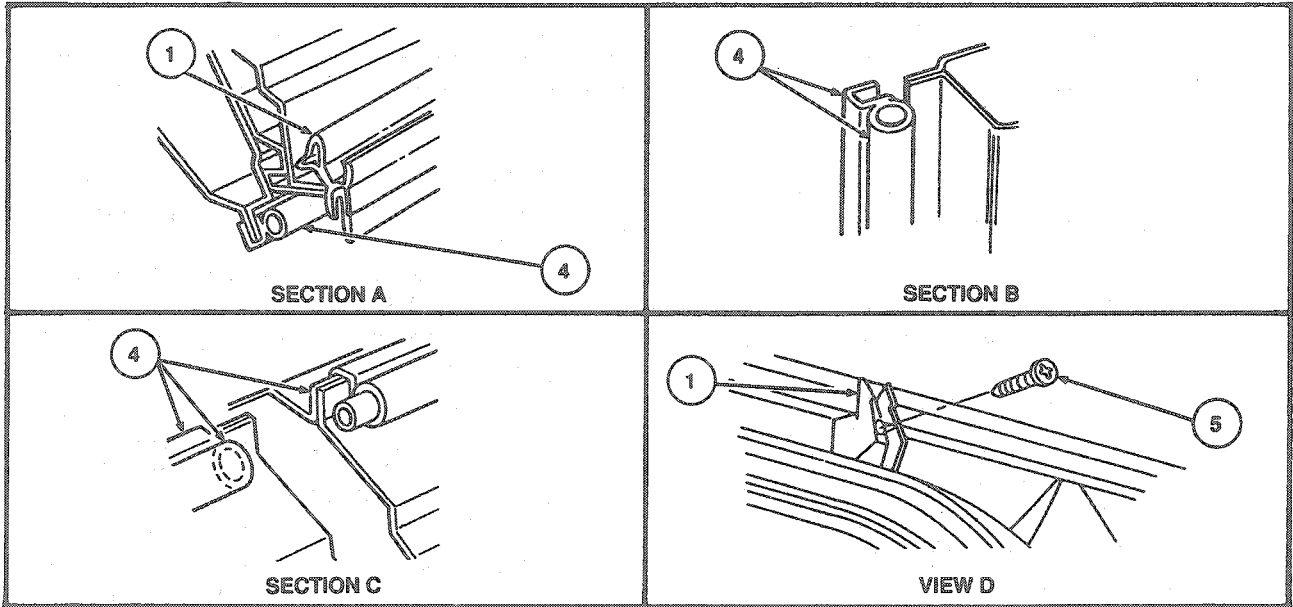
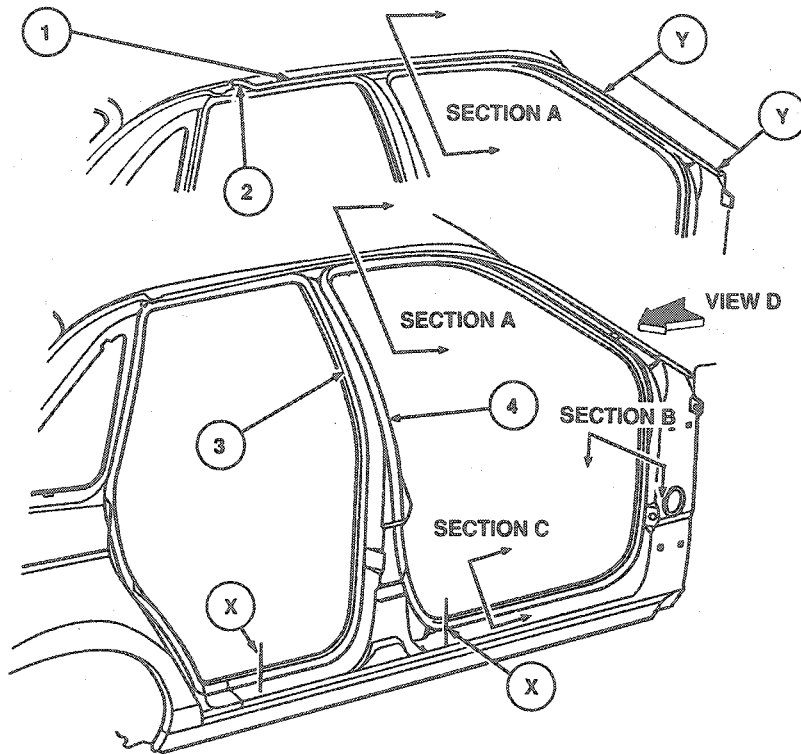
1. Remove interior garnish mouldings that cover weatherstrip.
2. Remove one weatherstrip retaining screw at base of A-pillar.
3. Pull weatherstrip off weld flange around door opening.

**Installation**

1. Inspect weatherstrip mounting flange for distortion. Flatten any distortions by using vise grips or pair of hammers.
2. Begin installation at point X as shown.
3. Continue installing weatherstrip around door opening. Weatherstrip must not be stretched during installation.
4. Cut weatherstrip approximately 6.35-12.7mm (1/4-1/2 inch) longer than needed and butt ends together.
5. Install retaining screw on A-pillar.
6. Install garnish mouldings. Refer to Section 01-05.

**NOTE:** Add a dab of Instant Adhesive E8AZ-19554-A (WSK-M2G402-A4 or 414) or equivalent to secure end of weatherstrip (except Sable sedan).

REMOVAL AND INSTALLATION (Continued)



N6560-E

Item	Part Number	Description
1	5 1222	Door Opening Weatherstrip Upper
2	ESA-M2G140-A 1	Adhesive
3	253A 10	Door Weatherstrip
4	20708	Door Weatherstrip
5	55927-S55	Screw (1 Req'd Each Side)



## REMOVAL AND INSTALLATION (Continued)

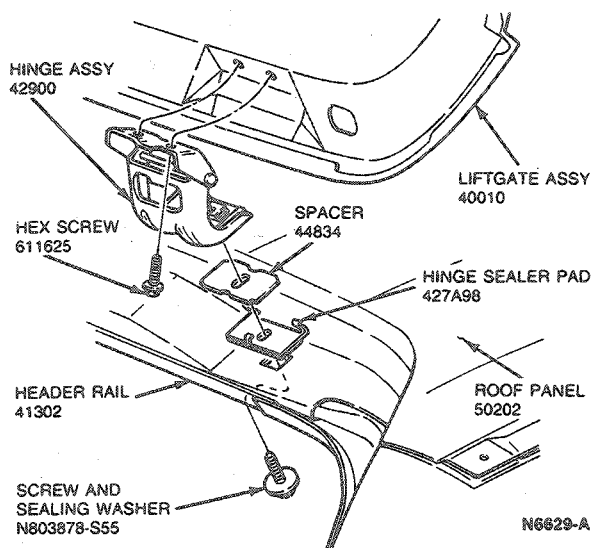
### Hinge, Liftgate

#### Removal

1. Open liftgate assembly.
2. Remove weatherstrip along top of liftgate opening and remove headlining covering retaining screw.
3. Support liftgate in an open position and remove support cylinder as outlined.
4. Remove hinge-to-roof frame retaining screw and washer assembly.
5. Remove hinge-to-liftgate retaining bolts, and remove hinge assembly from liftgate.

#### Installation

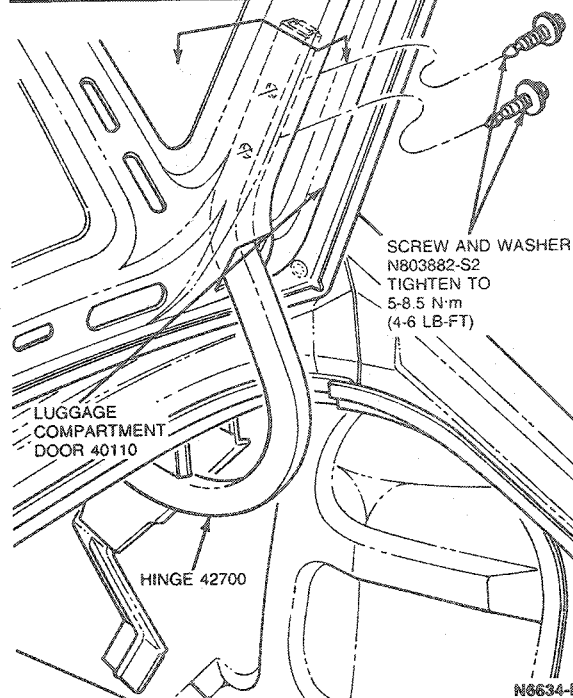
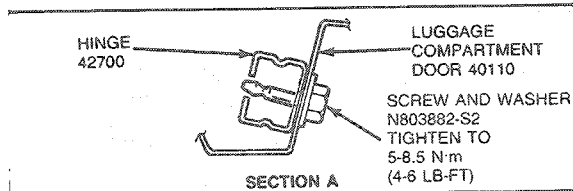
1. To install, reverse Steps 1 through 5. Seal the hinge to body with Ford Clear Silicone Rubber Sealer D6AZ-19562-AA (ESB-M4G92-A) or equivalent.
2. Tighten the hinge-to-roof frame screw and washer assembly to 17-27 N·m (13-19 lb-ft).
3. Tighten the hinge-to-liftgate screws to 7-11 N·m (5-8 lb-ft).



### Luggage Compartment Deck Lid

#### Removal and Installation

1. Remove four hinge-to-deck lid screws and remove deck lid.  
NOTE: Removal of the deck lid is a two-person operation.
2. To install, position deck lid to hinges and install four hinge-to-deck lid retaining screws. Tighten to 5-8.5 N·m (4-6 lb-ft)
3. Adjust as outlined.



### Liftgate

#### Removal and Installation

Before removing hinge-to-roof frame attachments at both hinges, scribe the location of each hinge on roof frame.

Remove hinge-to-roof frame screw and washer assembly at each hinge as outlined. Remove liftgate from vehicle.

To install, position hinges to scribe marks on roof frame and reverse the removal procedure. Tighten hinge-to-roof frame screw and washer assemblies to 5-7 N·m (45-61 lb-in).

NOTE: Liftgate removal and installation is a two-man operation.

### Luggage Compartment Deck Lid Weatherstrip

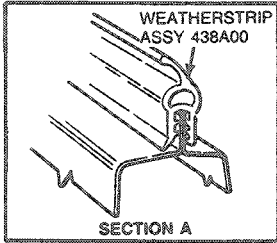
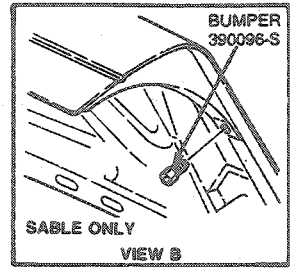
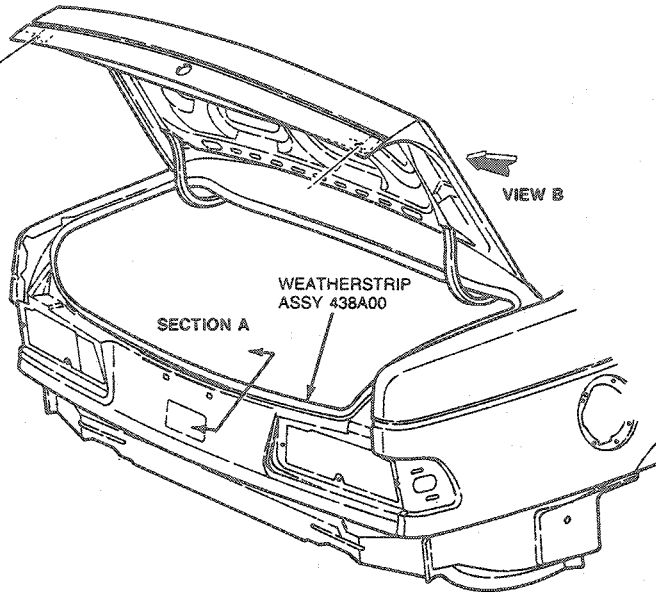
Weatherstrips are mechanically retained. No adhesive is required for retention.

NOTE: The weatherstrip may contain a stringy sealer which can stick to the flange when removed. The luggage compartment carpeting should be covered to protect it from contacting the sealer.

REMOVAL AND INSTALLATION (Continued)

Sedan

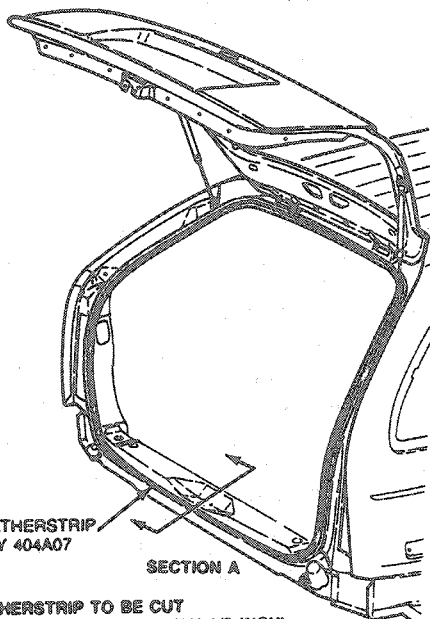
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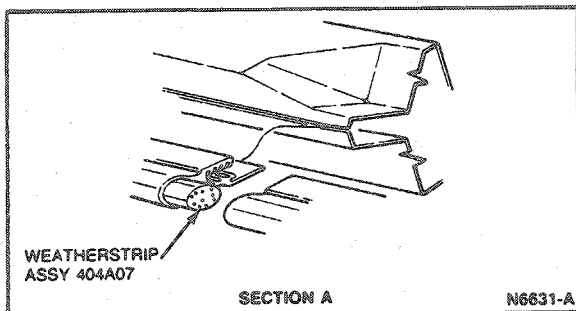
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## REMOVAL AND INSTALLATION (Continued)

## Wagon

WEATHERSTRIP  
ASSY 404A07

SECTION A

WEATHERSTRIP TO BE CUT  
APPROXIMATELY 6-12mm (1/4-1/2 INCH)  
LONGER THAN REQ'D AND BUTT  
TOGETHER, AVOID OVERLAPPINGWEATHERSTRIP  
ASSY 404A07

SECTION A

N6631-A

## ADJUSTMENTS

Refer to the illustrations under Removal and Installation while performing the following adjustments.

## Door Alignment

**NOTE:** Do not cover up a poor door alignment with a latch striker adjustment.

The door hinges provide sufficient adjustment to correct most door misalignment conditions. The holes of the hinge and / or the hinge attaching points are enlarged or elongated to provide for hinge and door alignment.

## Side Doors

1. Determine which hinge screws and nuts must be loosened to move door in desired direction.

2. Loosen hinge screws and nuts just enough to permit movement of door with padded pry bar.
3. Move door the estimated necessary distance. Tighten hinge screws and nuts to 25-35 N·m (18-26 lb-ft) and check door fit to ensure there is no bind or interference with adjacent panel.
4. Repeat operation until desired fit is obtained. Check striker plate alignment for proper door closing.

When performing the following adjustment procedures, refer to the appropriate illustration under Removal and Installation for component location and assembly.

## Luggage Compartment Deck Lid

## Sedan

The luggage compartment deck lid can be shifted fore-and-aft and from side-to-side on all models.

The luggage compartment deck lid should be adjusted for an even and parallel fit with the deck lid opening. The door should also be adjusted up and down for a flush fit with the surrounding panels. Care should be taken not to damage the luggage compartment deck lid or surrounding body panel.

Fore-and-aft and up-and-down adjustment of the deck lid is achieved by loosening the hinge-to-deck lid retaining screws, shifting the deck lid to the proper fit and tightening the retaining screws to 9-14 N·m (7-10 lb-ft).

## Torsion Bar, Deck Lid Hinge

1. Open the luggage compartment deck lid and note the pop-up distance of the deck lid. The deck lid should have adequate finger clearance.
2. If the deck lid does not have adequate finger clearance, the torsion bar tension should be increased.
3. If the deck lid pops open with more force than is desired, the torsion bar tension can be decreased.

**WARNING: USE CARE WHEN ADJUSTING THE TORSION BAR AS IT IS UNDER TENSION AND COULD SPRING OUT OF CONTROL IF NOT HANDLED PROPERLY.**

4. Support the deck lid in the full open position before adjusting the torsion bar.
5. To adjust a torsion bar, use a suitable tool designed to safely perform the adjustment shown under Torsion Bar Loading. Move the torsion bar end to another position (notch) to increase or decrease the tension.
6. Adjust one torsion bar and check the adjustment before adjusting the other torsion bar.

**ADJUSTMENTS (Continued)**

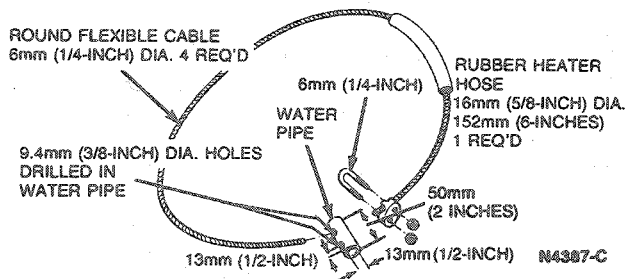
7. After torsion bar adjustment, the difference of the position of the torsion bar ends, between the RH and LH side, must not be more than one slot.

8. Using a 3/8-inch drive, 1/2-inch deep well socket and 6-inch extension, position the socket over the end of the torsion bar and lift to unlock the bar. Reposition the torsion bar up the hinge support to the top notch and release.

**Torsion Bar Loading**

**Sedan**

1. Locally obtain the following materials:
  - a. Round flexible cable; 6mm (1/4 inch) diameter by 1.2m (4 feet) long
  - b. One 6mm (1/4 inch) cable clamp
  - c. Water pipe: 13mm (1/2 inch) diameter by 50mm (2 inches) long
  - d. Rubber heater hose: 16mm (5/8 inch) diameter by 152mm (6 inches) long
2. Assemble materials above as shown.



**WARNING: SAFETY GLASSES MUST BE WORN WHEN PERFORMING THIS OPERATION.**

3. Install the torsion bar by inserting one end into the hole provided in the luggage compartment deck lid hinge and nest the other end into the upper groove of the opposite hinge support.
4. Position the handmade tool on the end of the torsion bar to be loaded.
5. With the help of an assistant, place a long flat-blade screwdriver over the top of the torsion bar to be loaded.
6. While pulling on the torsion bar with the tool, with the assistant holding the screwdriver, guide the torsion bar down along the rear edge of the support into the lower groove of the hinge support so the torsion bar can be locked in the lowest outboard adjustment notch.
7. Using the handmade tool, install the tool on the end of the torsion bar (if not already installed) and unlock the bar by pulling with the tool and work the torsion bar up the hinge support to the second notch and release. If further adjustment is required, proceed to Step 8.

**Hinge, Liftgate**

On wagon models, the liftgate can be adjusted up-and-down and side-to-side by loosening the header roof frame retaining screw and washer assembly. The liftgate can be adjusted in and out by shimming the hinges at the header roof frame.

The liftgate should be adjusted for an even parallel fit with liftgate opening and surrounding panels.

To adjust a hinge or hinges remove the weatherstrip and pull down headliner to gain access to the hinge attachment(s). Adjust the hinge(s) as necessary. Seal the hinge to body with Ford Clear Silicone Rubber Sealer D6AZ-19562-AA (ESB-M4692-A) or equivalent. Install headliner back into position and install weatherstrip.

**SPECIFICATIONS**

**TORQUE SPECIFICATIONS**

Description	N-m	Lb-Ft
Hinge Retaining Bolts / Nuts	25-35	18-26
Liftgate Hinge to Roof Screws	5-7	45-61 (Lb-In)
Hinge-to-Deck Lid Screws	9-14	7-10
Hinge-to-Roof Frame Screws	17-27	13-19
Hinge-to-Liftgate Screws	7-11	5-8
Deck Lid Retaining Screws	5-8.5	4-6

**SPECIAL SERVICE TOOLS**

**ROTUNDA EQUIPMENT**

Model	Description
103-00027	Door Rack