

**FORD:**

2000-2007 Crown Victoria, Taurus  
2005-2006 Ford GT  
2005-2007 Mustang  
2000-2003 Ranger  
2000-2007 Expedition  
2002-2007 Explorer

2004-2007 F-150

2007 Explorer Sport Trac

**LINCOLN:**

2000-2006 Lincoln LS  
2000-2007 Town Car, Navigator

**MERCURY:**

2000-2007 Grand Marquis, Sable

This article supersedes TSB **04-25-1** to update the vehicle model years.

**ISSUE**

Some vehicles may exhibit a bubbling or blistering under the paint on aluminum body parts. This is due to iron contamination of the aluminum panel.

**ACTION**

This TSB provides service tips and procedures, outlining methods to properly prepare and protect aluminum body parts from cross contamination.

**BACKGROUND**

Ford's Scientific Research Laboratory has performed a number of tests on vehicle body parts returned for corrosion related concerns. Testing has revealed that the aluminum corrosion was caused by iron particles working their way into the aluminum body part, prior to it being painted.

**SERVICE TIPS AND PROCEDURE**

When repairing a vehicle for corrosion or collision damage, it is essential that extreme care be taken to cover and protect all aluminum parts to prevent cross metal contamination. Areas in a shop where metal work is performed should be sectioned off, using at the very least curtain walls, to prevent metal dust migration. Cross contamination can also occur through the use of metal working tools (hammers, dolly's, picks, grinding wheels, etc.). Tools used for aluminum repairs should be kept separate, and not used to repair other metals. Wire brushes used on aluminum should be made of stainless steel.

**NOTE**

THIS PROCEDURE SHOULD ONLY BE USED ON NON-PERFORATED METAL. REVIEW WARRANTY AND POLICY MANUAL FOR VEHICLE WITH PERFORATED METAL.

**NOTE**

READ THIS PROCEDURE COMPLETELY BEFORE PERFORMING ANY SERVICE.

1. Corrosion should be removed by blasting. Use an aggressive blasting material, such as acrylic (salt grain size).
2. Use a DA sander with 180 grit paper backed abrasive. Only sand and featheredge the damaged area.
3. Mix and apply Ford approved epoxy primer, per the manufacturer's label instructions. Bake at 140° F (60° C), or use an infra-red lamp for curing.
4. If necessary, mix and apply two-part polyester filler to a slight over crown. Allow polyester filler to cure 20-30 minutes, or mix and apply spray polyester filler two-three (2-3) coats as necessary. Allow to cure per manufacturer's label instructions.
5. Hand-sand the repair area with 80 grit sand paper to remove excess filler.
6. Finish-sand the repair area with 400 grit sand paper.
7. Mix and apply Ford approved primer/surfacer per manufacturer's label instructions. Bake at 140° F (60° C) or use infra-red lamp for curing.

**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 06-25-15 (Continued)

8. Sand the primer/surfacer with 400-600 grit to level the surface.
9. The next two steps are wet-on-wet. Mix and apply to hiding Ford recommended basecoat material per manufacturer's label instructions. Allow to flash.
10. Mix and apply two (2) coats (2 mils minimum) of Ford approved clearcoat per manufacturer's label instructions. Allow flash time. Finish bake at 140° F (60° C).

**WARRANTY STATUS:** Information Only