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TO: All U.S. Ford and Lincoln Mercury Dealers

SUBJECT: **Safety Recall 04S20: Supplement #5**
All 2002 and Certain 2003 Model Year Ford 4-Door Explorer & Mercury Mountaineer Vehicles - Liftgate Glass Hinge and Ball Stud Bracket (if applicable) Replacement

Ref: **Safety Recall 04S20: Supplement #4** dated 12/21/04
Ref: **Safety Recall 04S20: Supplement #3** dated 12/9/04
Ref: **Safety Recall 04S20: Supplement #2** dated 12/6/04
Ref: **Safety Recall 04S20: Supplement #1** dated 11/16/04
Ref: **Safety Recall 04S20: Original Bulletin** dated 9/24/04
Ref: **Advance Notice - Safety Recall 04S20** dated 9/9/04

Based on information received from Dealership technicians, this supplement provides significant updates to help eliminate the incidence of glass breakage during or shortly after kit installation.

SPECIAL FORDSTAR BROADCAST PLANNED FOR FEBRUARY 4, 2005 (with later rebroadcasts). The broadcast will cover the entire 04S20 Safety Recall and address technician questions.

New!

PURPOSE OF THIS SUPPLEMENT

- *Provides additional repair tips and precautions based on input from dealer technicians (See Attachment III). These revised instructions will help eliminate glass breakage during or shortly after kit installation. The revised procedure:*
 - *Adds marking the location of the old hinges before removal.*
 - *Adds cleaning of the glass surface under the hinges when the hinges are replaced.*
 - *Adds inspection of the mounting hole edges for chipping; replace glass if chipped.*
 - *Adds alignment of the new hinges with marked lines.*
 - *Confirms that torque specifications are correct and required for a proper repair.*
- *Increases the labor allowance based on the revised procedure (see Attachment II, page 1).*
- *Provides a labor operation for a partial repair for situations where the glass breaks during kit installation (see Attachment II, page 1).*
- *Adds time for clean up of broken glass (see Attachment II, page 1).*
- *Provides a labor operation for circumstances when the customer arrives with a broken glass and a replacement glass with the updated hardware is available (see Attachment II, page 1).*

- Eliminates the requirement to call the Special Service Support Center (SSSC) prior to performing a related damage repair (see Related Damage in Attachment I, page 1).
- Eliminates the requirement to call the SSSC for rental vehicle authorization (see Rental Vehicles in Attachment I, page 2).
- Removes order restrictions on parts ordering (see Attachment II, page 2).

Important Changes from Previous Supplements Which Still Apply

- Identify the new hinge for orientation on the vehicle; there is a RH & LH hinge and a RH & LH hinge gasket and the parts are clearly marked. If unsure, remove the plastic hinge gasket and verify RH or LH. Failure to install the hinge and gasket in the correct location may lead to a broken liftgate glass. (See Attachment III, page 1 of 14).
- There are two different torque specifications for the hinge and ball stud bracket:
 1. The hinge to liftgate glass bolt is 8 Nm (71 lb-in).
 2. The ball stud bracket to liftgate glass bolt is 25 Nm (18 lb-ft).
 Incorrect torque at either location may lead to a broken liftgate glass.
- The round plastic spacer under the hinge-to-glass bolt must be transferred to the new bolt. Failure to reuse the round spacer may result in the glass shattering upon bolt installation. (See Attachment III, page 4 of 14)
- Early built 2002 units may require a different Hinge to Liftgate body nut (See Attachment III, page 1 of 14 for Technical Instructions and Attachment II for ordering information). This nut will only be required for 10% of the vehicles affected by this Safety Recall.
- Advise dealers of revisions to the Technical Instructions for Hinge Replacement. The hinge repair procedure did not clearly specify that the hinge-to-glass bolt spacer needs to be reused. Failure to reuse the spacer may result in the glass shattering upon bolt installation.
- Provide a simple means for determining if replacement glass has updated components (Attachment IV).
- Advise dealers of revised Questions and Answers (Attachment IV).
- Provide informational copy of customer follow-up postcard (Attachment V).

AFFECTED VEHICLES

All 2002 and 2003 model year 4-door Ford Explorer and Mercury Mountaineer vehicles built at St. Louis Assembly Plant (SLAP) and at Louisville Assembly Plant (LAP) from Job #1 2002 through June 23, 2003. Affected vehicles are identified in OASIS. In addition, for a list of vehicles assigned to your dealership, visit <https://web.fsavinlists.dealerconnection.com>. This information will be available on 9/24/04.

REASON FOR THIS SAFETY RECALL

In some of the affected 2002 model year vehicles, the ball stud bracket located on the rear liftgate window could rotate out of position on the glass. If this occurs, the window strut may detach and become trapped between the glass and the liftgate, possibly causing the window to drop unexpectedly or break.

On all of the affected vehicles (2002 and 2003 MY), the hinge which attaches the liftgate window to the liftgate body may separate from the liftgate body. If this occurs, the window could drop unexpectedly or break. If the liftgate window drops or breaks, either the person operating the window or a nearby person could be injured.

SERVICE ACTION

Vehicles Built From Job #1, 2002 Through March 3, 2002 (LAP) or March 10, 2002 (SLAP)

(See Attachment III for a visual method for identifying these vehicles utilizing the liftgate glass beauty bolts.)

At no charge to the vehicle owner, dealers are to replace both the right and left hand liftgate glass ball stud mounting brackets with a new design bracket. In addition, dealers are to replace both the right and left hand liftgate window hinges. This must be performed on all of the affected vehicles in your inventory as well as vehicles that have been delivered to customers.

PLEASE NOTE: The adhesive used to install the liftgate glass ball stud brackets will require at least two (2) hours to cure at 70° F or higher. If the vehicle must be moved to a much colder environment before two hours has elapsed, cure time will increase substantially before the liftgate glass struts can be reattached. The following guidelines must be followed in order to ensure properly cured adhesive:

- **Two (2) hour cure time at 70° F. (Preferred)**
- **Three (3) hour cure time at 50° F.**
- **Seven (7) hour cure time at 32° F.**
- **Below 32° F, call the Special Service Support Center at 1-800-325-5621 to review the particular circumstances and obtain further direction.**

PLEASE NOTE: We strongly advise dealers to schedule morning appointments for vehicles that require bracket replacement. By replacing the ball stud brackets in the morning, dealers will have the flexibility to allow the adhesive to properly cure and still allow the customer to pick up their vehicle before the end of the day. See "Rental Vehicles" in Attachment I for unusual circumstances where the specified cure time cannot be accommodated.

Vehicles Built From March 4, 2002 (LAP) or March 11, 2002 (SLAP) through June 23, 2003

(See Attachment III for a visual method for identifying these vehicles utilizing the liftgate glass beauty bolts.)

At no charge to the vehicle owner, dealers are to replace both the right and left hand liftgate window hinges only. This must be performed on all of the affected vehicles in your inventory as well as vehicles that have been delivered to customers. Vehicles built in this period do not require replacement of the ball stud strut brackets.

CAUTION:

In the event that a new liftgate glass must be ordered, upon receipt, be sure that the new glass has ALL of the following before installing on the vehicle:

- Thick design hinges
- Large strut brackets
- Hard adhesive

This is necessary because your service glass supplier may not have provided the latest level glass assembly. Replacement glass with one of the "New" NAGS numbers shown in the chart at the end of the Q & A Section (Attachment IV) will have ALL of the above components already installed. If the replacement glass has one of the "Old" NAGS numbers, use the illustration following the chart to determine which, if any, of the above components must be updated before installing the glass.

PLEASE NOTE: Federal law requires dealers to complete any outstanding safety recall service before a new vehicle is delivered to the buyer or lessee. Violation of this requirement by a dealer could result in a civil penalty of up to \$5,000 per vehicle. Correct all vehicles in your new vehicle inventory prior to delivery.

ATTACHMENTS

New!

Attachment I: *Administrative Information*

New!

Attachment II: *Labor Allowances and Parts Ordering Information*

New!

Attachment III: *Technical Information*

New!

Attachment IV: *Dealer Questions and Answers*

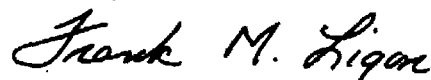
Attachment V: *Customer Announcement Postcard – Parts Availability*

QUESTIONS?

Claims Information: 1-800-423-8851

Special Service Support Center (Dealer Only) Questions: 1-800-325-5621

Sincerely,



Frank M. Ligon

Safety Recall 04S20

All 2002 and Certain 2003 Model Year Ford 4-Door Explorer & Mercury Mountaineer Vehicles
Liftgate Glass Hinge and Ball Stud Bracket (if applicable) Replacement

OASIS ACTIVATED? Yes. OASIS was activated 9/9/2004.

FSA VIN LIST ACTIVATED? Yes.

Available through FMCDDealer.com or at <https://web.fsavinlists.dealerconnection.com> by 9/24/04.

Owner names and addresses available by 10/1/04.

NOTE: Your FSA VIN list may contain owner names and addresses obtained from motor vehicle registration records. The use of such motor vehicle registration data for any purpose other than in connection with this recall is a violation of law in several states, provinces, and countries. Accordingly, you must limit the use of this listing to the follow-up necessary to complete this recall action.

STOCK VEHICLES

Correct all affected units in your new vehicle inventory before delivery.

SOLD VEHICLES

- Owners of affected vehicles will be directed to dealers for repairs in coordination with the available supply of parts.
- Contact any of your affected owners whose vehicles are not on your VIN lists but are identified in OASIS. Give the owner a copy of the Customer Notification Letter.
- Correct other affected vehicles identified in OASIS which are brought to your dealership.

TITLE BRANDED / SALVAGED VEHICLES

Affected title branded and salvaged vehicles are eligible for this Field Service Action.

New!**RELATED DAMAGE**

- *If a related damage condition exists that you believe to be caused by the covered condition, repair as necessary and submit a claim in accordance with the Warranty and Policy Manual (Section 4).*
- Refer to Attachment IV for additional information.

ADDITIONAL LABOR TIME

- If a condition exists that requires additional labor to complete the repair, call the Special Service Support Center to request approval **prior** to performing any additional labor. Requests for approval after completion of the repair will not be granted.
- If you encounter aftermarket equipment or modifications to the vehicle that might prevent the repair of the covered condition, call the Special Service Support Center.

Safety Recall 04S20

All 2002 and Certain 2003 Model Year Ford 4-door Explorer & Mercury Mountaineer Vehicles
Liftgate Glass Hinge and Ball Stud Bracket (if applicable) Replacement

OWNER REFUNDS

- Ford Motor Company is offering a refund for owner-paid repairs covered by this recall if the repair was performed prior to the date indicated in the reimbursement plan, which is posted with this bulletin. This plan is also available to owners through the Customer Relationship Center (CRC). The CRC will direct owners to seek reimbursement through authorized dealers or, at an owners' option, directly through Ford Motor Company at P.O. Box 6251, Dearborn, MI 48121-6251.
- Dealers are also authorized to refund owner-paid emergency repairs that were performed away from an authorized servicing dealer after the end date specified in the reimbursement plan. Refund claims that include other non-covered repairs, or those judged by Ford to be excessive, will not be accepted for reimbursement.
- **This safety recall must still be performed, even if the customer has paid for a previous repair. Claiming a refund will not close out the VIN for this recall.**
- Refund Claiming Information (Submit on separate repair line.)
 - Program Code: 04S20
 - Misc. Expense: REFUND
 - Misc. Expense: ADMIN
 - Misc. Expense: 0.2 Hrs.

New!**RENTAL VEHICLES**

A rental vehicle is only authorized when:

- *A vehicle arrives with a shattered back glass and a new glass must be ordered.*
- *A vehicle arrives with a broken hinge and the vehicle cannot be driven while parts are on order.*
- *The back glass breaks during or shortly after kit installation.*
- *Shop volume or service scheduling makes it impossible to store vehicles which require bracket replacement for any of the specified cure times. It is anticipated that rental vehicles will only be required in limited circumstances.*

New!**CLAIMS PREPARATION AND SUBMISSION**

- Enter claims using Direct Warranty Entry (DWE).
- Refund or related damage must be claimed on a repair line that is separate from the repair line on which the FSA is claimed.
- "MT" labor should be submitted on a separate repair line with the related damage flag checked.
- Refer to ACESII manual for claims preparation and submission information.
- *Anything other than the parts and labor operations specified in Attachment II must be on a related damage claim.*

Safety Recall 04S20

All 2002 and Certain 2003 Model Year Ford 4-Door Explorer & Mercury Mountaineer Vehicles
Liftgate Glass Hinge and Ball Stud Bracket (if applicable) Replacement

New!**LABOR ALLOWANCES**

Description	Labor Operation	Labor Time
Vehicles <u>with</u> Beauty Bolts <i>Replace both liftgate glass ball stud brackets and both liftgate glass hinges, inspect liftgate glass - vehicles built from Job #1 2002 through March 10, 2002 (SLAP) or through March 3, 2002 (LAP) units.</i>	04S20B	1.0 Hours
Vehicles <u>without</u> Beauty Bolts <i>Replace both liftgate glass hinges, inspect liftgate glass - vehicles built from March 11, 2002 (SLAP) or March 4, 2002 (LAP) through June 23, 2003.</i>	04S20C	0.5 Hours
<i>Replace Liftgate Glass assembly (if customer arrives with a broken liftgate glass or glass breaks during kit installation; includes broken glass cleanup).*</i>	04S20D	1.3 Hours
<i>Replace liftgate glass (chip or crack found during hinge replacement/glass inspection – glass does not break – no cleanup)*</i>	04S20E	0.9 Hours

***NOTE:** For partial repairs (glass breaks at any point during kit installation or inspection reveals a need to replace glass), submit M-time for the partial repair and order a new glass. In this situation, glass replacement will close the recall; therefore be sure the new glass has all the updated components (see Dealer Questions/Answers Q/A13).

TOOL REQUIREMENTS

Rotunda Tool 501-040 is required to complete the ball stud bracket replacement. Each dealer will be provided one applicator tool 501-040 at no charge. Tools have been mailed and should have arrived at all dealerships by December 1, 2004. The tool shipping container will indicate "Enclosed Adhesive Applicator Tool for Safety Recall 04S20."

Safety Recall 04S20

All 2002 and Certain 2003 Model Year Ford 4-Door Explorer & Mercury Mountaineer Vehicles
Liftgate Glass Hinge and Ball Stud Bracket (if applicable) Replacement

PARTS REQUIREMENTS / ORDERING INFORMATION**New!**

Parts ordering restrictions have been lifted (an announcement was sent via DOES II on 1/27/05).
Parts will not be direct shipped for this recall. Order your parts requirements through normal order processing channels.

Part Number	Description	Quantity
1L2Z-78420A26-AA*	Bracket and hinge repair kit Note: For vehicles built from Job#1 2002 through March 10, 2002 (SLAP), or through March 3, 2002 (LAP) units.	1 per vehicle
2L2Z-78420A68-AA	Hinge only repair kit Note: For vehicles built from March 11, 2002 (SLAP), or March 4, 2002 (LAP) through June 23, 2003.	1 per vehicle
N621926-S36	Nut and Washer Assy** (hinge to liftgate body) Note: Additional part for vehicles built from Job #1 2002 (SLAP and LAP) through April 30, 2001.	2 per vehicle (package unit of issue is 10)

New!

* For a copy of the Material Safety Data Sheets (MSDS), go to:
<http://www.fcsdchemicalsandlubricants.com/dealer/html/catalogindex.htm> or the PTS Website.

**This nut will only be required for 10% of the vehicles affected by this Safety Recall.

ORDER INFORMATION

The DOR/COR for this program is 50330. This number identifies parts ordered for this Safety Recall through the Special Service Support center (1-800-325-5621).

DEALER PRICE

For latest prices, refer to DOES II.

PARTS RETENTION AND RETURN

Follow the provisions of the Warranty and Policy Manual for "Parts Retention and Return Procedures."

EXCESS STOCK RETURN

Excess stock returned for credit must have been purchased from Ford Customer Service Division in accordance with Policy Procedure Bulletin 4000.

UPDATED FEBRUARY 2005

**CERTAIN 2002 AND 2003 MODEL YEAR EXPLORER/MOUNTAINEER VEHICLES —
LIFTGATE GLASS BALL STUD BRACKET AND HINGE REPLACEMENT**

NEW

Based on information received from Dealership technicians, we have made improvements to this Attachment III. A Fordstar Broadcast has been developed in conjunction with the release of this Dealer Bulletin and is available for viewing. Please take the time to view that broadcast.

OVERVIEW

This program involves replacing the liftgate glass ball stud brackets and liftgate glass hinges on certain 2002 and 2003 Model Year Explorer and Mountaineer vehicles.

- On early built 2002 model year vehicles, the liftgate glass ball stud brackets and liftgate glass hinges require replacement.
- On later built 2002 and all early 2003 model year vehicles, only the liftgate glass hinges require replacement.

NEW

CAUTION: Several early built 2002 model year vehicles (produced from November 2000 through approximately February 2001) were produced with right-hand threads on both right- and left-side ball stud brackets. After this time, the left-side bracket had left-hand threads and the right-side bracket had right-hand threads. The early brackets may also be easily identified as not having ANY adhesive between them and the glass. When removing ball stud bracket bolts, use extreme caution to turn the beauty bolt in the proper direction or the glass may shatter under the pressure.



NEW SERVICE PRECAUTIONS

WARNING: THE *NEW* HINGES AND PLASTIC HINGE GASKETS ARE IDENTIFIED AS EITHER RIGHT-HAND OR LEFT-HAND (PASSENGER SIDE OR DRIVER SIDE). IF INSTALLED ON THE WRONG SIDE OF THE VEHICLE, THE GLASS MAY SHATTER. SEE FIGURE 1 FOR IDENTIFICATION DETAILS.

NOTE: On some hinges the casting marks are very light and difficult to read. Look closely to make sure each bracket is properly identified.

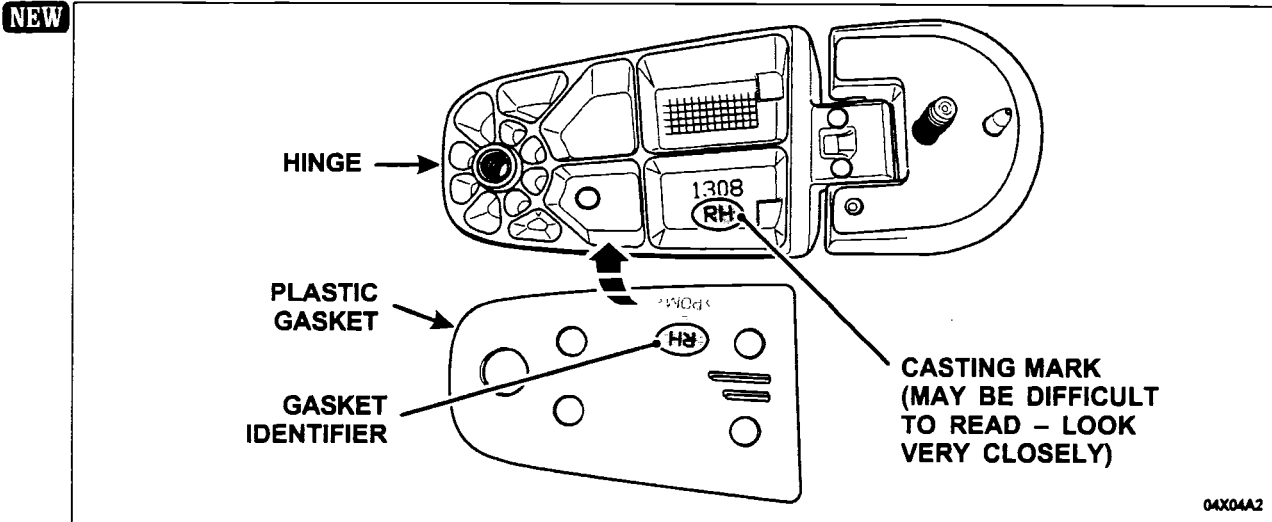


FIGURE 1

WARNING: THE PLASTIC SPACER LOCATED UNDER THE ORIGINAL HINGE-TO-GLASS BOLT MUST BE TRANSFERRED TO THE *NEW* BOLT. FAILURE TO INSTALL THIS SPACER WILL RESULT IN SHATTERING THE GLASS UPON BOLT INSTALLATION. SEE FIGURE 6.

CAUTION: DO NOT transfer the steel washer under the plastic hinge gasket from the old hinge to the *new* hinge. The plastic gasket on the *new* hinge will not fit properly causing improper hinge installation.

NOTE: 2002 model year vehicles built before April 30, 2001 may have been produced with 5-mm hinge-to-body nuts. When installing the *new* hinges, *new* 6-mm (Part Number - N621926-S36) nuts must be used. If 6-mm nuts are removed from the original hinge, retain for re-use.

To determine if *new* 6-mm nuts are required, attempt to install the original nuts on the *new* hinge by hand. If they go on easily, re-use the nuts. If they do not go on, use *new* 6-mm nuts.



INSPECTION

To properly identify the vehicle and decide which repairs to perform, inspect for the presence of liftgate glass beauty bolts.

- Early 2002 models use ball stud brackets that are secured with beauty bolts, which pass through the glass (the head of the bolt is visible on the outside of the glass) and are bonded to the glass about 150 mm (6 inches) from the top of the glass. See Figure 2. If beauty bolts are present, both the liftgate ball stud brackets and hinges will be replaced. Perform BOTH the Liftgate Glass Hinge Replacement and the Ball Stud Bracket Replacement. Begin your repairs with LIFTGATE GLASS HINGE REPLACEMENT.
- Later built 2002 and 2003 model year vehicles use revised ball stud brackets which are not secured with beauty bolts. If beauty bolts are not present, only the hinges will be replaced. Perform only the LIFTGATE GLASS HINGE REPLACEMENT.

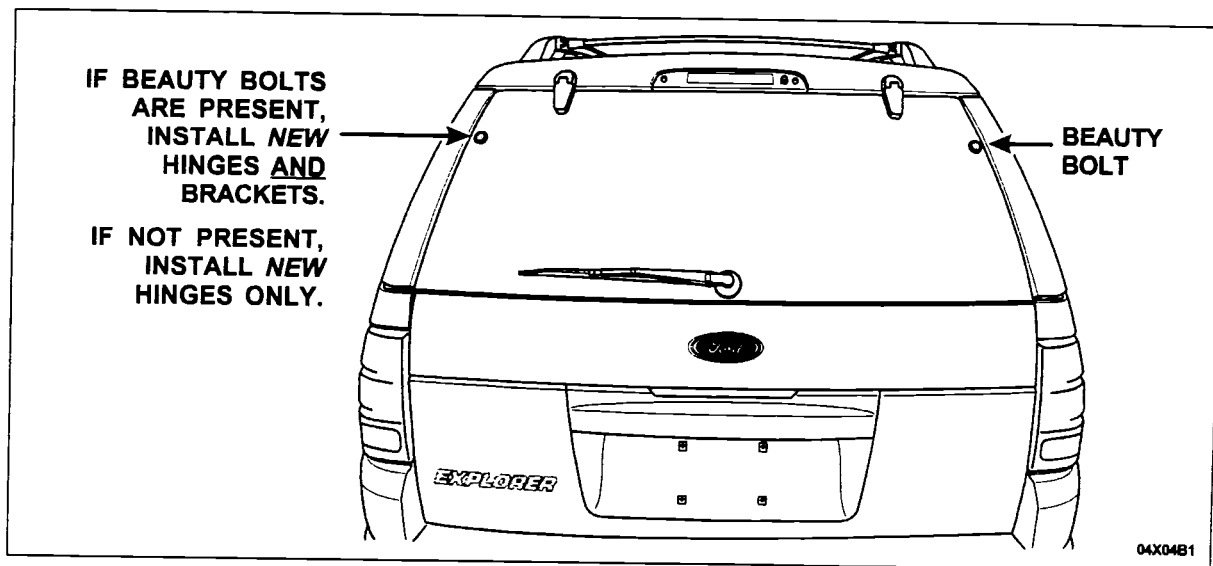


FIGURE 2



LIFTGATE GLASS HINGE REPLACEMENT – ALL AFFECTED VEHICLES

NOTE: The Hinge Replacement procedure must be completed prior to the Ball Stud Bracket procedure.

REMOVAL

WARNING: BE SURE TO USE PERSONAL PROTECTIVE EQUIPMENT SUCH AS SAFETY GLASSES AND EQUIPMENT THAT WILL PROTECT AGAINST PERSONAL INJURY IN THE EVENT OF GLASS BREAKAGE.

CAUTION: Do not use power tools when working on the glass.

1. Open the liftgate glass and support the glass with a jack stand positioned under the striker.
2. Disconnect the liftgate glass support struts from both ends and remove from the vehicle.
3. Remove the jack stand and carefully close the glass making sure the striker is engaged in the latch.

NEW

4. **CAUTION: The location of the original glass hinges must be clearly marked on the glass to make sure the *new* hinges are accurately positioned and that the glass is properly aligned. Failure to properly align the *new* hinges to these marks may result in glass shattering.**

Using a grease pencil, a non-permanent marker or tape, outline the entire perimeter of the original hinges to mark their exact location on the glass. See Figure 3.

NEW

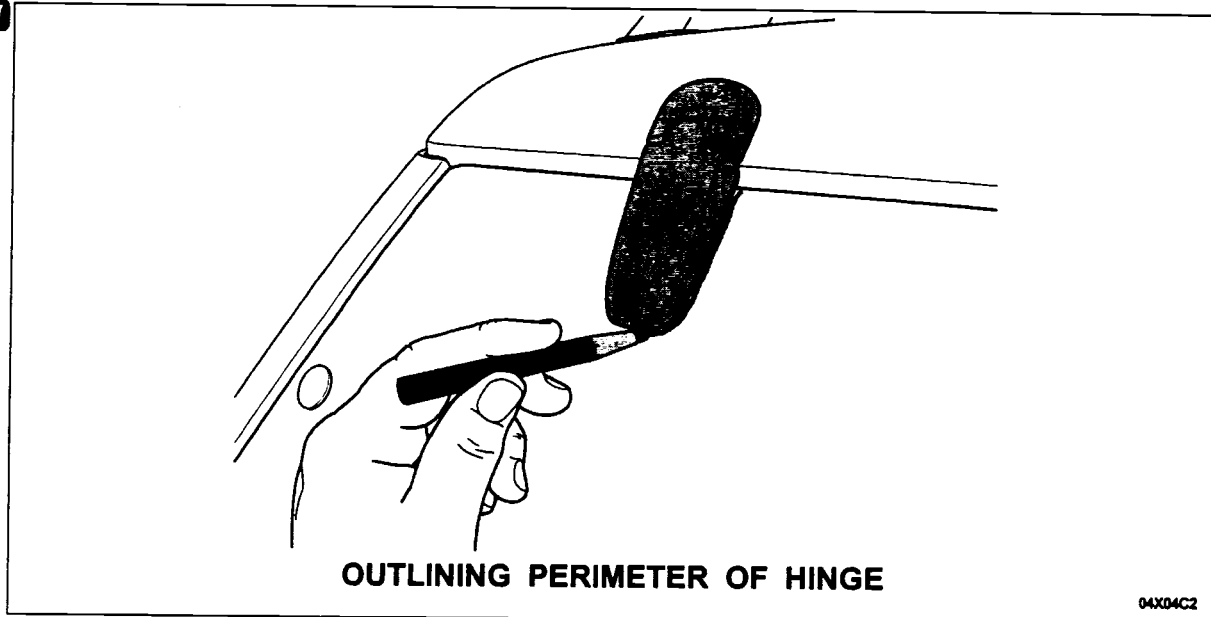


FIGURE 3

5. Open the full liftgate.



6. Position the upper part of the liftgate trim panel away from the liftgate to gain access to the hinge fasteners. See Figure 4.

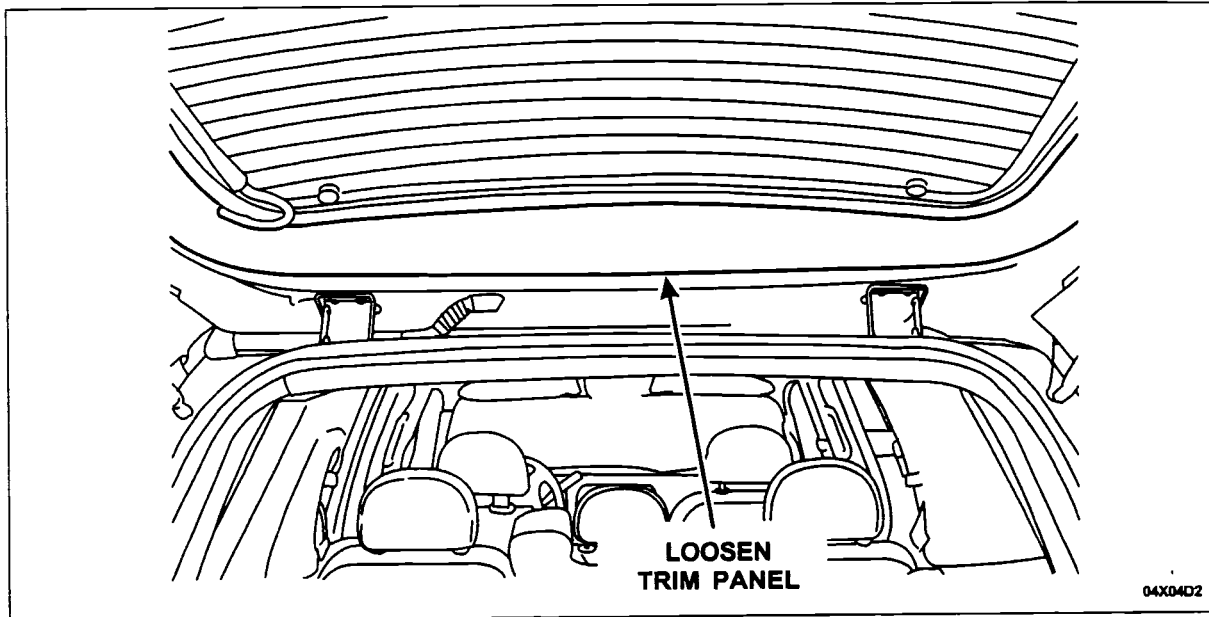


FIGURE 4

NEW

CAUTION: Replace only one hinge at a time. Removing both hinges at once will cause the glass to move greatly out of alignment and greatly increase the chances that the glass may shatter during or even after this service is completed.

Removing one hinge at a time may allow the glass to shift slightly out of position, but is easily corrected by positioning the *new* glass hinge following the marks made in Step 4.



- Using a magnetic socket or tool, remove one (1) liftgate glass hinge-to-body nut, then the hinge-to-glass bolt and remove one (1) hinge from the vehicle. Retain the plastic spacers from the hinge-to-glass bolts for use with the *new* bolts. See Figure 5.

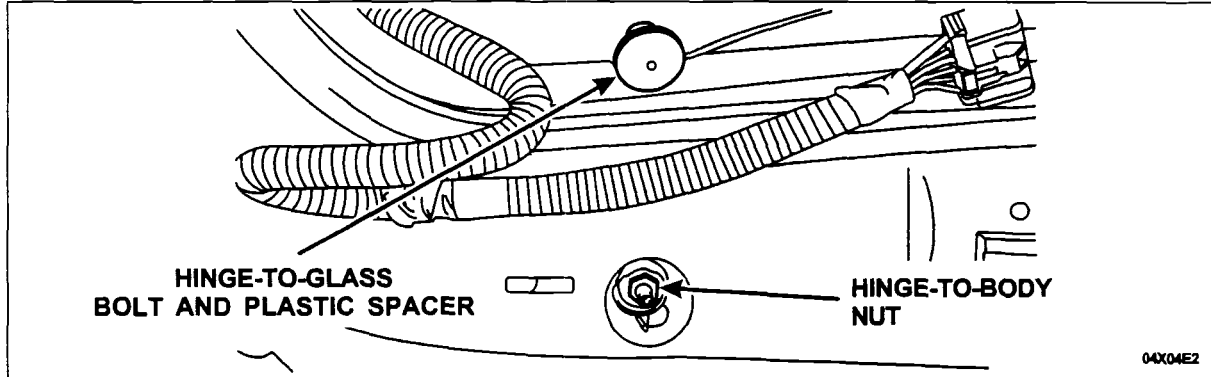


FIGURE 5

NEW

- Clean the glass, particularly at the edge around the hole, then inspect the edge of the hole in the glass to see if it is chipped or cracked. If the glass is chipped or cracked, the glass must be replaced. Discontinue this service in lieu of liftgate glass replacement.



INSTALLATION

NEW SERVICE PRECAUTIONS

WARNING: THE PLASTIC SPACER LOCATED UNDER THE ORIGINAL HINGE-TO-GLASS BOLT MUST BE CLEANED AND TRANSFERRED TO THE *NEW* BOLT. FAILURE TO INSTALL THIS SPACER WILL RESULT IN SHATTERING THE GLASS UPON BOLT INSTALLATION. SEE FIGURE 6.

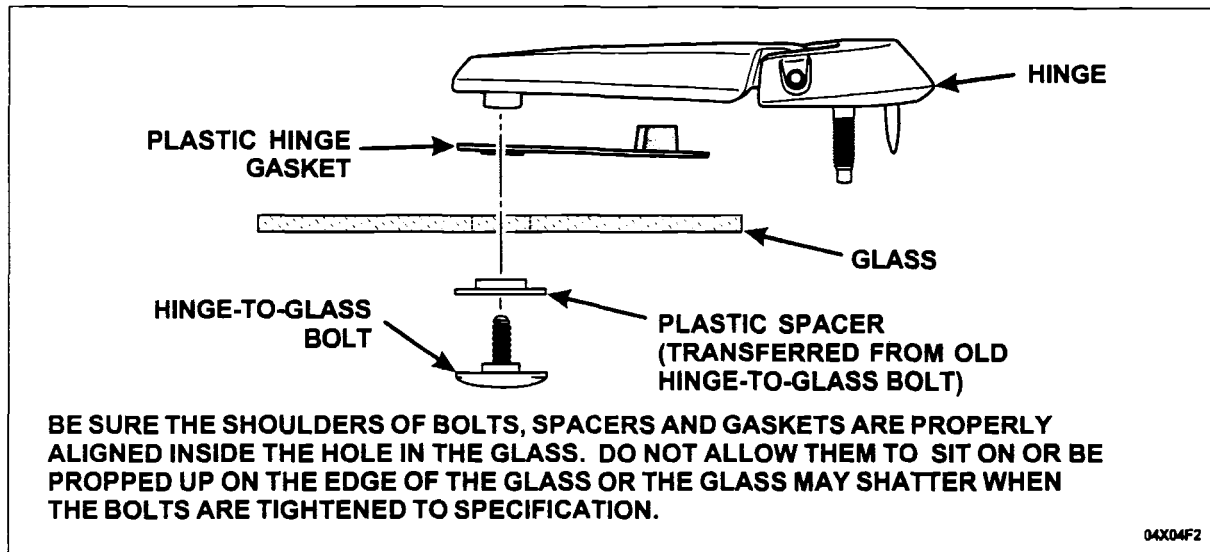


FIGURE 6

WARNING: THE *NEW* HINGES ARE IDENTIFIED AS EITHER RIGHT-HAND OR LEFT-HAND (PASSENGER SIDE OR DRIVER SIDE). IF INSTALLED ON THE WRONG SIDE OF THE VEHICLE, THE GLASS MAY SHATTER. SEE FIGURE 1 FOR IDENTIFICATION DETAILS.

CAUTION: DO NOT transfer the steel washer under the plastic hinge gasket from the old hinge to the *new* hinge. The plastic gasket on the *new* hinge will not fit properly causing improper hinge installation.

NEW CAUTION: Be sure the glass and plastic hinge gaskets are very clean and contain no grit, dirt, sand or any other foreign matter prior to installation. Even the smallest bit of any hard material captured between the plastic gasket and the glass may cause the glass to shatter.

NEW NOTE: When installing the plastic gasket onto the *new* hinge, be sure it sits flush onto the hinge surface. Please note that some gaskets are known to fit very tightly around the threaded boss which may make gasket installation difficult. Be sure the gasket is fully seated before installing the hinge.

NOTE: 2002 model year vehicles built before April 30, 2001 may have been produced with 5-mm hinge-to-body nuts. When installing the *new* hinges, *new* 6-mm (Part Number – N621926-S36) nuts must be used. If 6-mm nuts are removed from the original hinge, retain for re-use.

To determine if *new* 6-mm nuts are required, attempt to install the original nuts on the *new* hinge by hand. If they go on easily, re-use the nuts. If they do not go on, use *new* 6-mm nuts.



- NEW** 1. **WARNING: WHEN INSTALLING THE HINGE ASSEMBLY TO THE GLASS, BE SURE THE SHOULDERS OF BOLTS, SPACERS AND GASKETS ARE PROPERLY ALIGNED INSIDE THE HOLE IN THE GLASS. DO NOT ALLOW THEM TO SIT ON OR BE PROPPED UP ON THE EDGE OF THE GLASS OR THE GLASS MAY SHATTER WHEN THE BOLTS ARE TIGHTENED TO SPECIFICATION.**

Transfer the plastic spacer from the old hinge-to-glass bolt onto the *new* bolt, then apply Threadlock 262® (Motorcraft TA-26, red high strength) to the hinge-to-glass bolt threads even though it already has lock tite, then position the hinge onto the vehicle.

- NEW CAUTION: When working with glass, the torque specifications are very critical. Be sure the torque wrench used during this service has recently been calibrated so the fasteners are not over-tightened or under-tightened. Failure to use a calibrated torque wrench may result in glass shattering either during the repair or possibly after the repair is completed.**

2. Install the hinge bolt and nut FINGER TIGHT ONLY at this time.
3. Tighten the hinge BOLT FIRST to 8 Nm (71 lb-in).
4. Tighten the hinge NUT SECOND to 11 Nm (8 lb-ft or 97 lb-in).
5. Repeat Removal Steps 7 and 8 and Installation Steps 1 through 4 for the other hinge.
6. Reposition and secure the liftgate trim panel.
7. Close the liftgate.

NOTE: If the beauty bolts are present (See INSPECTION), proceed to the Liftgate Ball Stud Bracket Replacement procedure. If the beauty bolts are NOT present, complete Steps 8 and 9 and release the vehicle.

8. Install the liftgate glass support struts.
9. Remove the jack stand and close the liftgate glass.



LIFTGATE GLASS BALL STUD BRACKET REPLACEMENT – EARLY 2002 MODEL YEAR VEHICLES ONLY (VEHICLES WITH BEAUTY BOLTS)

CAUTION: Do not use power tools when working on glass.

NOTE: The *new* brackets are marked with a stamping, L or R followed by a number. They are **NOT** interchangeable. The L is for the driver side of the glass and has left-hand threads. The R is for the passenger side of the glass and has right-hand threads. The number can be ignored. See Figure 7.

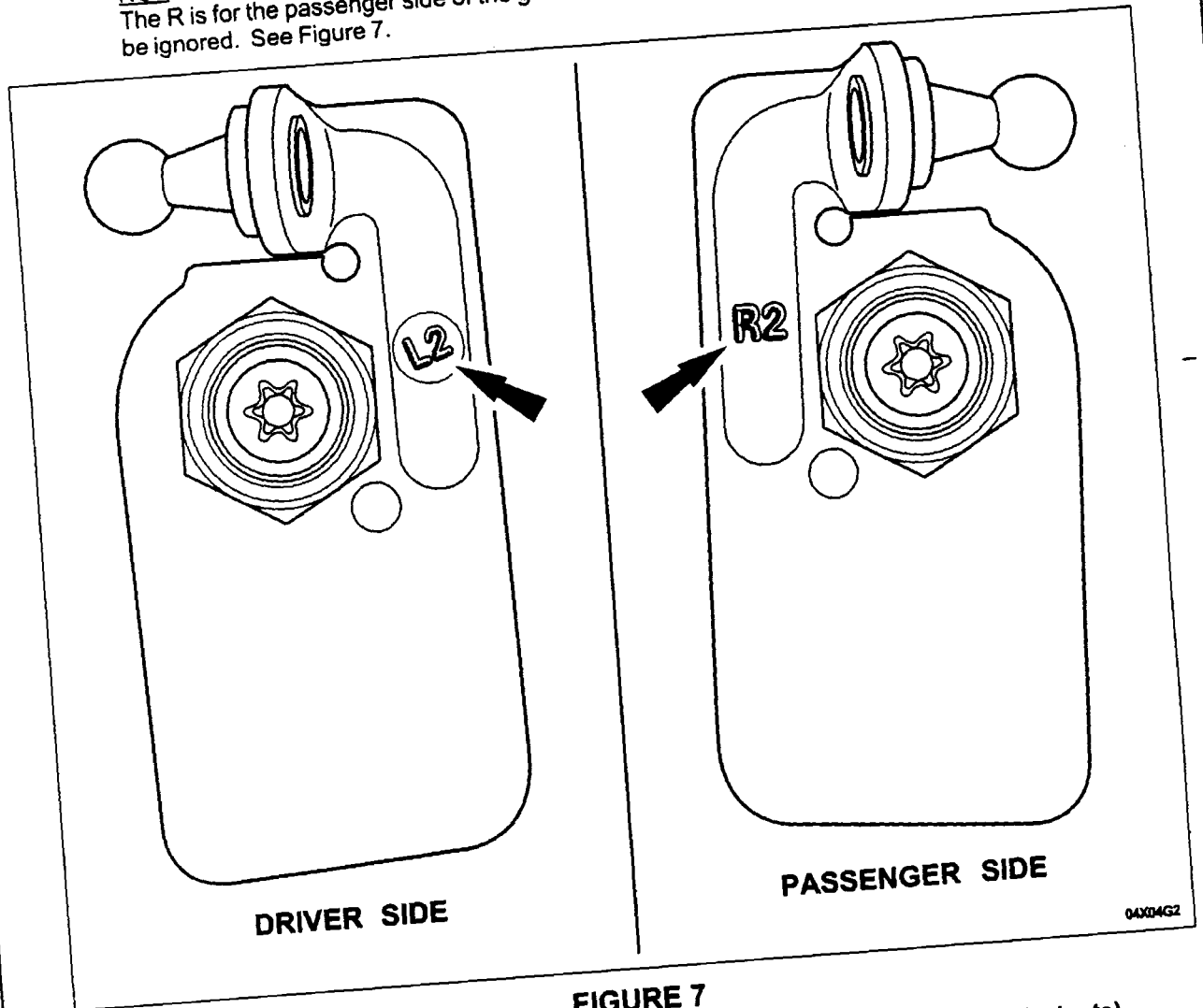


FIGURE 7

CAUTION: Due to the extremely short working time of the adhesive (less than one [1] minute), it is imperative that only one (1) bracket be replaced at a time. Failure to specifically follow these instructions will result in a ruined backglass or failure of the adhesive to bond properly to the glass.

NOTE: Before the installation of the liftgate glass ball stud bracket, make sure that the interior surface of the glass is clean and free of any visible moisture.



1. Open the liftgate glass and support the glass with a jack stand positioned under the striker.
2. **WARNING: PERSONAL PROTECTIVE EQUIPMENT (SAFETY GLASSES) IS REQUIRED WHEN WORKING WITH GLASS OR INJURY MAY OCCUR IN THE EVENT OF GLASS BREAKAGE.**

NEW NOTE: If you encounter ball stud brackets that do not twist off easily after removing the beauty bolt, it may be due to an alternative adhesive that was applied as an interim repair. If the brackets cannot be removed, the glass must be replaced. Discontinue this service in lieu of liftgate glass replacement.

NEW CAUTION: Several early built 2002 model year vehicles (produced from November 2000 through approximately February 2001), were produced with right-hand threads on both right- and left-side ball stud brackets. After this time, the left-side bracket had left-hand threads and the right-side bracket had right-hand threads. The early brackets may also be identified as not having ANY adhesive between them and the glass. When removing ball stud bracket bolts, use extreme caution to turn the beauty bolt in the proper direction or the glass may shatter under the pressure.

Remove the bracket from the glass by first removing the beauty bolt using a T-30 Torx bit, then twist the bracket off the glass using a 17-mm box-end wrench.

NOTE: With the liftgate glass open, be sure to properly orient the *new* brackets with the ball stud pointing upward and outward. See Figure 8.

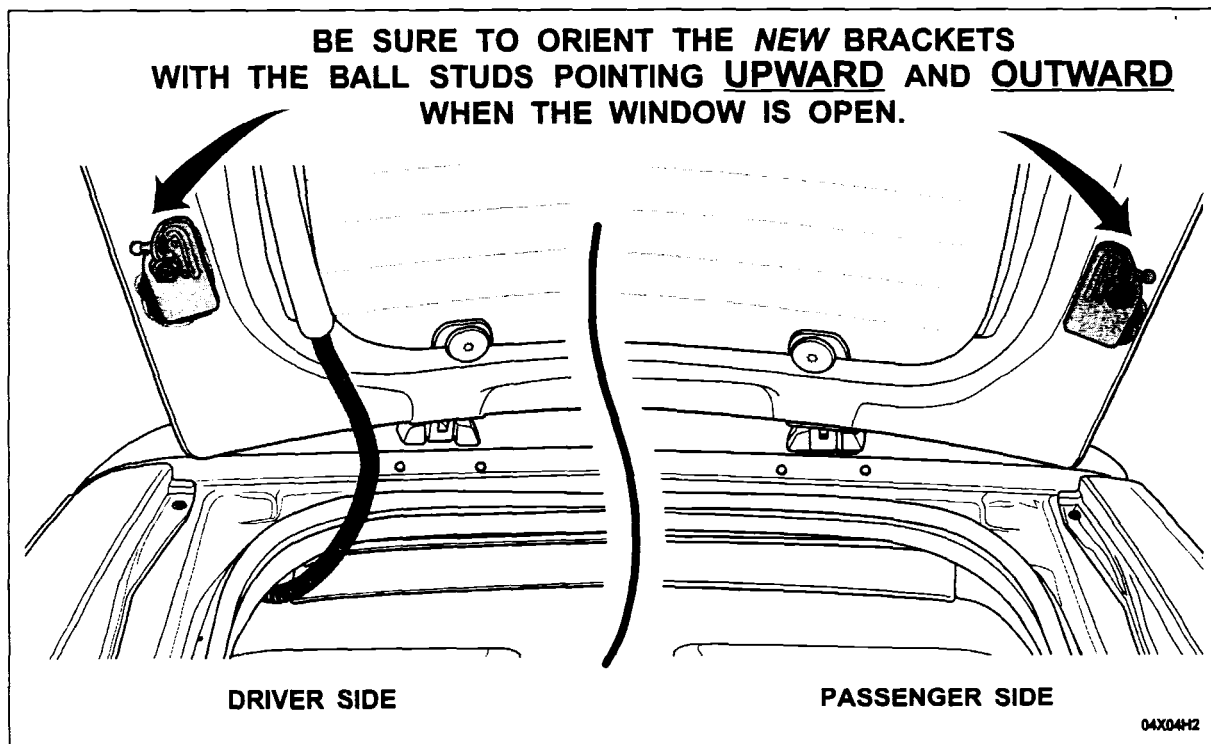


FIGURE 8



3. Hold the **new** bracket in position on the glass with the ball stud pointing UP and OUT (with the liftgate glass open). Mark the area around the bracket using masking tape or vinyl tape. Leave a space approximately 7 mm (1/4 in) between the edge of the bracket and the tape. The taped-off area should be approximately 57-mm (2-1/4 in) wide and 89-mm (3-1/2 in) high. See Figure 9 for proper placement and dimensions. After the tape is applied, remove the bracket. The tape will be used as an alignment guide, therefore, keep the tape in place until completing the final bracket alignment.

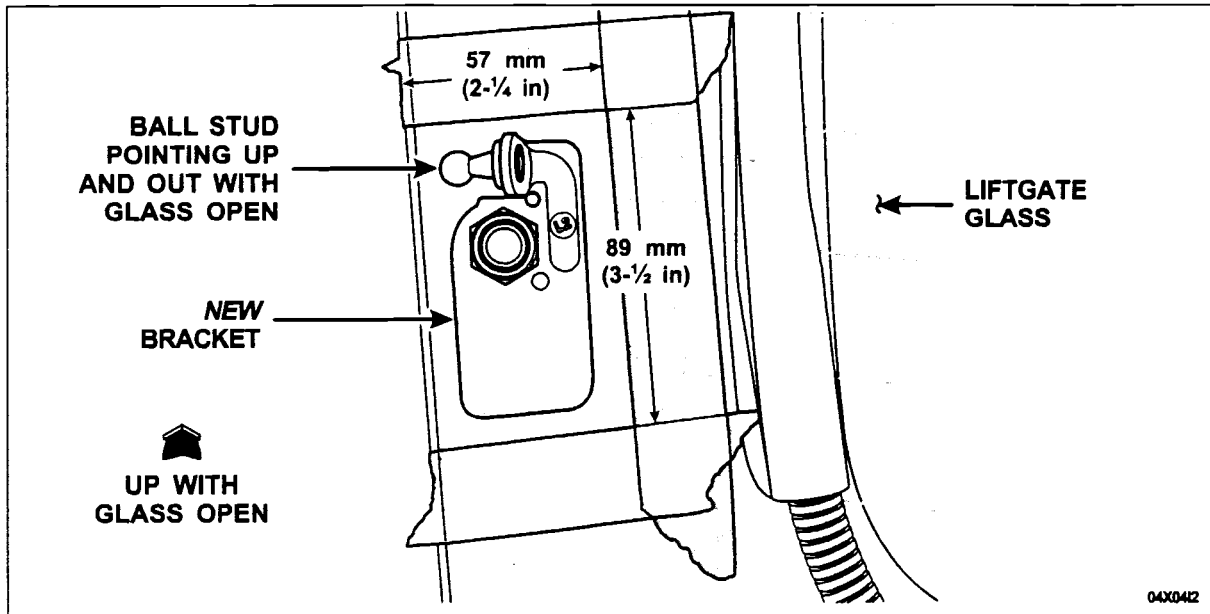


FIGURE 9



4. **CAUTION: Care should be taken to avoid damage to the frosted coating on the glass.**
Completely remove all existing adhesive from the glass using a sharp razor blade scraper.
Clean the area of any residual adhesive using the supplied Scotch Brite® scuff pad. See Figure 10.
5. **NEW** Clean the area using the supplied alcohol wipe and allow it to dry completely, ensuring no moisture is present. Then, inspect the edge of the hole for any chips or cracks. If the glass is chipped or cracked, the glass must be replaced. Discontinue this service in lieu of liftgate glass replacement.

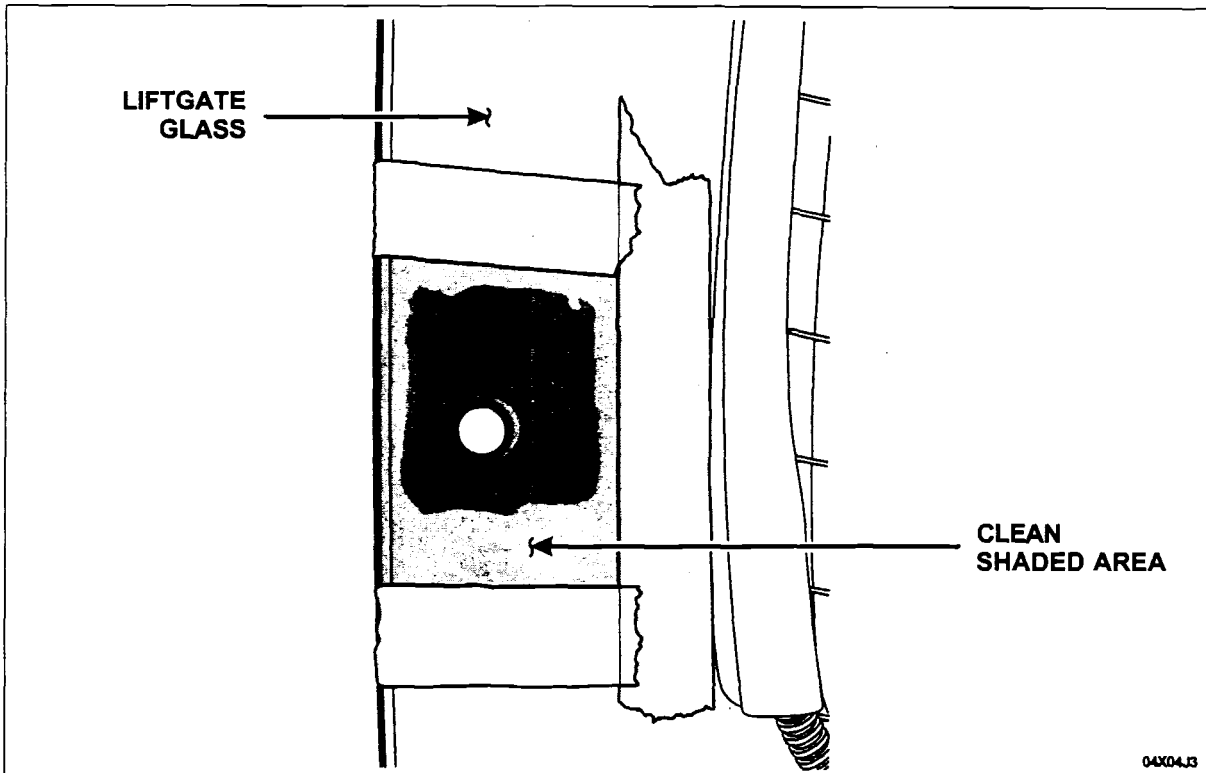


FIGURE 10

CAUTION: This primer requires a minimum of fifteen (15) minutes dry time before adhesive can be applied. Failure to wait the necessary fifteen (15) minutes will lead to the failure of the adhesive.

6. Using one of the supplied dauber brushes, neatly apply a thin coat of Chemlok 144® primer to the taped-off area, then carefully remove the tape. **Allow the primer to dry for at least fifteen (15) minutes, ensuring no moisture is present before installing the new brackets.**

While waiting for the primer to dry, remove the original bracket and prepare the surface on the opposite side of the glass (repeat Steps 2 through 7).

7. **NOTE: When scuffing the new bracket, use light pressure to avoid exposing bare metal.**
Using the Scotch Brite® scuff pad, carefully scuff the backside of both new brackets so that the surface no longer has a shiny appearance, then wipe it clean with one of the supplied alcohol wipes.



NEW

8. **CAUTION:** Be sure the glass and plastic washers are very clean and contain no grit, dirt, sand or any other foreign matter prior to installation. Even the smallest bit of any hard material captured between the plastic washer and the glass may cause the glass to shatter.

Install the plastic spacer (with locating tab) and rubber washer onto the *new* brackets as shown in Figure 11. Also, place a plastic washer onto the beauty bolt with the collar toward the glass.

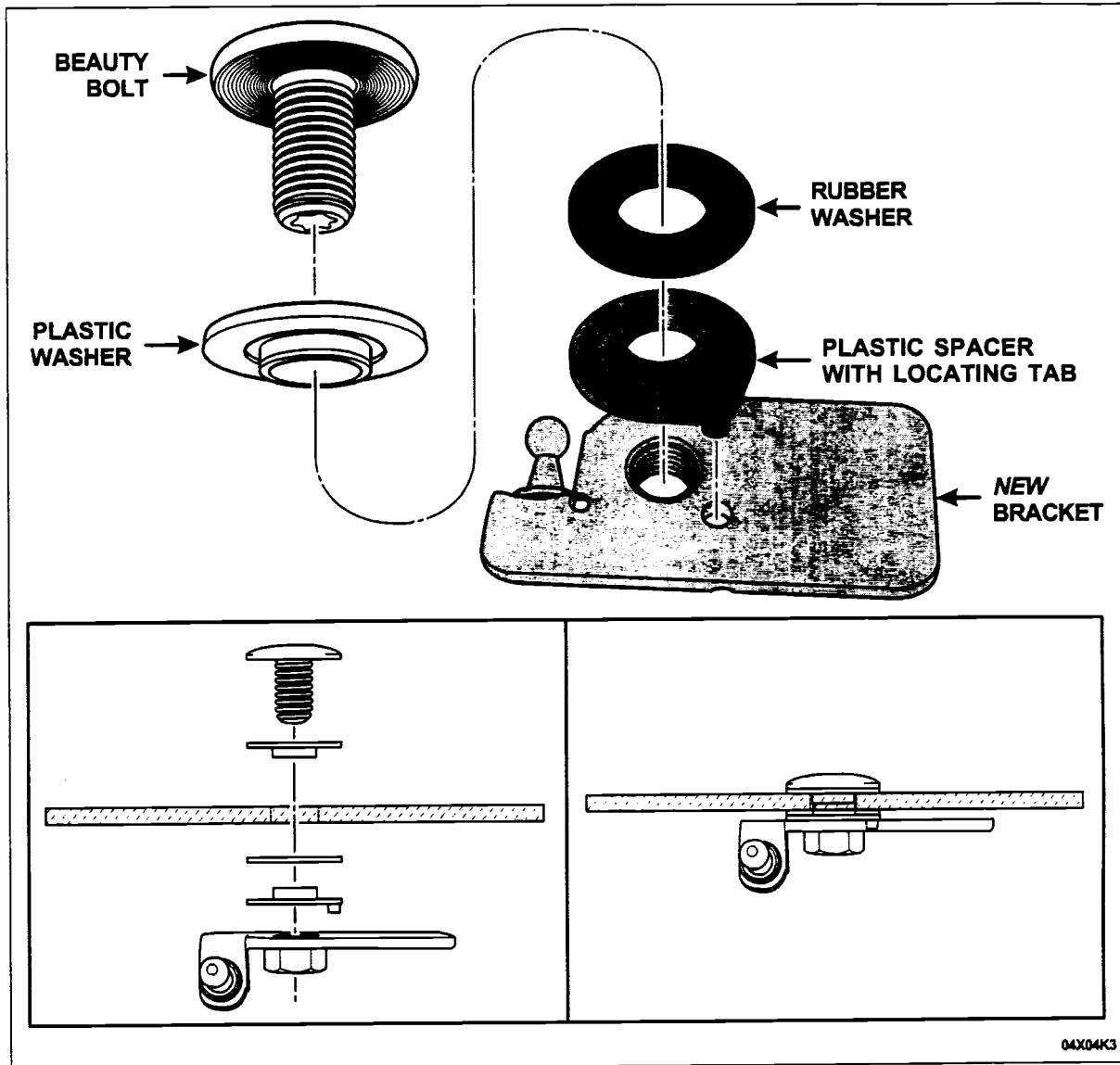


FIGURE 11



9. **CAUTION:** Failure to prepare the adhesive cartridge and mixer tip as described may cause insufficient mixing of the product. This may lead to insufficient bonding of the bracket(s) to the glass.

Assemble the adhesive cartridge and application tool and purge the cartridge as follows:

- A) Trim approximately 13 mm (0.5 in) off the top of both mixer tips, down to the last ring. See Figure 12.
- B) Install the Fusor® #143 adhesive cartridge into the application tool (No. 501-040).
- C) Dispense a small amount of adhesive from the cartridge onto a piece of scrap cardboard to level the plungers and to ensure an even flow of both components.
- D) Install one (1) mixer tip onto the cartridge and dispense a 75-mm (3-in) bead of the adhesive onto a piece of scrap cardboard (until the product is evenly mixed and the color is consistent).

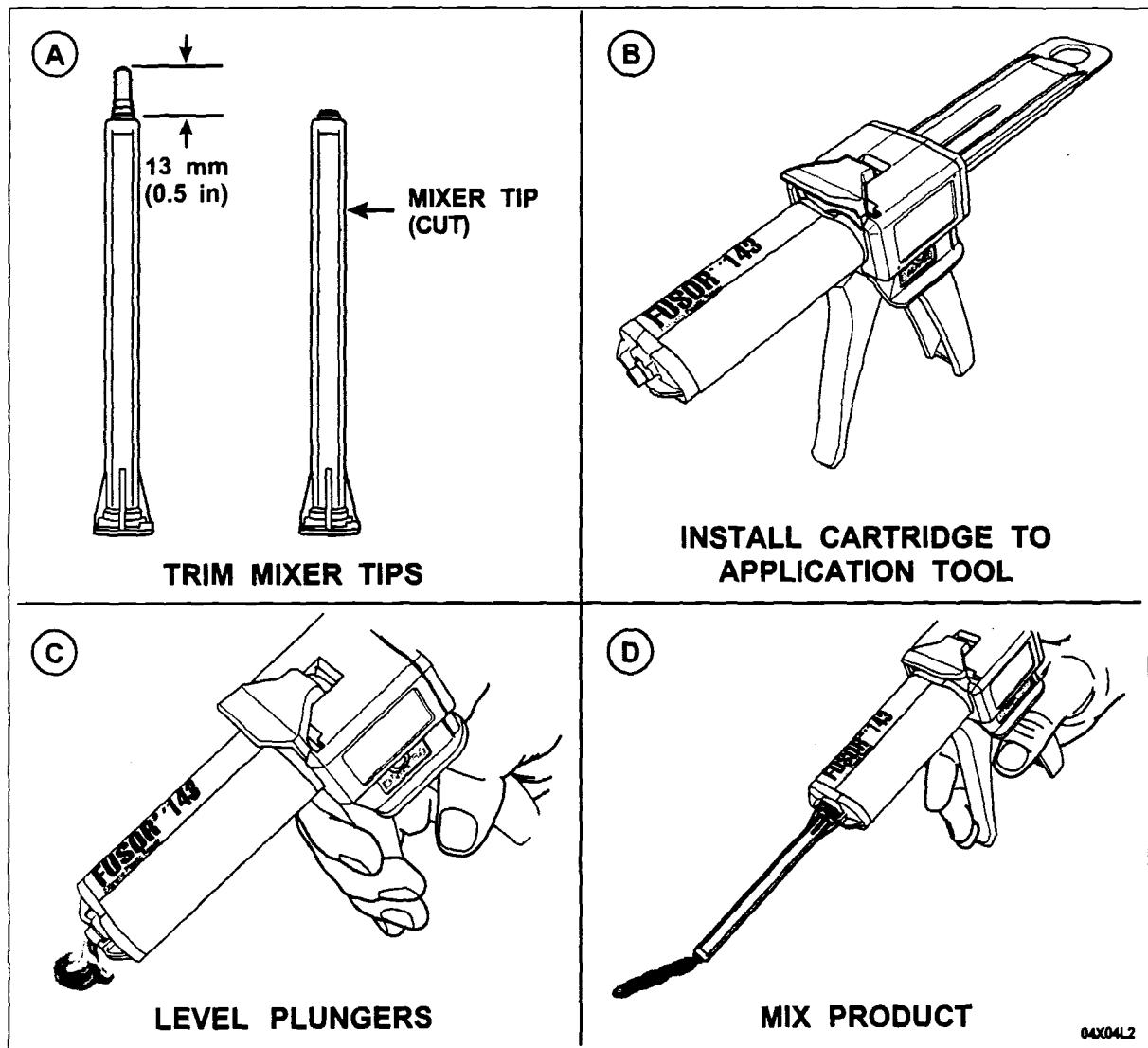


FIGURE 12



NOTE: Due to the working times involved and the necessity of changing mixing tips on the application tool, these instructions are written to perform installation of the left-side bracket first, then the right-side bracket. Please review these instructions and understand the process before proceeding with adhesive application and bracket installation.

10. **CAUTION:** The adhesive used to install the liftgate glass ball stud brackets will require at least two (2) hours to cure at 21° C (70° F) or higher. If the vehicle must be moved to a much colder environment before two hours has elapsed, cure time will increase substantially before the liftgate glass struts can be reattached. The following guidelines must be followed in order to ensure properly cured adhesive:

- Two (2) hour cure time at 21° C (70° F) (Preferred)
- Three (3) hour cure time at 10° C (50° F)
- Seven (7) hour cure time at 0° C (32° F)
- Below 0° C (32° F), call the Special Service Support Center at 1-800-325-5621 to review the particular circumstances and obtain further direction.

NOTE: Once the adhesive mixes, you will have less than one (1) minute to install the *new* bracket before the adhesive begins to set. The adhesive will require at least two (2) hours at 70°F or higher to cure before the liftgate glass support struts can be attached.

NOTE: Keep the used mixer tip attached to the cartridge after use.

After the primer has dried for fifteen (15) minutes, apply three (3) **large** beads (9-10 mm in diameter) of adhesive to the backside of the *new* left-side bracket. See Figure 13.

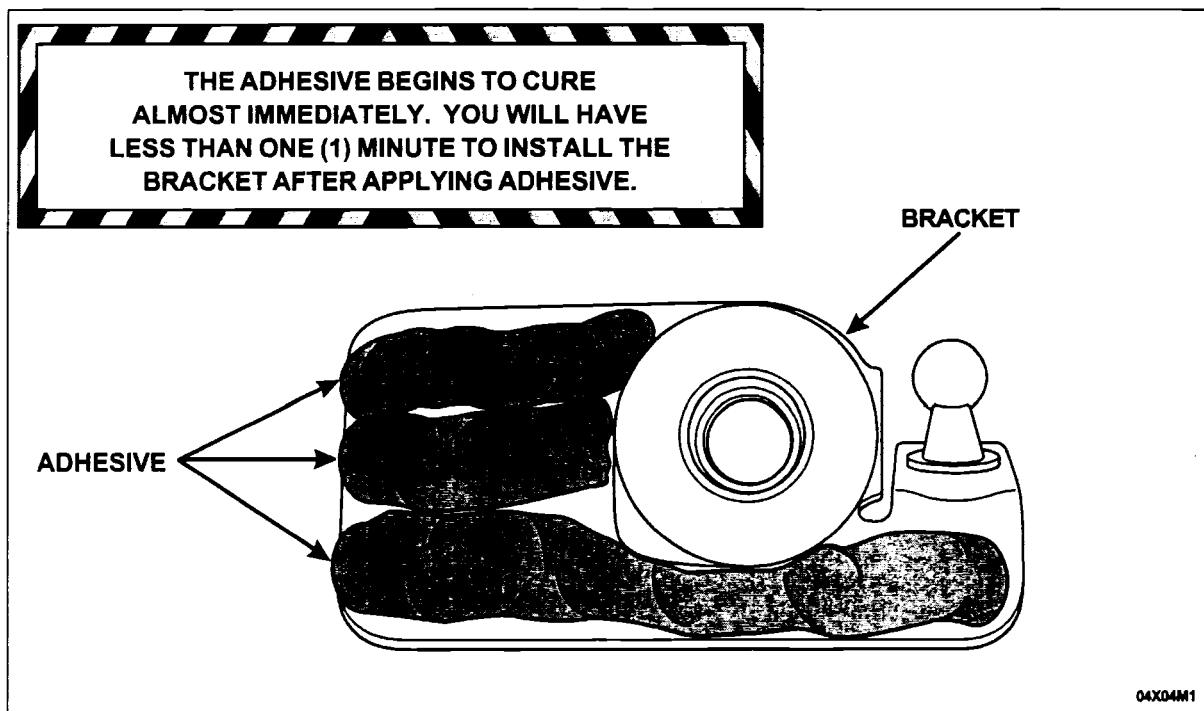


FIGURE 13



11. NOTE: Left side bolts and brackets have left-hand threads.

NOTE: Once the bracket is in position, DO NOT lift it from the glass. You may twist or turn the bracket slightly, but it must remain in contact with the glass to prevent the formation of air bubbles in the adhesive.

With the correct left-hand thread beauty bolt and plastic washer ready in one hand, position the **new** left-side bracket onto the glass and align it with the beauty bolt hole and parallel with the edge of the glass. Install the beauty bolt and snug it down hand tight.

CAUTION: While tightening the bolt, some adhesive will be squeezed out from under the bracket. DO NOT WIPE AWAY THE EXCESS ADHESIVE.

NEW

CAUTION: When working with glass, the torque specifications are very critical. Be sure the torque wrench used during this service has recently been calibrated so the fasteners are not over-tightened or under-tightened. Failure to use a calibrated torque wrench may result in glass shattering either during the repair or possibly after the repair is completed.

While holding the bracket nut with a 17-mm box or open-end wrench, tighten the bolt to 25 Nm (18 lb-ft). See Figure 14.

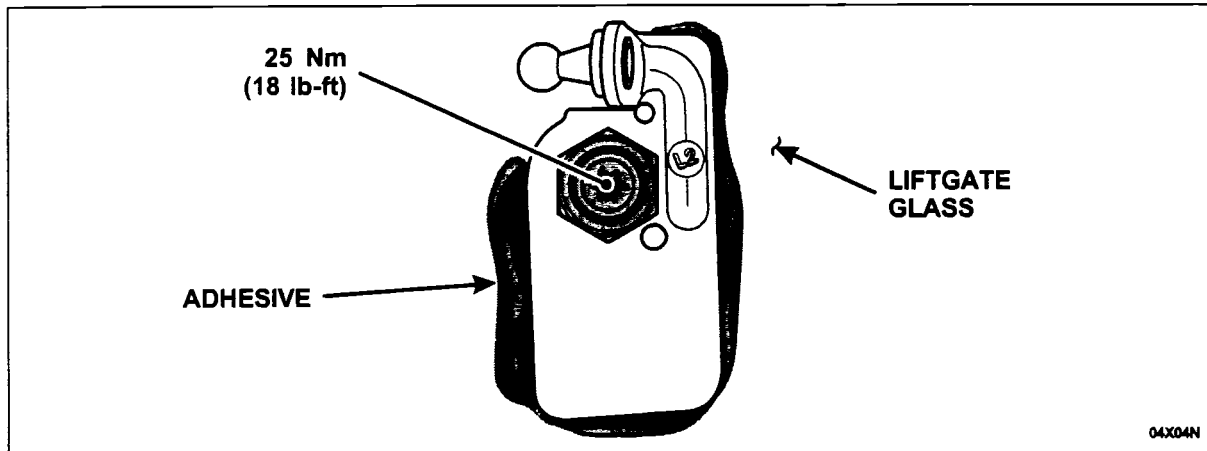


FIGURE 14

12. Once the **new** bracket is in place, make sure the edge of the bracket is parallel to the edge of the glass. If the bracket position needs to be adjusted, you may turn it using a 17-mm wrench. DO NOT separate the bracket from the glass once the bracket is in position.

CAUTION: The adhesive used to install the liftgate glass ball stud brackets will require at least two (2) hours to cure at 21° C (70° F) or higher. If the vehicle must be moved to a much colder environment before two hours has elapsed, cure time will increase substantially before the liftgate glass struts can be reattached. The following guidelines must be followed in order to ensure properly cured adhesive:

- Two (2) hour cure time at 21° C (70° F) (Preferred)
- Three (3) hour cure time at 10° C (50° F)
- Seven (7) hour cure time at 0° C (32° F)
- Below 0° C (32° F), call the Special Service Support Center at 1-800-325-5621 to review the particular circumstances and obtain further direction.



13. NOTE: Be sure to use a **new** mixer tip for each bracket.

Install a **new** trimmed mixer tip onto the adhesive cartridge, then dispense a 75-mm (3-in) bead of adhesive onto a piece of scrap cardboard to ensure the product is evenly mixed in the tip and is ready for application.

14. Apply three (3) **large** beads (9-10 mm in diameter) of adhesive to the backside of the **new** right-side bracket. See Figure 13.
15. With the correct right-hand thread beauty bolt and plastic washer ready in one hand, position the **new** right-side bracket onto the glass and align it with the beauty bolt hole and parallel with the edge of the glass. Install the beauty bolt and snug it down hand tight.

CAUTION: While tightening the bolt, some adhesive will be squeezed out from under the bracket. DO NOT WIPE AWAY THE EXCESS ADHESIVE.

While holding the bracket with a 17-mm box or open-end wrench, tighten the bolt to 25 Nm (18 lb-ft). See Figure 14.

16. Once the **new** bracket is in place, make sure the edge of the bracket is parallel to the edge of the glass. If the bracket position needs to be adjusted, you may turn it using a 17-mm wrench. DO NOT separate the bracket from the glass once the bracket is in position.

CAUTION: The adhesive used to install the liftgate glass ball stud brackets will require at least two (2) hours to cure at 21° C (70° F) or higher. If the vehicle must be moved to a much colder environment before two hours has elapsed, cure time will increase substantially before the liftgate glass struts can be reattached. The following guidelines must be followed in order to ensure properly cured adhesive:

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- Seven (7) hour cure time at 0° C (32° F)
- Below 0° C (32° F), call the Special Service Support Center at 1-800-325-5621 to review the particular circumstances and obtain further direction.

17. Remove the jack stand, carefully close the glass making sure the striker is engaged in the latch, and allow the adhesive to cure as indicated in the caution above.
18. After the adhesive has cured as required per the caution above, reattach the liftgate glass support struts before releasing the vehicle to the customer.



**Safety Recall 04S20
Dealer Questions and Answers**

Q1) Why do later built vehicles only need hinge replacement?

A1) Vehicles built after March 10, 2002 (SLAP) or March 3, 2002 (LAP) have an entirely different lift strut bracket design, and are not affected.

New!

Q2) If the strut has come off the ball stud bracket, should the strut be replaced?

A2) No, the strut does not need to be replaced except for the rare case where a strut is bent.

New!

Q3.) What if the liftgate glass detached and caused damage to nearby components?

A3.) Repair as necessary and submit a claim in accordance with the Warranty and Policy Manual (Section 4).

Q4) Some customers have experienced a cracked liftgate appliqué. Is this related to the recall?

A4) No, the appliqué is not related in any way to the issues addressed by this recall. Applique repairs are not covered by this recall.

New!

Q5) When can I provide the customer with a rental vehicle?

A5) A rental vehicle is only authorized when:

- *A vehicle arrives with a shattered back glass and a new glass must be ordered, or arrives with a broken hinge and the vehicle cannot be driven while a replacement hinge is on order.*
- *The back glass breaks during or shortly after kit installation.*
- **Shop volume or service scheduling makes it impossible to store vehicles that require bracket replacement for any of the specified cure times. It is anticipated that rental vehicles will only be required in limited circumstances.**

New!

Q6) If the original liftgate brackets have previously been repaired with an adhesive that prevents the technician from removing the small brackets from the glass, does the glass need to be replaced?

A6) Yes. Be sure the new glass has all the updated components (see Dealer Questions/Answers No.13)

Q7) What can customers do until parts are available?

A7) Parts are now available, but customers should still be advised to not use the liftgate glass until repairs are completed. Please note that the full liftgate may continue to be used to access the rear compartment of the vehicle.

**Safety Recall 04S20
Dealer Questions and Answers**

New!

Q8) How will customers be advised when parts are available?

A8) *The second customer notice indicating that dealers can now order parts was mailed beginning in mid-December, 2004. As of February, 2005, mailing quantities are being coordinated with the available supply of parts. Customers will be advised to contact their dealer for an appointment to have Safety Recall 04S20 performed. See Attachment V for a copy of the customer announcement postcard.*

New!

Q9) What if the customer arrives with the rear liftgate glass hinge broken?

A9) *Repair with revised hinge kit.*

Q10) When can dealers expect to see the applicator guns for the adhesive?

A10) All applicator guns should have arrived at dealerships by December 1, 2004. This is the same applicator gun that was supplied to dealers for previous recall programs.

New!

Q11) What if the customer arrives with the rear liftgate glass broken?

A11) *Replace the glass assembly. Be sure the new glass has all the updated components (see Dealer Questions/Answers No.13)*

Q12) What if the vehicle was involved in a collision and the liftgate glass was broken?

A12) This condition is not part of Safety Recall 04S20. However, when a new liftgate glass is received for the collision repair, be sure that the glass has ALL of the updated components mentioned below before installing. See Question #13.

Q13) If the liftgate glass is broken, requiring an order to be placed for a service replacement glass, will the strut brackets and liftgate hinges on the new glass need to be replaced?

A13) In the event that a new liftgate glass must be ordered, be sure that the new glass has ALL of the following before installing on the vehicle:

- Thick design hinges
- Large strut brackets
- Hard adhesive

This is necessary because your service glass supplier may not have provided the latest level glass assembly. Replacement glass with one of the "New" NAGS numbers shown in the chart below will have ALL of the above components already installed. If the replacement glass has one of the "Old" NAGS numbers, use the illustration following to determine which, if any, of the above components must be updated before installing the glass.

**Safety Recall 04S20
Dealer Questions and Answers**

NOTE: NAGS (National Auto Glass Specification) Number information (located on the shipping container and on the glass) can be used to determine the latest level of service glass.

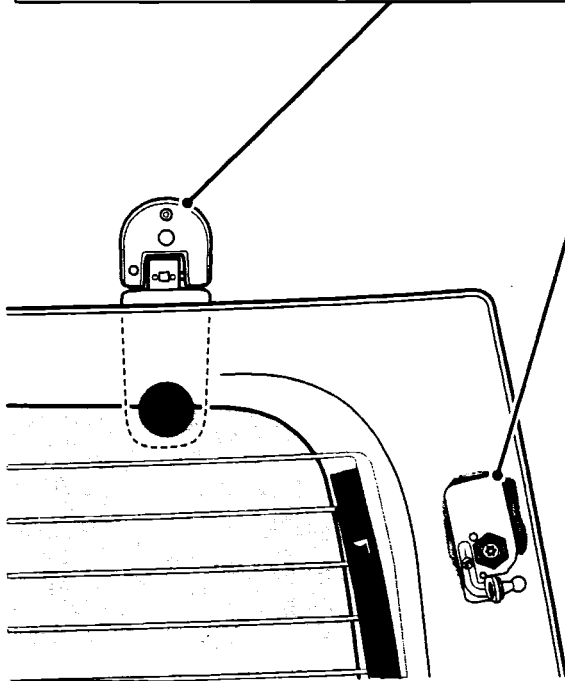
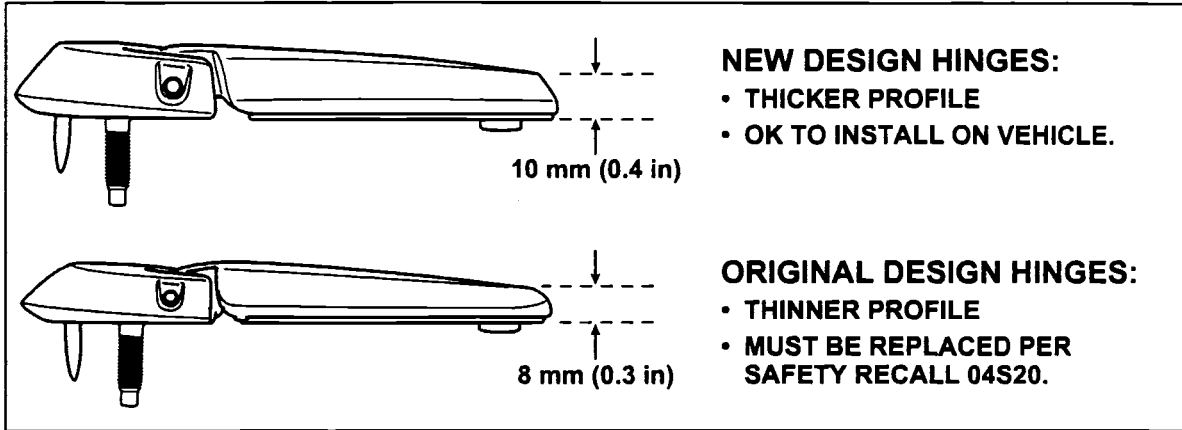
Early 2002 Models				
New Part Number	New NAGS* Number	Description	Old Part Number	Old NAGS Number
1L2Z-78422A12-AE	DB10895 YPY	Explorer, heated, privacy tint, 7- holes	1L2Z-78422A12-AD	DB10769 YPY
1L2Z-78422A12-CE	DB10898 YPY	Mountaineer, heated, privacy tint, 7-holes	1L2Z-78422A12-CD	DB10772 YPY
Late 2002 and 2003 Models				
3L2Z-78422A12-AC	DB10556 YPY	Explorer, heated, privacy tint, 5- holes	3L2Z-78422A12-AB	DB10399 YPY
3L2Z-78422A12-CC	DB10559 YPY	Mountaineer, heated, privacy tint, 5-holes	3L2Z-78422A12-CB	DB10402 YPY

*Glass with "New" NAGS numbers include paint-to-match appliqué and all new components required for Safety Recall 04S20:

- Thick design hinges
- Large strut brackets
- Hard adhesive

THE REPLACEMENT GLASS MUST HAVE:

- The new design hinges.
- Large strut brackets.
- Hard adhesive.



LARGE BRACKET:

- INSPECT FOR SOFT ADHESIVE BY ATTEMPTING TO LEAVE IMPRESSIONS WITH FINGERNAIL.
- BRACKET MUST BE REPLACED PER SAFETY RECALL 04S20 IF ADHESIVE IS SOFT.
- BRACKETS OK IF ADHESIVE IS HARD.

CAUTION: ATTEMPTING TO REMOVE A BRACKET THAT IS ATTACHED WITH THE NEW (HARD-TO-THE-TOUCH) ADHESIVE WILL LIKELY RESULT IN SHATTERING OF THE LIFTGATE GLASS.

SMALL BRACKET:

- MUST BE REPLACED PER SAFETY RECALL 04S20.

Safety Recall 04S20
Customer Follow-Up Postcard (To Be Mailed Beginning Mid-December 2004)



Important Parts Notification

Safety Recall 04S20

Dear Explorer or Mountaineer Owner,

December 2004

In October, 2004 we mailed you a letter announcing a Safety Recall concerning the rear liftgate glass on your Explorer or Mountaineer. At that time, parts were not yet available. **YOUR DEALER CAN NOW ORDER PARTS FOR YOUR VEHICLE.** At no charge to you, your dealer will install the updated parts for the rear liftgate glass. Please contact your dealer to schedule an appointment; however, due to initial limited parts supplies, your dealer may need several weeks to schedule your appointment.

Please note: Until you have this recall repair completed, we strongly recommend that you do not use the liftgate glass. Instead, use the larger liftgate door to access the rear compartment of your vehicle.

Sincerely,

A handwritten signature in cursive script that reads "Frank M. Ligon".

Frank M. Ligon
Director
Service Engineering Operations



Frank M. Ligon
Ford Motor Company
P. O. Box 1904
Dearborn, Michigan 48121

September 2004

Safety Recall 04S20 - Vehicles built from Job #1 2002 through March 10, 2002 at St Louis Assembly Plant (SLAP) or through March 3, 2002 at Louisville Assembly Plant (LAP)

Mr. John Sample
123 Main Street
Anywhere, USA 12345

Your Vehicle Identification Number: 12345678901234567

This notice is sent to you in accordance with the requirements of the National Traffic and Motor Vehicle Safety Act.

Ford Motor Company has decided that a defect which relates to motor vehicle safety exists in certain 2002 Ford Explorer and Mercury Mountaineer vehicles.

We apologize for this situation and want to assure you that, with your assistance, we will correct this condition. Our commitment, together with Ford and Lincoln Mercury dealers, is to provide you with the highest level of service and support possible.

What is the issue?

In some of the affected vehicles, the liftgate window may drop unexpectedly when it is being operated. When the window drops it may strike a person nearby or the glass may break creating the potential for cuts or bruises.

What will Ford and your dealer do?

Effective Late November 2004: At no charge, dealers will replace both strut mounting brackets and both hinges on the liftgate glass with new design parts. We expect these new design parts will be available late November 2004. We will notify you when parts are available so you can contact your dealer for an appointment to have Safety Recall 04S20 performed on your vehicle.

How long will it take?

The time needed for this repair is less than one-half day. However, due to service scheduling requirements, your dealer may need your vehicle for a longer period of time. To ensure a proper repair, your dealer may also need your vehicle for a longer time when outside temperatures are very low.

What are we asking you to do?

WARNING: Until this recall has been performed, do not open or close your liftgate glass. The larger liftgate door is not affected by this recall, so you can still use it to access the rear compartment of your vehicle. **See the attached illustration for guidance.** When parts become available, we will notify you and ask you to call your dealer to request a service date for Recall 04S20. At that time, provide the dealer with the Vehicle Identification Number (VIN) of your vehicle. The VIN is printed near your name at the beginning of this letter.

If you do not already have a servicing dealer, you can access <http://www.genuinefilmservice.com> for dealer addresses, maps, and driving instructions.

Please note: Federal law requires that any vehicle lessor receiving this recall notice must forward a copy of this notice to the lessee within ten days.

Have you previously paid for this repair?

If you paid to remedy the issue addressed in this notice, you may be eligible for a refund either through your dealer or directly from Ford Motor Company.

To verify eligibility and expedite reimbursement, give your paid original receipt to your dealer. Refund requests, including all required documentation, may also be mailed to Ford at P.O. Box 6251, Dearborn, Michigan 48121-6251. Refund requests mailed to Ford may take up to 60 days to process.

Detailed information regarding eligibility for Ford's reimbursement program and documentation requirements may be obtained by contacting the Ford Customer Relationship Center at 1-866-436-7332. Owners who have previously paid for this repair are still eligible to have the recall described in this letter performed.

Have you changed your address or sold the vehicle?

If you have, please fill out the enclosed prepaid postcard and mail it to us so we can update our records. If you have sold the vehicle, the information you provide on the postcard will be used to notify the new owner about this recall.

Can we assist you further?

If you have difficulty getting your vehicle repaired promptly and without charge, please contact your dealership's Service Manager for assistance.

If you still have concerns, please contact the Ford Motor Company Customer Relationship Center and one of our representatives will be happy to assist you.

Call 1-866-436-7332. For the hearing impaired call 1-800-232-5952 (TDD).

Office Hours: (Eastern Time Zone)

Monday – Friday: 8AM – 8PM

Saturday: 9AM – 5:30PM

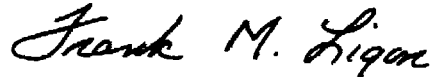
If you wish to contact us through the Internet, our address is:

www.ownerconnection.com

If you are still having difficulty getting your vehicle repaired in a reasonable time or without charge, you may write the Administrator, National Highway Traffic Safety Administration, 400 Seventh Street S. W., Washington, D. C. 20590 or call the toll free Auto Safety Hotline at 1-888-327-4236 or 1-800-424-9393.

Thank you for your attention to this important matter.

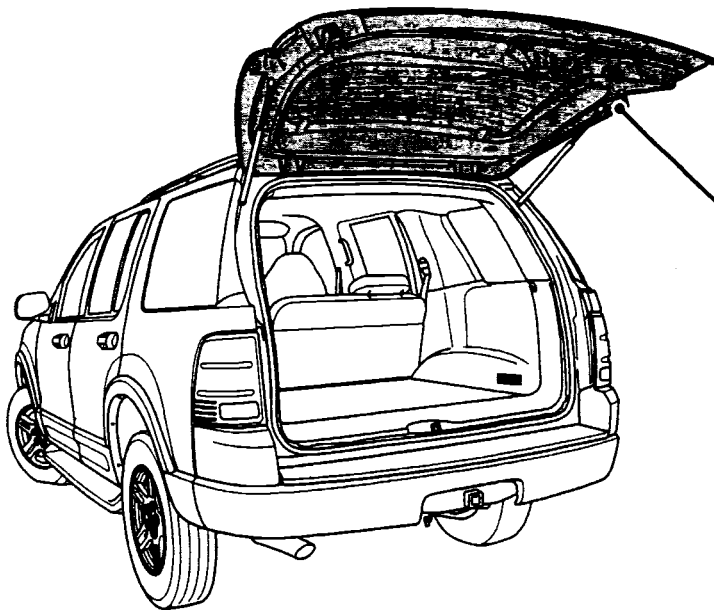
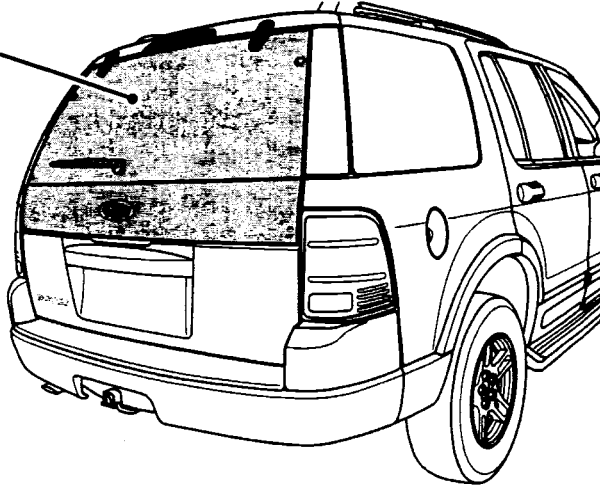
Sincerely,



Frank M. Ligon
Director
Service Engineering Operations

**CUSTOMER INSTRUCTIONS
UNTIL REPAIRS ARE COMPLETED**

**DO NOT
OPEN/CLOSE GLASS**



**OK TO
OPEN LIFTGATE**



Frank M. Ligon
Ford Motor Company
P. O. Box 1904
Dearborn, Michigan 48121

September 2004

Safety Recall 04S20 - Vehicles built from March 11, 2002 at St Louis Assembly Plant (SLAP) or March 4, 2002 at Louisville Assembly Plant (LAP) through June 23, 2003

Mr. John Sample
123 Main Street
Anywhere, USA 12345

Your Vehicle Identification Number: 12345678901234567

This notice is sent to you in accordance with the requirements of the National Traffic and Motor Vehicle Safety Act.

Ford Motor Company has decided that a defect which relates to motor vehicle safety exists in certain 2002 and 2003 Ford Explorer and Mercury Mountaineer vehicles.

We apologize for this situation and want to assure you that, with your assistance, we will correct this condition. Our commitment, together with Ford and Lincoln Mercury dealers, is to provide you with the highest level of service and support possible.

What is the issue? In some of the affected vehicles, the liftgate window may drop unexpectedly when it is being operated. When the window drops it may strike a person nearby or the glass may break creating the potential for cuts or bruises.

What will Ford and your dealer do? **Effective Late November 2004:** At no charge, dealers will replace both hinges on the liftgate glass with new design parts. We expect these new design parts will be available late November 2004. We will notify you when parts are available so you can contact your dealer for an appointment to have Safety Recall 04S20 performed on your vehicle.

How long will it take? The time needed for this repair is less than one-half day. However, due to service scheduling requirements, your dealer may need your vehicle for a longer period of time.

What are we asking you to do?

WARNING: Until this recall has been performed, do not open or close your liftgate glass. The larger liftgate door is not affected by this recall, so you can still use it to access the rear compartment of your vehicle. **See the attached illustration for guidance.** When parts become available, we will notify you and ask you to call your dealer to request a service date for Recall 04S20. At that time, provide the dealer with the Vehicle Identification Number (VIN) of your vehicle. The VIN is printed near your name at the beginning of this letter.

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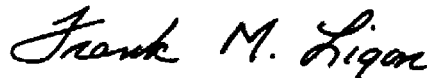
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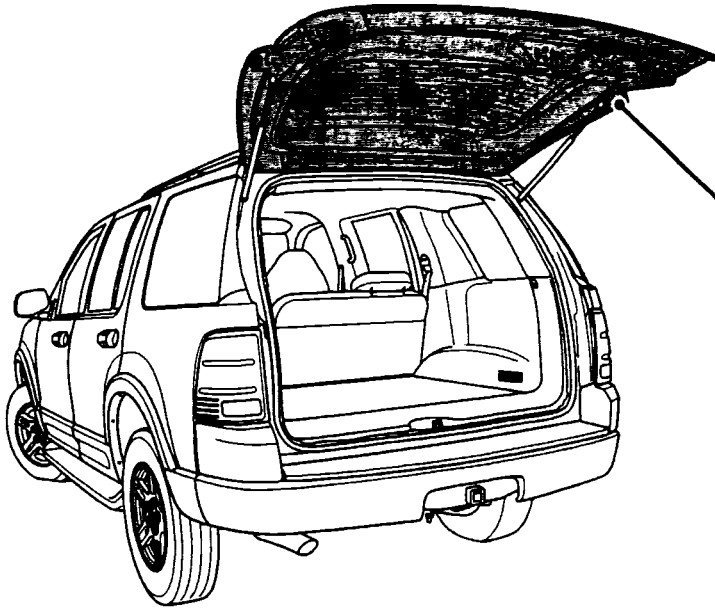
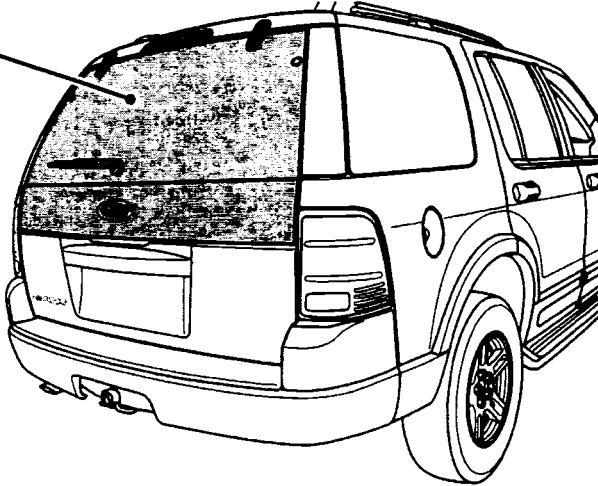
Sincerely,



Frank M. Ligon
Director
Service Engineering Operations

**CUSTOMER INSTRUCTIONS
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**OK TO
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