

Inner Body Reinforcing Panels

General Equipment

3 Phase Inverter Spot Welder 254-00002
Compuspot 700F Welder 190-50080
I4 Inverter Spot Welder 254-00014
Inverter Welder with MIG Welder 254-00015

Material

Item	Specification
Motorcraft® Premium Undercoating PM-25-A	—
Motorcraft® Rust Inhibitor Aerosol PM-24-A	—
Seam Sealer TA-2	—

Coupe



WARNING: Invisible ultraviolet and infrared rays emitted in welding can injure unprotected eyes and skin. Always use protection such as a welder's helmet with dark-colored filter lenses of the correct density. Electric welding will produce intense radiation, therefore, filter plate lenses of the deepest shade providing adequate visibility are recommended. It is strongly recommended that persons working in the weld area wear flash safety goggles. Also wear protective clothing. Failure to follow these instructions may result in serious personal injury.



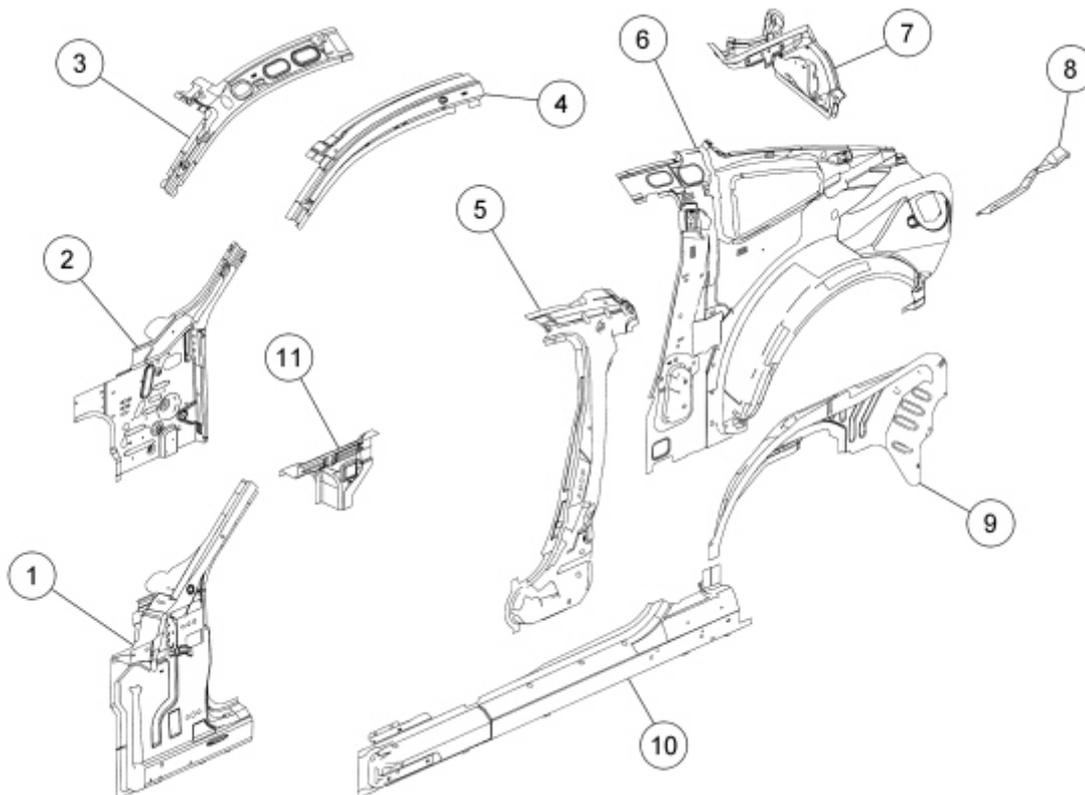
WARNING: Do not cut or grind body side components within 50 mm (1.96 in) of restraint anchoring points. Welding within 50 mm (1.96 in) of restraint anchoring points may result in incorrect operation of restraint devices. For additional restraints anchoring location information, refer to [Section 501-20A](#) and [Section 501-20B](#). Failure to follow these instructions may result in serious injury to vehicle occupant(s).



WARNING: Do not carry out body side sectioning repairs in areas of laser welds. Factory laser welds cannot be duplicated with conventional welding equipment and structural integrity may be compromised. Failure to follow this instruction may result in serious injury to vehicle occupant(s).



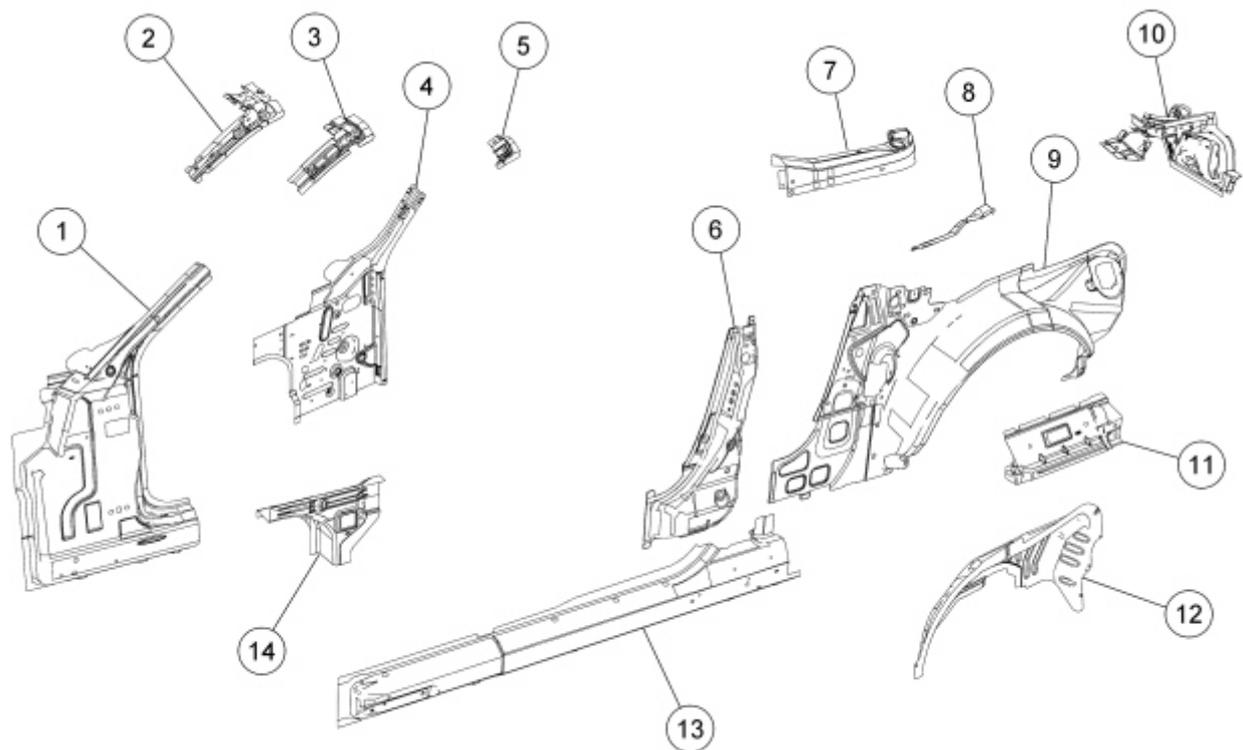
WARNING: Do not carry out body side sectioning repairs in areas of door hinge or striker anchoring points. Welding within 50 mm (1.96 in) of door hinge or striker locations may compromise structural integrity during a collision. Failure to follow these instructions may result in serious injury to vehicle occupant(s).



N0058063

Item	Part Number	Description
1	02501 LH/ 02500 RH	A-pillar assembly — High-Strength Low Alloy (HSLA) 350 steel
2	02039B LH/ 02038B RH	Cowl side panel — HSLA 350 steel
3	02509 LH/ 02508 RH	A-pillar reinforcement — HSLA 350 steel
4	02505 LH/ 02504 RH	A-pillar inner — HSLA 350 steel
5	24301 LH/ 24300 RH	B-pillar inner — HSLA 350 steel (part of 27791 LH/ 27790 RH)
6	27791 LH/ 27790 RH	Quarter panel inner — mild steel
7	28061 LH/ 28060 RH	Quarter panel upper rear extension — mild steel
8	28059 LH/ 28058 RH	Quarter panel lower extension — mild steel
9	—	Wheelhouse inner panel — mild steel (part of 27791 LH/ 27790 RH)
10	02B67 LH/ 02B66 RH	Rocker panel reinforcement — HSLA 350 steel
11	02733 LH/ 02732 RH	Gusset — HSLA 350 steel

Convertible

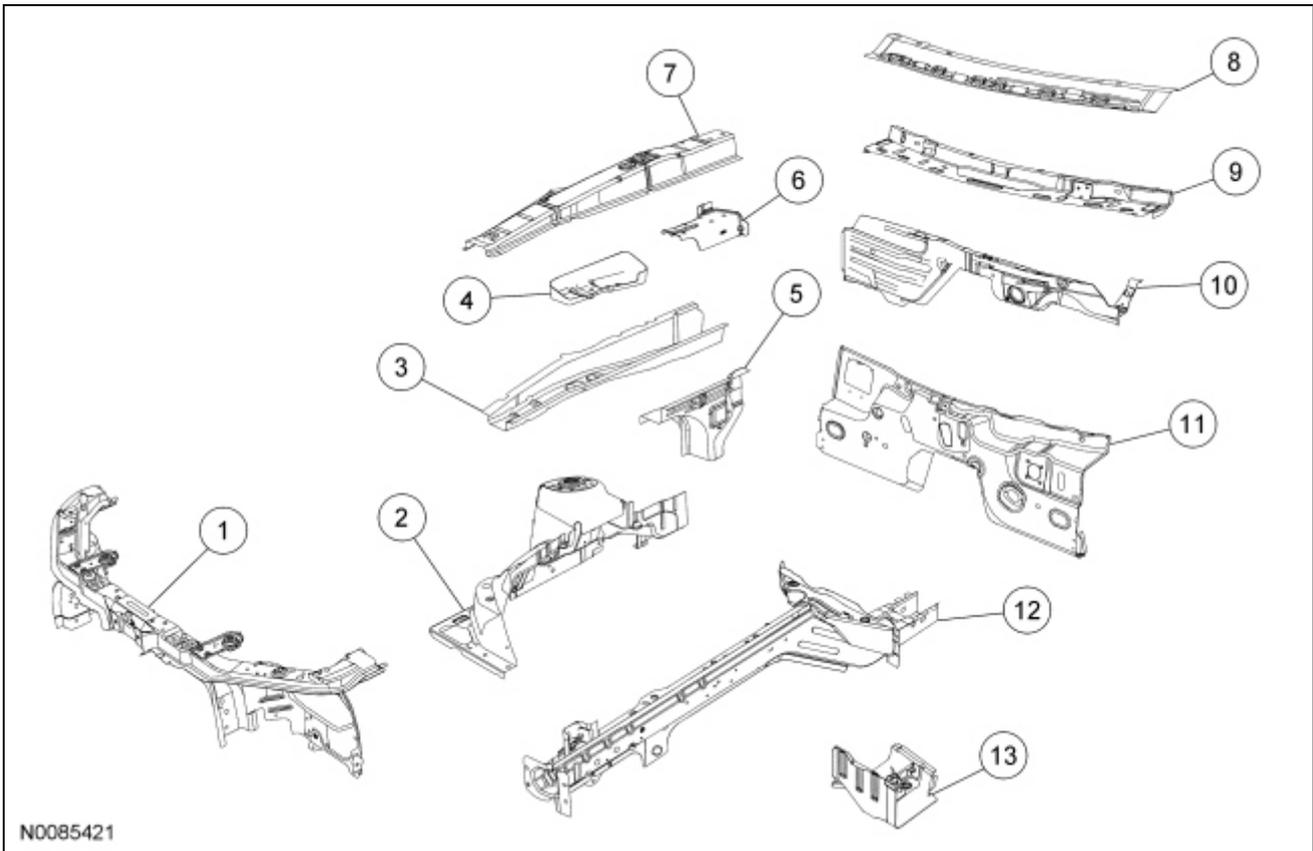


N0058062

Item	Part Number	Description
1	02501 LH/ 02500 RH	A-pillar assembly — High-Strength Low Alloy (HSLA) 350 steel
2	02509 LH/ 02508 RH	A-pillar reinforcement — HSLA 350 steel
3	02505 LH/ 02504 RH	A-pillar inner panel — HSLA 350 steel
4	02039B LH/ 02038B RH	Cowl side panel — HSLA 350 steel
5	025B33 LH/ 025B32 RH	Bracket — HSLA 350 steel
6	24301 LH/ 24300 RH	B-pillar reinforcement — HSLA 350 steel (part of 27791 LH/ 27790 RH)
7	280C99 LH/ 280C98 RH	C-pillar reinforcement — mild steel
8	28059 LH/ 28058 RH	Quarter panel lower rear extension — mild steel
9	27791 LH/ 27790 RH	Quarter panel inner — mild steel
10	28061 LH/ 28060 RH	Quarter panel upper rear extension — mild steel
11	28153 LH/ 28152 RH	Quarter panel upper outer panel — mild steel
12	—	Wheelhouse inner panel — mild steel (part of 27791 LH/ 27790 RH)
13	02B67 LH/ 02B66 RH	Rocker panel reinforcement — HSLA 350 steel
14	02733 LH/ 02732 RH	Bracket — HSLA 350 steel

Front Structure

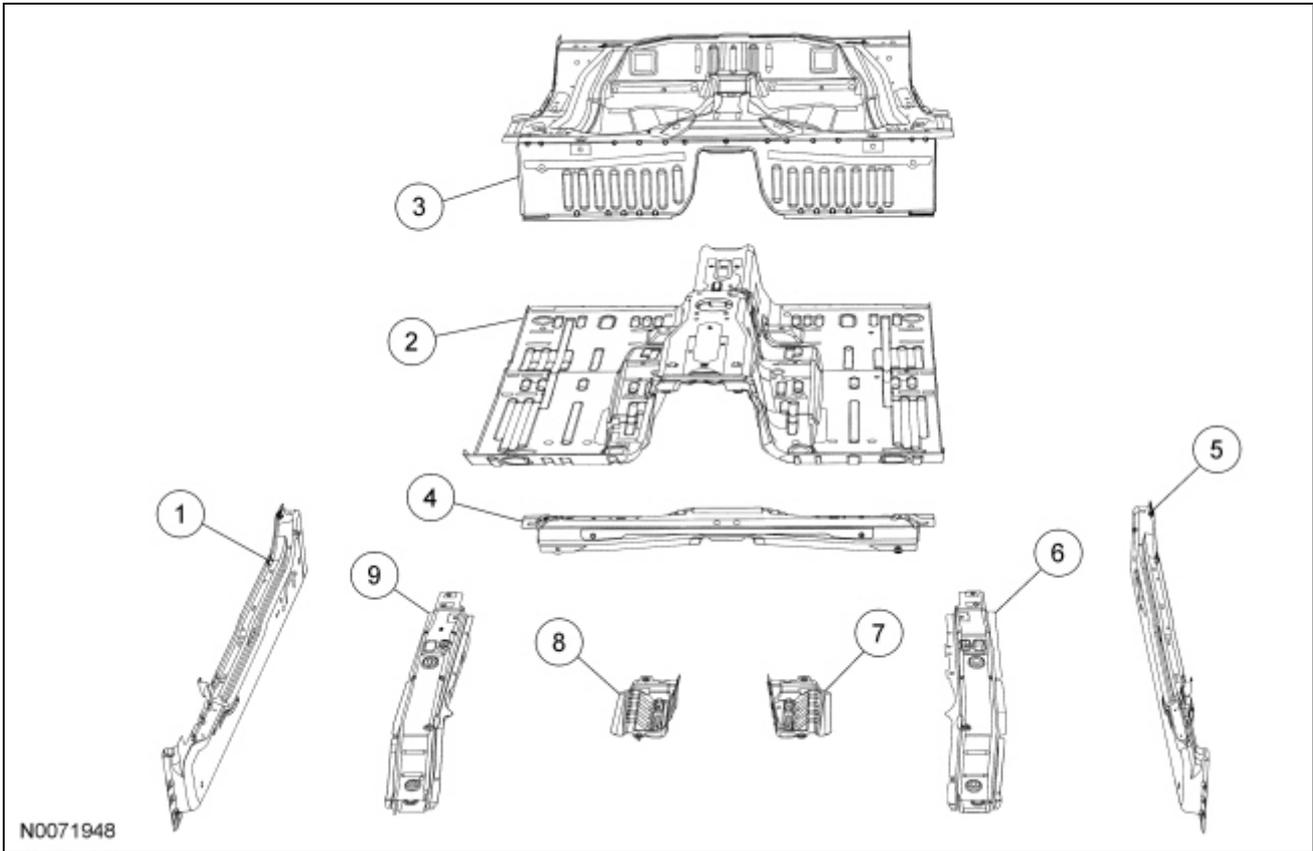
NOTE: LH fender apron and frame rail view shown, RH similar.



N0085421

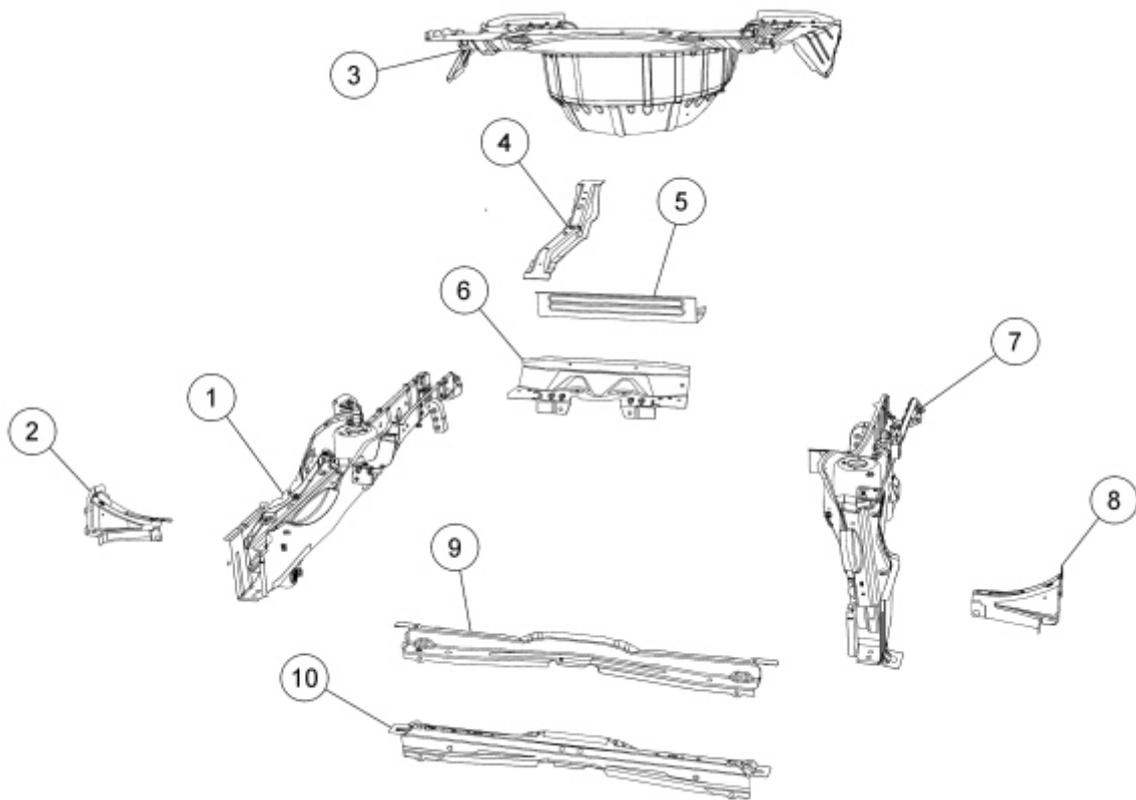
Item	Part Number	Description
1	16138	Radiator support — mild steel
2	16055 LH/ 16054 RH	Apron assembly — mild steel
3	16061 LH/ 16060 RH	Inner fender lower — mild steel
4	16D157 LH/ 16D156 RH	Inner fender reinforcement — mild steel
5	02733 LH/ 02732 RH	Gusset — High-Strength Low Alloy (HSLA) 350 steel
6	16D041 LH/ 16D040 RH	Inner fender reinforcement — mild steel
7	16155 LH/ 16154 RH	Inner fender upper — mild steel
8	302015	Cowl top outer panel — mild steel
9	302030	Cowl top inner panel — mild steel
10	—	Dash panel center — mild steel
11	1605	Dash panel lower — mild steel
12	10463 LH/ 10462 RH	Side member assembly — HSLA 350 steel
13	—	Reinforcement (part of 160554 LH/ 16054 RH) — HSLA 350 steel

Underbody Front



Item	Part Number	Description
1	10116	Floor side member assembly (RH) — High-Strength Low Alloy (HSLA) 350 steel
2	11135	Floor pan assembly — mild steel
3	11160	Floor pan assembly — mild steel
4	11644	Crossmember — mild steel
5	10117	Floor side member assembly (LH) — HSLA 350 steel
6	10535	Floor side member assembly (LH) — HSLA 350 steel
7	10063	Side member extension (LH) — HSLA 350 steel
8	10062	Side member extension (RH) — HSLA 350 steel
9	10534	Floor side member assembly (RH) — HSLA 350 steel

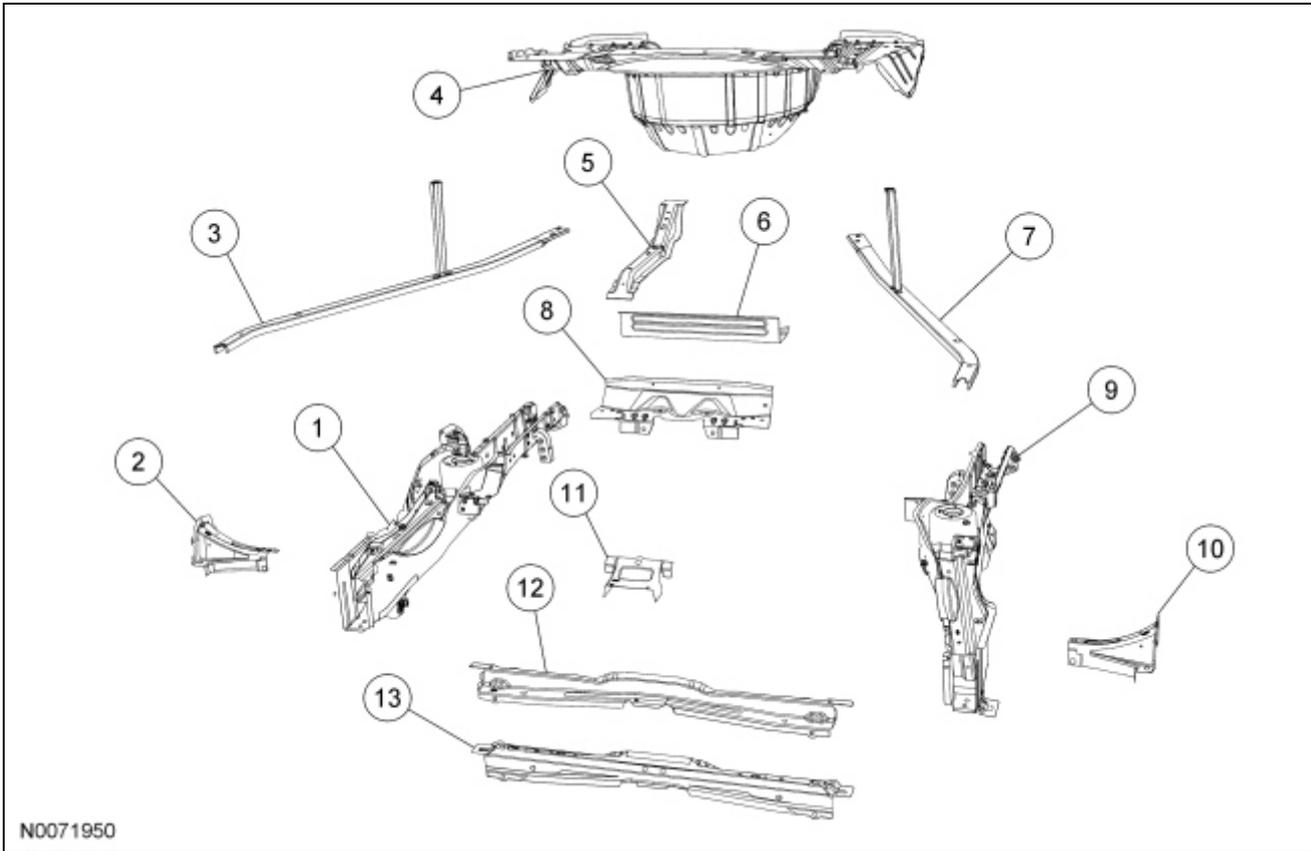
Underbody Rear — Coupe



N0071949

Item	Part Number	Description
1	10456	Side member assembly (RH) — High-Strength Low Alloy (HSLA) 350 steel
2	280C06	Support (RH) — HSLA 350 steel
3	11215	Floor pan assembly — mild steel
4	111K48	Reinforcement — HSLA 350 steel
5	10780	Rear crossmember — HSLA 350 steel
6	102A24	Center crossmember — HSLA 350 steel
7	10457	Side member assembly (LH) — HSLA 350 steel
8	280C07	Support (LH) — HSLA 350 steel
9	44502	Crossmember — HSLA 350 steel
10	11644	Crossmember — HSLA 350 steel

Underbody Rear — Convertible



N0071950

Item	Part Number	Description
1	10456	Side member assembly (RH) — High-Strength Low Alloy (HSLA) 350 steel
2	280C06	Support (RH) — HSLA 350 steel
3	102B54	Brace (RH) — mild steel
4	11215	Floor pan assembly — mild steel
5	11K48	Reinforcement — HSLA 350 steel
6	10780	Rear crossmember — HSLA 350 steel
7	102B55	Brace (LH) — mild steel
8	102A24	Center crossmember — HSLA 350 steel
9	10457	Side member assembly (LH) — HSLA 350 steel
10	280C07	Support (LH) — HSLA 350 steel
11	116A34	Reinforcement — mild steel
12	44502	Crossmember — HSLA 350 steel
13	11644	Crossmember — HSLA 350 steel

⚠ WARNING: Never install used or reconditioned parts (as specified below) from pre-owned, salvaged or damaged vehicles. The use of such parts could lead to serious injury.

Never use non-Ford parts or accessories for completing repairs.

Ford Motor Company does not approve or recognize body and structural repair procedures, tools, parts or anything but new genuine Ford equipment. Ford cannot attest to the safety, quality, durability or legality of non-Ford parts or accessories. Use of such parts could lead to serious personal injury as they may contain damage which is not visible.

Ford does not approve use of the following:

- Salvaged or used parts
- Major body clips or assemblies from salvage vehicles
- Aftermarket structural or body components
- Salvaged or reconditioned wheels
- Used supplemental restraint system (SRS) components
 - air bags
 - restraint system modules
 - safety belts, buckles or retractors
 - crash sensors

Returning a vehicle to pre-accident condition can only be assured if repair procedures are carried out by skilled technicians using new genuine Ford parts and Ford-approved methods. Structural component repair procedures approved by Ford, using genuine Ford parts, have been validated by Ford Motor Company engineers.

Ford Motor Company does not endorse, cannot attest to, and makes no representations regarding structural repairs (frames, rails, aprons and body panels) carried out using non-genuine Ford Motor Company parts or non-Ford-approved methods. In particular, Ford makes no representations that the vehicle will meet any crash safety or anti-corrosion performance requirement. Such parts and methods have not been tested by Ford, and may not meet Ford's requirements for safety, performance, strength, quality, durability and corrosion protection.

Ford Motor Company bears no responsibility or liability of any kind if repairs are performed using alternative structural component repair procedures and/or parts.

NOTE: Factory spot welds may be substituted with either resistance spot welds or Metal Inert Gas (MIG) plug welds. Spot/plug welds should equal factory welds in both location and quantity. Do not place a new spot weld directly over an original weld location. Plug weld hole should equal 8 mm (0.31 in) diameter.

NOTE: The following steps provide a general guideline for replacement of body structure components. Refer to exploded views for specific component and assembly information.

1. **NOTICE: Electronic modules and related wiring may be damaged when exposed to heat from welding procedures. Carefully disconnect and remove, or position away from heat affected areas.**

NOTE: When it is necessary to carry out weld-bonding procedures, refer to [Weld-Bonding](#) in this section.

Remove the outer body sheet metal from the affected area prior to carrying out any reinforcing panel replacement. For additional information, refer to [Sectioning Guidelines](#) in this section.

2. Where possible, create a backer piece using a portion of the old panel. This will create a stronger joint.
 3. When welding overlapping surfaces or substrates, apply a weld-through primer between the surfaces prior to welding. When the surfaces have been welded, apply corrosion protection material to the exterior surfaces or substrates.
 - Make sure horizontal joints and flanges are correctly sealed with seam sealer to prevent moisture intrusion. Water and moisture migrate to horizontal joints and corrosion tends to occur more rapidly in these areas. Metal surfaces must be clean and dry before applying seam sealer.
 4. Proceed with refinishing procedures following Ford-approved paint guidelines. Apply corrosion protection to the repair area as required.
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