







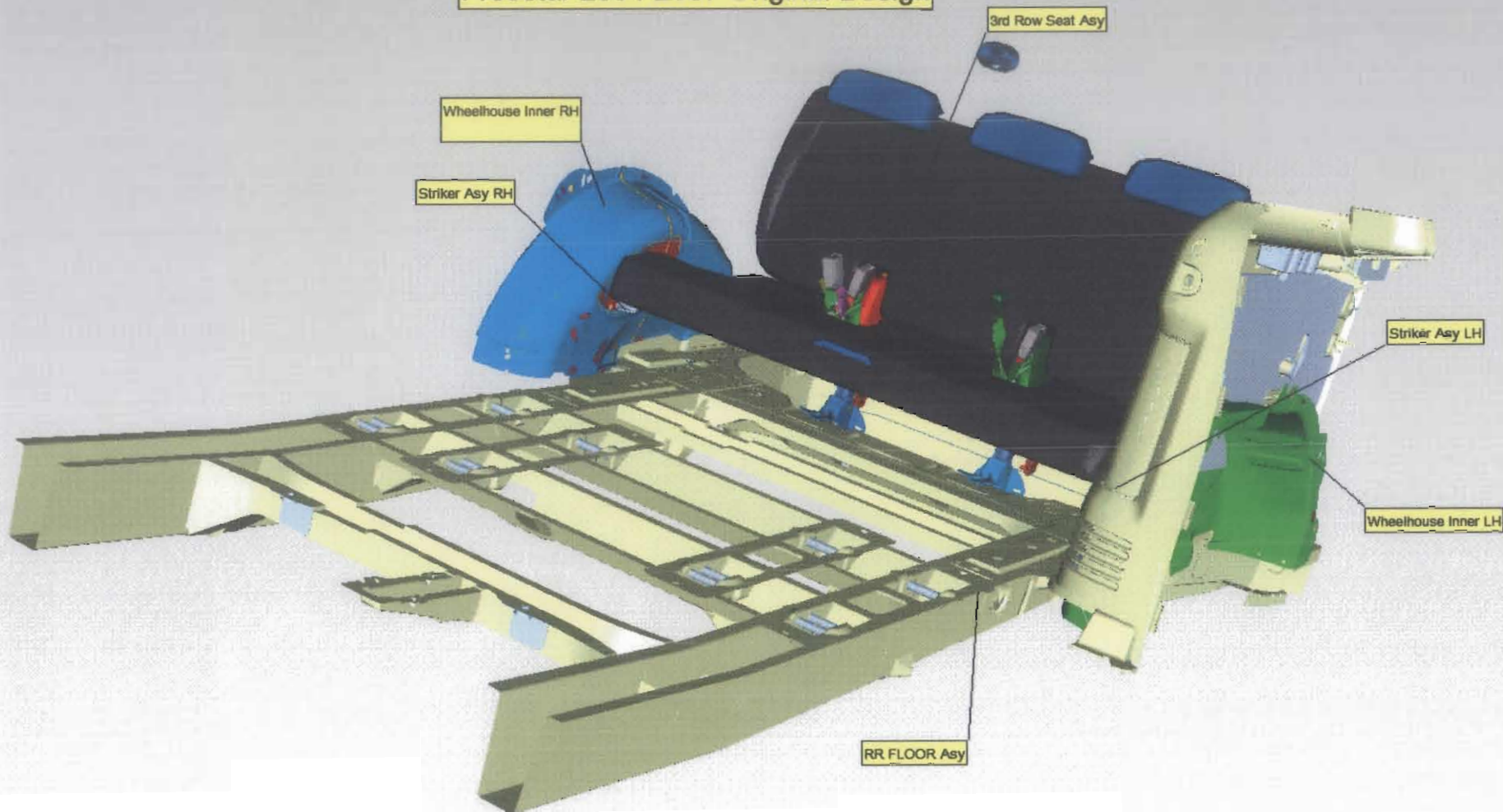
From: Tuneff, Mark (M.S.)
Sent: Tuesday, September 25, 2012 12:33 PM
To: Pancioli, Tim (T.N.); Frommann, Mike (M.W.)
Subject: Free*

We met at the Body and Paint Shop this morning and got agreement on the patch panel model. Additionally three sets of panels (I think we retained two) were hand punched to transfer the pilot holes. Tower took one set back to incorporate the holes into the CAD model. They are making three additional sets and we should have all of them either Friday or Monday.

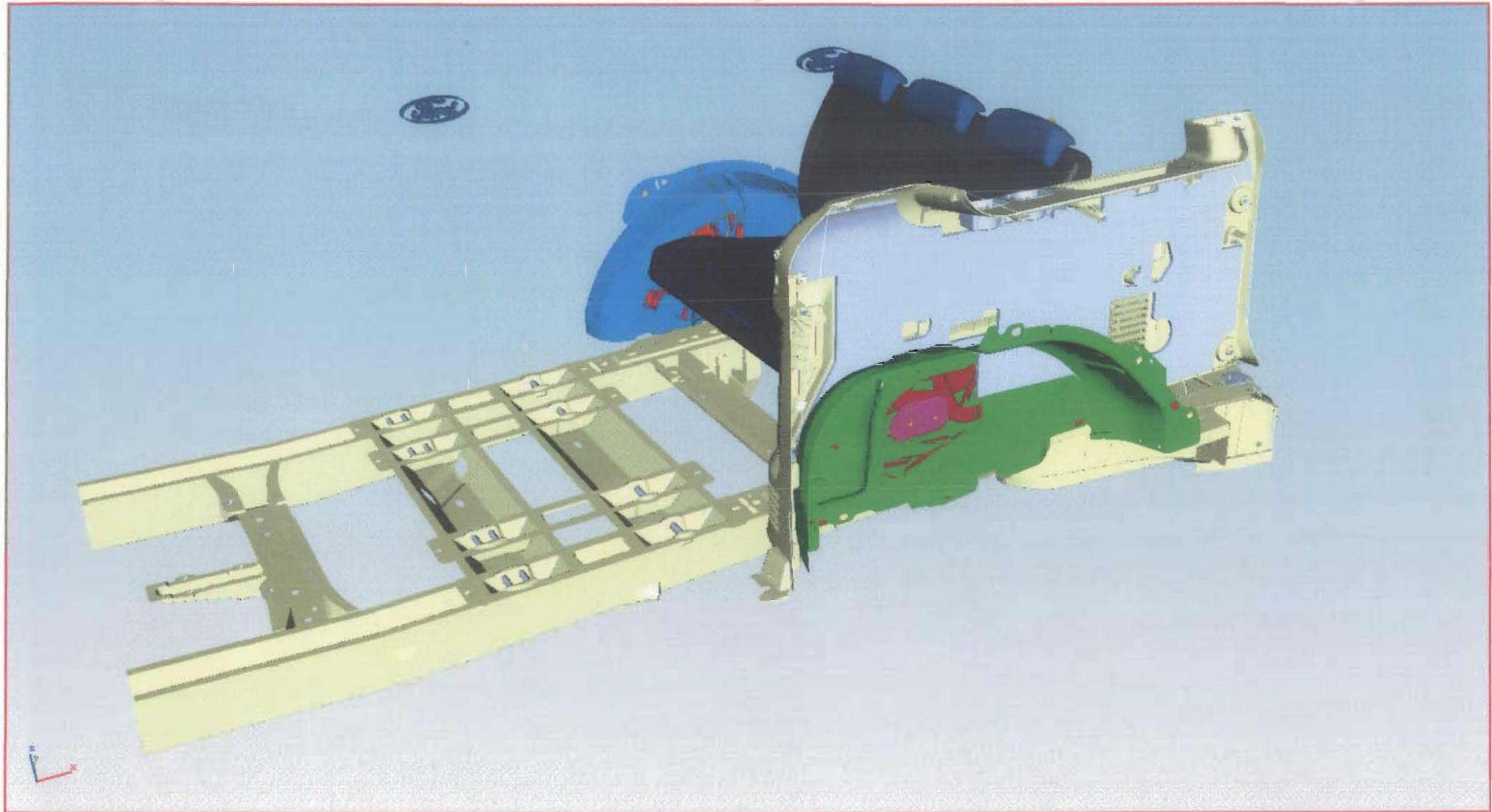
So, I believe between the brackets/fasteners that Dan has, the panels that Gerry has and will have, and the sealer that Gerry has (currently has a case of tubes) everything is available to conduct some trials!

Mark Tuneff
Ford Motor Company
Automotive Safety Office
Phone: 313-323-0394
Fax: 313-594-2268

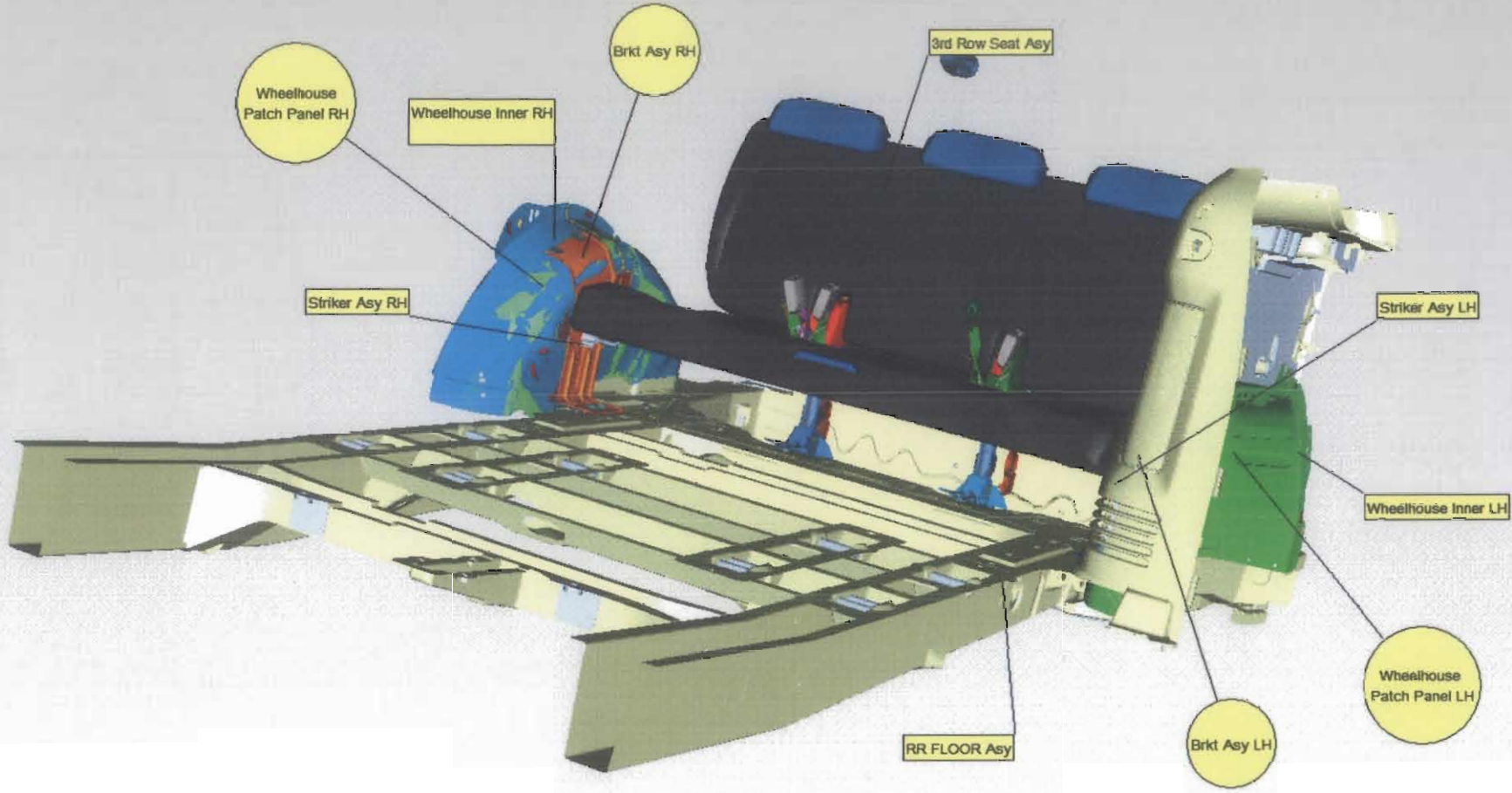
Freestar 2004-2007 Original Design







Freestar 2004-2007 Service Design



Freestar 3rd Row Seat Striker Repair

- Repair is done by a general service technician with normal hand tools
- Minimal disruption to the vehicle
- Brackets relocate mounting points for seat strikers and eliminate concerns of structure deterioration
- External patch panels provide seal from water/contaminate entry and further corrosion

Freestar 3rd Row Seat Striker Repair

- Parts & hardware are contained in one kit
 - Urethane sealer and spray undercoating are procured separately by dealer
- Service Labor Time for Repair is 3.1 Hours

Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



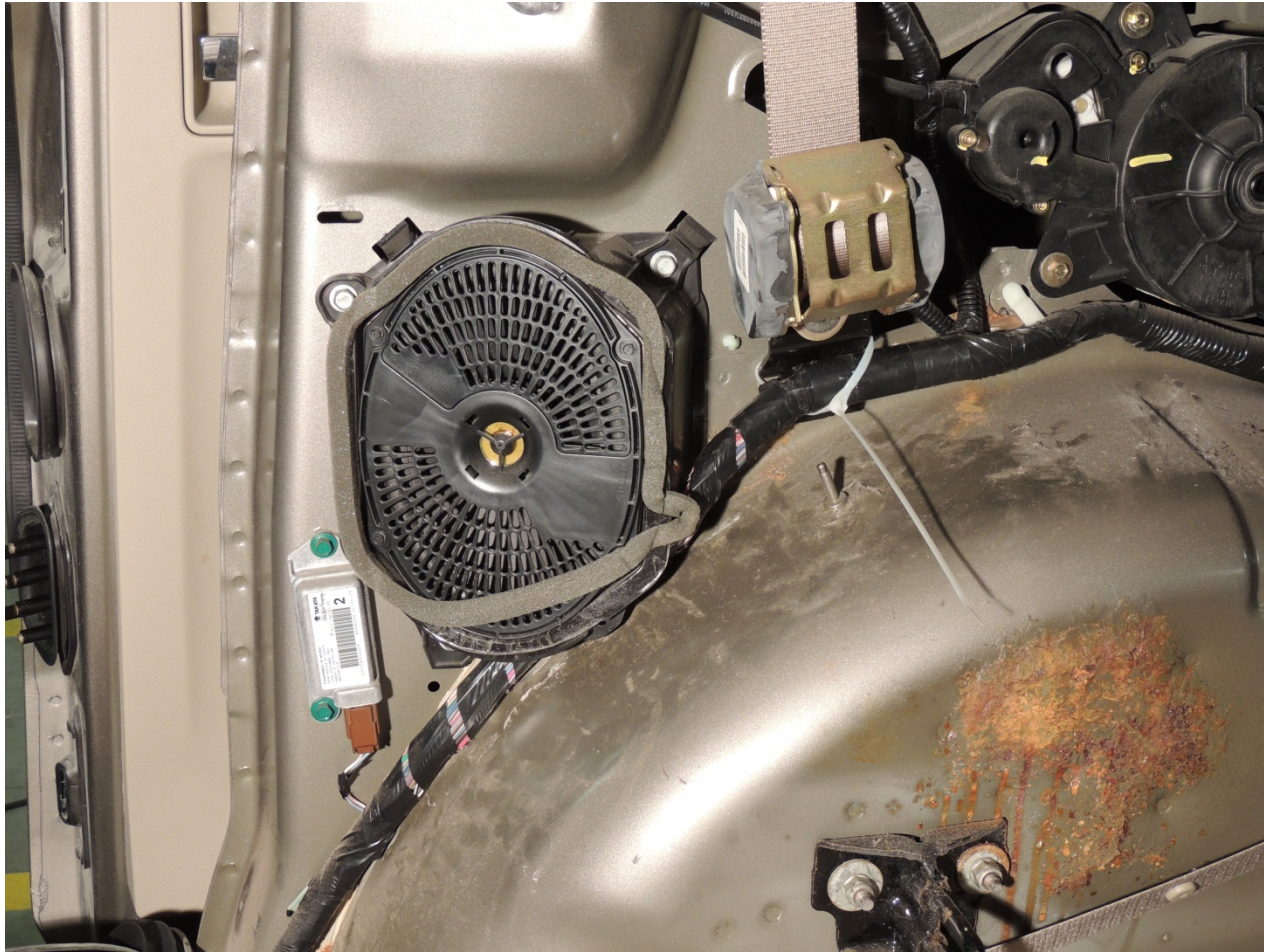
Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



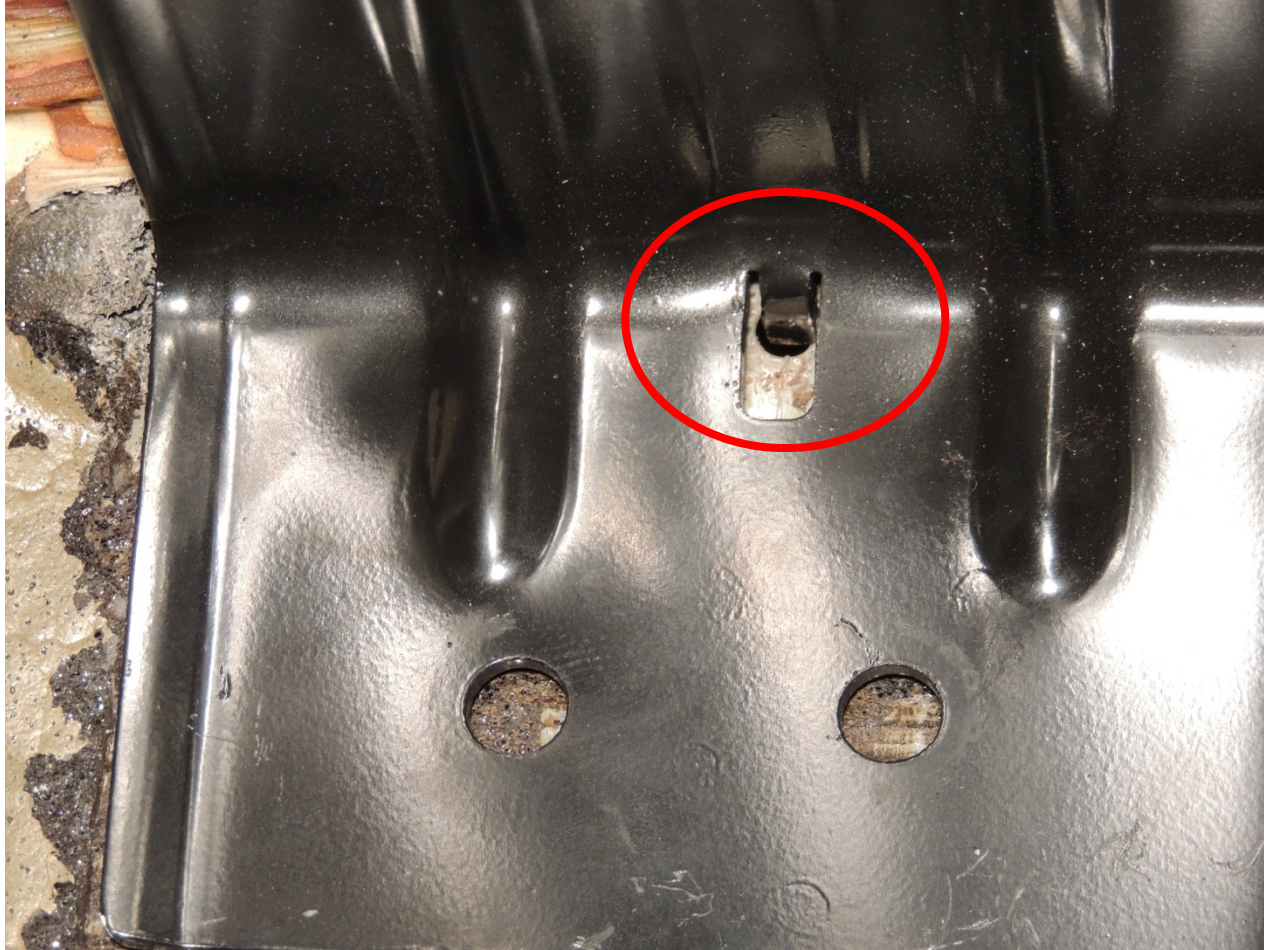
Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



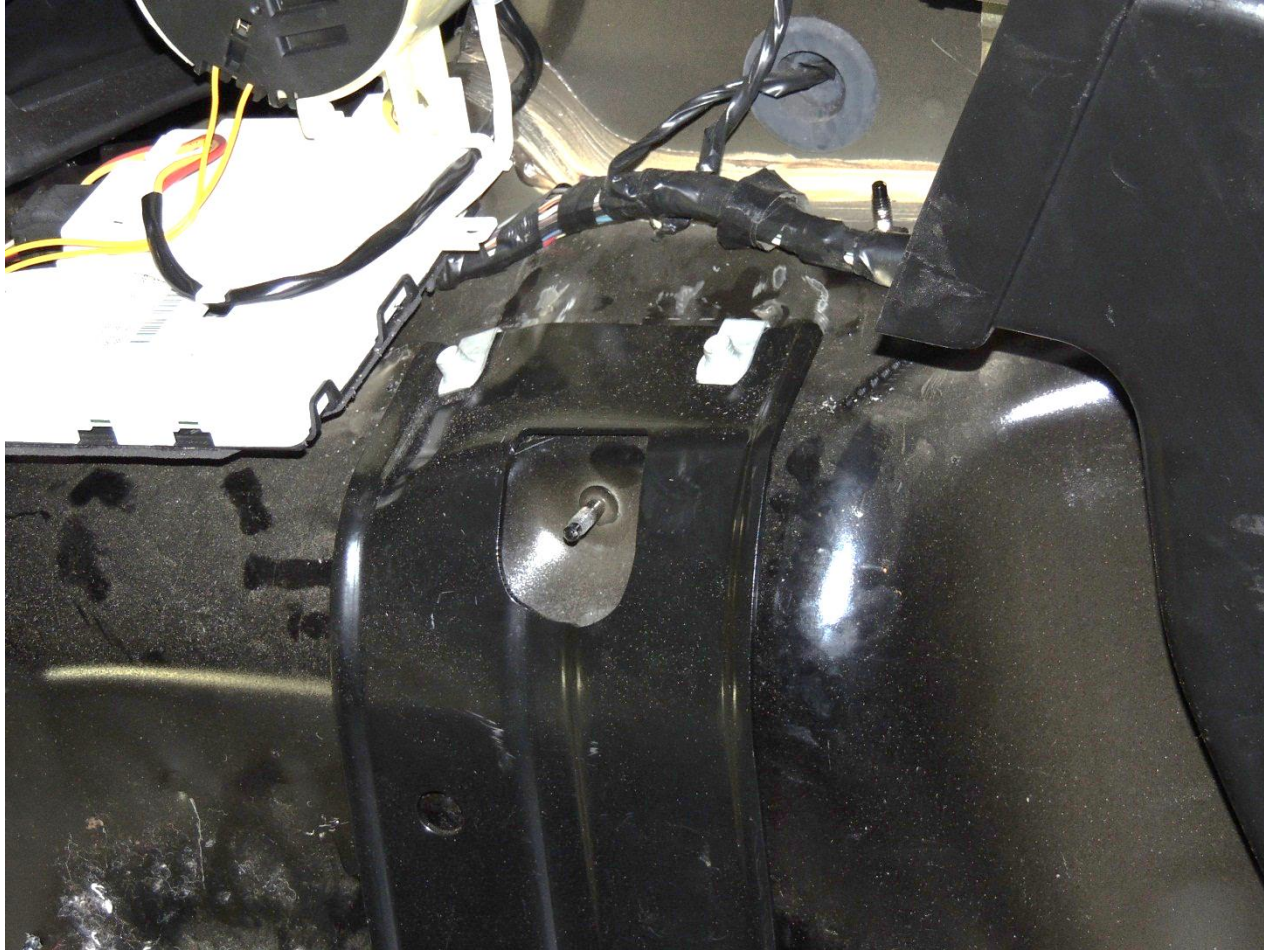
Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview



Repair Procedure Overview

- To complete repair:
 - Coat patch panels with spray undercoating
 - Install wheels/tires
 - Install original 3rd row striker assemblies
 - Reinstall interior trim, carpets, seats to original positions, etc.
 - Adjust strikers for proper proper seat operation

Repair Procedure Overview

Questions/Comments?

Repair Procedure Overview

Thank You!

From: Girolamo, Robert (R.F.)
Sent: Thursday, August 02, 2012 1:54 PM
To: Tuneff, Mark (M.S.)
Cc: Gurney, Chris (C.A.)
Subject: Freestar 3rd Seat Striker
Attachments: CG1BP011.pdf

Normally I only see VOQ reports, here's a CQIS report ...

Robert Girolamo

Automotive Safety Office
Fairlane Plaza South Suite 500
Phone: (313)84-58513 e-mail: rgirolam@ford.com

GCQIS Report Analysis

Report Summary

Report 1 of 1

Query Name: REPORT RETRIEVAL

Folder Number: [File Report To This Folder](#) [File Report To A Folder](#) [Download Options](#)
[Add Comments](#) [Previous](#) [Next](#) [Save](#) [Mail Report](#)

Report Detail Section : View Details [Attachments: 10](#)

Report# : CG1BP011 NHL **Received:** 07/27/2012
CCRG/EPRC: S **Reviewed Status:** **Date:** 07/31/2012
Vehicle: 2004,FREESTAR ,SEL ,LIMITED,WAGON ,2FMDA58214E **Build Date:** 10/10/2003
Odometer : 115,581 M **Engine:** 4.2L EFI **Calibration:** 4A41NA0A
Transmission: 4F50N **Axle:** **A/C:** YES
Dealer: USA 04611 Moser Motor Sales, Inc. **Phone#:** (260) 589-2171
City: Berne **State:** Indiana **Country :** USA
Originator: JOE GRABER
Symptom: 1 10 3 42 COMF/ENT,SEATS,2ND ROW/REAR,LOOSE/ATTACH
Status:
VFG: V03 SEATING
Additional Symptom: SEAT LATCH RUSTED
Fix: **Causal Component :**
Condition Code:

Hotliner: CGROH4 **Phone:** 313 317-9395 **Regn Cd:** G2 Detroit
Engineering: **Phone:** **TAR:**
Dlr Contact: JOE GRABER **Phone:** 260 589-2171 **Title Cde:** SM

KOEO:
KOEC:
KOER:

Comments:

REPAIR 07/27/2012 12:48PM CHRISTOPHE GROH MSS - FCSD - TECH SVC HOTLINE
 WEB FORM DATA - CONCERN:LEFT LATCH STRIKER FOT 2ND ROW SEAT FELL OUT
 BECAUSE STRIKER REINFORCEMENT RUSTED AWAY FROM INNER WHEEL
 HOUSING. DIAGNOSTICS: EXAMINED AND TOOK PICTURES. PARTS
 REPLACED:NONE TECH QUESTION:HAVE THERE BEEN ANY SIMILAR ISSUES? ANY
 REPAIR SUGGESTIONS SINCE THIS IS A SAFETY RELATED CONCERN? CUSTOMER
 REQUESTS TO HAVE PICTURES SENT TO FORD. WHAT IS MY BEST OPTION?

RECOMM 07/27/2012 12:48PM CHRISTOPHE GROH MSS - FCSD - TECH SVC HOTLINE
 HI JOE, IMAGES CAN BE SENT TO ETECH1@FORD.COM TO BE ATTACHED TO
 THIS HOTLINE ASSITANCE REQUEST. IF THE CUSTOMER WOULD LIKE TO SUBMIT
 THEIR OWN IMAGES REGARDING THE COCNERN THEY CAN CONTACT THE CUSTOMER
 RELASTIONSHIP CENTER AT 800-392-3673. IT WILL BE NECCESARY TO
 REPLACE THE DAMAGED PORTIONS OF THE BODY AND REPAIR THE SEAT BRACKET
 AS NECCESARY. RCOMMENT TO CONTACT PARTS ASSISTANCE CENTER AND VERIFY
 THE CORRECT COMPONENTS/PANELS NECCESARY TO REPAIR THE VEHICLE. SELECT
 PACO (PARTS ASSISTANCE CENTER ONLINE) UNDER PARTS & SERVICE TAB ON
 FMCDEALER. IF THE BODY REPAIRS CAN NOT BE MADE IN HOUSE IT MAY BE
 NECCESARY TO SUBLET TO A BODY REPAIR FACILITY.

ADD-ON 07/27/2012 12:48PM CHRISTOPHE GROH MSS - FCSD - TECH SVC HOTLINE
 CONSULTED C.GLENNIE: IF PICTURES ARE EMAILED TO ETECH1 PLEASE ATTACH
 TO GCQIS REPORT

ADD-ON 07/31/2012 10:02AM CHRISTOPHE GROH MSS - FCSD - TECH SVC HOTLINE

[Download Options](#)

ADDED IMAGES TO REPORT

Folder Number:

[File Report To This Folder](#)

[File Report To A Folder](#)

[Add Comments](#)

[Previous](#)

[Next](#)

[Save](#)

[Mail Report](#)

Requester: RGIROLAM
Report Summary
Server: FCWS686

Ford Proprietary, Private

2-Aug-2012
Retention: None

PARTS — SERVICE



07/12/2012 04:34 PM

EA12-003 000745

07/12/2012 04:34 PM



07/12/2012 04:34 PM



07/12/2012 04:33 PM



07/12/2012 04:33 PM



07/12/2012 04:32 PM



07/12/2012 04:32 PM

EA12-003 000751



07/12/2012 04:31 PM



07/12/2012 04:31 PM



3F23 1731057 ADW
CAV 3 LH
2PPK

5

07/12/2012 04:31 PM

From: Shastry, Sushil (S.)
Sent: Monday, May 14, 2012 3:02 PM
To: Witkowski, Brian (B.J.)
Subject: Freestar wheelhouse corrosion

Hi Brian,

I am working on Freestar wheel house corrosion issue and wondering if you could help me with recommending a suitable material to patch holes/corroded sections of wheel house.

Attached is picture of wheel house assembly with corrosion formation/no material condition on inner/outer wheel house area. We would like to patch this area in service and wondering if there are any suitable material/process that we can use it. Let me know if you would like to see any parts, I can stop by at your office this week to show you wheel house assembly parts.

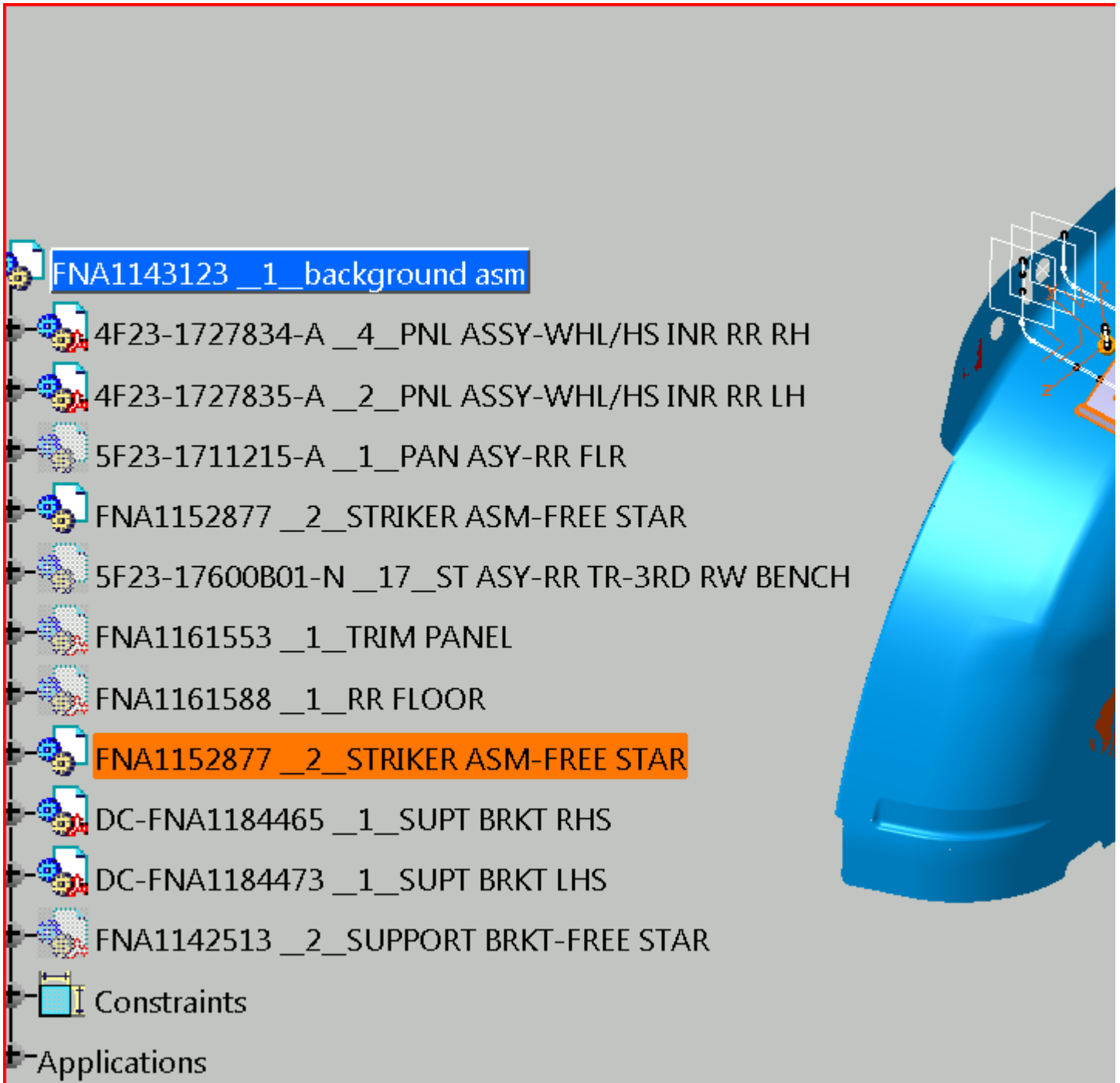
MY 2004 Freestar: Wheelhouse Corrosion Issue

Corrosion Lab sample, 80 k miles



Thanks
Sushil

From: Tannous, Dan (D.)
Sent: Friday, April 27, 2012 11:56 AM
To: Shastry, Sushil (S.)
Subject: Freestar Updated Brkt



Best Regards,

Dan Tannous
D & R Engineer

CRFTVC
25111 Glendale
Redford, MI 48239
Phone:(313)-592-2149 Cell (313) - 790-4347
E-mail: dtannous@ford.com

From: Tuneff, Mark (M.S.)
Sent: Thursday, May 10, 2012 1:04 PM
To: Pancioli, Tim (T.N.); Bonanni, Gerry (G.); Woodall, Robert (R.W.)
Subject: FW: Bracket assembly pictures
Attachments: DSCF1181.jpg; DSCF1160.jpg; DSCF1161.jpg; DSCF1162.jpg; DSCF1164.jpg;
DSCF1165.jpg; DSCF1166.jpg; DSCF1167.jpg; DSCF1168.jpg; DSCF1169.jpg;
DSCF1170.jpg; DSCF1175.jpg; DSCF1176.jpg; DSCF1178.jpg; DSCF1180.jpg;
DSCF1181.jpg; DSCF1187.jpg; DSCF1190.jpg; DSCF1191.jpg; DSCF1193.jpg

FYI.

-----Original Message-----

From: Shastry, Sushil (S.)

Sent: Tuesday, April 24, 2012 4:50 PM

To: Tuneff, Mark (M.S.); Ott, David (D.J.)

Cc: Kolar, Ted (T.V.)

Subject: Bracket assembly pictures

Per your request, forwarding the attached pictures of bracket assembly.
Let me know if you need any additional pictures.

Thanks
Sushil





































Medcraft 33-04463
PANA

⚠ WARNING
To reduce the risk of injury and / or death, ensure the seat is properly latched in the upright position / pulling the seat forward.

⚠ AVERTISSEMENT
Pour réduire les risques de blessures ou de décès, assurez-vous que le siège est bien verrouillé en position verticale et / ou tiré vers l'avant.





From: Donna Hope <donna.hope@martinrea.com>
Sent: Thursday, March 08, 2012 3:38 PM
To: Shastry, Sushil (S.)
Subject: FW: Confirmation
Attachments: 20120216164356.pdf

Sushil,

Per our conversation. Please see attached.

Donna Hope

Martinrea Ridgetown
99 Golf Course Line
Ridgetown, ON N0P 2C0
CANADA
519-674-0711 X240

From: Ian Wood
Sent: Friday, February 17, 2012 10:33 AM
To: mtuneff@ford.com
Cc: Donna Hope; Don Gillier; Paul Escott
Subject: FW: Confirmation

Good morning Mark

We have look in all our current and past records and databases: we can not find any information on the parts you are looking for.

Thanks

Ian Wood
Industrial Engineering
Martinrea Fabco
99 Golf Course Line
Ridgetown, Ontario
N0P 2C0
Phone 519 674 0711
Fax. 519 674 0500
ian.wood@martinrea.com

From: Donna Hope
Sent: February 16, 2012 4:47 PM
To: mtuneff@ford.com
Cc: Ian Wood
Subject: FW: Confirmation

Mark,

Attached are copies of the Ford service screens from Ford DDL. I have forwarded this e-mail a few people for information. I will be off until Tuesday and will try to get all the info requested.

Donna Hope

Martinrea Ridgetown
99 Golf Course Line
Ridgetown, ON N0P 2C0
CANADA
519-674-0711 X240

From: Tuneff, Mark (M.S.) [<mailto:mtuneff@ford.com>]
Sent: Thursday, February 16, 2012 3:45 PM
To: Donna Hope
Subject: Confirmation

Hi Donna,

This note is to confirm our telephone conversation concerning the 2004-2007 model year Ford stamping questions. For reference we were discussing service part numbers:

3F2Z-1727886-AA

3F2Z-1727887-AA

These are the rear wheel well inner components for the Freestar/Monterrey vehicles. I understand that the "886" part number is now a -BA suffix and is currently obsolete. The "887" part is currently available in the -AA version but is also now a -BA suffix, but there are a small number available.

If possible, it would be very helpful for us to know:

- A bill of material for the parts
- Any process sheets for the parts
- Any change history that may be available
- If the tooling is still available to produce both parts (one is left hand and one is right hand)
- Also, if any history of production facilities (back during vehicle production and then into service)

Thank you very much for your assistance!

Mark Tuneff
Ford Motor Company
Automotive Safety Office
Phone: 313-323-0394
Fax: 313-594-2268

==>

ENG PART: **4F23 1727835 AA** ORIGIN: **WERS** REGION: USG STAT:
 Eng Name: PNL ASY QTR WHL/HS INR LH PT: PTO: VL:
 Svc Part: **3F2Z- 1727887-AA** Replaces: Y Is Replcd: N USG IND:

P In Out
 t Vl Yr Yr Feature Descriptions Feature Descriptions
 - - - - -

T A4 04 07 FREESTAR/MONTEREY

F1=Help F4=Prv F5=Nxt F9=UAFA F10=EXEA F11=EPEA F13=RPLD F14=RPLG
 RECORD FOUND AA27827

==>

SERVICE PART: **3F2Z- 1727887-AA** PANEL AND WHEELHOUSE - QTR - INNER
ENGINEERING PART: **4F23 1727835 AA** ORIGIN: **WERS**
SUPPLIER LOC: **F014J** FINIS: **4599287**
Vendor Part: Fam Buy:
Motorcraft Part: Prime Suplr: **F014J**
Comparable Part: Packager Cd: F201C
Replaced Part: 3F2Z- 1727887-BA Mat Content:
Replacing Part: Ship Mlt: 0
Buyer: 04C [REDACTED] NBA Phone: [REDACTED]
Dmnd Anlyst: 3GB ADAM MATUSKA X84302 NDA Phone: [REDACTED]
Prod Anlyst: 205 TODD CAVENDER NPA Phone: [REDACTED]
Price Anlyst: I88 DAWIT TEKLEMARIAM Profs ID: DTEKLEMA
Color Name: Pallet Qty: 20
Pnd Obs: Svc Disp: Unit Issue: 1 Overpack Qty: 0
Obs Not: Mech Ob Cd: Trfc Cd: 411 Max Ord Qty: 0
Obs Eff: Procure Cd: 3 Hvy Trk App/Cd: 2 / Min Run Qty: 0
Eff In: 08/25/03 Rlse Hld: N Fab/Hold: N Min Ship Qty: 0
Eff Out: 01/02/07 Final Rlse: N Wgt UOM: LB Package Wgt: 6.15
Ord Dte: 08/25/03 Spec Pgm: N Dir Ship: Standard Cst:
Commdty: 010104 Volume Grp: F Rack/Plt: ZE21 Dealer Net:
F1=Help F2=GIMA F4=PrvPart F5=NxtPart F6=PIGA F9=DEEA F10=HIIA F11=ARFA
RECORD FOUND AA27827

==>

SERVICE PART: **3F2Z- 1727887-BA** PANEL AND WHEELHOUSE - QTR - INNER
ENGINEERING PART: **4F23 1727887 AA** ORIGIN: **WERS**
SUPPLIER LOC: **F014A** FINIS: **4599288**
Vendor Part: Fam Buy:
Motorcraft Part: Prime Suplr:
Comparable Part: Packager Cd: F201C
Replaced Part: Mat Content:
Replacing Part: **3F2Z- 1727887-AA** Ship Mlt: 0
Buyer: B27 XXXXXXXXXX NBA Phone:
Dmnd Anlyst: 3HA TOMAS BREZINA X 84311 NDA Phone: 800-973-3109
Prod Anlyst: 205 TODD CAVENDER NPA Phone: 313-390-6858
Price Anlyst: I88 DAWIT TEKLEMARIAM Profs ID: DTEKLEMA
Color Name: Pallet Qty: 0
Pnd Obs: 05/21/03 Svc Disp: U Unit Issue: 1 Overpack Qty: 0
Obs Not: 09/30/03 Mech Ob Cd: Trfc Cd: 79 Max Ord Qty: 0
Obs Eff: 09/30/03 Procure Cd: Hvy Trk App/Cd: 2 / Min Run Qty:
Eff In: 08/25/03 Rlse Hld: N Fab/Hold: N Min Ship Qty:
Eff Out: 01/02/07 Final Rlse: N Wgt UOM: Package Wgt: 0.00
Ord Dte: 08/25/03 Spec Pgm: N Dir Ship: Standard Cst:
Commdty: 010104 Volume Grp: C Rack/Plt: Dealer Net:
F1=Help F2=GIMA F4=PrvPart F5=NxtPart F6=PIGA F9=DEEA F10=HIIA F11=ARFA
RECORD FOUND AA27827

==>

SERVICE PART: **3F2Z- 1727887-AA** _____ PANEL AND WHEELHOUSE - QTR - INNER
 BACKCAST: **Y** DEMAND GROUP: _____

A	C	YEAR	Quantity	Replaced Part Number	Message
-	-	----	-----	-----	-----
		2012	3		
		2011	6		
		2010	2		
		2009	1		
		2008	4		
		2007	16		
		2006	11		
		2005	19		
		2004	5		
		2003	0	3F2Z- 1727887-BA	REPLACED
		2002	0		
		2001	0		
		2000	0		

F1=Help F2=FirstMonth

MORE RECORDS AVAILABLE

AA27827

==>

SERVICE PART: **3F2Z- 1727887-AA** PANEL AND WHEELHOUSE - QTR - INNER
 LOCATION LEVEL: **2** Out Of Tolerance: N As Of Date: 01/31/12
 RECEIVING LOC: _____ Forecaster Id: 05 Remarks: Y

Mth/Yr	Pr 3 Yr Dmd	Pr 2 Yr Dmd	Pr Yr Dmd	Forecast
02/12	0	0	0	0
03/12	0	0	1	1
04/12	0	0	0	1
05/12	1	0	0	0
06/12	0	0	1	1
07/12	0	0	0	1
08/12	0	0	0	0
09/12	0	0	1	1
10/12	0	0	3	1
11/12	0	0	0	0
12/12	0	2	0	1
01/13	0	0	2	1
TOTAL	1	2	8	8

F1=Help F2=FBVA F4=ISVA F5=PrevLoc F6=NextLoc F9=GIMA F10=CPHA F11=SDBA
 RECORD FOUND AA27827

==> Analyst: 3GB

SERVICE PART: 3F2Z- 1727887-AA PANEL AND WHEELHOUSE - QTR - INNER

ENGINEERING PART: 4F23 1727835 AA ORIGIN: WERS

SUPPLIER LOC: F014J MARTINREA FABCO METALLIC FINIS: 4599287

Vendor Part:

Motorcraft Part: Prime Suplr: F014J

Role: M

-----Inventory-----	-----Stocking Demand-----	Backcast:
FCSD Available: 38	Current Month: 1	Max Ord Qty: 0
Pkgr Available: 0	Prior Month: 2	Volume Group: F
In-Trans Pkgr: 0	Prior Month 2: 0	Last Release:
In-Trans FCSD: 0	Prior Month 3: 0	Lead Time: 30
Transfers: 0	Curr Forecast: 0	Procure Cd: 3
Back Ord Pcs: 0	6-Mo Forecast: 4	Sales Restr: N
Tot Inventory: 38	Out of Tolerance: N	Last ASN Qty:
		Last ASN:
Tot Curr Pos: 38	Back Ord Lines: 0	Last Rcpt Pkg:
Est'd Max Pos: N/A	Off B/O Date:	Abnormal Cat: 3
Firm Release: N	Unit Issue: 1	Design Style:
FAD Inventory: 0	Pnd Obs:	Stock Exhaust:

F1=Help F2=GPMA F4=PrvPart F5=NxtPart F6=BDLA F9=DEEA F10=HIIA
 F11=CPHA F13=SYKA F14=SMKA F15=SCKA F16=ISBA F17=LXEA F18=RXEA F19=DRIA
 RECORD FOUND AA27827

Ford Inventory

==>

ENG PART: **4F23 1727834 AA** _____ ORIGIN: **WERS** REGION: _ USG STAT: _
 Eng Name: PNL ASY QTR WHL/HS INR PT: _ PTO: _____ VL: _
 Svc Part: **3F2Z- 1727886-AA** Replaces: Y Is Replcd: N USG IND: _

P In Out

t	Vl	Yr	Yr	Feature Descriptions	Feature Descriptions

B A4 07 FREESTAR/MONTEREY

T A4 04 07 FREESTAR/MONTEREY

F1=Help F4=Prv F5=Nxt F9=UAFA F10=EXEA F11=EPEA F13=RPLD F14=RPLG
 RECORD FOUND

AA27827

==>

SERVICE PART: **3F2Z- 1727886-AA** PANEL AND WHEELHOUSE - QTR - INNER
ENGINEERING PART: **4F23 1727834 AA** ORIGIN: **WERS**
SUPPLIER LOC: **F014J** FINIS: **4599286**
Vendor Part: Fam Buy:
Motorcraft Part: Prime Suplr:
Comparable Part: Packager Cd: F201C
Replaced Part: 3F2Z- 1727886-BA Mat Content:
Replacing Part: Ship Mlt: 0
Buyer: 04C [REDACTED] NBA Phone: [REDACTED]
Dmnd Anlyst: 3GB ADAM MATUSKA X84302 NDA Phone: 800-973-3109
Prod Anlyst: 205 TODD CAVENDER NPA Phone: 313-390-6858
Price Anlyst: I88 DAWIT TEKLEMARIAM Profs ID: DTEKLEMA
Color Name: Pallet Qty: 20
Pnd Obs: 06/03/11 Svc Disp: U Unit Issue: 1 Overpack Qty: 0
Obs Not: 06/03/11 Mech Ob Cd: Trfc Cd: 411 Max Ord Qty: 0
Obs Eff: 08/12/11 Procure Cd: 0 Hvy Trk App/Cd: 2 / Min Run Qty: 0
Eff In: 06/23/03 Rlse Hld: N Fab/Hold: N Min Ship Qty: 0
Eff Out: 01/02/07 Final Rlse: N Wgt UOM: LB Package Wgt: 6.15
Ord Dte: 06/23/03 Spec Pgm: N Dir Ship: Standard Cst:
Commdty: 010104 Volume Grp: C Rack/Plt: ZE21 Dealer Net:
F1=Help F2=GIMA F4=PrvPart F5=NxtPart F6=PIGA F9=DEEA F10=HIIA F11=ARFA
RECORD FOUND AA27827

==>

SERVICE PART: **3F2Z- 1727886-BA** PANEL AND WHEELHOUSE - QTR - INNER
ENGINEERING PART: **3F23 1727886 AJ** ORIGIN: **WERS**
SUPPLIER LOC: **F014A** FINIS: **4521150**
Vendor Part: Fam Buy:
Motorcraft Part: Prime Suplr:
Comparable Part: Packager Cd: F201C
Replaced Part: Mat Content:
Replacing Part: **3F2Z- 1727886-AA** Ship Mlt: 0
Buyer: B27 [REDACTED] NBA Phone:
Dmnd Anlyst: 3HA TOMAS BREZINA X 84311 NDA Phone: 800-973-3109
Prod Anlyst: 205 TODD CAVENDER NPA Phone: 313-390-6858
Price Anlyst: I88 DAWIT TEKLEMARIAM Profs ID: DTEKLEMA
Color Name: Pallet Qty: 0
Pnd Obs: 05/21/03 Svc Disp: U Unit Issue: 1 Overpack Qty: 0
Obs Not: 09/12/03 Mech Ob Cd: Trfc Cd: 79 Max Ord Qty: 0
Obs Eff: 09/12/03 Procure Cd: Hvy Trk App/Cd: 2 / Min Run Qty:
Eff In: 06/23/03 Rlse Hld: N Fab/Hold: N Min Ship Qty:
Eff Out: 01/02/07 Final Rlse: N Wgt UOM: Package Wgt: 0.00
Ord Dte: 06/23/03 Spec Pgm: N Dir Ship: Standard Cst:
Commdty: Volume Grp: C Rack/Plt: Dealer Net:
F1=Help F2=GIMA F4=PrvPart F5=NxtPart F6=PIGA F9=DEEA F10=HIIA F11=ARFA
RECORD FOUND AA27827

From: Healey, Basil (P.B.)
Sent: Wednesday, August 15, 2012 1:05 PM
To: Rooker, Heather (H.R.)
Subject: FW: Detailed Parts List (BOM) and any pricing details needed

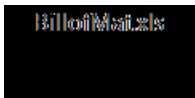
From: Shastry, Sushil (S.)
Sent: Wednesday, August 15, 2012 1:03 PM
To: Pancioli, Tim (T.N.); Healey, Basil (P.B.)
Cc: Frommann, Mike (M.W.); Tuneff, Mark (M.S.)
Subject: RE: Detailed Parts List (BOM) and any pricing details needed

Tim,

Attached is the bill of material.

We currently have 2004 vehicle (White 2004, Freestar vehicle) with prototype bracket/hardware installed on it. If it meets your requirements, you can use this vehicle/hardware and SLA patch panel to complete the initial time study. The bracket/hardware design is very close to production release design.

I will have next round of prototype parts (production release level - Bracket and patch panels) available around 08/27/2012.



Thanks
Sushil

From: Pancioli, Tim (T.N.)
Sent: Tuesday, August 14, 2012 2:02 PM
To: Shastry, Sushil (S.); Healey, Basil (P.B.)
Cc: Frommann, Mike (M.W.); Tuneff, Mark (M.S.)
Subject: Detailed Parts List (BOM) and any pricing details needed
Importance: High

Sushil / Basil - We are working with finance on understanding how the parts and labor will be priced for this recall and it would be real helpful if we had a detailed parts list and similar pricing estimates for each of the pieces for the discussions. We know these are a work in progress and anything you can provide would be appreciated. We need this today if you can provide whatever you have.

Sushil – Similarly, we will need to do a rough labor time study with a virgin vehicle as soon as we have some of those outer patch panels and representative hardware. Please advise when we will have the parts and I'll set this up. I will write a rough draft of the Tech Instructions for Bob to follow for the trial. I will collaborate with you and other key team members on the order of the repair steps.

Thanks,
Tim

2004 - 2007 Freestar: Support Bracket Bill of Material

				QTY /Vehicle	Supplier
4F23 605W07 AA PLT ASY RR ST CSHN LAT STRKR ANC Kit Asy		Final	New	1	
4F23	278B87 AA BRA QTR WHL/HS TO RR FLR S/M RR	Component	New	1	Tower
4F23	605K39 AA PLT RR ST BK FLR REINF	Component	New	1	Tower
W520833	S437 NUT U SPG M8 0.8-4.0 P/T	Component	C/O	2	Current Production
W708951	S437 BOLT&WSHR M8X24 HX PIL FL 10	Component	C/O	2	Current Production
W713528	S440 NUT M10 HF PTM 8	Component	C/O	2	Current Production
W716814	S439 BOLT&RET M10X30 HF PIL DUAL 10	Component	New	1	Alpha?
4F23 605W08 AA PLT ASY RR ST CSHN LAT STRKR ANC Kit Asy		Final	New	1	
4F23	278B86 AA BRA QTR WHL/HS TO RR FLR S/M RR	Component	New	1	Tower
4F23	605K39 AA PLT RR ST BK FLR REINF	Component	New	1	Tower
W520833	S437 NUT U SPG M8 0.8-4.0 P/T	Component	C/O	2	Current Production
W708951	S437 BOLT&WSHR M8X24 HX PIL FL 10	Component	C/O	2	Current Production
W713528	S440 NUT M10 HF PTM 8	Component	C/O	2	Current Production
W716814	S439 BOLT&RET M10X30 HF PIL DUAL 10	Component	New	1	Alpha?
Patch Panel Assembly					
4F23-277A21	AA	Final	New	1	Tower?
4F23-277A20	AA	Final	New	1	Tower?
W790320	(S900 Zinc Finish) Attachment screws, 1/2 inch drill screw	End item	NEW	50	Motorcity Fastener (Shelf item)

From: Strack, Fred (F.)
Sent: Friday, August 10, 2012 3:28 PM
To: Rooker, Heather (H.R.); Healey, Basil (P.B.)
Subject: FW: Ford Freestar Wheel Well Patch

Please see that attached comments from Tower. Tooling adaptation on the BSP tooling for the patch panel is 5 weeks, however they were asked to quote an early bank build.

Please provided direction on 1) early banking of parts and 2) authorization for procuring steel. If no bank is needed then tooling can be done in 5 weeks. This is a shorter lead time than the bracket tools.

Final CAD is required before any changes can be made.

Steel costs are fluctuating so current quotes are based on \$0.60 per pound.

Regards,

Fred Strack
Buyer - Ford Global Purchasing - FCSD
313-390-1592
Fax 313-621-2940

From: John Taylor [<mailto:taylor.john@towerinternational.com>]
Sent: Friday, August 10, 2012 3:23 PM
To: Strack, Fred (F.)
Cc: Mike Kavulich; Mark Mariotti
Subject: Ford Freestar Wheel Well Patch

Fred,

Just a note regarding "early parts" while we are building the production tools to run Ford Freestar wheel well patch panels. The coils of steel (both \$\$ and availability) are quickly becoming our biggest obstacle in the making of early parts (quantity = 10,000 ~ 12,000). Here is what we are up against.

- We need a purchase order for securing the steel very soon. We have located 75% of the need steel for early parts, the steel just needs to be slit to our width. Cost is \$0.60 a pound.
- The blank weighs 27.56 pounds
- We need 11 coils at 30,000 pounds each to produce 12,000 pairs of wheel well patches
- We will need four to five weeks to modify the form tool (Ford draw die from Buffalo Stamping)

Tower intends to set the tools up in Elkton, run five ~ six weeks of parts (750 pairs a week). Then send draw tool out for modifications needed to run production (four to five weeks), then run existing early parts while finishing the other two new tools (pierce and trim dies). This process (early fix of draw die) would give Tower

the ability to produce more early parts than the quoted 10,000 ~ 12,000 pair, but having material to run "up front" parts is essential.

Regards,

John Taylor

Tower International

Manager: Product Design

Manager: Prototype Engineering

Desk: 248.675.6130

Cell: 248.444.0065

Fax: 248.675.6631

Subject: FW: Freestar 3rd Row Seat Latch SLTS Development
Location: FBP3 Main Garage

Start: Thu 10/11/2012 8:30 AM
End: Thu 10/11/2012 1:00 PM
Show Time As: Tentative

Recurrence: (none)

Meeting Status: Not yet responded

Organizer: Pancioli, Tim (T.N.)

Forwarding in case you want to and are able to drop in to review repair. The vehicle we are using for the Time Study was rated as a "3" on one side and a "4" on the other side (5 being the worst).

Thanks,
Tim

-----Original Appointment-----

From: Pancioli, Tim (T.N.)
Sent: Monday, October 08, 2012 2:04 PM
To: Pancioli, Tim (T.N.); Sukiennik, John (J.); Grove, Dave (Dave.Grove@spx.com); Wilson, Lee (Lee.Wilson@spx.com); 'Roscoe, Bob'; Rivera, Santos (S.); Frommann, Mike (M.W.); Tuneff, Mark (M.S.)
Subject: Freestar 3rd Row Seat Latch SLTS Development
When: Thursday, October 11, 2012 8:30 AM-1:00 PM (UTC-05:00) Eastern Time (US & Canada).
Where: FBP3 Main Garage

This trial will serve purposes for development of Service Labor Time Development and to enable capturing necessary photos for Technical Instructions.

Note that I will schedule a meeting to occur Wednesday to review changes in procedure including:

- Relaxed cleaning of undercoating in wheel well
- Reordering of some procedure steps
- How to best secure wire harnesses up and out of the way
- How to best direct technicians to protect harnesses from sharp screws after patch panel installation
 - Cut off screws?
 - Use tie straps to hold harnesses up?
 - Other ideas?

From: Pancioli, Tim (T.N.)
Sent: Monday, July 30, 2012 1:01 PM
To: Frommann, Mike (M.W.); Bazil, Tom (Thomas E.); Kopeika, Charles (C.R.)
Subject: FW: Freestar buck build w/ SLA Patch Panels

Importance: High

FYI – This shows the proposed area of coverage.

From: Shastry, Sushil (S.)
Sent: Monday, July 30, 2012 12:23 PM
To: Tuneff, Mark (M.S.); Pancioli, Tim (T.N.); Bonanni, Gerry (G.); Woodall, Robert (R.W.); Leach, Michael (MDL.); Tannous, Dan (D.)
Cc: Kolar, Ted (T.V.)
Subject: Freestar buck build w/ SLA Patch Panels
Importance: High

FYI -
Attached please find some pictures of buck with SLA patch panels (W/ drill screws and no sealer /adhesive). We are planning to use sealer/adhesive material on patch panel prototype parts (metal parts) .



Thanks
Sushil

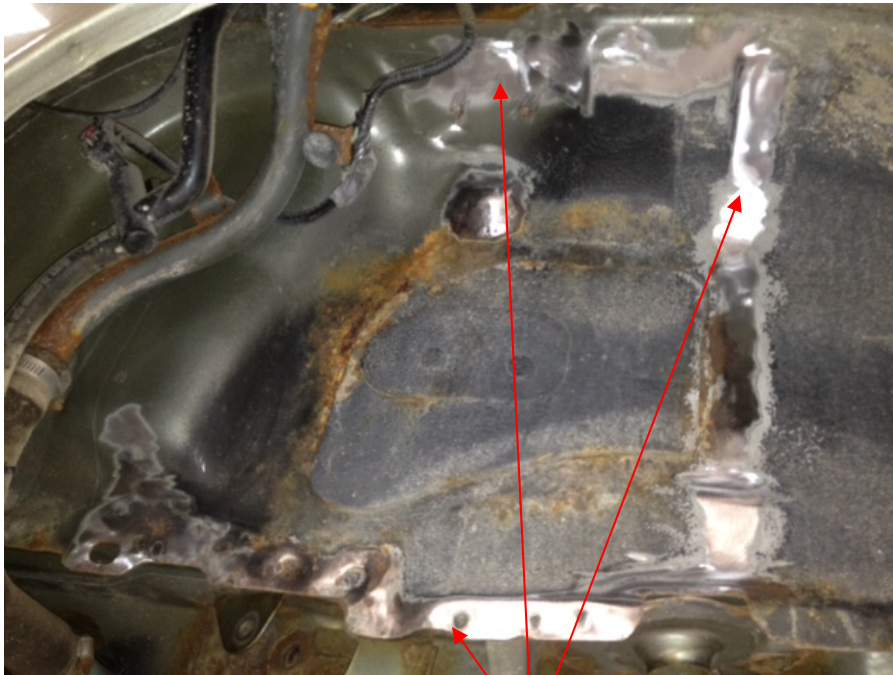
2004 Freestar

Buck Build w/ SLA Patch Panel

07/27/2012

2004 Freestar Buck: SLA Patch Panels

- **Driver side:**



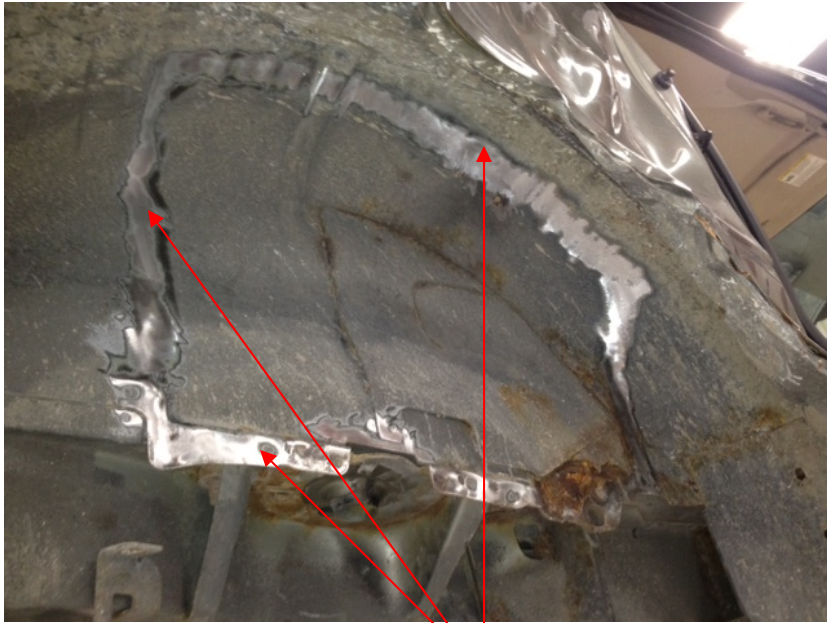
Cleaned surface area for sealer/adhesive



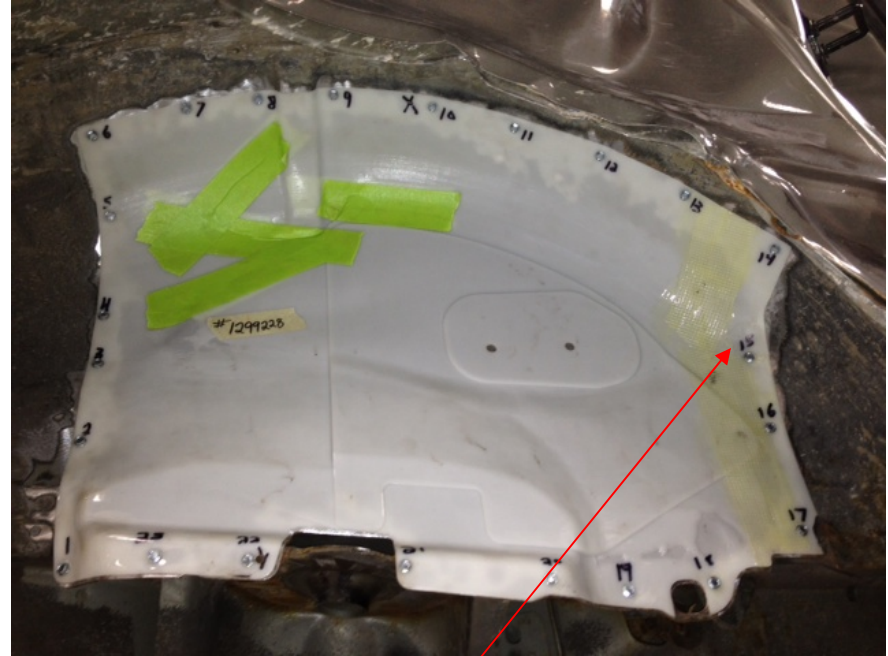
22 Drill Screws (Size #8, 1/2 inch)

2004 Freestar Buck: SLA Patch Panels

- **Passenger Side:**



Cleaned surface area for sealer/adhesive



23 Drill Screws (Size #8, 1/2 inch)

From: Frommann, Mike (M.W.)
Sent: Friday, September 21, 2012 3:19 PM
To: Bazil, Tom (Thomas E.)
Subject: FW: Freestar meeting tomorrow.

Info.

From: Tuneff, Mark (M.S.)
Sent: Thursday, September 20, 2012 3:32 PM
To: Pancioli, Tim (T.N.); Frommann, Mike (M.W.)
Subject: RE: Freestar meeting tomorrow.

Laurie and Gerry were in the call today and we had a good discussion about the chemicals, but no conclusions... Bottom line is neither the 104A nor the sealer are currently released as Motorcraft. The 104A was but it has been discontinued due to low usage. Apparently simply reinstating it is not desirable from the FCSD Purchasing side. So, three options, only two of which are considered good options:

- 1) Don't release the two commodities as Motorcraft and direct local procurement. Both chemicals are available under trade names.
- 2) Release the two chemicals in a separate kit from the hardware as Motorcraft. Eliminates shelf-life concerns in the hardware kit and makes obtaining the items easier for the dealerships. This would require Tox reviews and approvals, even for the 104A that was previously released. Laurie is pursuing but having some difficulty getting the information from the suppliers. Considered feasible.
- 3) See 2) but add them to the hardware kit. Not desirable due to shelf life concerns.

The suppliers are concerned for 2) in that dealers will likely realize a cost difference in the commodities and it may cause them commercial issues. Either 1) or 2) seem to be feasible and 1) would be available immediately while 2) will take a little longer to resolve the release issues.

Engineering was meeting this afternoon to observe the proto panels being stamped. If all goes well they expect panels to be ready for trial by Tuesday. Stay tuned for more information.

From: Pancioli, Tim (T.N.)
Sent: Wednesday, September 19, 2012 4:34 PM
To: Tuneff, Mark (M.S.); Frommann, Mike (M.W.)
Subject: RE: Freestar meeting tomorrow.

Between us, I think we need to make a final decision of how we want the dealers to get the urethane and undercoating and communicate that clearly to Laurie so she has one direction. Perhaps our earlier discussions have confused and she is not sure what direction to proceed. So, the options are:

- We kit both together (probably a problem for shelf life and other reasons)
- We offer as separate Ford Motorcraft parts available through our system
- We advise dealers what products to obtain locally

I think she is working on the second option and still wondering if we want to kit them. If there are cost advantages, we may want to still discuss, but in the end we really need to make sure these are approved and available at launch.

From: Tuneff, Mark (M.S.)
Sent: Wednesday, September 19, 2012 4:01 PM
To: Frommann, Mike (M.W.)
Cc: Pancioli, Tim (T.N.)
Subject: RE: Freestar meeting tomorrow.

Thanks for the head's up! I'm hearing rumbling about having parts Monday but I haven't been able to confirm that yet. The last information that I had was the adhesive was NOT in the kit but would be available at the depot level. Tim probably saw the note from Laurie that I saw earlier that left me confused, but she was one of the proponents of not having it in the kit due to shelf life. Stay tuned.

From: Frommann, Mike (M.W.)
Sent: Wednesday, September 19, 2012 3:59 PM
To: Tuneff, Mark (M.S.)
Cc: Pancioli, Tim (T.N.)
Subject: Freestar meeting tomorrow.

Mark,

Tim and I have an offsite tomorrow, so we won't make the 3rd Row seat meeting. Our concern at this point is when we will get prototype parts for the next trial. Also of interest, are the adhesives in or out of the kit?

From: Strack, Fred (F.)
Sent: Friday, September 21, 2012 10:37 AM
To: Bonanni, Gerry (G.); Tuneff, Mark (M.S.); Rooker, Heather (H.R.); Healey, Basil (P.B.)
Subject: FW: Freestar Patch Pictures
Attachments: Freestar 1.JPG; Freestar 2.JPG; Freestar 3.JPG

Importance: High

FYI

I will schedule a meeting for Tuesday morning.

I sent Dan a note that these screw holes (red, below) are starter holes and we should not hold up a release to make a 0.175mm hole change when we have self-tapping sheet metal screws released.

Regards,

Fred Strack
Buyer - Ford Global Purchasing - FCSD
313-390-1592
Fax 313-621-2940

From: Tannous, Dan (D.)
Sent: Friday, September 21, 2012 10:24 AM
To: Strack, Fred (F.)
Subject: FW: Freestar Patch Pictures
Importance: High

Fred, attached are pictures of 1st hit of prototype parts. The areas of concern were addressed and tools were reworked and parts were re-hit , some improvement but additional re-work may be required pending the trials next week.

Tower will ship (3) sets LH/RH panels (Laser Trim, E-Coat, **No 3.0 mm Holes**) to TDM CVC on Tuesday 9/25/2012. The balance of parts (3) sets will include the 3.175 mm (1/8") holes, according to math data .

The areas of concern we discussed will be addressed and possible design change pending the successful trials. One of the reasons why we have this condition may be due to the 12.0 mm offset, we may have to reduce (xx.x mm) pending the trials and confirmation from Tower on the production tool process etc.

Please distribute to the team and let me know what day & location (full day) for the trials .

Best Regards,

Dan Tannous
D & R Engineer

CRFTVC
25111 Glendale
Redford, MI 48239
Phone:(313)-592-2149 Cell (313) - 790-4347
E-mail: dtannous@ford.com

From: Jeff Farrell [<mailto:Jeff@completeprototype.com>]
Sent: Thursday, September 20, 2012 3:11 PM
To: Tannous, Dan (D.)
Cc: Jeff Kruszewski (kruszewski.jeff@towerinternational.com)
Subject: Freestar Patch Pictures

Dan,
Pictures attached as requested

Jeffrey O. Farrell
Complete Prototype Services Inc.
586-929-2200

www.completeprototype.com