SECTION 01-19 Bumpers

VEHICLE APPLICATION

Taurus / Sable.

REMOVAL AND INSTALLATION

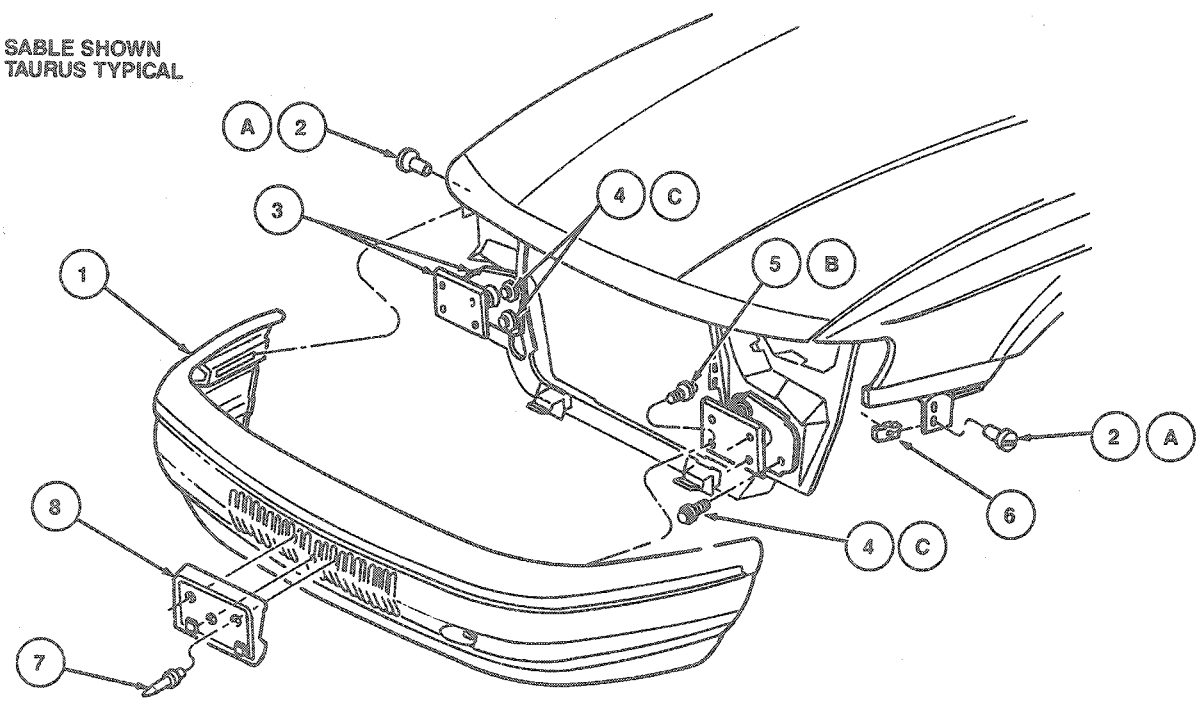
Refer to the following illustrations when performing Removal and Installation procedures on the front and rear bumper assemblies.

CAUTION: Never apply excessive heat to bumper surface. Heat could cause distortion of the bumper.

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

Bumper, Front
Taurus / Sable Except SHO

SABLE SHOWN
TAURUS TYPICAL



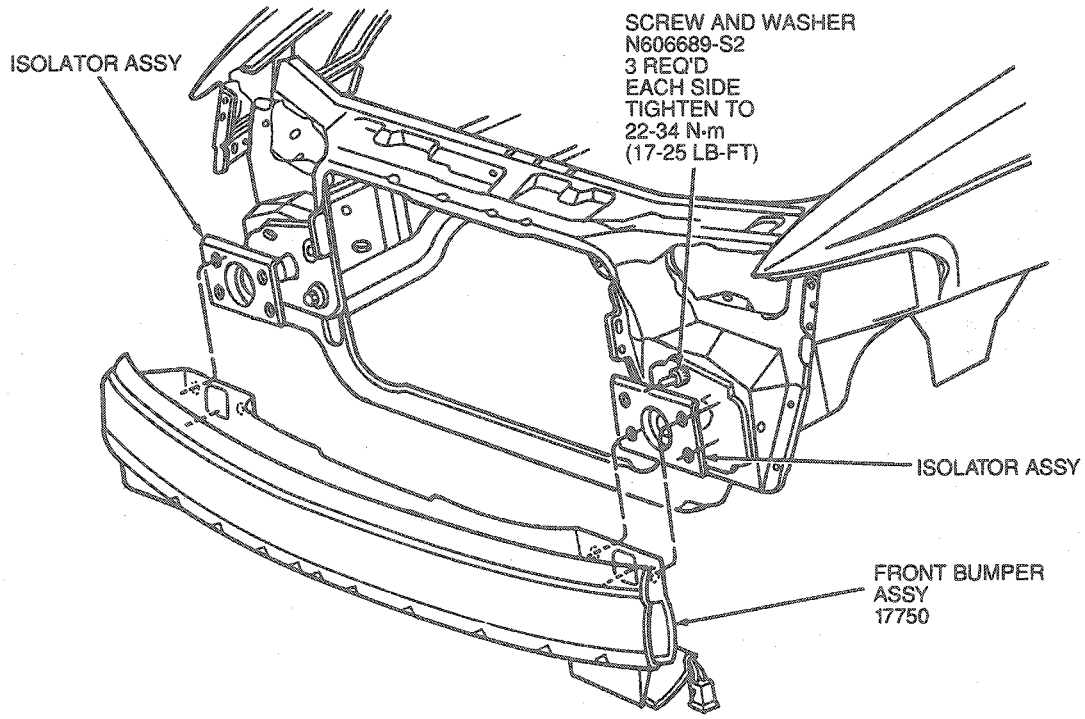
N9263-B

REMOVAL AND INSTALLATION (Continued)

Item	Part Number	Description
1	17750	Front Bumper Assy
2A	N804984-S100	Screw and Washer (1 Req'd Each Side)
3	17D809	Isolator and Bracket Assy
4C	N606689-S2	Screw and Washer Assy (3 Req'd Each Isolator)
5B	N805433-S54	Screw and Washer (3 Req'd Each Side)

(Continued)

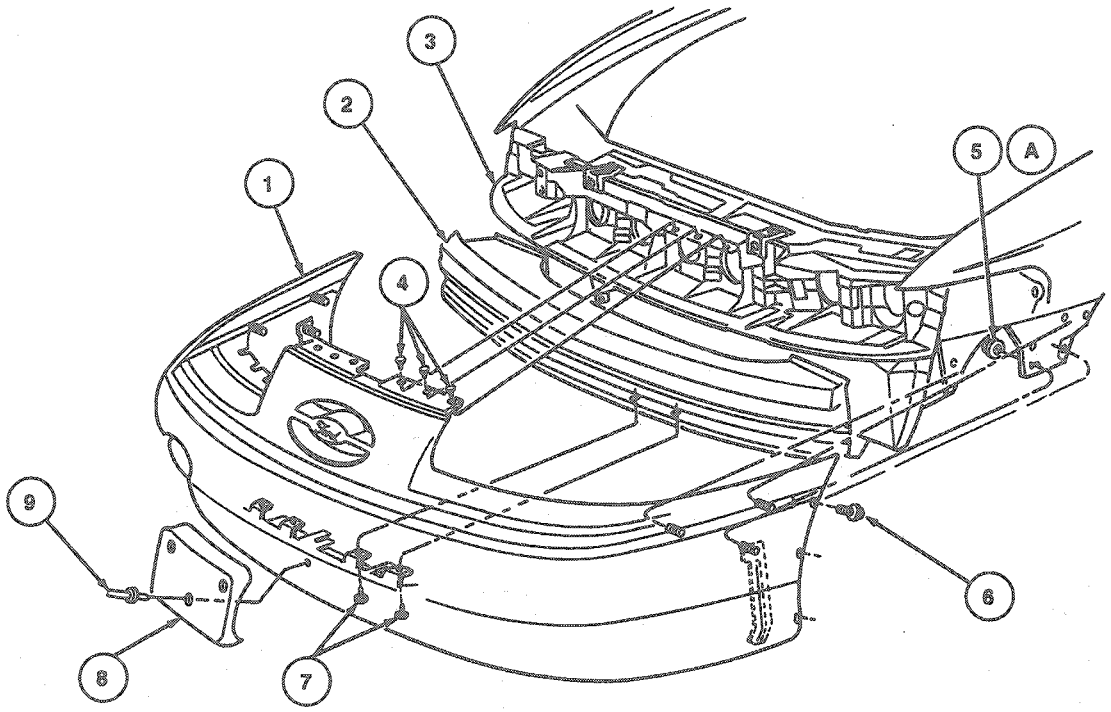
Item	Part Number	Description
6	N800538-S101	U-Nut (1 Req'd Each Side)
7	N805150-S	Rivet (3 Req'd) (Sable)
8	17N397	Bracket Assy (Sable)
A		Tighten to 9-21 N·m (7-15 Lb-Ft)
B		Tighten to 22-34 N·m (17-25 Lb-Ft)
C		Tighten to 17-27 N·m (13-19 Lb-Ft)



N9264-A

REMOVAL AND INSTALLATION (Continued)

Taurus SHO



N9265-A

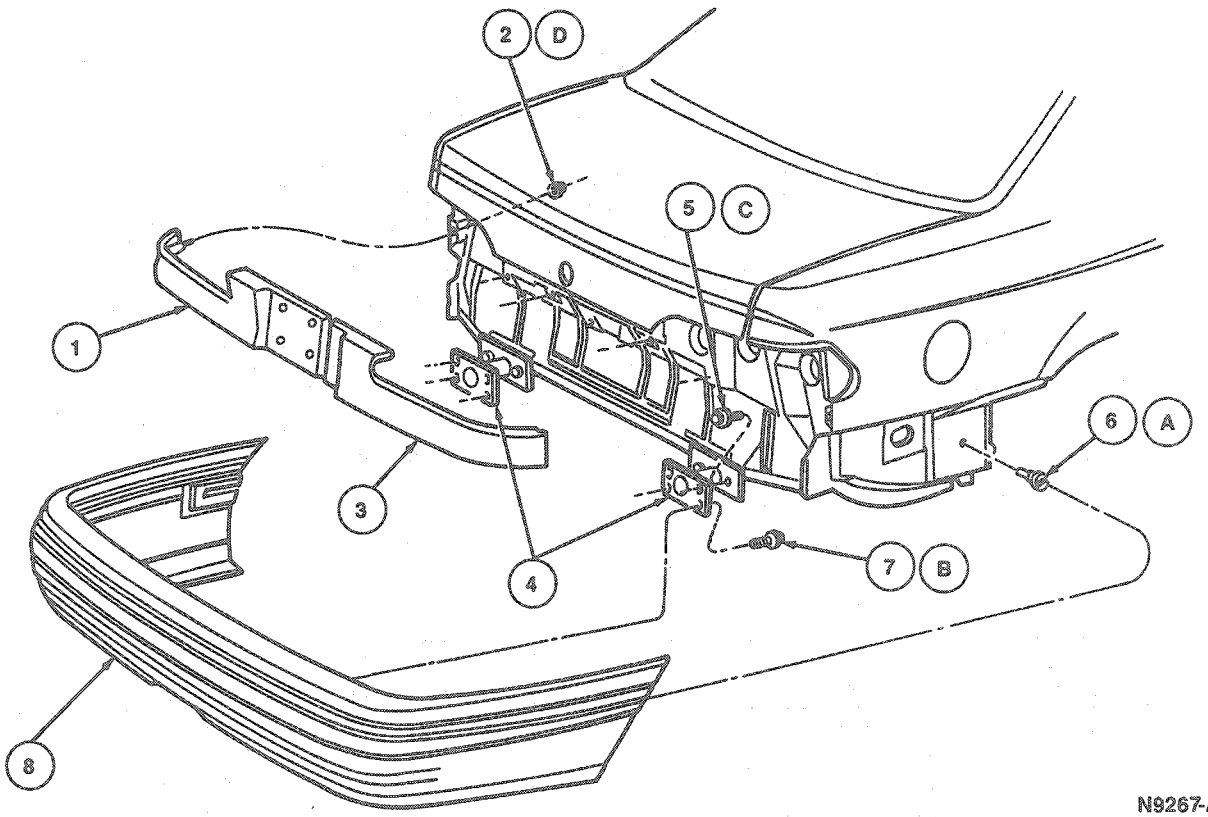
Item	Part Number	Description
1	17D957	Front Bumper Cover
2	17750	Front Bumper Assy
3	8A164	Grille Opening Reinforcement
4	388577-S	Push Pin (3 Req'd Each Side)
5A	N621906-S36	Nut and Washer (2 Req'd Each Side)

(Continued)

Item	Part Number	Description
6	388577-S	Push Pin (1 Req'd Each Side)
7	388577-S	Push Pin (2 Req'd Each Side)
8	17A385	Front License Plate Bracket
9	N803043-S	Rivet (3 Req'd)
A		Tighten to 4.5-6.9 N·m (40-61 Lb-in)

REMOVAL AND INSTALLATION (Continued)

Bumper, Rear—Sedan
Taurus



N9267-A

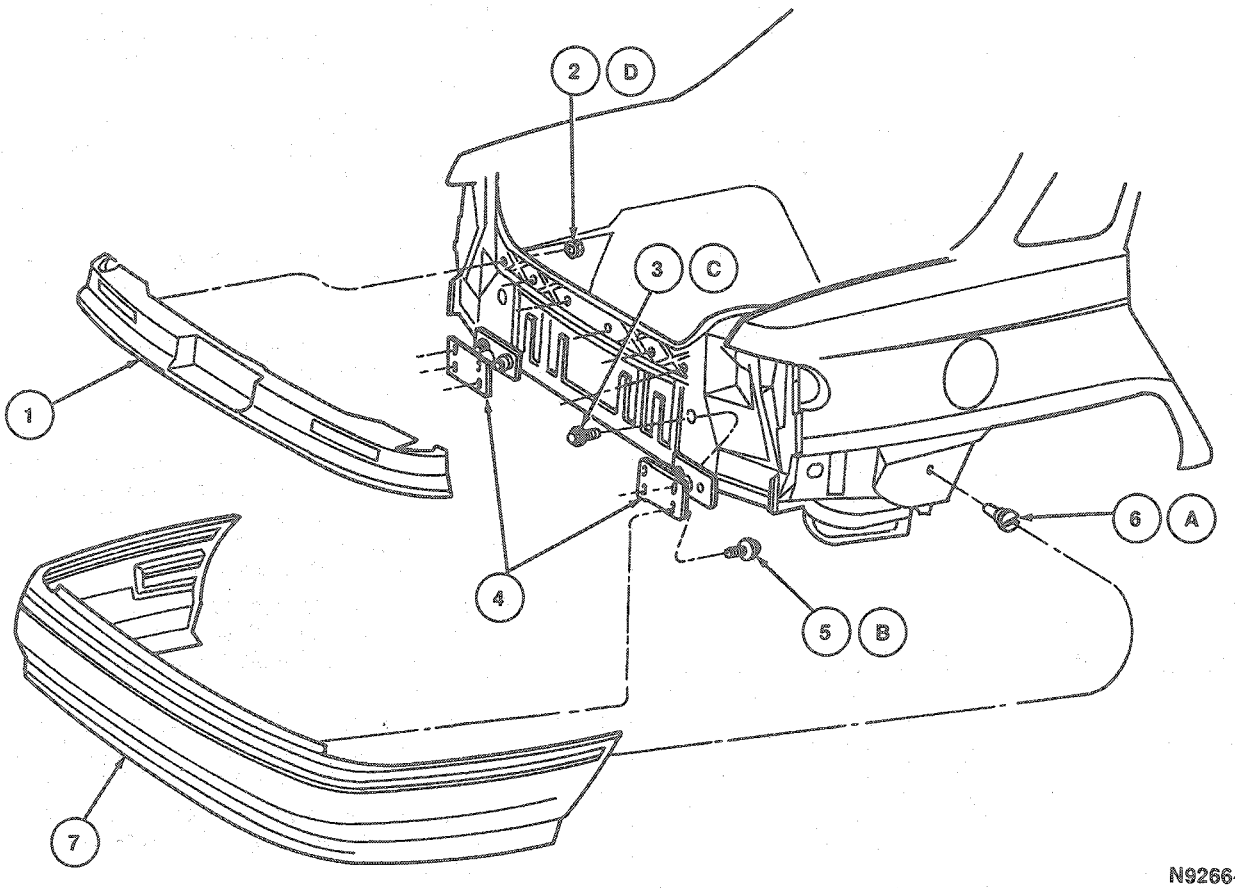
Item	Part Number	Description
1	42A341	LH Lower Back Finish Panel Assy
2D	N621926-S36	Nut and Washer (10 Req'd)
3	42A340	RH Lower Back Finish Panel Assy
4	17D788 (RH) 17D864 (LH)	Isolator and Bracket Assy
5C	N606702-S2	Screw and Washer (2 Req'd Each Side)
6A	N804984-S100	Screw and Washer (1 Req'd Each Side)

(Continued)

Item	Part Number	Description
7B	N805433-S54	Screw and Washer (3 Req'd Each Side)
8	17775 17D780	Rear Bumper Assy Bumper and Cover Assy (Taurus SHO)
A		Tighten to 9.5-15 N·m (8-11 Lb-Ft)
B		Tighten to 22-34 N·m (16-25 Lb-Ft)
C		Tighten to 35-55 N·m (26-40 Lb-Ft)
D		Tighten to 9-14 N·m (7-10 Lb-Ft)

REMOVAL AND INSTALLATION (Continued)

Sable



N9266-A

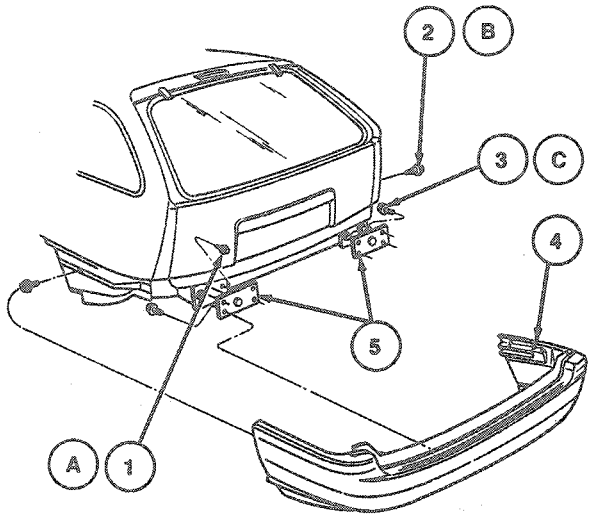
Item	Part Number	Description
1	17805	Deflector Assy
2D	N621926	Nut and Washer Assy (10 Req'd)
3C	N606702-S2	Screw and Washer Assy (2 Req'd)
4	17D788 (RH) 17D864 (LH)	Isolator and Bracket Assy
5B	N805433-S54	Screw and Washer (2 Req'd Each Side)

(Continued)

Item	Part Number	Description
6A	N804984-S100	Screw and Washer (1 Req'd Each Side)
7	17775	Rear Bumper Assy
A		Tighten to 9.5-15 N·m (8-11 Lb-Ft)
B		Tighten to 22-34 N·m (16-25 Lb-Ft)
C		Tighten to 35-55 N·m (26-40 Lb-Ft)
D		Tighten to 9-14 N·m (7-10 Lb-Ft)

REMOVAL AND INSTALLATION (Continued)

Bumper, Rear—Wagon



N6646-E

Item	Part Number	Description
1A	N606702-S2	Screw and Washer Assy (2 Req'd)
2B	N804984-S100	Screw and Washer (1 Req'd Each Side)
3C	N805433-S54	Piloted Screw and Washer (3 Req'd Each Side)
4	17775 AW (Taurus) 17775 BW (Sable)	Rear Bumper Assy
5	17D788 (RH) 17D864 (LH)	Rear Isolator and Bracket Assy
A		Tighten to 35-55 N·m (26-40 Lb-Ft)
B		Tighten to 9.5-15 N·m (8-11 Lb-Ft)
C		Tighten to 22-34 N·m (16-25 Lb-Ft)

Bumper, Front and Rear

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 making body frame service near them.

Removal

1. Remove bolts retaining bumper to isolator and bracket assemblies. Disconnect and remove fog lamps or front cornering lamps, if so equipped. On SHO vehicles, remove front bumper cover assembly as outlined.
2. Slide bumper off screw and washer assemblies mounted on front fender (or quarter panel for rear bumper removal).

Installation

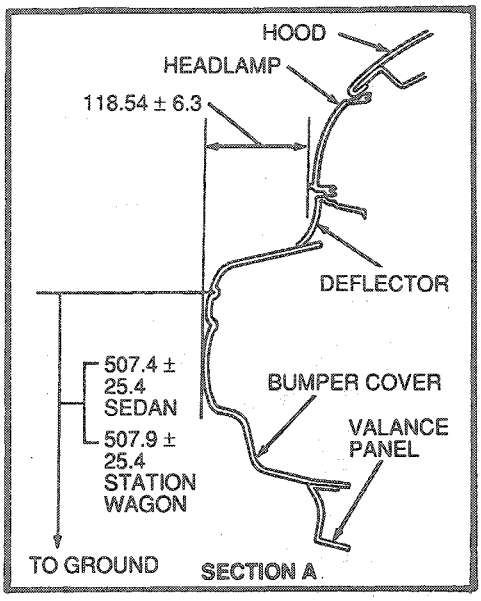
NOTE: Only the attaching hardware shown may be used. Do not substitute any other parts or finishes for those specified.

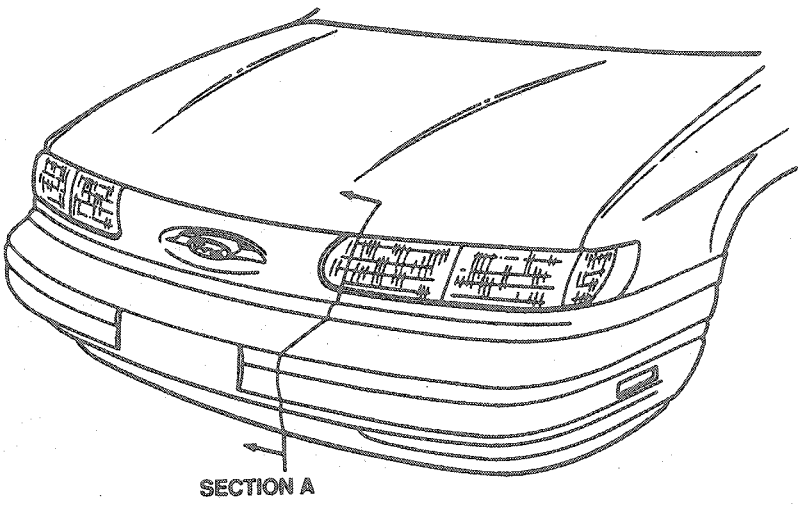
The Taurus valance panel is secured to the front bumper with 10 push pins. The Sable valance panel is secured to the front bumper with eight push pins on the bottom.

1. If the bumper is to be replaced, assemble valance panel for front bumpers and paint new bumper. Assemble step pad and stone deflector for Station Wagon rear bumper. Assemble front cornering lamps, if so equipped.
2. To install Station Wagon rear bumper step pad, starting at center of pad, carefully align attaching tabs to bumper and impact pad surface with rubber mallet.
3. Slide bumper onto screw and washer assemblies mounted on front fender (or quarter panel). Install front cornering lamp sockets, if so equipped.
4. Position bumper to isolators and install retaining bolts. Refer to the following illustrations for Adjustments.
5. Tighten isolator-to-bumper bolts to 22-34 N·m (17-25 lb-ft).

REMOVAL AND INSTALLATION (Continued)

Bumper, Front
Taurus Except SHO

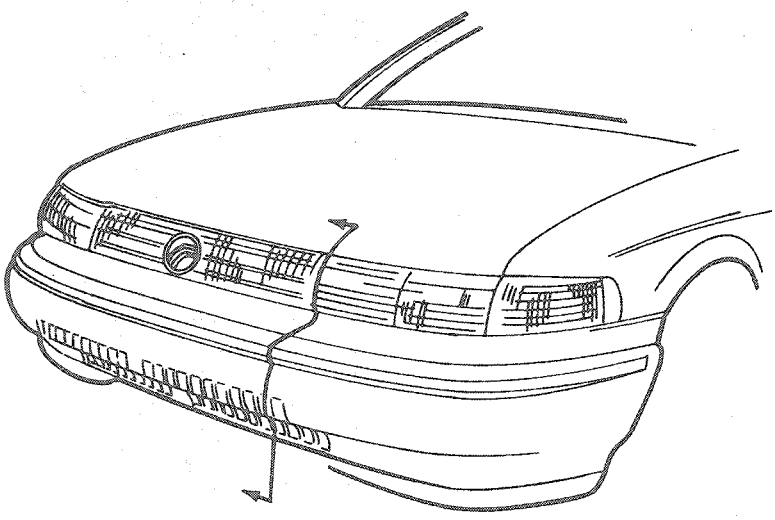


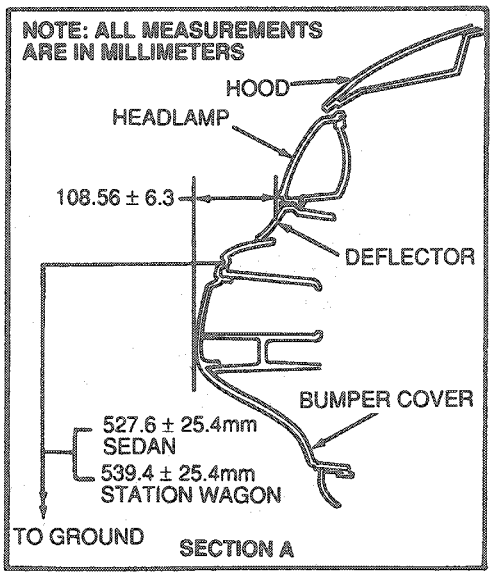


NOTE: ALL MEASUREMENTS ARE IN MILLIMETERS

N9323-B

Sable

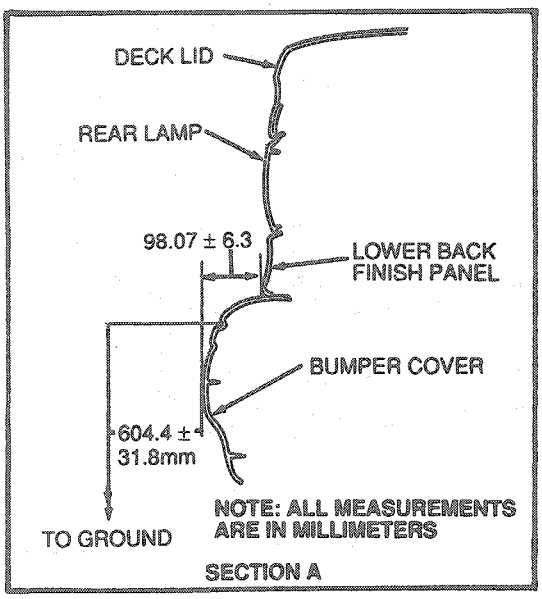


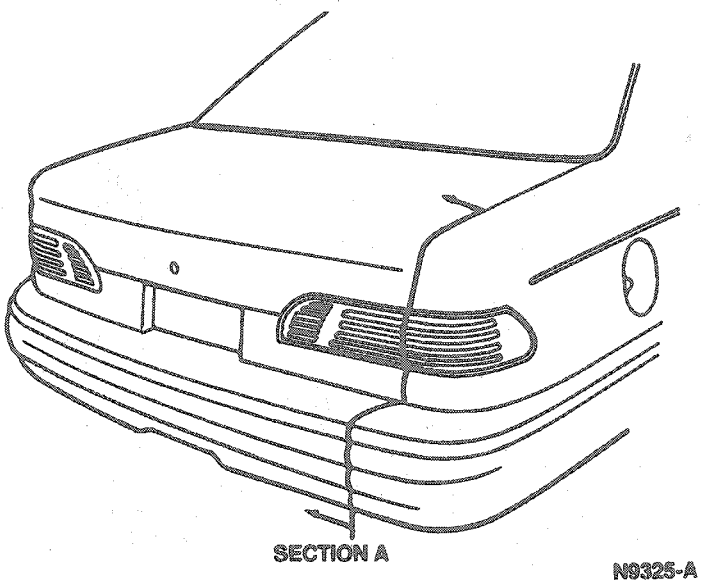


N9324-A

REMOVAL AND INSTALLATION (Continued)

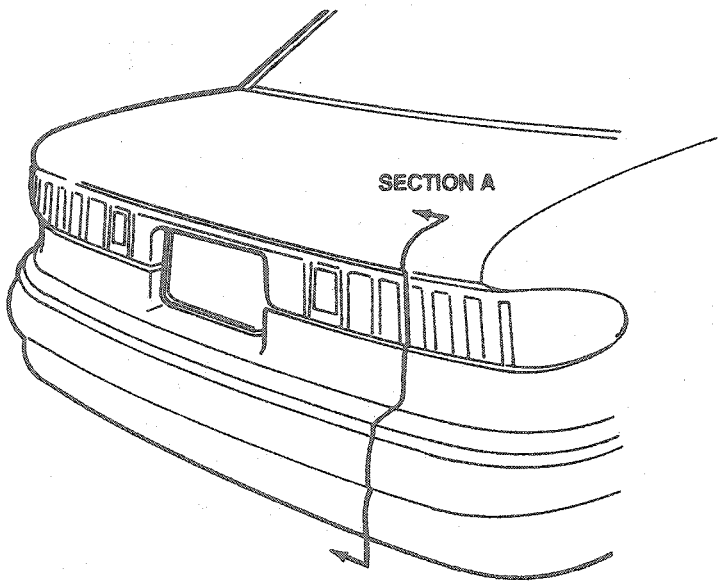
Bumper, Rear
Sedan
Taurus Except SHO

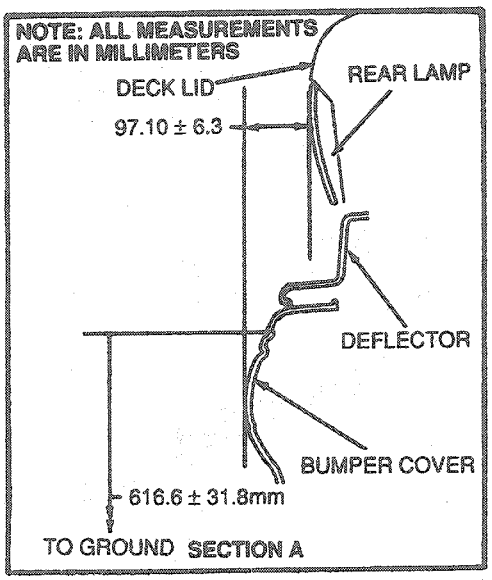




N9325-A

Sable

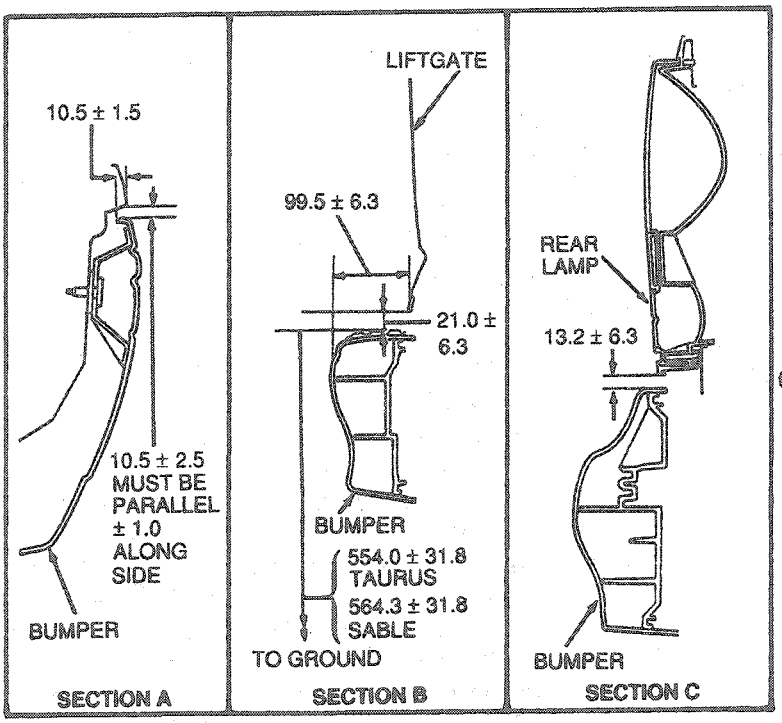




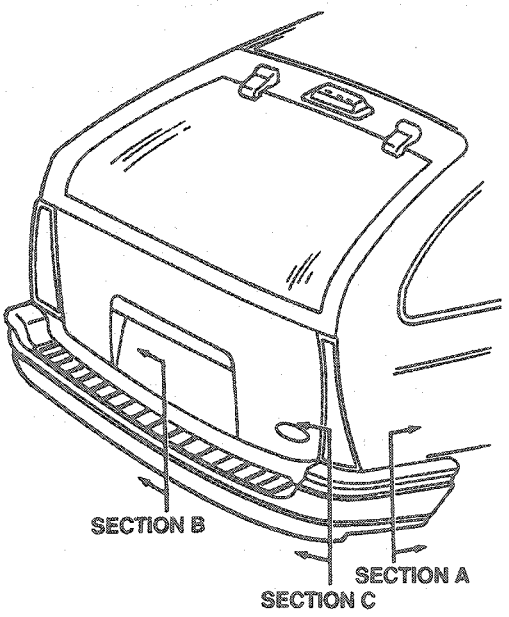
N9326-A

REMOVAL AND INSTALLATION (Continued)

Bumper, Rear
Station Wagon

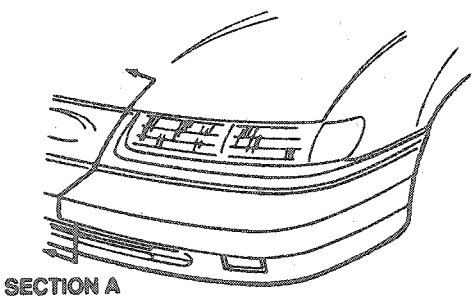


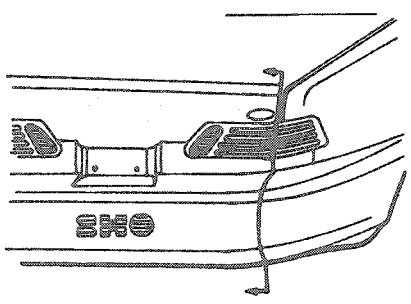
NOTE: ALL MEASUREMENTS ARE IN MILLIMETERS

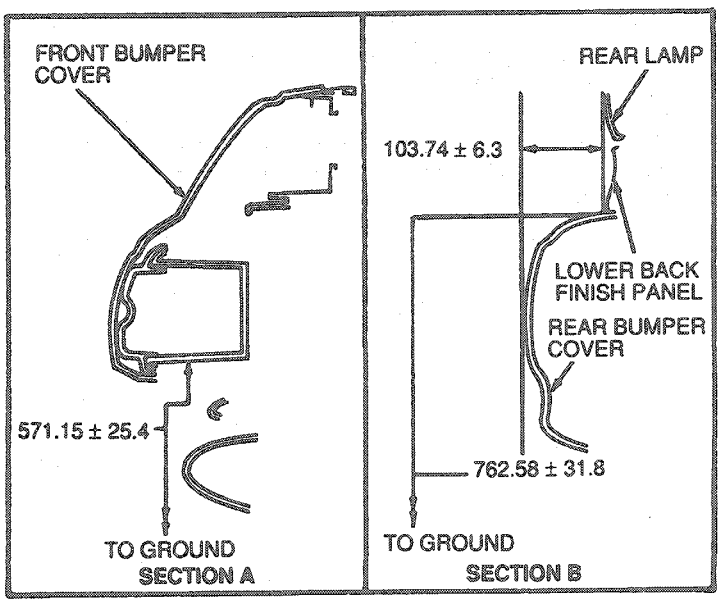


N9327-A

Taurus SHO







NOTE: ALL MEASUREMENTS ARE IN MILLIMETERS

N9328-A

REMOVAL AND INSTALLATION (Continued)

Bumper Isolator and Bracket

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 making body frame service near them.

Refer to the appropriate illustration under Bumper Removal and Installation.

Removal

1. Remove bumper assembly as outlined.
2. To remove front isolator, remove three bolts retaining isolator to body. Remove isolator. To remove rear isolator, remove two bolts attaching isolator to rear frame rails. Remove isolator.

Installation

1. Install isolator and bracket and tighten bolts to 17-27 N·m (13-20 lb-ft) for front isolator. Tighten rear isolator bolts to 35-55 N·m (26-40 lb-ft).
2. Install and adjust bumper assembly as outlined.

Bumper Stone Deflector

Rear

Sedan

Removal and Installation

1. Remove bumper as outlined.
2. From inside luggage compartment, remove ten nuts retaining stone deflector to lower back panel.
3. Carefully pull outboard ends of stone deflector away from quarter panels and move deflector rearward.
4. To install, reverse Removal procedure.

Station Wagon

Removal and Installation

1. Remove bumper assembly as outlined.
2. Remove 11 screws retaining stone deflectors to bumper.
3. To install, reverse Removal procedure.

Bumper Cover

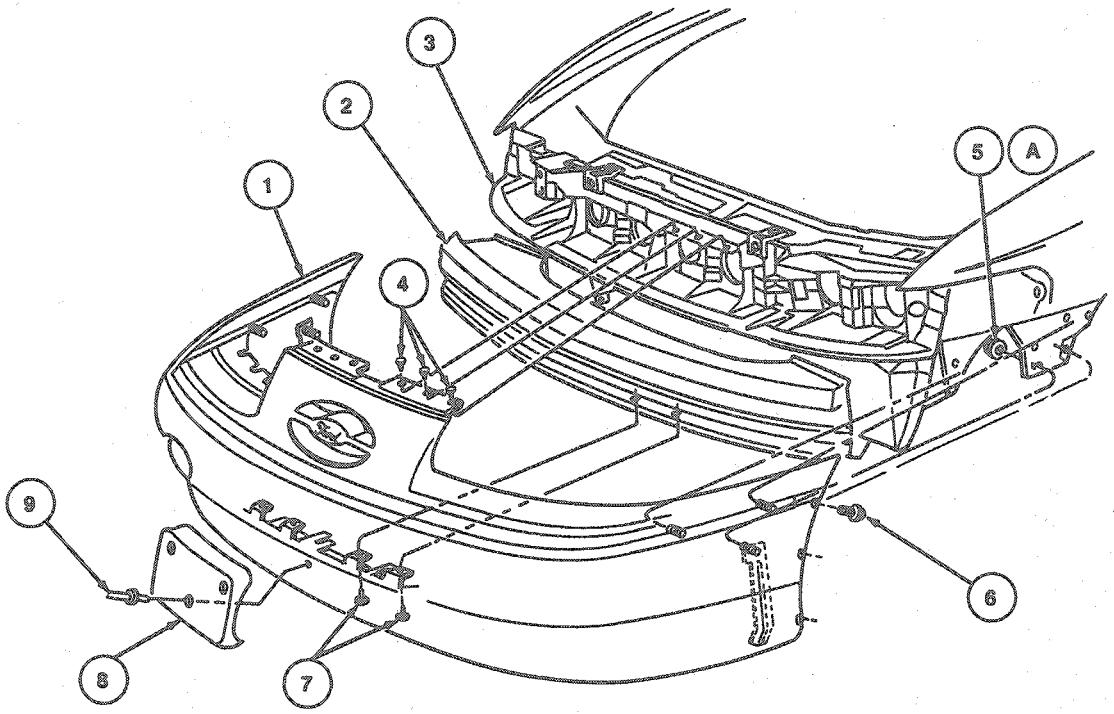
Front

Taurus SHO

Removal and Installation

1. Remove six push pins retaining cover to top of grille opening panel.
2. Remove four push pins retaining cover to bottom of bumper.
3. Remove two push pins (one each side) retaining cover to front fender wheel opening flange.
4. Remove four nuts (two each side) retaining cover to front fenders.
5. Pull ends of cover away from front fenders to clear retaining studs and remove cover.
6. If replacing cover, transfer license plate mounting bracket if so equipped.
7. To install, reverse Removal procedure.

REMOVAL AND INSTALLATION (Continued)



N9265-A

Item	Part Number	Description
1	17D957	Front Bumper Cover
2	—	Front Bumper Assy
3	8A164	Grille Opening Reinforcement
4	388577-S	Push Pin (3 Req'd Each Side)
5A	N621906-S36	Nut and Washer (2 Req'd Each Side)

(Continued)

Item	Part Number	Description
6	388577-S	Push Pin (1 Req'd Each Side)
7	388577-S	Push Pin (2 Req'd Each Side)
8	17A385	Front License Plate Bracket
9	N803043-S	Rivet (3 Req'd)
A		Tighten to 4.5-6.9 N·m (40-61 Lb-In)

Rear

Removal and Installation

1. Remove rear bumper as outlined.
2. Remove 10 push pins retaining cover to backside of bumper.
3. Remove six plastic rivets (three each side) retaining ends of cover to ends of bumper. Use a small diameter punch to knock out center of rivets.
4. To install, reverse Removal procedure.

REPAIR

Plastic Bumper Cover

Taurus SHO

Cuts and cracks to the front or rear bumper cover where substrate material has not been removed can be repaired using Instant Adhesive E8AZ-19554-A (WSK-M2G351-A6), or equivalent. Gouges, tears and holes, where substrate material has been damaged, can be repaired using 3M Structural Adhesive Tube Kit No. 8101, or equivalent. Paint repairs can be made using commercially available flexible paint repair systems.

The following repair procedures can be used for either the front or the rear bumper cover assemblies. The first procedure is for cuts or cracks; the second procedure is for gouges, tears and punctures.

REPAIR (Continued)

Holes as large as approximately 76.2mm (3 inches in diameter can be satisfactorily repaired. The location of the damage must, however, be such that the back-up tape will support the patch properly, and allow the repair to match the original contours of the panel.

Repair Procedure for Cuts or Cracks

1. Wash the repair area with soap and water. Then clean the repair area with solvent such as 3M General Purpose Cleaner or equivalent.
2. Apply a thin coating of Instant Adhesive E8AZ-19554-A (WSK-M2G351-A6), or equivalent to one surface of the cut or crack. Position the surfaces very carefully together in their original position. Quickly and firmly press the two surfaces together for at least one minute. Good bond strength is developed after one minute but maximum strength requires 3 to 12 hours cure time. **Note the precautions on adhesive container.**
3. If the part did not have the paint damaged and the repair was properly positioned, painting may not be required. However, if painting is necessary, proceed as follows:
   a. Scuff-sand the repair area with a sanding block and No. 360 paper. Be careful not to sand through the color coat surface. Usually dulling the surface is sufficient. Wipe off the repair area with a clean, dry cloth or an air gun.
   b. Wipe the sanded surface with a wax and grease remover.
   c. Spray 0.75-1.0 ml. of flexible color coat and allow to dry for 15-20 minutes.
   d. Spray 0.75-1.0 ml. flexible clearcoat over the color coat. Allow to dry per manufacturer instructions.

Repair Procedure for Damaged or Removed Surface

1. Wash the repair area with soap and water. Then clean the repair area with solvent such as 3M General Purpose Cleaner or equivalent.
2. Using a suitable grinder or sanding block with No. 36 Disc or Coarse Abrasive Paper, grind or abrade away sufficient substrate material around the damaged area to maximize adhesion of repair material.
3. Featheredge the paint around the repair area.
4. Wipe off repair area with a clean dry cloth or an air gun.
5. Flame treat the exposed substrate repair area to improve adhesion. A propane torch with a one inch long blue flame kept moving over the surface until the exposed substrate is a light brown color is sufficient. Minimum paint damage will result if the flame is kept moving.
6. Clean the underside of the repair with wax and grease remover. Apply 3M Auto Body Repair Tape (part no. 6930) or equivalent to the underside of the repair area.
7. Using the 3M Company Structural Adhesive Tube Kit Part No. 8101, or equivalent, mix the repair filler material. Carefully follow the instructions on the tubes and on the kit container to ensure correct mixing and application of the repair material.

   NOTE: To prevent air bubbles during mixing, the components should be scraped together with downward pressure and spread thinly on the mixing board. **Adhesive should be used within two minutes after mixing.** Observe safety precautions when handling adhesive.
8. Apply mixed adhesive to area with a squeegee in two steps.
   a. Apply a light coat over entire area and allow to dry.
   b. Mix and apply second coat to restore the contour.
9. In restoring the contour, spread from edges toward center, filling all low areas. If voids, bubbles or low areas occur, mix more adhesive and apply to repair as needed.
10. Heat lamps or guns may be used to speed drying. However, as excessive heat may damage the substrate, do not use lamps closer than 4-5 feet to repair area or heatguns at 190°-120° for longer than 20 minutes. An inexpensive cooking thermometer can be used to monitor the temperature.

    NOTE: The adhesive can be sanded after the 20 minute heat (lamp or gun) cure or after one hour at room temperature.

    CAUTION: Sanding in two directions tends to lift edges and spoil the repair.
11. Grind or block sand the repair area down to correct contour. Grind with a No. 240 Disc followed by a No. 320 Paper followed by No. 400 Wet or dry paper.

    CAUTION: Spot or glazing putty should not be used for soft plastic component repairs.
12. Examine the finish sanded repair and fill any bubbles, holes or low spots with additional adhesive as needed.
13. The entire panel surface must be scuff sanded (orbital type disc or block) with No. 320 disc or paper.
14. Clean repair area by blowing off with an air gun.
15. Wipe the entire area to be painted with a clean dry cloth or tack cloth to ensure cleanliness.
16. Apply two or more prime paint coats thinned in accordance with the directions on the paint can. Allow 30 minutes drying time. Finish paint the properly primed repair area in accordance with procedure for minor cuts and cracks.

REPAIR (Continued)

Plastic Bumpers

Cuts and cracks to the radiator grille opening panel or bumpers in non-structural areas, where substrate material has not been removed, can be repaired using the approved service material: 3M® Flexible Parts Repair Material No. 05900.

The following repair procedures can be used for either the grille opening panel or the bumper assemblies in non-structural areas.

Repair Procedures For Non-Structural Areas

Before proceeding with the repair, examine the damaged area carefully. If damage has penetrated the bumper material, remove the bumper from the vehicle to be able to work on both sides. The following steps apply to both inside and outside surfaces unless otherwise indicated.

1. Wash the repair area with soap and water.
2. Clean the area thoroughly with a solvent such as 3M General Purpose Cleaner or equivalent.
3. Using a 3 inch No. 36-grade disc, grind the damaged area to form a tapered V-groove.
4. On the inside, use the same disc to rough up a 2 inch area surrounding the damage. On the outside, feather edge the paint around the damaged area for at least 2 inches with No. 180-grit paper.
5. Apply 3M No. 5900 Flexible Parts Repair Material or equivalent to the roughed-up area on the inside. While it is still wet, apply fiberglass cloth over the adhesive.
6. Apply an additional coat of 3M No. 5900 over the fiberglass cloth, making sure to cover the weave of the cloth completely.
7. On the outside surface, apply 3M No. 5900 to the grooved areas only. Allow 20-30 minutes drying time at 60-80°F.
8. Sand the filled areas on the outside surface with No. 180-grit paper on an orbital sander. If necessary, fill any voids or low areas with additional No. 5900 and allow to dry.
9. Finish-sand the outside surface with No. 220-grit paper with appropriate backup (hard sanding block or hand sanding pad).

SPECIFICATIONS

TORQUE SPECIFICATIONS

Description	N·m	Lb-Ft
Bumper-to-Fender Screws	9-21	7-15
Isolator-to-Bumper Assy Screws	22-34	16-25
Isolator-to-Reinforcement Screws	17-27	13-19
Fender-to-Bumper Assy Nuts	4.5-6.9	40-61 (Lb-In)
Back Panel Nuts	9-14	7-10
Isolator-to-Body Screws	35-55	26-40
Bumper-to-Fender Screws	9.5-15	8-11

SECTION 01-20A Restraints, Active

VEHICLE APPLICATION

Taurus/Sable.

DESCRIPTION AND OPERATION

A continuous loop, single retractor restraint system is used on these vehicles.

The lap and shoulder safety belts are factory installed. If safety belt, or cable/buckle assemblies are removed for any reason, they should be installed as outlined. Tighten the anchor bolts to 30-40 N·m (23-29 lb-ft) and anchor nuts to 60-90 N·m (44-66 lb-ft) as shown in appropriate illustration.

WARNING: CHILDREN HAVING A SEATING HEIGHT GREATER THAN 71 CM (28 INCHES) SHOULD USE THE SAFETY BELTS PROVIDED WITH THE VEHICLE. HOWEVER, THE SHOULDER BELT PORTION OF THE LAP/SHOULDER SAFETY BELT SHOULD NOT BE USED IF IT CONTACTS THE CHILD'S FACE, CHIN, NECK OR THROAT. IF THE SHOULDER PORTION OF THE SAFETY BELT EITHER TOUCHES THE CHILD'S FACE, CHIN, NECK OR THROAT, MOVE THE CHILD CLOSER TO THE CENTER OF THE VEHICLE. IF THE SHOULDER BELT STILL DOES NOT FIT, MOVE THE CHILD TO A SEAT WITH A LAP BELT ONLY. IF THE SAFETY BELTS ARE NOT ADJUSTED PROPERLY, THE CHILD'S CHANCES OF BEING INJURED IN A COLLISION INCREASE.

WARNING: ALL VEHICLE OCCUPANTS, INCLUDING PREGNANT WOMEN, SHOULD WEAR SAFETY BELTS FOR MAXIMUM PROTECTION IN THE EVENT OF A COLLISION. ALL VEHICLE OCCUPANTS, INCLUDING PREGNANT WOMEN, SHOULD BE SURE THE LAP SAFETY BELT, OR LAP SAFETY BELT PORTION OF THE LAP/SHOULDER BELT, IS FITTED SNUGLY AND AS LOW AS POSSIBLE AROUND THE HIPS, NOT THE WAIST. SHOULDER BELTS SHOULD ALSO BE PROPERLY ADJUSTED FOR MINIMUM SLACK. FAILURE TO PROPERLY USE THE SAFETY BELTS MAY INCREASE THE CHANCES AND/OR SEVERITY OF INJURY IN THE EVENT OF A COLLISION.

ACCORDING TO ACCIDENT STATISTICS, PROPERLY RESTRAINED CHILDREN ARE SAFER IN THE REAR SEAT THAN IN THE FRONT SEAT. FOR YOUNG CHILDREN, INFANT AND CHILD RESTRAINTS SHOULD BE OBTAINED AND USED IN ACCORDANCE WITH THE INSTRUCTIONS PROVIDED BY THE MANUFACTURER OF THE INFANT AND CHILD RESTRAINT. CHILD RESTRAINT USE IS REQUIRED BY LAW.

The driver's safety belt system incorporates a chime and indicator warning to indicate non-safety belt usage. The safety belt warning indicator illuminates for approximately eight seconds after the ignition switch is turned on, regardless of safety belt usage. The safety belt warning chime is grounded by a switch in the LH inboard buckle. The safety belt warning chime will sound for approximately eight seconds unless the driver's belt is connected.

DESCRIPTION AND OPERATION (Continued)

Belt Buckle

The inboard belt buckle is secured on the seat track for bucket seat applications or on the slide bar for flight bench seat applications, allowing the buckle to move with the seat.

Attaching the tongue and buckle secures the occupant with both lower and upper restraints. This tongue and belt attachment can be accomplished by a single, continuous movement.

Lap Safety Belts, Center

Lap safety belts are provided for all front center (except bucket seat applications) seats and are secured to seat track. Lap safety belts for rear center seating positions are secured to the floorpan.

Lap/Shoulder Safety Belt, Front

The lap/shoulder safety belt extends from a retractor which is located on the B-pillar post for the front seat. This retractor is designed to let the belt move in or out freely at all times, except during hard braking, cornering or impacts of 8 km/h (5 mph) or more.

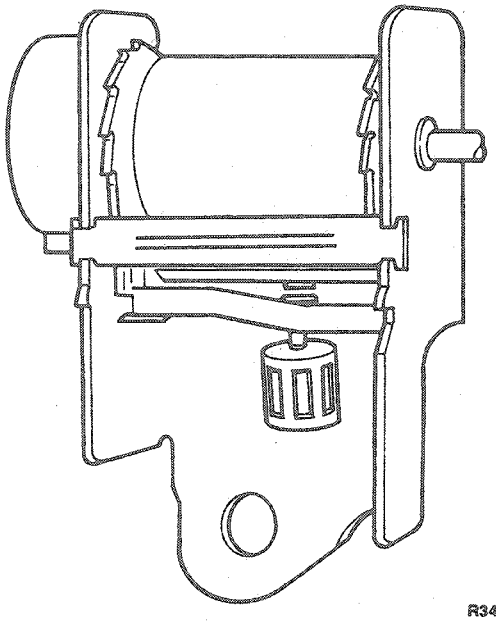
The front shoulder safety belt is guided through the belt guide which is mounted on the B-pillar and inside center pillar trim panel.

The belt then passes through a D-ring above and behind the occupant's shoulder which directs the belt at the proper downward angle over the occupant's shoulder and chest to the lap safety belt buckle. The belt has a slip tongue that latches to lap belt buckle then continues through slip tongue outboard to the sill which acts as a lap belt.

Lap/Shoulder Safety Belt, Rear

The lap/shoulder safety belt extends from a retractor located on vehicle structure (package tray on sedan and rearward of door on station wagon). The retractor is designed to allow the belt to move in or out freely at all times except during hard braking, cornering or impacts of 8 km/h (5 mph) or more.

The belt is routed through a D-ring on station wagon and through a bezel in the package tray for sedan. The belt is then directed downward at an angle over the occupant's shoulder and chest to the lap safety belt buckle. The belt has a slip tongue that latches to the lap belt buckle and continues through the slip tongue outboard to the floor.



R3404-B

Auxiliary Seat, Station Wagon

The auxiliary seat lap safety belt consists of a belt and buckle assembly on the outboard side and safety belt retractors with tongue on inside. Both are mounted to the floorpan. To fasten the belt, pull belt out of the retractor with a steady motion and insert the tongue into the buckle. Adjust belt snug around hips (never across the waist) and return excess belt into retractor. Failure to do so may result in injury in a rear end collision.

WARNING: NEVER INSTALL INFANT OR CHILD SAFETY SEATS IN THE AUXILIARY SEAT, BECAUSE THEY MAY NOT PROVIDE ADEQUATE PROTECTION FROM PERSONAL INJURY IN A COLLISION.

Child Restraint—Tether Attachment

Tether Anchorage Hardware

If tether anchorage hardware is required for the child safety seat but is not provided by the child safety seat manufacturer, tether anchor hardware kits can be obtained at no charge from any Ford or Lincoln-Mercury dealer. Attachment holes at each rear seating position have been provided in all vehicles.

Canadian Vehicles Only

All vehicles built for sale in Canada include a tether anchor hardware kit for use with Canadian Child Safety Seats.

Some aftermarket child safety seats provide a tether strap which goes over the back of the vehicle seat and attaches to an anchorage in the floor or panel behind the rear seat.

DESCRIPTION AND OPERATION (Continued)

If a tethered safety seat is installed in the front seat, the tether strap should be hooked to the rear seat lap belt tongue or the webbing of the buckled rear seat lap belt behind the child safety seat. Attachment holes (at each rear seating position) have been provided to attach the tether anchor hardware kit.

WARNING: WHEN USING ANY INFANT OR CHILD RESTRAINT SYSTEM IT IS IMPORTANT THAT YOU FOLLOW THE INSTRUCTIONS PROVIDED BY THE MANUFACTURER CONCERNING ITS INSTALLATION AND USE. FAILURE TO FOLLOW EACH OF THE RESTRAINT MANUFACTURER'S INSTRUCTIONS CAN RESULT IN A CHILD STRIKING THE VEHICLE'S INTERIOR DURING A SUDDEN STOP OR COLLISION.

WARNING: IT IS IMPORTANT THAT THE BOLT/ANCHOR BE SECURELY TIGHTENED TO SPECIFICATION. OTHERWISE, THE CHILD SAFETY SEAT MAY NOT BE PROPERLY SECURED AND THE CHILD COULD BE INJURED IN CASE OF A SUDDEN STOP OR ACCIDENT.

WARNING: DO NOT PLACE INFANT OR CHILD SEATS IN THE AUXILIARY (THIRD) SEAT, BECAUSE THEY MAY NOT PROVIDE ADEQUATE PROTECTION FROM PERSONAL INJURY IN THE CASE OF A COLLISION.

LOCATION

Dimension A is the distance from the center line of the vehicle to the center of the attachment holes.
Dimension B is the approximate distance from the center of the radio speaker grille opening to the center of the tether attachment holes.

	Dimension A — Centerline to Tether Hole		Dimension B — Speaker Grille Opening to Tether Hole		Hole Size	
Vehicle	mm	inches	mm	inches	mm	inches
Taurus Outboard Location	380	15.0	222	8.75	9.0	0.35
Sable Outboard Location	380	15.0	222	8.75	9.0	0.35
Taurus Inboard Location	150	6.0	203	8.0	9.0	0.35
Sable Inboard Location	150	6.0	203	8.0	9.0	0.35

CR4383-C

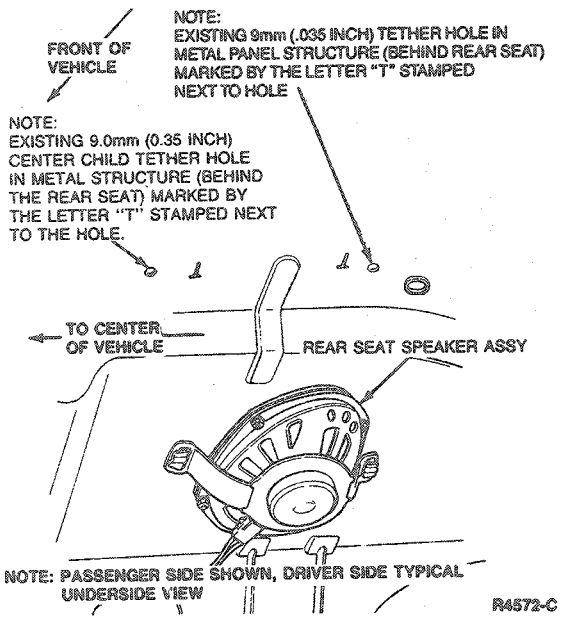
LOCATION (Continued)

Tether Attachment

Rear Window Tray

Sedan

On Sedan models, three (one each side and one near the center) 9mm (0.35-inch) top tether attachment holes in the rear window tray structure (behind the rear seat) have been provided for attachment of the anchor hardware supplied with the safety seat, if required. For easy identification, these holes are marked with the letter "T" stamped behind the hole.

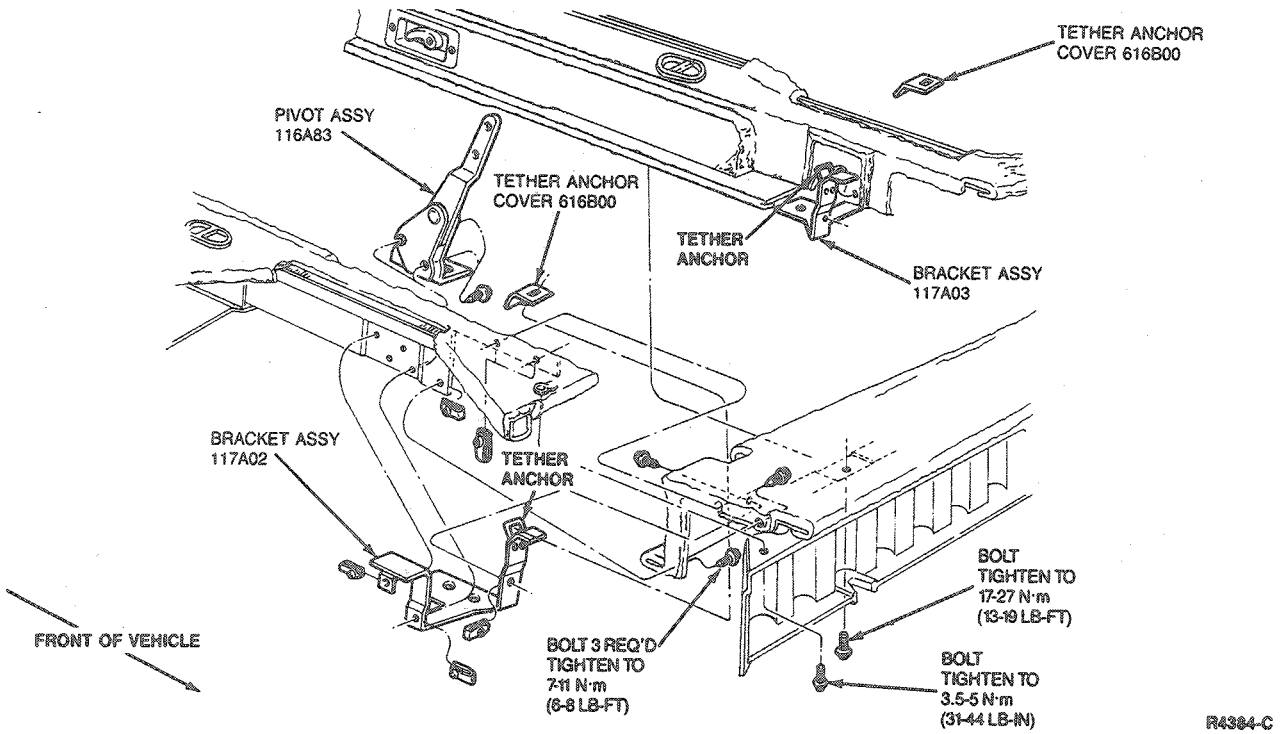


LOCATION (Continued)

Wagon Without Auxiliary Rear Seat—All

On all Wagon models, two (one each side) steel U-shaped load floor anchors located on the forward auxiliary floor trim panel have been provided for attachment of the child safety tethers. The tether anchors are easily accessed by inserting a small screwdriver under the attachment anchor covers and prying them off the anchors.

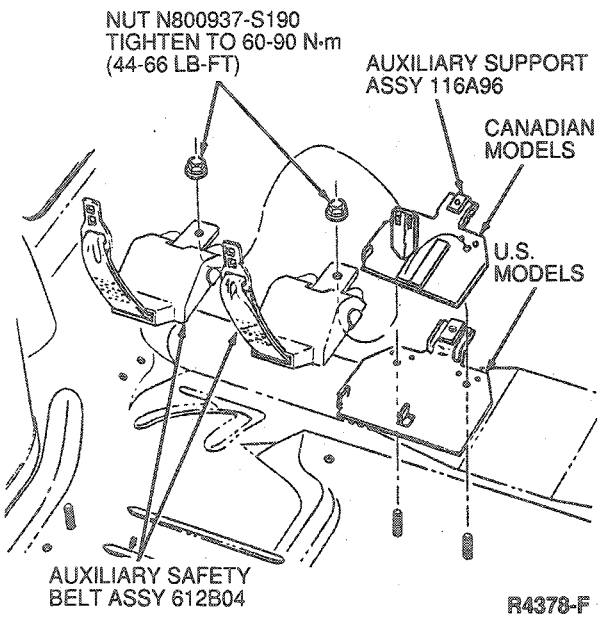
WARNING: IF THE ANCHOR BOLTS ARE EVER REMOVED, THE HOLE(S) IN THE FLOOR MUST BE SEALED TO PREVENT THE POSSIBILITY OF FUMES ENTERING THE PASSENGER COMPARTMENT.



LOCATION (Continued)

Wagon With Auxiliary Seat, U.S. With Auxiliary Seat, Canada—All

Standard on Canadian Wagon models and on U.S. Wagon models with the auxiliary (third) seat, tether attachments have been provided on the auxiliary seat center support bracket for attaching rear (second) seat tether restraints only.



REMOVAL AND INSTALLATION

Lap/Shoulder Safety Belt Retractor Assembly, Front

NOTE: Seat Belt Bolt Bit T77L-2100-A or equivalent should be used for safety belt bolt removal and installation on front outboard belts. A metric socket is necessary to remove or install inboard buckles and center passenger belt anchors.

Removal

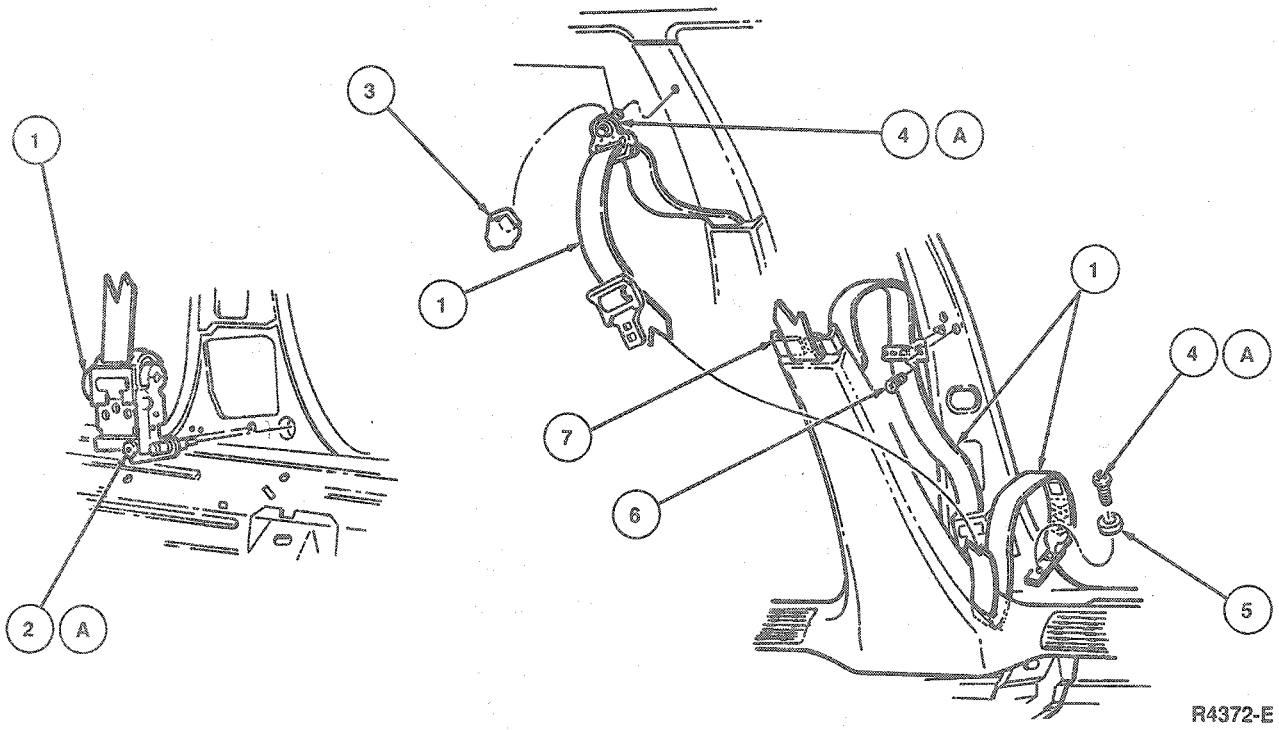
1. Remove D-ring cover.
2. Insert bolt bit and remove belt bolt.
3. Remove B-pillar upper trim panel.
4. Remove scuff plate/center pillar trim panel retaining screws and panel.
5. Remove safety belt through slot in upper center trim panel.
6. Remove safety belt anchor plate-to-sill bolt and rubber washer.
7. Remove safety belt retractor bolt.
8. Remove web guide retaining screw and slide guide rearward to remove from B-pillar.
9. Remove outboard safety belt assembly from vehicle.
10. Remove nut/bolt from inboard buckle assembly. On LH side, disconnect warning chime wire and pry locator off the seat.
11. Pull buckle upward to remove from seat.

Installation

1. To install, reverse Removal procedure. Be sure to position belts as shown.
2. Tighten all attaching bolts to 30-40 N·m (23-29 lb-ft). Cycle system several times to ensure proper operation of retractor. Make sure belt is not twisted.

REMOVAL AND INSTALLATION (Continued)

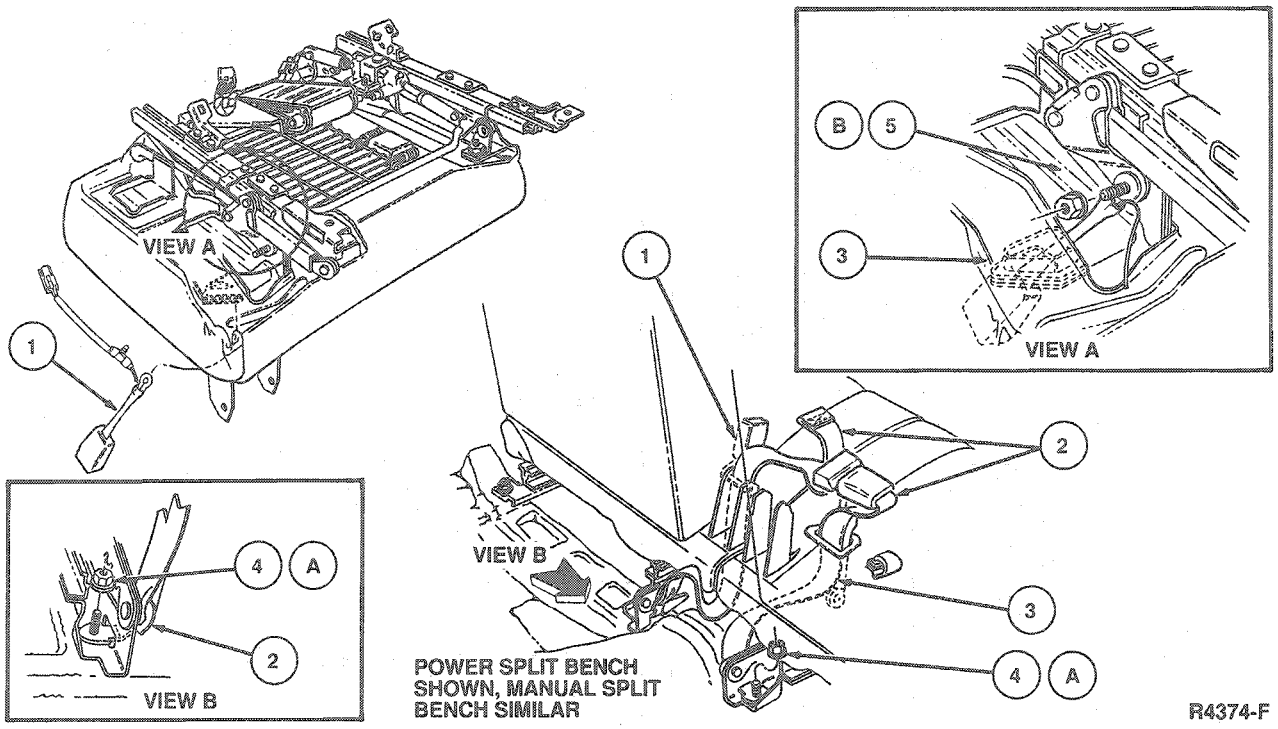
Safety Belts, Outboard



Item	Part Number	Description
1	611B08	Belt and Retractor Assy
2A	389370-S100	Bolt
3	60262	Cover
4A	386277-S100	Bolt (1 Req'd Each Side)
5	387194-S	Washer
6	56902-S2	Screw (1 Req'd Each Side)
7	24346	Scuff Plate / Lower Body Center Pillar Moulding
A		Tighten to 30-40 N·m (23-29 Lb-Ft)

REMOVAL AND INSTALLATION (Continued)

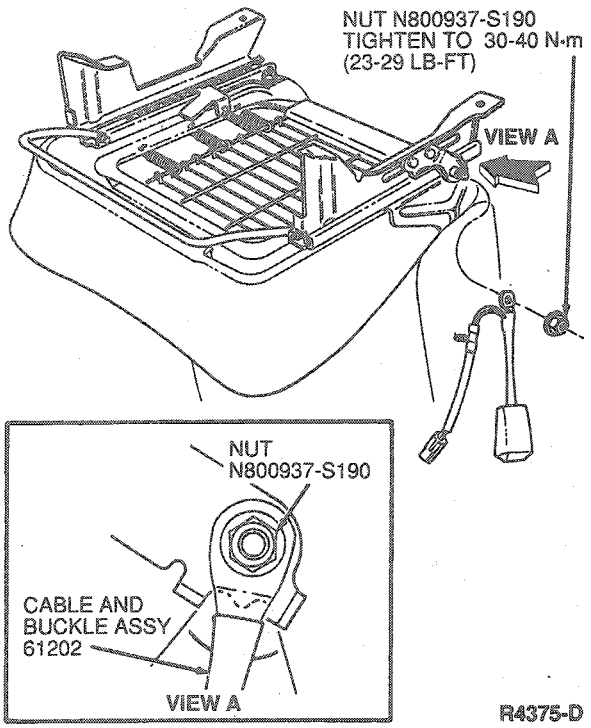
Safety Belts, Inboard
Split Bench—Power Seat



Item	Part Number	Description
1	61203	Cable and Buckle Assy
2	611B60	Center Safety Belt Assy
3	61202	Cable and Buckle Assy
4A	N620483-S36	Nut
5B	N800937-S190	Nut
A		Tighten to 68-92 N·m (50-68 Lb-Ft)
B		Tighten to 30-40 N·m (23-29 Lb-Ft)

REMOVAL AND INSTALLATION (Continued)

Safety Belts, Inboard Bucket



Safety Belts, Rear

Tools Required:

- Seat Belt Bolt Bit T77L-2100A

Seat Belt Bolt Bit T77L-2100-A should be used for safety belt removal and installation.

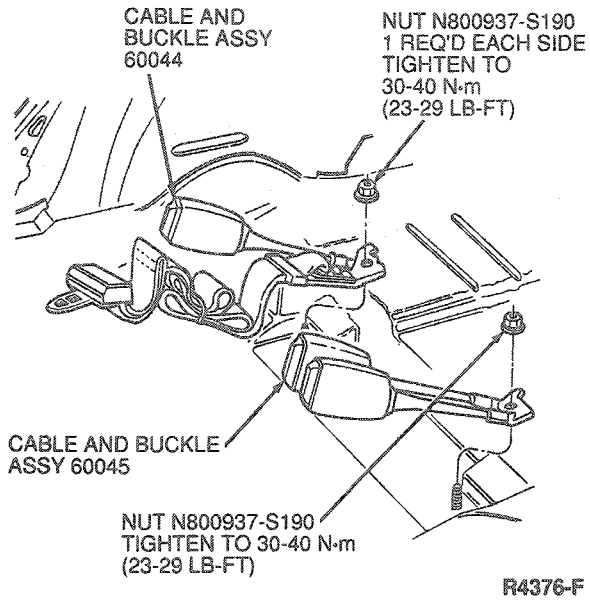
Removal

1. Remove rear seat back and cushion. Refer to Section 01-10A.
2. Remove the angel wing trim and package tray trim. Refer to Section 01-10A.
3. Remove buckle end anchor plate nuts and remove buckle end belts.
4. Remove retaining bolt to both rear seat retractors. Remove retractors.

   NOTE: When only the outboard or center safety belt assembly is replaced, the brass ring holding one anchor plate of the center safety belt assembly and the buckle end anchor anchor of the outboard safety belt must be pried open and discarded in order to slide belt anchor plate out of assembly.

Installation

1. Reverse Removal procedure, being sure to position belts and retractor as shown.
2. Tighten all retaining nuts to 30-40 N·m (23-29 lb-ft). Cycle system to ensure proper operation of retractor. Ensure safety belt is not twisted.



Lap/Shoulder Safety Belt, Rear

Sedan

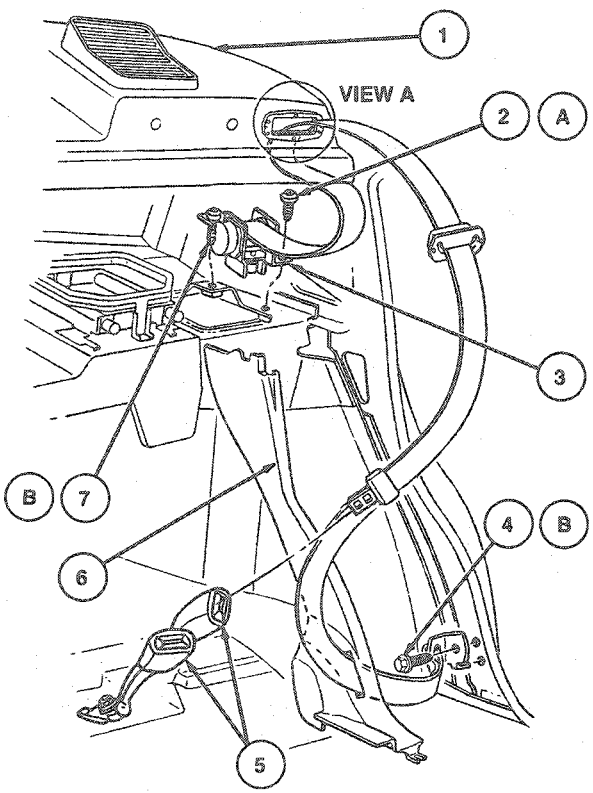
Removal and Installation

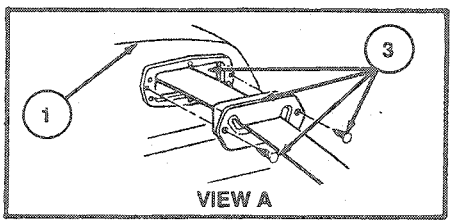
1. Remove rear seat cushion. Refer to Section 01-10A.
2. Remove rear seat back. Ensure on vehicles equipped with head restraint, the web guide is opened. Refer to Section 01-10A.
3. Remove buckle end anchor plate nuts and remove buckle end belts.
4. Remove upper and lower quarter trim panels.
5. Remove safety belt anchor plate-to-sill bolt.
6. Snap out bezel in package tray trim panel.
7. Remove rear stoplamp assembly.
8. Remove package tray trim panel.
9. Remove retractor anchor bolt and retractor screw.
10. Remove anchor plate end of belt through the opening in the quarter trim panel and the package tray trim panel.
11. Remove outboard safety belt assembly from the vehicle.
12. Repeat procedure on opposite side.
13. To install, reverse Removal procedure. Cycle retractor to check for proper operation. Ensure safety belt is not twisted.

    NOTE: Be sure to tighten all retaining bolts as outlined.

REMOVAL AND INSTALLATION (Continued)

Sable

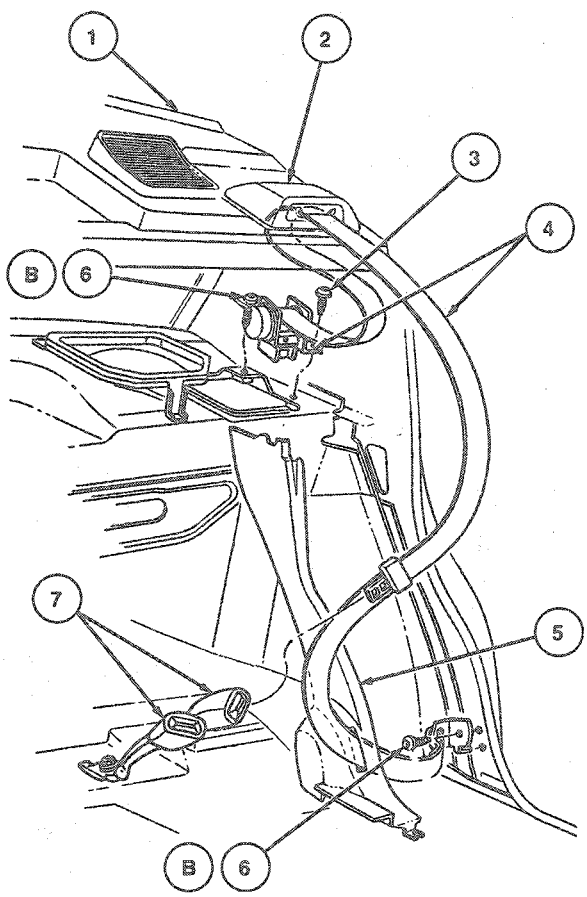




R4962-D

Item	Part Number	Description
1	46668	Package Tray Trim Panel Assy
2A	N801010-S40	Screw (1 Req'd Each Side)
3	611B68	Rear Safety Belt and Retractor Assy
4B	389370-S100	Bolt (1 Req'd Each Side)
5	60044	Rear Safety Belt Cable and Buckle Assy
6	27790	Quarter Trim Panel Assy
7B	389370-S100	Screw
A		Tighten to 22-34 N·m (17-24 Lb-Ft)
B		Tighten to 30-43 N·m (23-31 Lb-Ft)

Taurus



R4961-E

Item	Part Number	Description
1	46668	Package Tray Trim Panel Assy
2	13C46	Rear Shoulder Belt Retractor Cover
3A	N801010-S40	Screw (1 Req'd Each Side)
4	611B68	Rear Safety Belt and Retractor Assy
5	27790	Quarter Trim Panel Assy
6B	389370-S100	Bolt (1 Req'd Each Side)
7	60044	Rear Safety Belt Cable and Buckle Assy
A		Tighten to 22-34 N·m (17-24 Lb-Ft)
B		Tighten to 30-40 N·m (23-29 Lb-Ft)

Station Wagon

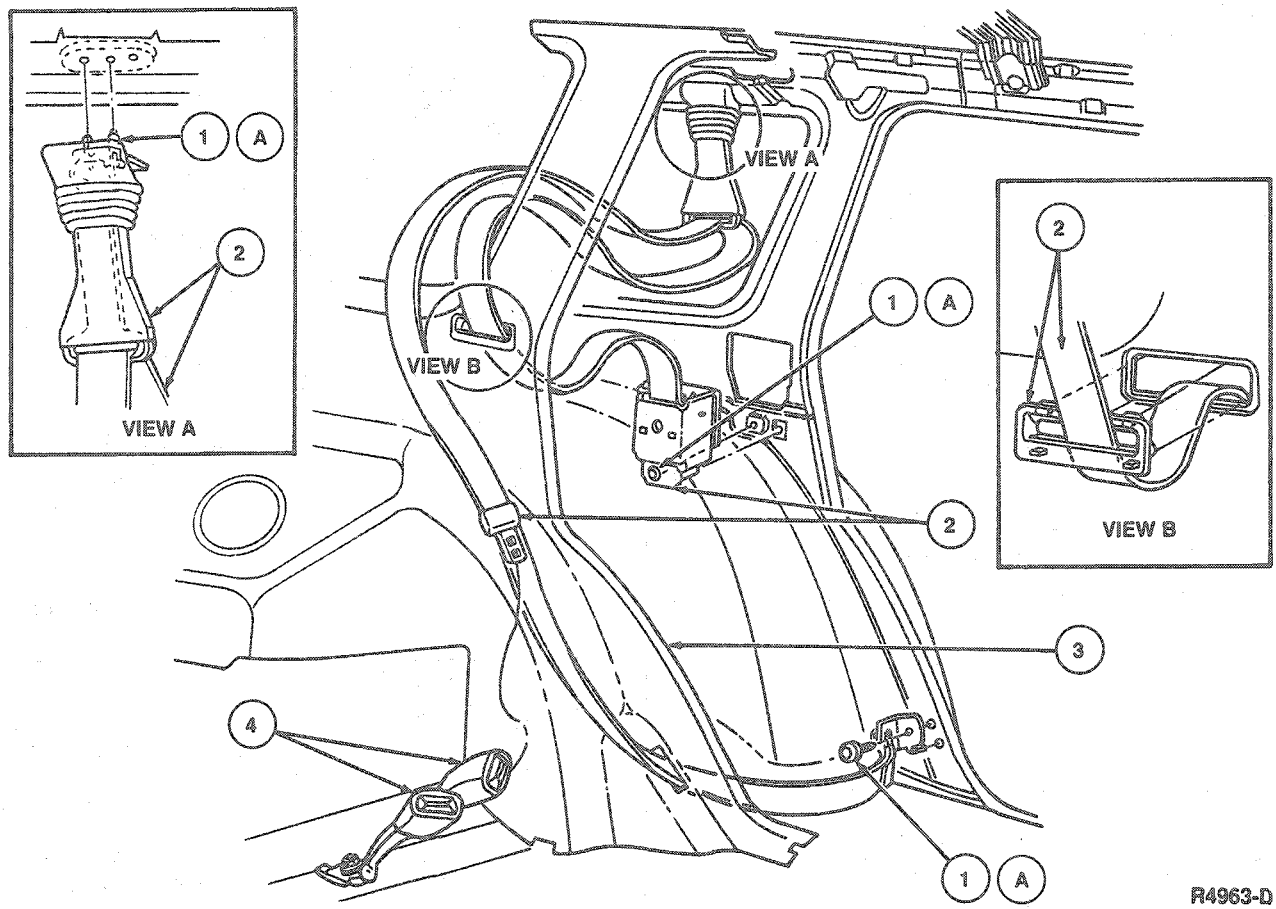
Removal and Installation

1. Remove rear seat cushion. Refer to Section 01-10A.
2. Remove rear seat back. Refer to Section 01-10A.
3. Remove buckle end anchor plate nuts and remove buckle end belts.

REMOVAL AND INSTALLATION (Continued)

4. Remove roof side inner rear moulding on driver's or passenger's side.
5. Remove bolt in sling assembly.
6. Remove quarter trim panel.
7. Remove safety belt anchor plate-to-sill bolt.
8. Remove safety belt through slot near sill.
9. Snap out bezel in quarter trim panel.
10. Remove safety belt assembly through bezel opening.
11. Remove safety belt retractor bolt.
12. Remove outboard safety belt assembly from vehicle.
13. Repeat procedure on opposite side.
14. To install, reverse Removal procedure. Cycle retractor to check for proper operation. Ensure safety belt is not twisted.

    NOTE: Be sure to tighten all retaining bolts to 30-40 N·m (23-29 lb-ft).



Item	Part Number	Description
1A	389370-S100	Bolt
2	11B68	Rear Safety Belt and Retractor Assy
3	27790	Quarter Trim Panel Assy
4	60044	Rear Safety Belt Cable and Buckle Assy
A		Tighten to 30-40 N·m (23-29 Lb-Ft)

REMOVAL AND INSTALLATION (Continued)

Safety Belt, Auxiliary Seat

Wagon

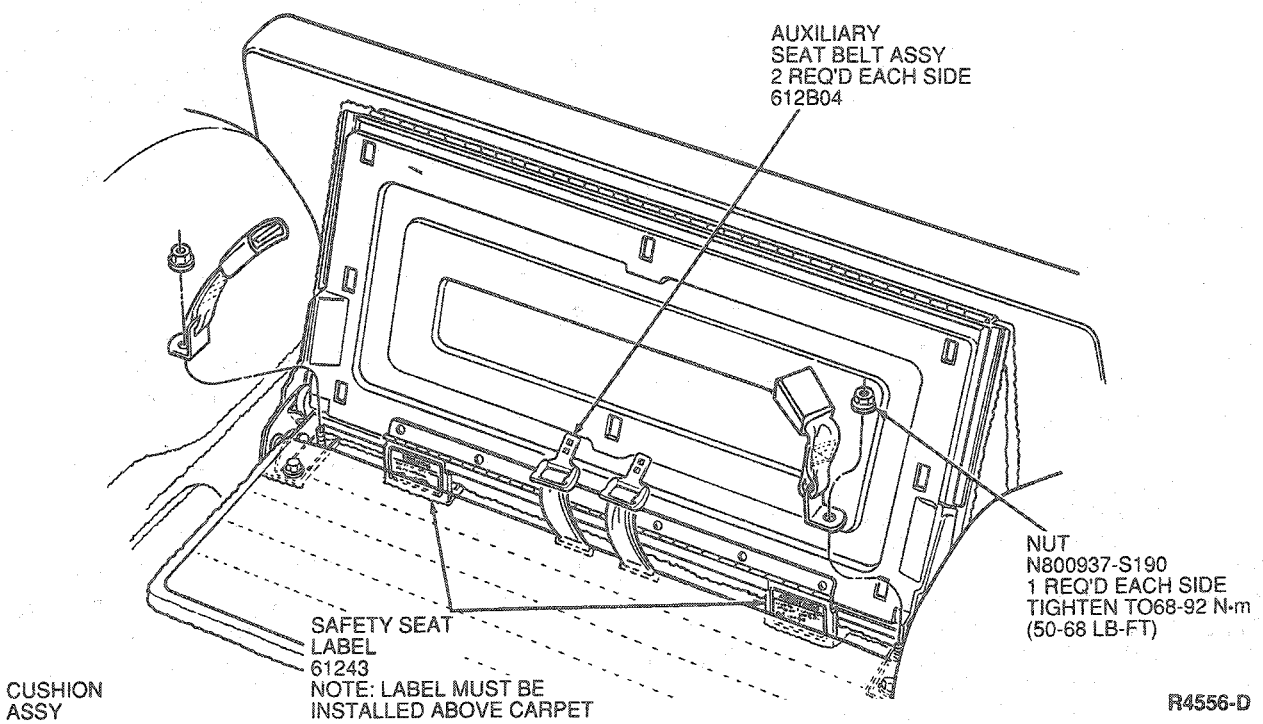
Removal

1. Remove nut to remove outboard belt and buckle assembly.
2. Remove inboard retractor. Remove rear seat back.
3. Remove three screws retaining front panel of load floor assembly.
4. Remove the front panel. Reach between floorpan and load floor and remove the nut to pull out the retractor.

Installation

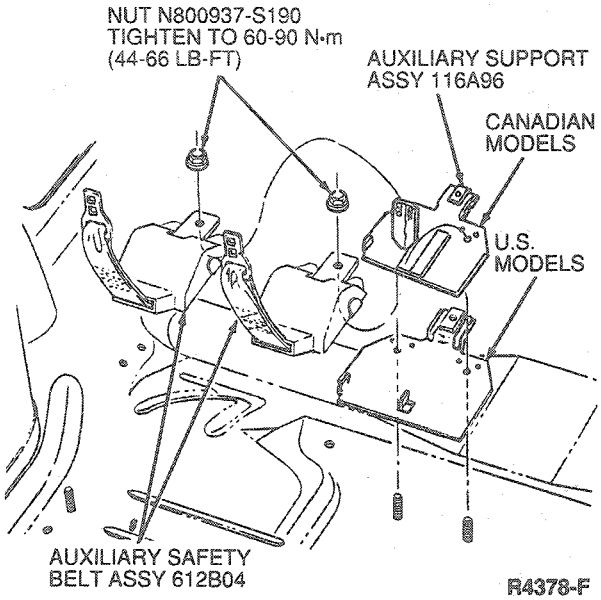
1. To install, reverse Removal procedure. Position belts as shown.
2. Tighten all retaining nuts to 60-90 N·m (44-66 lb-ft). Cycle retractor several times to ensure proper operation of retractor. Make sure safety belt is not twisted.

Safety Belts, Auxiliary Outboard



REMOVAL AND INSTALLATION (Continued)

Seat Belts, Auxiliary Inboard



CLEANING AND INSPECTION

Safety Belt Maintenance

Safety belt assemblies should be periodically inspected to ensure that they have not become damaged and that they remain in proper operating condition, particularly if they have been subjected to severe stress.

WARNING: ALL SAFETY BELT ASSEMBLIES INCLUDING RETRACTORS AND ATTACHING HARDWARE SHOULD BE INSPECTED AFTER ANY COLLISION. FORD RECOMMENDS THAT ALL SAFETY BELT ASSEMBLIES IN USE DURING A COLLISION BE REPLACED UNLESS THE COLLISION WAS MINOR AND A QUALIFIED TECHNICIAN FINDS THAT THE BELTS SHOW NO DAMAGE AND CONTINUE TO OPERATE PROPERLY. SAFETY BELT ASSEMBLIES NOT IN USE DURING A COLLISION SHOULD ALSO BE INSPECTED AND REPLACED IF EITHER DAMAGE OR IMPROPER OPERATION IS NOTED.

Before installing the new safety belt assembly, safety belt attaching areas must be inspected for damage and distortion. If the attaching points are damaged and distorted, the sheet metal must be reworked back to its original shape and structural integrity.

Install new safety belt(s) using the appropriate instructions. Perform Functional Test Procedure.

Belt Webbing

Clean the belt webbing only with a mild soap solution recommended for cleaning upholstery or carpets. Follow instructions provided with soap.

WARNING: DO NOT BLEACH OR RE-DYE THE WEBBING, AS WEBBING MAY WEAKEN.

MAJOR SERVICE OPERATIONS

The lap / shoulder safety belts are factory installed in their proper locations. If the belts are removed for any reason, they should be installed as shown in Removal and Installation. The 7 / 16 x 20 Torx® head anchor bolts must be hand started and tightened to 30-40 N·m (23-29 lb-ft).

Safety Belt

Without Anchorage Plate Thread Damage

1. Remove damaged bolt for anchor reinforcement and discard.
2. Install a new bolt. Refer to Specifications for part number.

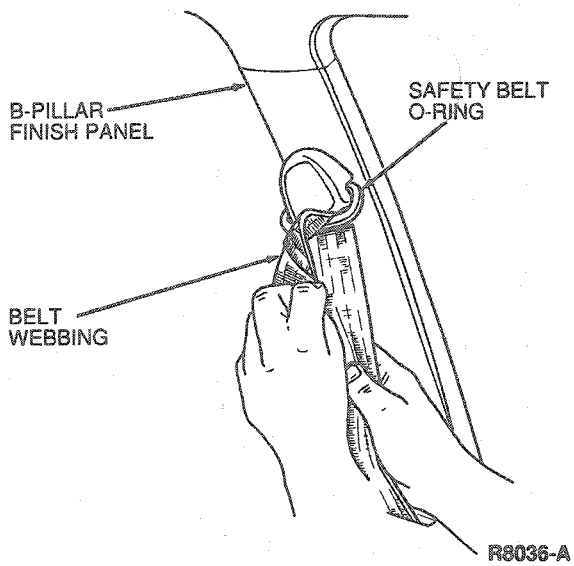
With Anchorage Plate Thread Damage

1. Remove broken or stripped bolt and discard.
2. Drill out internal threads in safety belt anchorage plate with a 27 / 64-inch drill.
3. Re-thread anchorage plate with a 1 / 2-13 tap.
4. Blow out chips.
5. Install attachment parts in proper sequence. Refer to applicable illustrations under Removal and Installation. Original parts are to be replaced with the service parts indicated in safety belt parts replacement chart.

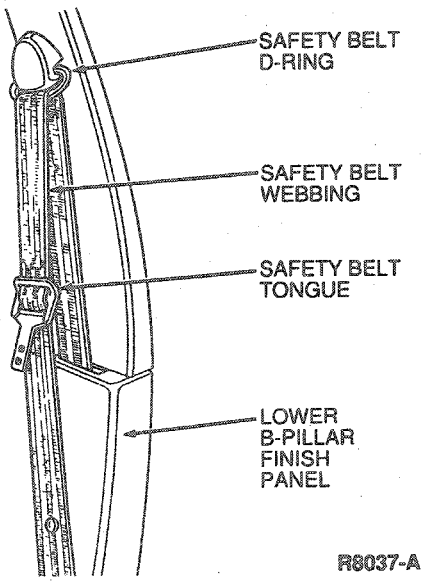
MAJOR SERVICE OPERATIONS (Continued)

Safety Belt Twisted at the "D" Ring

1. Grasp belt webbing at the "D" ring.

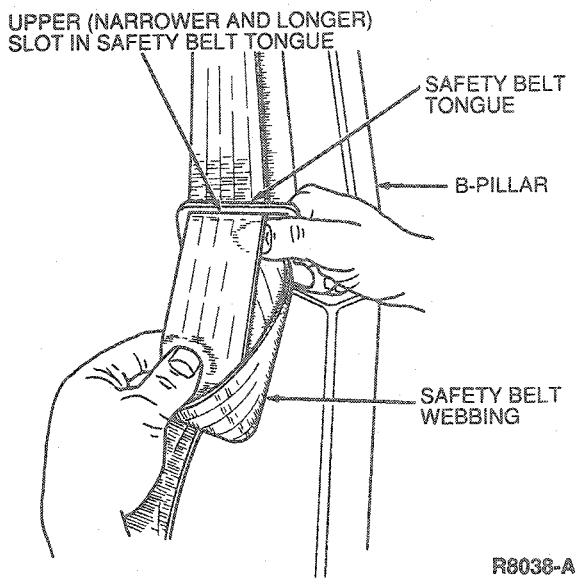


2. Rotate and fold belt webbing over itself as required to remove the twist.
3. Feed the folded portion of the belt through the "D" ring.
4. When completed, safety belt tongue should face outward.

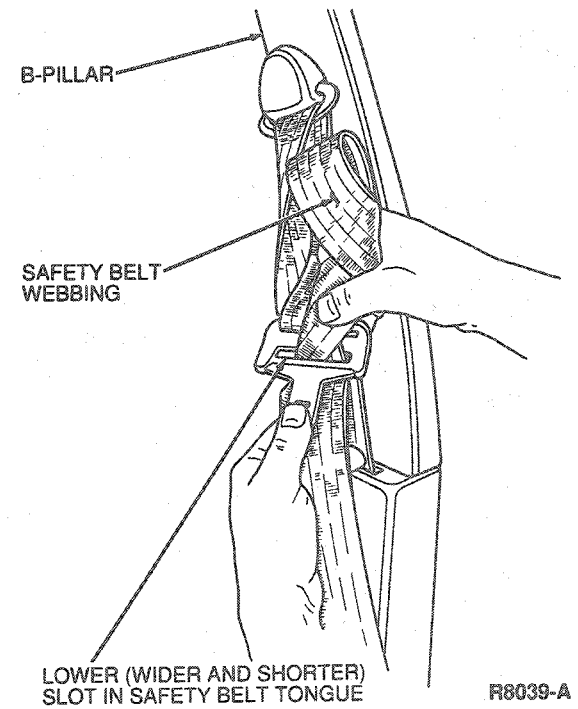


Safety Belt Tongue Rotated on the Belt

1. Grasp belt tongue and pull down on belt webbing to form a loop through the upper (narrow and longer) slot in the tongue.

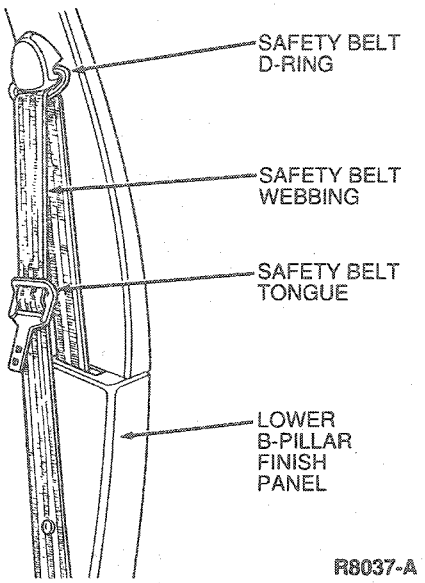


2. Working within the upper slot, rotate and fold belt webbing over itself as required to remove the twist.
3. Pull the excess belt webbing back through the upper slot in the tongue.
4. Repeat Steps 1, 2 and 3 to complete the removal of the twist at the lower (wider and larger) slot in the tongue.



MAJOR SERVICE OPERATIONS (Continued)

5. When completed, safety belt tongue should face outward.



Functional Test Procedure

Determine the type(s) of safety belt assembly(s) that has been replaced. Test the new safety belt assembly using the appropriate procedure.

Continuous Loop Shoulder/Lap Safety Belt Test—System With Movable Tongue and One Retractor

1. Driver will buckle up and proceed to a safe test area. If RH front or rear passenger safety belt must be tested, a passenger should be buckled into RH front or rear seat. (The RH front passenger belt may be tested using a driver only, providing driver has the ability to grasp RH front shoulder belt and extend it approximately 66cm (26 inches) with no compromise to safe driving). This method applies to 8 km/h (5 mph) test only.

   NOTE: The RH front and rear shoulder belts should not be extended fully as to preclude the possibility of a false feeling (full extension vs. lockup).

2. After reaching a safe area to perform sudden stops, driver will attain a speed of approximately 8 km/h (5 mph). The driver should inform passenger (if applicable) that he is preparing to make a severe brake application. At this time, both driver and rider should grasp their respective shoulder harnesses and prepare to lean slightly forward at the moment brake application is made.

3. The driver will make a maximum brake application without tire skid. (The maximum brake application should be on dry concrete or equivalent hard road surface; never on a wet or gravel road). The driver and passenger should lean forward slightly into shoulder harness. At this instant, belts should lock up without webbing payout.

   WARNING: THE DRIVER AND PASSENGER MUST BE PREPARED TO BRACE THEMSELVES IN THE EVENT THE RETRACTOR DOES NOT LOCK.

4. If there is a lockup of both shoulder straps, safety belt assemblies are functioning properly. Should either or both retractors fail to lock up at the 8 km/h (5 mph) speed, repeat the test at a constant 24 km/h (15 mph). (This test must be performed with RH front or rear passenger if RH front or rear belts are to be tested.)

5. If either or both shoulder safety belts do not lock up at 24 km/h (15 mph) test, return vehicle for service of malfunctioning safety belts. Remove retractor and rework sheet metal back to its original shape and structural integrity in retractor's mounting surface. Install retractor assembly and re-test safety belt assembly(s) as previously stated.

   NOTE: If the retractor of a new safety belt assembly has been bolted into a damaged or distorted mounting area, the new retractor could be warped and may not function. If this is the case, reshape the sheet metal back to its original shape and structural integrity and install another new complete safety belt assembly.

ADJUSTMENTS

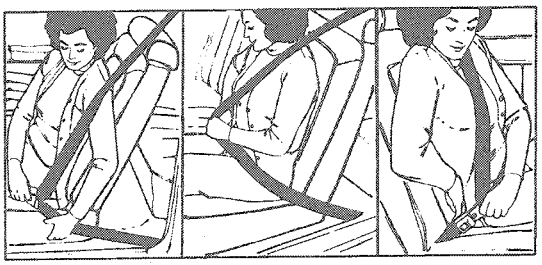
Lap/Shoulder Safety Belts, Front and Rear

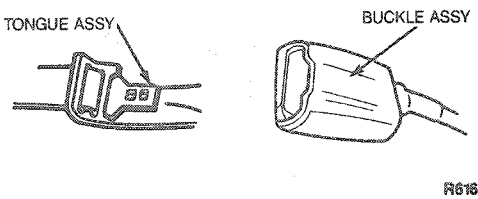
Fastening Belts

After entering the vehicle, adjust the front seat to obtain the best position for driving comfort, access to controls and visibility. Then, use the following procedure for fastening belts.

ADJUSTMENTS (Continued)

Pull the lap / shoulder safety belt from the retractor so that the shoulder portion of the belt crosses the shoulder and chest. Then, insert the belt tongue into the proper buckle until a snap is heard and a latch is felt.





R6161-C

Shoulder Portion Adjustment

The shoulder restraint portion of the belt adjusts automatically to a snug position.

WARNING: DO NOT INTRODUCE SLACK INTO THE SAFETY BELT SYSTEM BECAUSE THE BELT LOCKS UPON IMPACT WHERE IT IS POSITIONED. USE THE SHOULDER SAFETY BELT ON THE OUTSIDE SHOULDER ONLY. NEVER WEAR THE SHOULDER BELT UNDER THE ARM. NEVER SWING IT AROUND THE NECK OVER THE INSIDE SHOULDER. NEVER USE A SINGLE BELT FOR MORE THAN ONE PERSON. ENSURE THE LAP PORTION OF THE BELT IS FITTED SNUGLY AND AS LOW AS POSSIBLE AROUND THE HIPS, NOT ON THE WAIST. FAILURE TO FOLLOW THESE PRECAUTIONS COULD INCREASE THE CHANCE AND/OR SEVERITY OF INJURY IN AN ACCIDENT.

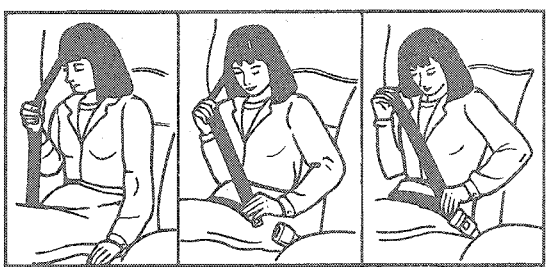
After unbuckling the belt it is recommended that care be taken during retraction to prevent it from striking other passengers, hitting trim panels or painted door surfaces.

Lap Portion Adjustment

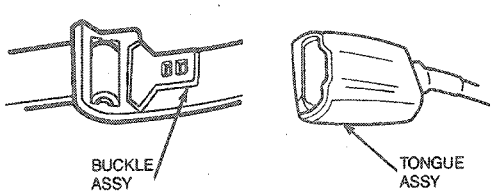
Pull up on the shoulder portion of the belt to tighten the lap portion to a snug fit. Be sure the belt is as low on hips as possible.

The belt system allows freedom of movement, locking only on hard braking hard cornering or impacts of approximately 8 km / h (5 mph) or more. The system cannot be made to lock by jerking on the belt.

WARNING: USE THE SHOULDER BELT ON THE OUTSIDE SHOULDER ONLY. NEVER WEAR THE SHOULDER BELT UNDER THE ARM. NEVER SWING IT AROUND YOUR NECK OVER THE INSIDE SHOULDER. NEVER USE A SINGLE BELT FOR MORE THAN ONE PERSON. BE SURE THE LAP PORTION OF THE BELT IS FITTED SNUGLY AND AS LOW AS POSSIBLE AROUND THE HIPS, NOT ON THE WAIST. FAILURE TO FOLLOW THESE PRECAUTIONS COULD INCREASE THE CHANCE AND/OR SEVERITY OF INJURY IN AN ACCIDENT.



VIEW A



VIEW A R6714-B

The vehicle is equipped with a manually adjusted lap belt for the rear center seat occupant. Insert the belt tongue into the proper buckle until a snap is heard. Pull on both sides of belt to ensure the buckle is latched. Pull up on the end of the belt to tighten the lap portion to a snug fit. Ensure the belt is as low on the hips as possible.

WARNING: ENSURE THE LAP PORTION OF THE BELT IS FITTED SNUGLY, AND AS LOW AS POSSIBLE AROUND THE HIPS, NOT AROUND THE WAIST. FAILURE TO DO SO MAY INCREASE THE CHANCE OF INJURY IN THE EVENT OF A COLLISION.

WARNING: EACH SEATING POSITION IN THE VEHICLE HAS A SPECIFIC SAFETY BELT ASSEMBLY WHICH CONSISTS OF ONE BUCKLE AND ONE TONGUE. THE SAFETY BELT ASSEMBLY IS DESIGNED TO BE USED AS A PAIR AND IS NOT TO BE USED ACROSS SEATING POSITIONS.

ADJUSTMENTS (Continued)

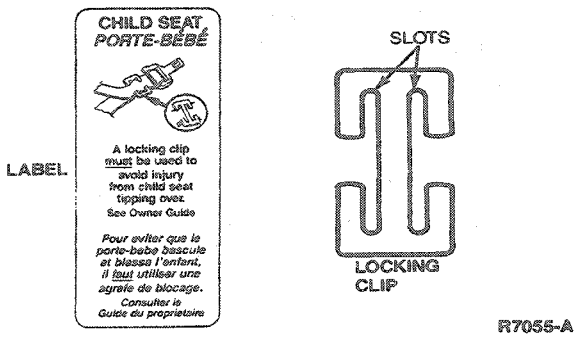
Safety Seats for Children

Use a safety seat that is recommended for the size and weight of the child. Always follow the safety seat manufacturer's instructions when installing and using the safety seat. When installing a child safety seat be sure to use the correct safety belt buckle for that seating position and make sure the tongue is securely fastened in the buckle.

Child Seat Installation with Locking Clip

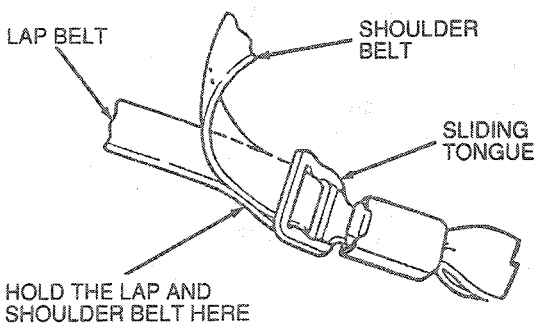
The locking clip must be used to secure a child seat when the vehicle has a shoulder and lap belt with a sliding tongue. Every seat belt that requires a locking clip is identified on the belt, with the label as shown in the illustration. **The locking clip is installed on a sample piece of webbing to show proper installation.**

If the locking clip is not used, injuries could result from the child seat tipping over during normal vehicle braking or cornering.

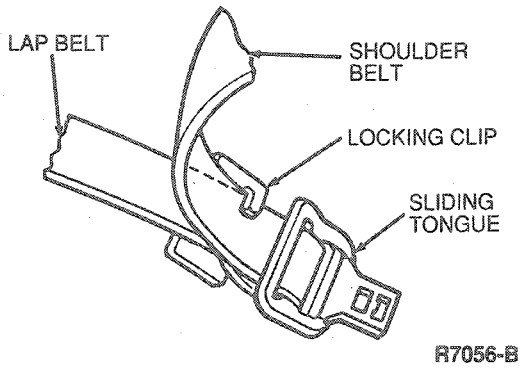


Use the following procedure to install the locking clip:

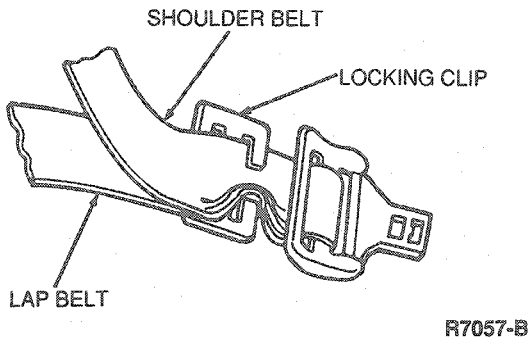
1. Thread the belt webbing through the child seat according to the child seat manufacturer's instructions.
2. Buckle safety belt. Pull on shoulder portion of the belt to make the lap portion fit snugly. Keeping lap belt snug, hold lap and shoulder belt portions of webbing together next to slip tongue and unbuckle safety belt.



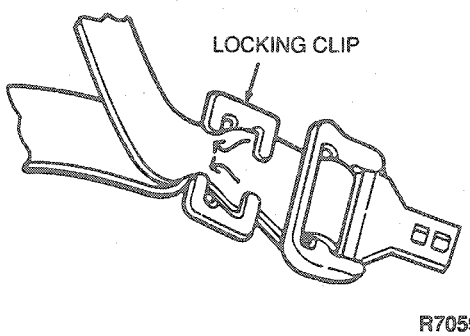
3. Slide either corner of locking clip slot that is closest to the tongue over both layers of belt webbing, as shown.



4. Pinch both opposite edges of belt webbing together and insert into locking clip slot as shown.



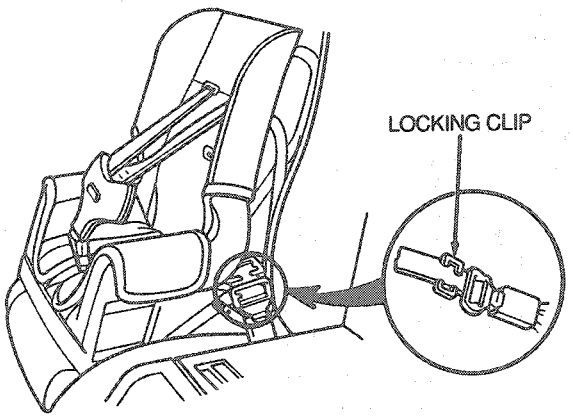
5. Pinch both layers of webbing together and insert into other slot of locking clip in same manner as Step 4.



ADJUSTMENTS (Continued)

6. Buckle safety belt. Forcibly tilt the child seat from side to side and also tug it forward to see if it is held securely in place. If excessive movement occurs, repeat Steps 3 through 6 or properly install child seat in a different seating position in the vehicle.

VIEW OF FINAL INSTALLATION



SEAT DESIGN SHOWN AS REFERENCE ONLY

R7610-A

SPECIFICATIONS

PARTS REPLACEMENT CHART—LAP AND SHOULDER BELT WITH DAMAGED WELD NUT ANCHOR PLATE THREADS

PRODUCTION PARTS		
Part No.	Code Letter	Part Name
386277-S100	IK	Bolt—7/16-20 x 1.38 Pan Shldr. Tapping—.50 Shlder.
389370=S100	IM	Bolt—7/16-20 x 1.15 Pan Head Tapping
N803286-S190	—	Screw—M12 x 1.75 x 20 Pan Head

(Continued)

PARTS REPLACEMENT CHART—LAP AND SHOULDER BELT WITH DAMAGED WELD NUT ANCHOR PLATE THREADS (Cont'd)

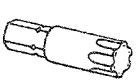
PRODUCTION PARTS		
Part No.	Code Letter	Part Name
N803886-S190	—	Bolt—M12 x 1.95 x 34 Pan Head Shoulder Pilot
385709-S36	T	Bolt—1/2-13 x 1.38 Pan Head Shoulder Locking
389478-S190	U	Bolt—1/2-13 x 1.15 Pan Head Locking

* Identification letter on Top Bolt Head or Face of Spacer.

TORQUE SPECIFICATIONS

Description	N·m	Lb-Ft
Safety Belt Anchor Bolts	30-40	23-29
Safety Belt Anchor Nuts	60-90	44-66
Auxiliary Seat Anchor Bolts	7-11	6-8
Auxiliary Seat Tether Anchor Bolts	17-27	13-19
Auxiliary Seat Support Bolt	3.5-5	31-44 (Lb-In)
Split Bench Safety Belt Nut	68-92	50-68
Rear Safety Belt Nuts	30-43	23-31
Screw	22-34	17-24
Bucket Seat Safety Belt Anchor Nut	30-40	23-29
Auxiliary Seat Safety Belt Outboard Anchor Nuts	68-92	50-68

SPECIAL SERVICE TOOLS

Tool Number/ Description	Illustration
T77L-2100-A Seat Belt Bolt Bit	 T77L-2100-A