

**FORD:**

1997-2001 Taurus  
2000-2001 Focus  
1997-2001 Expedition, F-250 LD, Windstar,  
F-Series

**LINCOLN:**

1998-2001 Navigator

**MERCURY:**

1997-2001 Sable

This article supersedes TSB **01-09-8** to update the vehicle line and model year coverage and service procedure.

**ISSUE**

Some vehicles may exhibit corrosion at the hem flange at bottom of any door/tailgate where the outer panel is folded over the inner panel.

**ACTION**

Repair corrosion at the hem flange using special hem flange tools. Refer to the following Service Procedure.

**SERVICE PROCEDURE****NOTE**

READ THIS REPAIR PROCEDURE COMPLETELY BEFORE PERFORMING ANY SERVICE ACTIONS.

**NOTE**

THE USE OF FORD OR MOTORCRAFT BRAND PRODUCTS ARE MANDATORY ON ALL REPAIR CLAIMS PAID BY FORD UNLESS OTHERWISE SPECIFIED IN EMISSIONS, SAFETY RECALLS, OWNER NOTIFICATION PROGRAMS, TSB'S OR OTHER COMPANY PUBLICATIONS. THE COST OF NON-FORD/MOTORCRAFT PRODUCTS USED FOR A WARRANTY, ESP/ESC OR AWA REPAIR WITHOUT JUSTIFYING THEIR USE (SUCH AS EMERGENCY REPAIR) IS NOT REIMBURSABLE. EXAMPLES OF FORD PRODUCTS ARE ADHESIVES, SEALERS, SOLVENTS, CLEANERS, WASHES, AND OTHER SPECIAL PRODUCTS LISTED IN THE FORD CAR CARE PRODUCTS MANUAL.

**NOTE**

TECHNICIANS SHOULD WEAR THE APPROPRIATE EYE, HAND AND HEARING PROTECTION WHILE PERFORMING THESE REPAIR PROCEDURES. ADHESIVES AND SEALERS USED IN THESE PROCEDURES SHOULD BE USED IN A WELL-VENTILATED AREA.

1. Inspect the inside of the door/tailgate at the lower edge only for corrosion/bubbling.
2. Follow the Workshop Manual procedure for the removal of the interior door panel or tailgate and tailgate moldings.
3. Use shop air to blow out the drain holes in the bottom of the door/tailgate and apply 25 mm (1") tape to the outer skin at the bottom to prevent scuffing.
4. Use a hammer and screwdriver to slightly lift the corner of the hem flange.
5. Insert TOOL 501-078/1(RT) or TOOL 501-078/2(LT) in an air impact gun (620 kPa (90 psi) air pressure is required for consistent tool operation). Using the tool lift the hem flange continuing across the bottom of the door/tailgate and stop just before the end.
6. Use an angle grinder or wire brush to remove all corrosion on the bottom of the hem flange and inner door/tailgate panel. Follow by blowing off with compressed air.
7. Using appropriate hand protection, brush on Corrosion Converter (Sem# 69508) on the corroded area. Use light coat and let flash dry 2-5 minutes. Follow by using a damp cloth to wipe off corrosion residue.

**NOTE:** The information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment to do the job properly and safely. It informs these technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The procedures should not be performed by "do-it-yourselfers". Do not assume that a condition described affects your car or truck. Contact a Ford, Lincoln, or Mercury dealership to determine whether the Bulletin applies to your vehicle. Warranty Policy and Extended Service Plan documentation determine Warranty and/or Extended Service Plan coverage unless stated otherwise in the TSB article. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ford Motor Company reserves the right to supersede this information with updates. The most recent information is available through Ford Motor Company's on-line technical resources.

## TSB 04-18-11 (Continued)

8. Sand with a DA sander using 360 grit sand paper the lower areas of the door/tailgate where paint was disturbed, keeping the repair area small. Feather edge for a paint blend as necessary. Blow off the panel with clean compressed air. Clean the panels with wax and remover.
9. Mix and brush on Ford approved epoxy or self-etching primer to all bare hem flange areas on the bottom of the door/tailgate. Bake at 140° F (60° C) panel temperature per manufacturers label instructions.
10. Install the Motorcraft TA-1 adhesive cartridge into the application gun 501-040. Squeeze out some material to purge the cartridge. Install the tip on the cartridge and squeeze out some material to make sure of even mixing of the adhesive components.
11. Apply the adhesive between the hem flange and bottom of the inner door/tailgate panel. Work time is 45 minutes at 70° F (21° C). Adhesive cure time is 8 hours.
12. Use TOOL 501-080 to re-hem (close down) the hem flange. Start in a corner, and insert the center of the tool over the area to close down and hit with a hammer.
13. Install the Motorcraft TA-2 urethane cartridge into the application gun 501-040. Squeeze out some material to purge the cartridge. Install the tip on the cartridge and squeeze out some material to make sure of even mixing of the adhesive components.
14. Apply Motorcraft TA-2 urethane seam sealer around the door/tailgate hem flange to give a finished appearance.
15. Remove any residual sealer with adhesive remover. Sealer is paintable in 10 minutes and within 24 hours.
16. Mask the door/tailgate for color application.
17. Mix and apply Ford approved basecoat color to the inside of the door/tailgate area and allow material to flash off.
18. Mix and apply Ford approved clearcoat to inside of the door/tailgate and bake at 140° F (60° C) panel temperature per following manufacturers recommended baking time.
19. Spray Dominion Sure Seal Amber anti corrosion coating (24011) to the inside of the door/tailgate at the hem location. Do not plug drain holes.
20. Demask the vehicle and, reinstall the inner door panel or tailgate moldings.

### SPECIAL TOOLS

- 501-078/1 RH Hem Opening Tool (Tools are direct ship from O.T.C.)
- 501-078/2 LH Hem Opening Tool
- 501-080 Hem Closing Tool
- 501-040 Adhesive Gun (Adhesive Gun not included in kits. This is a commonly used commercially available gun. Must be ordered separately from Rotunda.)

PART NUMBER	PART NAME
TA-1	Motorcraft Metal Bonding Adhesive
TA-2	Motorcraft Urethane Seam Sealer
Obtain Locally	Corrosion Converter (Sem #69508)
Obtain Locally	360 Grit Sand Paper
Obtain Locally	Ford Approved Epoxy Or Self-Etching Primer
Obtain Locally	Dominion Sure Seal Amber Anti Corrosion Sealer 24011

**WARRANTY STATUS:** Eligible Under Provisions Of New Vehicle Limited Warranty Coverage