



Service Engineering Operations  
Customer Service Division

Ford Motor Company  
PO Box 1904  
Dearborn, Michigan 48121

December 18, 2024

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

**SUBJECT:** **Customer Satisfaction Program 23B56 - Supplement #1**  
Certain 2020 - 2023 Model Year Escape Vehicles  
Inspect Front Door Check-Arm Reinforcement Spot Welds

**REF:** **Customer Satisfaction Program 23B56**  
Published May 20, 2024

**New! REASON FOR THIS SUPPLEMENT**

- **RENTAL VEHICLES:** Process for requesting more than 4 days has changed.
- **REPAIR PHOTO SUBMISSION:** Process for submitting photos has changed.
- **CLAIMS PREPARATION AND SUBMISSION:** Technician Competency Requirement updated and subletting rules expanded.
- **LABOR ALLOWANCES:** Explanation of labor operation combinations that will close the Field Service Action (FSA).
- **PARTS REQUIREMENTS / ORDERING INFORMATION:** New process for restricted parts.

**PROGRAM TERMS**

This program will be in effect through May 31, 2027. There is no mileage limit for this program.

**URGENCY / EXPIRATION DATE**

We recommend dealers utilize their FSA VIN Lists' names and address to contact customers with affected vehicles. This will help minimize the number of vehicles that may experience multiple cracked/broken door check-arm reinforcement spot welds, which requires a more extensive repair. FSA VIN Lists were made available on February 22, 2024.

**AFFECTED VEHICLES**

Vehicle	Model Year	Assembly Plant	Build Dates
Escape	2020 - 2023	Louisville	November 13, 2018 through June 19, 2023

US population of affected vehicles: 557,448. Affected vehicles are identified in OASIS and FSA VIN Lists.

**REASON FOR THIS PROGRAM**

On all of the affected vehicles, the front door check-arm reinforcement welds can crack and may eventually pull away from the door structure. If not repaired, the check-arm reinforcement may eventually detach from the door structure. This can cause a rattling noise and increased door opening/closing efforts. It may also interfere with door glass operation and the ability of the check arm to hold the door in the open position.

**SERVICE ACTION**

Dealers will inspect the front door check-arm reinforcement bracket welds. Vehicles with **less than 3** welds completely separated from the door AND weld cracks that do not exceed 10mm in length will have a reinforcement kit installed to strengthen the area and prevent welds from cracking or breaking. Vehicles with **3 or more** completely separated welds from the door OR any weld cracks that exceed

10mm in length will receive a full door replacement. This service must be performed on all affected vehicles at no charge to the vehicle owner.

**NOTE:** If a front door has been replaced after November 18, 2023, no action needs to be performed on the replaced door.

### **OWNER NOTIFICATION MAILING SCHEDULE**

*Owner letters were mailed the week of June 3, 2024.* Dealers should repair any affected vehicles that arrive at their dealerships, whether or not the customer has received a letter.

### **New! ATTACHMENTS**

- *Administrative Information*
- *Labor Allowances and Parts Ordering Information*
- Technical Instructions
- Mobile Service Repair Assessment
- Owner Notification Letter
- Additional Attachments (Service kit installation templates)

### **QUESTIONS & ASSISTANCE**

For questions and assistance, contact the Special Service Support Center (SSSC) via the SSSC Web Contact Site. The SSSC Web Contact Site can be accessed through the Professional Technician System (PTS) website using the SSSC link listed at the bottom of the OASIS VIN report screen or listed under the SSSC tab.

Customer Service Division

**Customer Satisfaction Program 23B56 – Supplement #1****MOBILE SERVICE REPAIR ASSESSMENT LEVEL**

- All repairs in this program have the following assessment level:  
Ⓢ - Not a Mobile Service Repair

**OASIS ACTIVATION**

OASIS was activated on February 22, 2024.

**FSA VIN LISTS ACTIVATION**

FSA VIN Lists have been made available through <https://web.fsavinlists.dealerconnection.com> since February 22, 2024. Owner names and addresses were available the week of June 17, 2024.

**NOTE:** Your FSA VIN Lists 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 program 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 service action.

**SOLD VEHICLES**

- Owners of affected vehicles will be directed to dealers for repairs.
- Immediately contact any of your affected customers whose vehicles are not on your VIN list but are identified in OASIS. Give the customer a copy of the Owner Notification Letter (when available) and schedule a service date.
- Correct other affected vehicles identified in OASIS which are brought to your dealership.
- Dealers are to prioritize repairs of customer vehicles over repairs of new and used vehicle inventory.

**STOCK VEHICLES**

- Correct all affected units in your new vehicle inventory before delivery.
- Use OASIS to identify any affected vehicles in your used vehicle inventory.

**BRANDED / SALVAGED TITLE VEHICLES**

Affected branded / salvaged title vehicles are eligible for this service action.

**OWNER REFUNDS**

- Ford Motor Company is offering a refund for owner-paid repairs covered by this program if the repair was performed before the date of the Owner Notification Letter. This refund offer expires 6 months after the owner received their owner letter.
- Dealers are also pre-approved to refund owner-paid emergency repairs that were performed away from an authorized servicing dealer after the date of the Owner Notification Letter. Non-covered repairs, or those judged by Ford to be excessive, will not be reimbursed.
- Refunds will only be provided for the cost associated with front door replacement due to broken check-arm reinforcement welds.

**Customer Satisfaction Program 23B56 – Supplement #1****New! RENTAL VEHICLES**

*Rental vehicles are only approved for this program when a door(s) must be replaced. Dealers are pre-approved for up to 4 days for a comparable rental vehicle. Follow Extended Service Plan (ESP) guidelines for dollar amounts. Rentals will only be reimbursed for the day(s) the vehicle is at the dealership for door replacement. Prior approval for more than 4 rental day(s) is required from the Centralized Loaner Support Team. Contact the Centralized Loaner Support Team via CRC Dealer Portal for consideration and approval if appropriate.*

**ALTERNATIVE TRANSPORTATION**

If a customer is unable or does not wish to rent a vehicle but still requires transportation, the rental reimbursement allowance can be used for alternative transportation. Alternative transportation is approved for \$100 per day for both Ford and Lincoln customers. The dollar-per-day allowance can be cumulative across multiple rides per day (e.g., ride to work \$20 and ride home \$24).

- Alternative transportation reimbursement can be claimed for both short-term and long-term scenarios.
- Any amount over the cost-per-day limits will be the customer's responsibility.
- The customer will need to pay upfront and provide proof of payment to the dealer.
- Dealers will then need to submit for reimbursement following the Rental Vehicle Reimbursement Process and then refund the customer.

Examples of alternative transportation:

- Taxi
- Public Transportation - Subway, Train, or Bus
- Rideshare alternatives (Uber, Lyft, etc.)

**New! REPAIR PHOTO SUBMISSION**

Ford has requested photo evidence prior to performing a front door replacement for this FSA.

- The SSSC must provide approval prior to replacing a front door(s).
- If a door meets the replacement criteria (refer to Front Door Repair Procedure attachment), contact the SSSC and upload the necessary photos of the broken and/or cracked welds around the door check-arm as an attachment for review. *This can be done in two ways:*
  - *Directly in the SSSC contact request form while submitting your contact on your desktop.*
  - *Via PTS Mobile under the Images / Files Upload menu selection*
    - *You should select SSSC in the sub-menu and ensure your P&A code is correct. Upload the photo(s) by selecting the appropriate FSA with the option to use a prior contact ID. These photo(s) will be associated with your SSSC contact during submission.*
    - *If you have not submitted a SSSC contact yet, then you can still upload the photo(s) via PTS Mobile, and the photo(s) will be available when opening your SSSC contact for this VIN and recall.*
- Upon approval, the SSSC will provide an approval code that must be used for claiming.

**Customer Satisfaction Program 23B56 – Supplement #1****ADDITIONAL REPAIR (LABOR TIME AND/OR PARTS)**

Additional repairs identified as necessary to complete the FSA should be managed as follows:

- For related damage and access time requirements, refer to the Warranty and Policy Manual / Section 6 – Ford & Lincoln Program Policies / General Information & Special Circumstances for FSAs / Related Damage.
- For vehicles within new vehicle bumper-to-bumper warranty coverage, no SSSC approval is required, although related damage must be on a separate repair line with the “Related Damage” radio button checked.
  - Ford vehicles – 3 years or 36,000 miles
- For vehicles outside new vehicle bumper-to-bumper warranty coverage, submit an Approval Request to the SSSC Web Contact Site before completing the repair.

**New! CLAIMS PREPARATION AND SUBMISSION**

- **Technician Competency Requirement:** *The STST Competency 10 certification requirement in the U.S. market only will be enforced starting with repair orders opened on or after August 31, 2024. FSA repairs will reject and the claim will not be paid if the repairing technician is not certified in STST Competency 10 FSA. See EFC15332 for more details.*
  - **Claim Entry:** Enter claims using Dealer Management System (DMS) or One Warranty Solution (OWS) online.
    - When entering claims:
      - Claim type 31: Field Service Action
      - Sub Code: 23B56
      - Customer Concern Code (CCC): B09
      - Condition Code (CC): 61
      - Causal Part Number: Use 7820125 for all kit installations and LH door or both door replacements, and 7820124 only for RH door replacements - Quantity 0
    - For additional claims preparation and submission information, refer to the Recall and Customer Satisfaction Program (CSP) Repairs in the OWS User Guide.
  - **Related Damage/Additional labor and/or parts:** Must be claimed as Related Damage on a separate repair line from the FSA with the same claim type and subcode as described in Claim Entry above.
- IMPORTANT:** Click the Related Damage Indicator radio button.
- **Rentals:** Note: Rentals are provided only for claims with a front door replacement. For rental vehicle claiming, follow Extended Service Plan (ESP) guidelines for dollar amounts. Enter the total amount of the rental expense under the Miscellaneous Expense code RENTAL.
  - **Refunds:** Submit refunds on a separate repair line.
    - Program Code: 23B56
    - Misc. Expense: ADMIN
    - Misc. Expense: REFUND
    - Misc. Expense: 0.2 Hrs.
  - Multiple refunds should be submitted on one repair line and the invoice details for each repair should be detailed in the comments section of the claim.

Customer Satisfaction Program 23B56 – **Supplement #1****CLAIMS PREPARATION AND SUBMISSION (continued)**

- **Additional parts not listed in the parts section:** Additional parts such as fasteners may be submitted on the same repair line on which the FSA is claimed.
- **Provision for Locally Obtained Supplies:** Only applies to door replacement. Includes paint and paint supplies. Submit on the same line as the repair.
  - Program Code: 23B56
  - Misc. Expense: OTHER
  - Misc. Expense: Claim up to \$1,000.
- **Sublet Mechanical and Painting:** *Applies to kit installation and door replacement.* This program may be sublet to a body/paint shop if required. Sublet documentation must be retained. Submit on the same line as the repair.
  - Program Code: 23B56
  - Misc. Expense: FSAOSL
  - Misc. Expense:
    - Claim up to \$8,000 for 2 doors (whole job – parts and labor, including paint),
    - \$4000 for one door (whole job – parts and labor including paint).
    - \$3000 for 2 doors (paint only),
    - \$2000 for one door (paint only),
    - *\$240 for service kit installation per door.*
- **Miscellaneous Labor Operations:** For sublet repairs only, claim 0.2 hours for door check arm reinforcement weld inspection.
  - For sublet repairs only, claim 0.2 hours for administration of sublet forms.

## Labor Allowances and Parts Ordering Information

Page 1 of 3

### Customer Satisfaction Program 23B56 – *Supplement #1*

#### **New!** LABOR ALLOWANCES

Description	Labor Operation	Labor Time
Inspect check-arm reinforcement spot welds in both front doors. If door passes inspection, install service kit ( <b>one door</b> ).	23B56H	1.4 Hours
Inspect check-arm reinforcement spot welds in both front doors. If both doors pass inspection, install service kits ( <b>two doors</b> ). <i>This closes the FSA.</i>	23B56J	2.6 Hours
<b>One Door Replacement – Mechanical procedures only</b> - Remove and install all door components including molding, remove and install and adjust one door (cannot be claimed with F or G). <i>This closes the FSA when combined with D and H.</i>	MT23B56B	M-time Up to 3.5 hours
<b>Two Door Replacement – Mechanical procedures only</b> - Remove and install all door components including molding, remove and install and adjust both doors (cannot be claimed with F or G). <i>This closes the FSA when combined with E.</i>	MT23B56C	M-time Up to 6.3 hours
<b>One Door Replacement - Paint only</b> (cannot be claimed with F or G). <i>This closes the FSA when combined with B and H.</i>	MT23B56D	M-time Up to 4.7 hours
<b>Two Door Replacement - Paint only</b> (cannot be claimed with F or G). <i>This closes the FSA when combined with C.</i>	MT23B56E	M-time Up to 9.4 hours
<b>One Door Replacement - Mechanical <u>and</u> Paint</b> (cannot be claimed with B, C, D or E). <i>This closes the FSA when combined with H.</i>	MT23B56F	M-time Up to 8.2 hours
<b>Two Door Replacement - Mechanical <u>and</u> Paint</b> (cannot be claimed with B, C, D or E). <i>This closes the FSA.</i>	MT23B56G	M-time Up to 15.7 hours
<b>Extra time for Tri-coat – One Door</b>	MT23B56K	M-time Up to 0.5 hours
<b>Extra time for Tri-coat – Two Doors</b>	MT23B56L	M-time Up to 1.0 hour
Time allowed to submit photos to SSSC for door replacement.	23B56ZZ	0.2 Hours

Customer Satisfaction Program 23B56 – **Supplement #1****New! PARTS REQUIREMENTS / ORDERING INFORMATION****Restricted Part Ordering:**

To place an order for parts, submit an Enhanced Order Entry (formerly Special Parts Order Process) order in the DOW system. **SSSC contact is not required to order K-Coded parts on this program.** More information can be found in EFC 15482.

Service Part Number	Claim Quantity	Package Order Quantity	Number in Package	Description
LJ6Z-78235A62-A	Up to 2	Up to 2	1	Escape door service kit
W721069-S300	12 per vehicle	3	4	Door trim panel push pin
LJ6Z-7820125-C	Up to 1	Up to 1	1	Escape front door – Left ( <b>Note: SSSC approval required for door replacement</b> )
LJ6Z-7820124-D	Up to 1	Up to 1	1	Escape front door – Right ( <b>Note: SSSC approval required for door replacement</b> )

Dealers will be notified via a DOES II communication if circumstances warrant a change in part supply strategy and when open ordering resumes.

Less than 3% of the affected vehicle population is expected to require a front door replacement.

**DEALER PRICE**

For the latest prices, refer to DOES II.

**PARTS RETENTION, RETURN, & SCRAPPING**

Follow the provisions of the Warranty and Policy Manual, Section 1 - WARRANTY PARTS RETENTION AND RETURN POLICIES. If a replaced part receives a scrap disposition, the part must be scrapped by all applicable local, state, and federal environmental protection and hazardous material regulations. Federal law prohibits selling motor vehicle parts or components that are under safety, compliance, or emissions recall.

**EXCESS STOCK RETURN**

The excess stock returned for credit must have been purchased from Ford Customer Service Division by Policy Procedure Bulletin 4000.



**Customer Satisfaction Program 23B56 – Supplement #1**

**REPLACED FSA PARTS INSPECTION AND SIGN OFF**

Effective March 1<sup>st</sup>, 2021, all parts replaced as part of an FSA repair with a repair order open date of March 1<sup>st</sup>, 2021, or later must be inspected and signed off on the repair order by a member of your dealer's fixed operations management team or an employee the task has been delegated to. If the task is to be delegated to a non-management employee, the employee needs to be someone other than the technician who completed the repair and needs to understand the importance of completing this task consistently and accurately.

- All parts replaced as part of an FSA repair should be returned to the parts department following the Warranty Parts Retention and Return Policies.
- Inspect the replaced parts to verify the FSA repair was completed.
- If the FSA repair is found to be complete, the designated employee signs the repair order line or parts return stamp area (electronic or hand signed) for the FSA repair indicating the parts were inspected and validated to have been replaced.
- After the parts have been inspected, they should be handled based on the guidance in the parts status report in the Online Warranty System (Hold, Return, CORE, Scrap, etc.). Please visit FMCDEALER > PARTS & SERVICE > WARRANTY ADMINISTRATION & WARRANTY PARTS RETURN for the latest [Immediate Scrap List](#) information.
- This process is subject to review during warranty audits for FSA repairs with a repair order open date of March 1<sup>st</sup>, 2021, or later. Any eligible FSA claims requiring parts replacement found not to have been inspected and signed off during a warranty audit will be subject to chargeback and consideration for enrollment into the Dealer Incomplete Recall Repair Process.

**Note:** Other approvals (electronic or handwritten) for add-on repair lines, dealer-owned vehicle repairs, and repeat repairs do not qualify as FSA parts inspection approvals. The post-repair FSA parts inspection process (electronic or handwritten) is independent of other warranty approval requirements. The approval by the designated employee implies that the FSA parts were found to be replaced and must be able to be identified on the Repair Order. If multiple FSAs require approval on a single Repair Order, each applicable occurrence will require individual post-repair approval by the designated employee.

## CERTAIN 2020-2023 MODEL YEAR ESCAPE VEHICLES — INSPECT FRONT DOOR CHECK-ARM REINFORCEMENT SPOT WELDS

### SERVICE INSPECTION PROCEDURE

**IMPORTANT!** The Service Technician Specialty Training (STST) Competency 10 certification requirement in the U.S. market only will be enforced starting with repair orders opened on or after August 31, 2024. Field Service Action (FSA) repairs will reject and the claim will not be paid if the repairing technician is not certified in STST Competency 10 FSA. See Electronic Field Communication (EFC)15332 for more details.

**NOTE:** This inspection procedure must be performed on both front doors.

1. Check OASIS warranty history. Has this vehicle had a front door replacement after 18-Nov-2023?

Yes - This is the latest part number door and requires no further action or installation of a reinforcement kit. Continue to Step 2.

No - Continue on to Step 2.

**NOTE:** This inspection procedure must be performed on both front doors, unless a front door(s) was replaced after 18-Nov-2023.

2. On both sides, open the front door and detach the two (2) closest push pins from the front door mounted weatherstrip as shown in Figure 1.

**NOTE:** Left Hand (LH) side shown, Right Hand side similar.

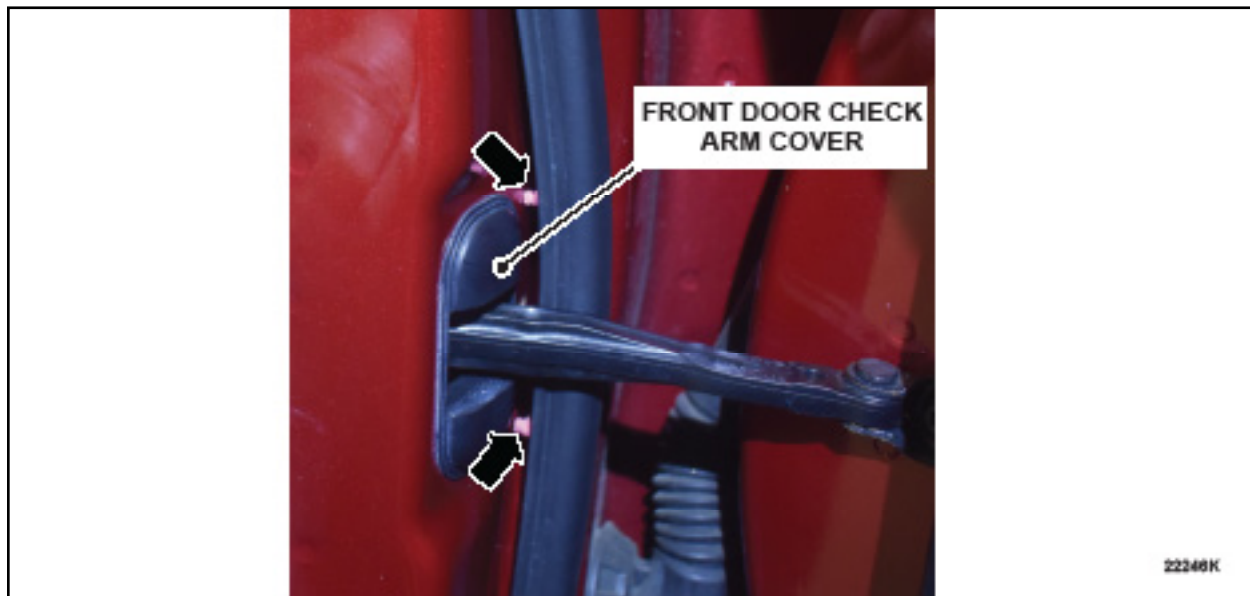


FIGURE 1



3. During the following inspection you will need to determine if the front door check arm bracket spot welds are cracked or separated from the door inner on both front doors. Locate the 3 spot welds under the door mounted weatherstrip as shown in Figure 2.

**NOTE:** Front door and front door mounted weatherstrip removed for clarity.



**FIGURE 2**

4. Inspect the spot welds on each door. Figures 3 and 4 show examples of the various damaged spot welds.

- Upon inspection of the door check arm spot welds on each door, pick the appropriate repair based on the inspection. One (1) of the two (2) repairs must be performed on each front door.

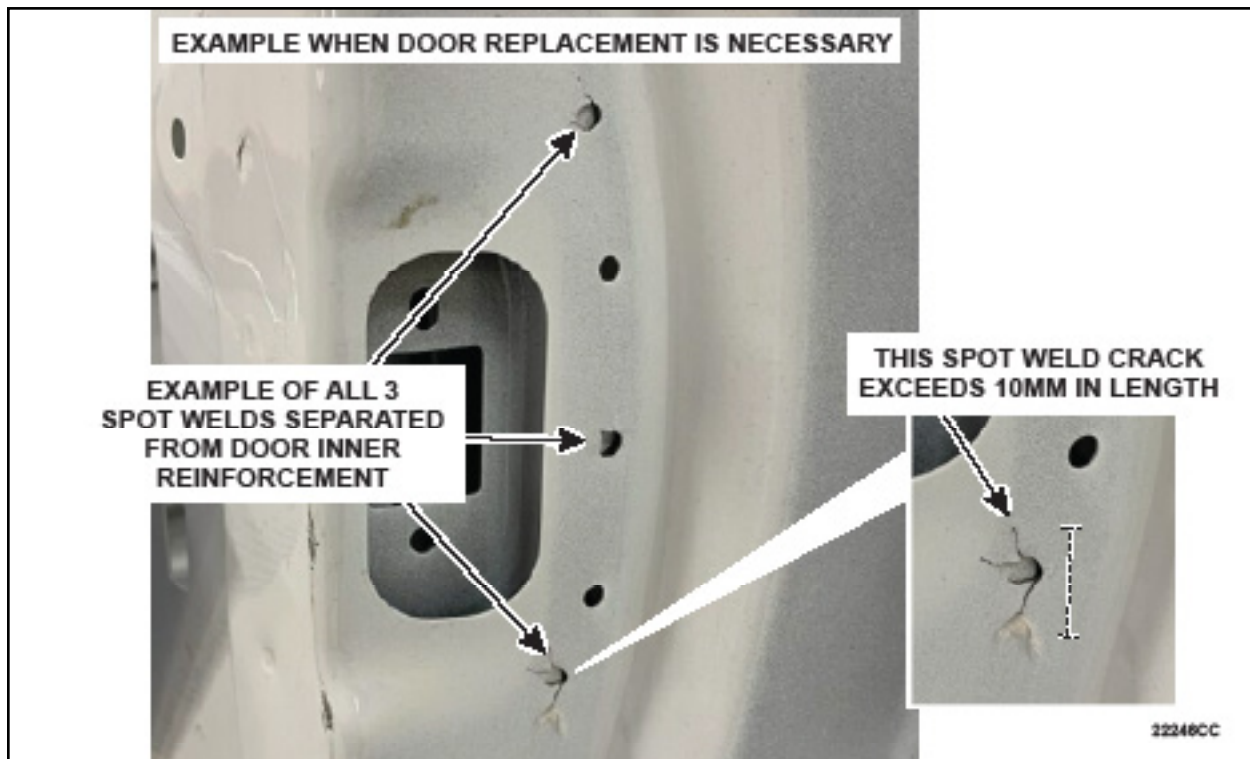
**Replacement of the Front Door Assembly is Required if:**

- Any weld has a crack more than 10 mm (0.39 inches) in length. **See the Front Door Replacement Procedure attachment.**
- AND/OR**
- Three (3) or more spot welds have completely separated from the door inner. **See the Front Door Replacement Procedure attachment.**

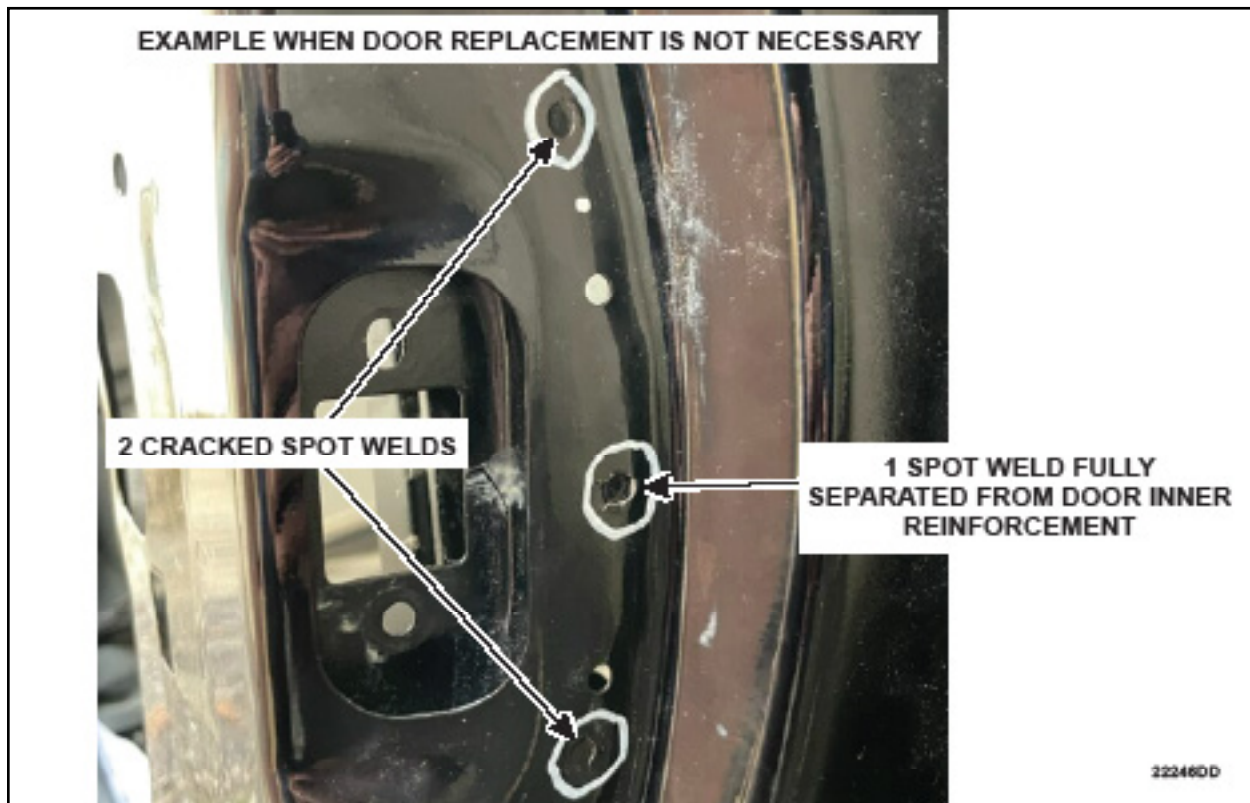
**Installation of the Service Kit - Rivet Plate Installation is Required if:**

- Two (2) or less spot welds have completely separated from the door inner **and** each crack is less than 10 mm (0.39 inches) in length. If welds are cracked but not separated from the door inner, it is acceptable to have two (2) or more cracked welds and proceed with the rivet plate installation. **See the Service Repair Procedure on Page 4.**
- OR**
- All welds are intact. **See the Service Repair Procedure on Page 4.**





**FIGURE 3**



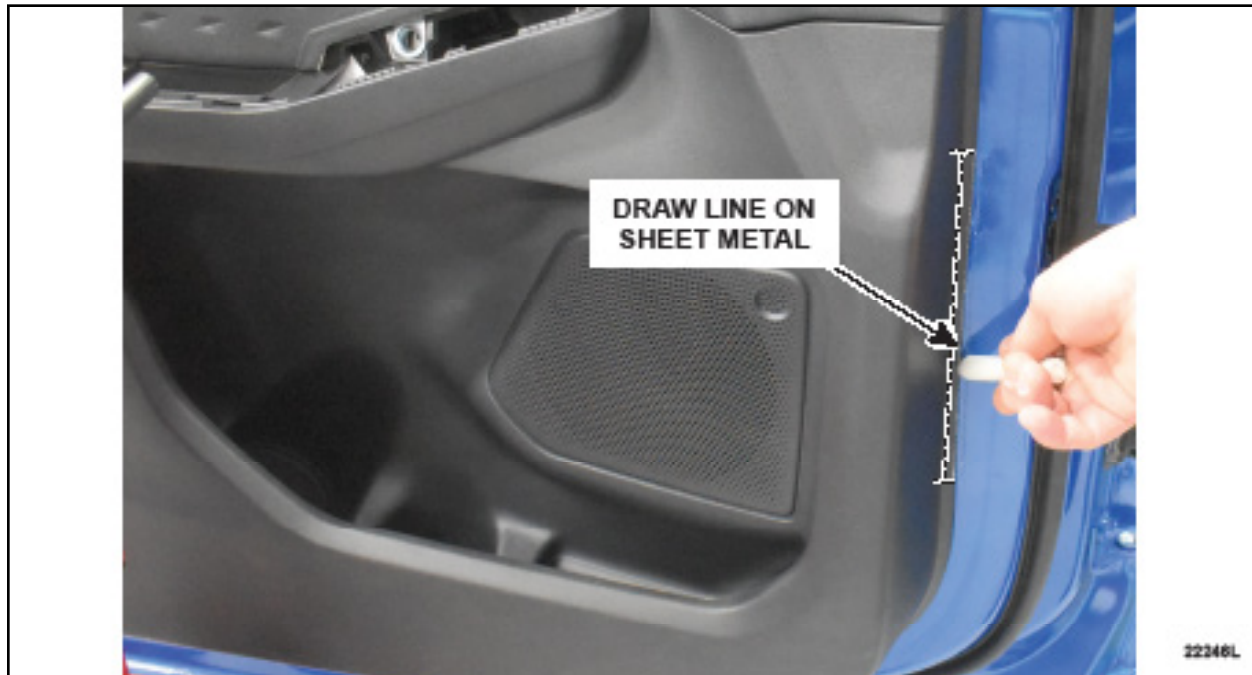
**FIGURE 4**



## SERVICE REPAIR PROCEDURE

**NOTE:** This procedure can be performed on the right-hand and/or left-hand side front door(s).  
Left front door shown right front door similar.

1. Using a non-permanent marking tool, such as a wax pen, chalk, pencil etc, draw a line on the door sheet metal, marking the edge of the door panel for later reference. See Figure 5.



**FIGURE 5**

2. Remove the front door trim panel. Follow the Workshop Manual (WSM) procedures in Section 501-05.
3. Using a door lift, remove the front door assembly. Follow the WSM procedures in Section 501-03.





4. Carefully release the door mounted weatherstrip retainers from the seal and position the weatherstrip to the side as shown in Figure 6.



**FIGURE 6**

5. Remove and discard the two (2) retainers closest to the door check arm cover as shown in Figure 7.



**FIGURE 7**



6. If equipped, remove the front door check arm cover. See Figure 8.

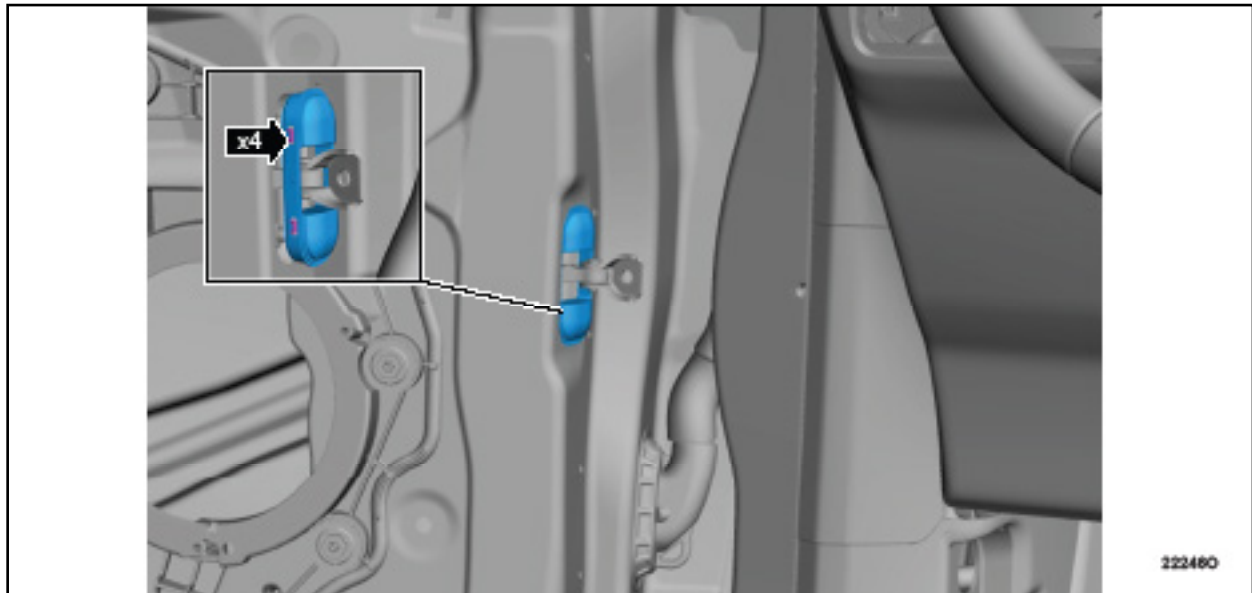


FIGURE 8

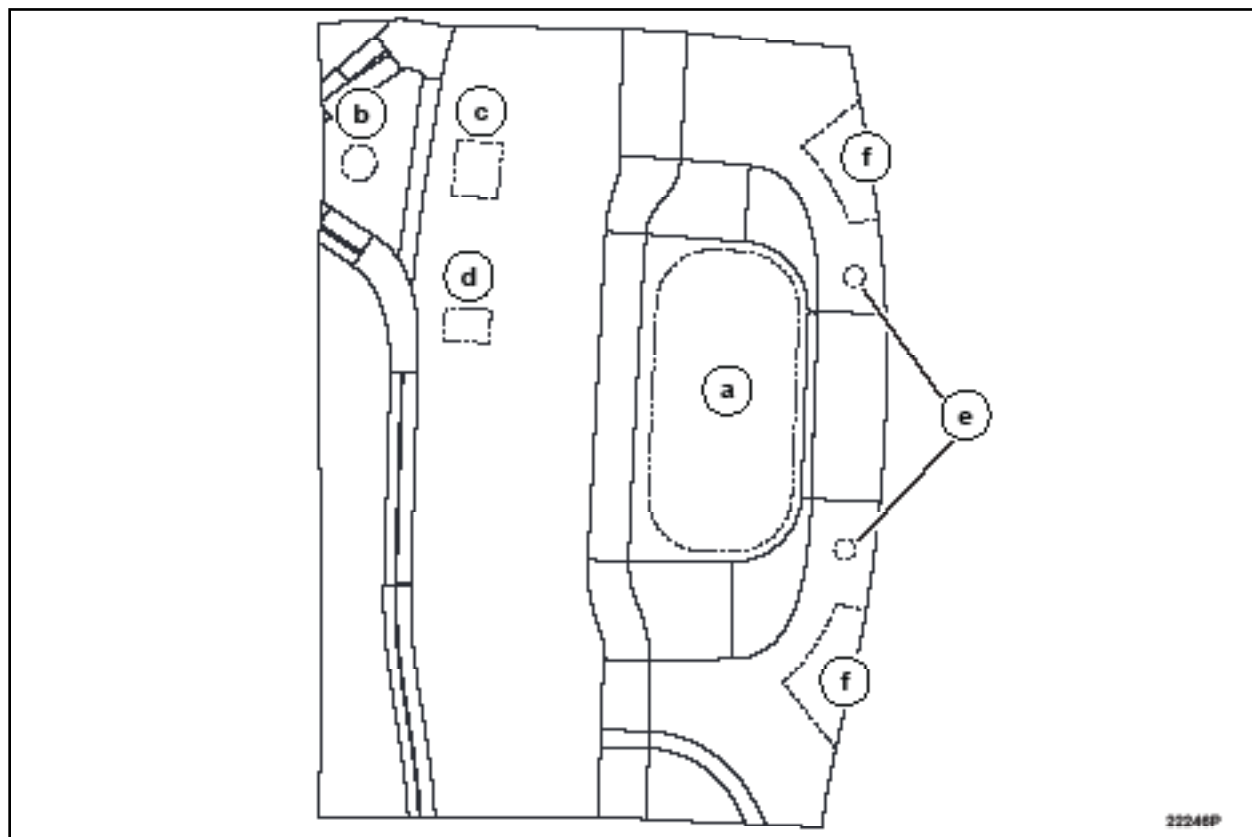


7. Refer to the separate template attachments, print and cut-out the dotted line portions on the paper template as shown in Figure 9.

**NOTE: Printing Directions: Print on 8.5" x 11" paper in portrait orientation, Custom Scale at 100%.**

- a. Cut out the door check arm opening.
- b. Cut out the larger perforated circle.
- c. Cut out upper larger perforated square.
- d. Cut out lower smaller perforated square.
- e. Cut out both perforated circles.
- f. Cut out the upper and lower corner pieces.

**NOTE: The Figure below only shows the areas in which to cut-out of the template. Do not print this Figure, refer to the separate template attachments.**



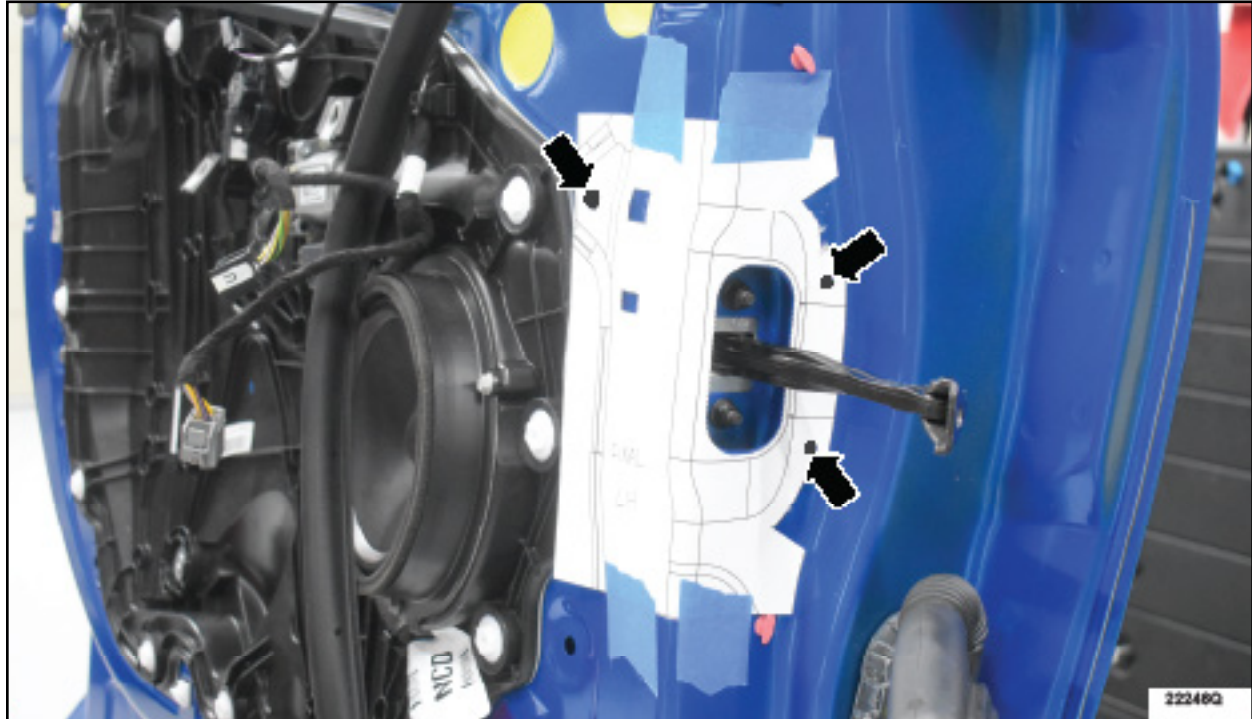
**FIGURE 9**





8. Install the template over the door check strap. Use the contours drawn on the template and the three (3) circles that were cut out to align the template in place, then tape the template down. See Figure 10.

**NOTE:** Make sure the template does not move while taping it to the sheet metal before continuing to the next Step.



**FIGURE 10**



9. On the two curved lines, pointed to in Figure 11, inspect by slightly lifting the template to check for any welds or weld separation lines near the curved line. Make a mark on the curved line where it is at least 10 mm (0.39 inch) away from a spot weld or a weld separation line. See Figure 11.

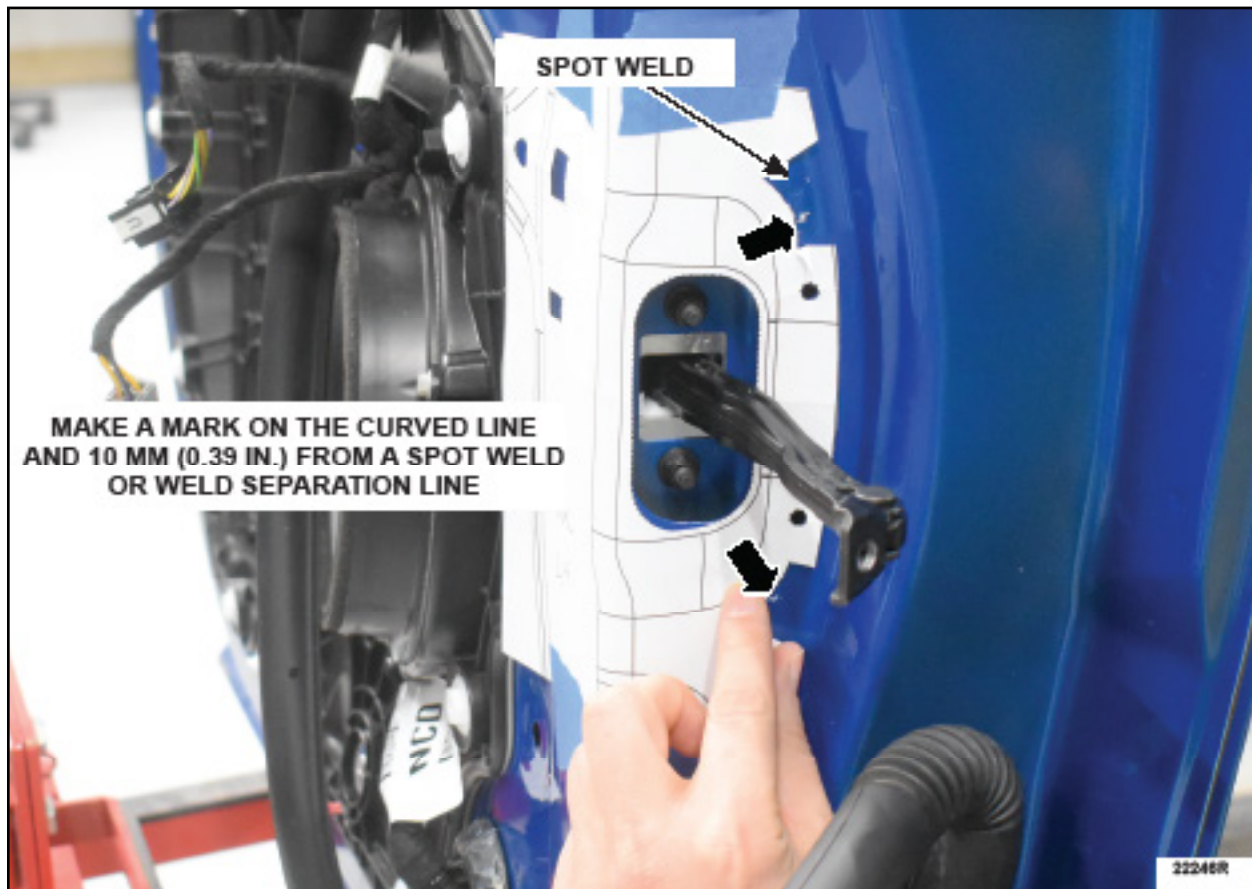
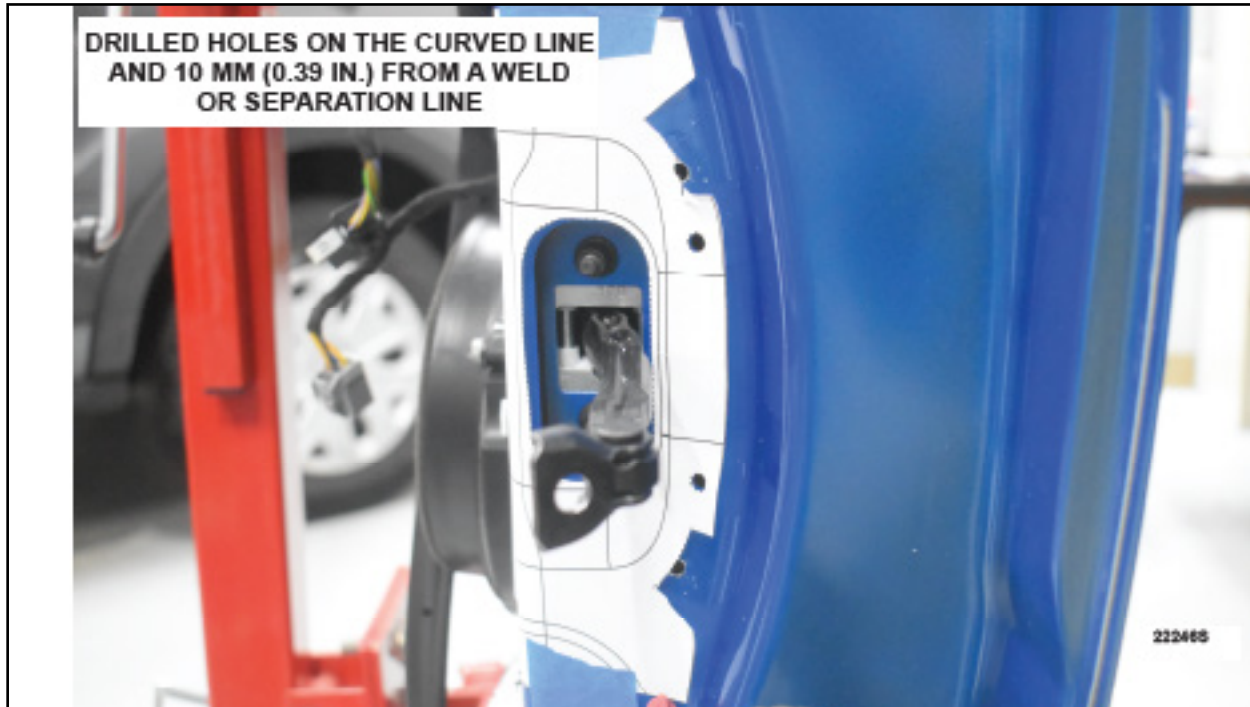


FIGURE 11



10. Using a 5 mm (13/64 in.) drill bit, center punch and drill out the previously mark locations.  
See Figure 12.

**NOTE:** Using a sharp, spring loaded center punch will help prevent the drill bit from slipping from the designated hole location.



**FIGURE 12**



11. Find the line inside each square, from Figure 5, that was drawn on the sheet metal before removing the door panel. Make a mark on the door latch side of the line, making sure it is at least 10 mm (0.39 inch) away from a spot weld or a weld separation lines. Using a 5mm drill bit, center punch and drill out both marked locations as shown in Figure 13.

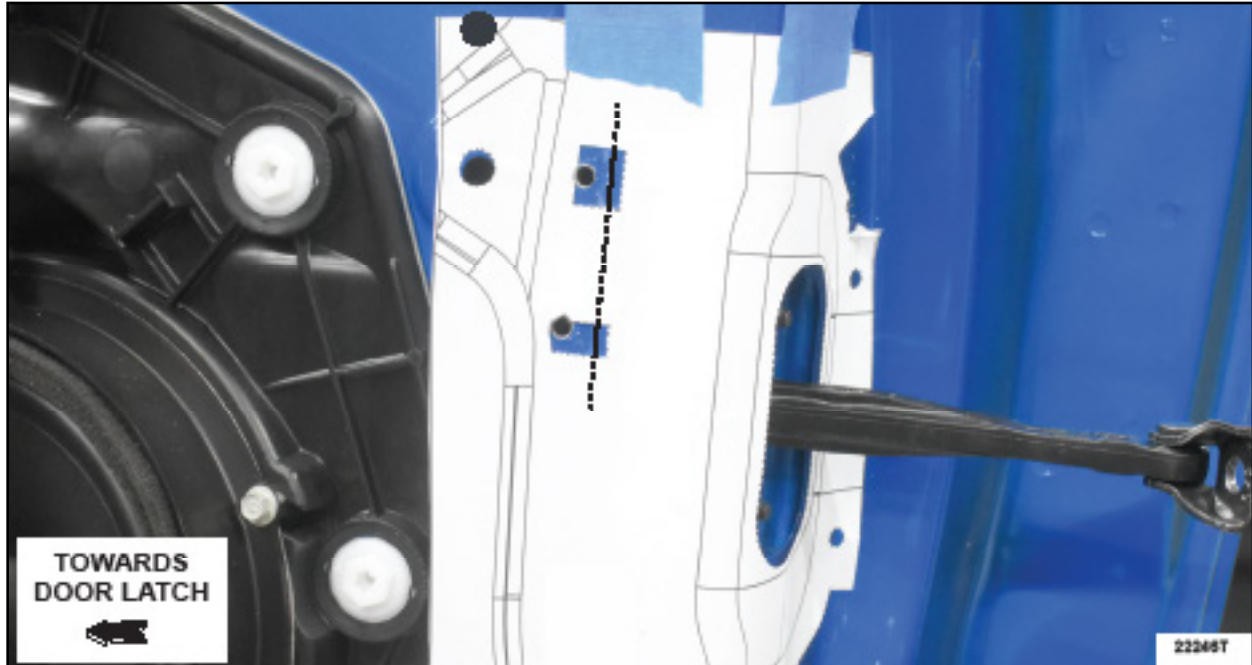


FIGURE 13





12. Remove the template from the door. Using a brush, apply Motorcraft® PM-13-A (anti-corrosion coating) to the bare metal portion of each hole that was just drilled out. See Figure 14.

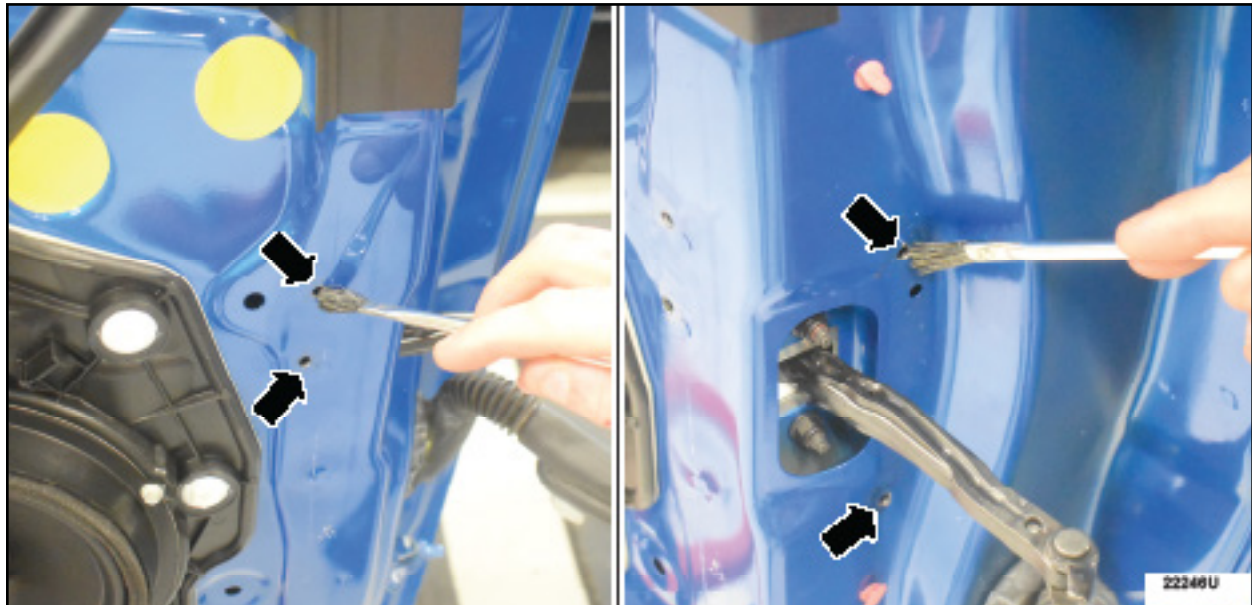


FIGURE 14

13. Using four (4) of the pop rivets included in the service kit and a rivet gun, install all four rivets into the previously drilled out holes. See Figure 15. Figure 16 shows all four (4) rivets installed.

**NOTE:** Using a rivet gun with longer handles will give more leverage to install the rivets.

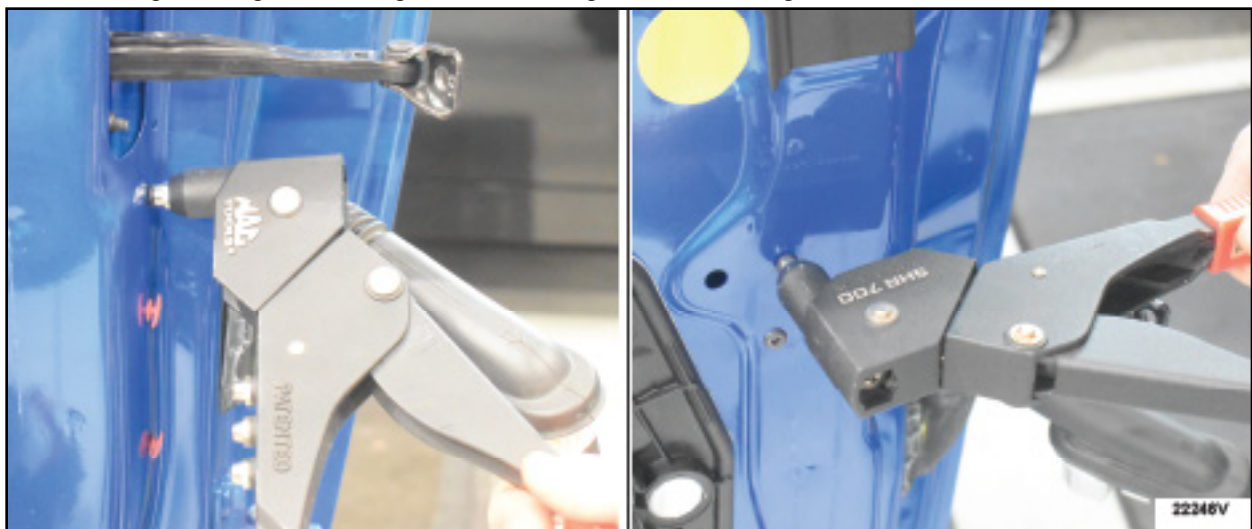
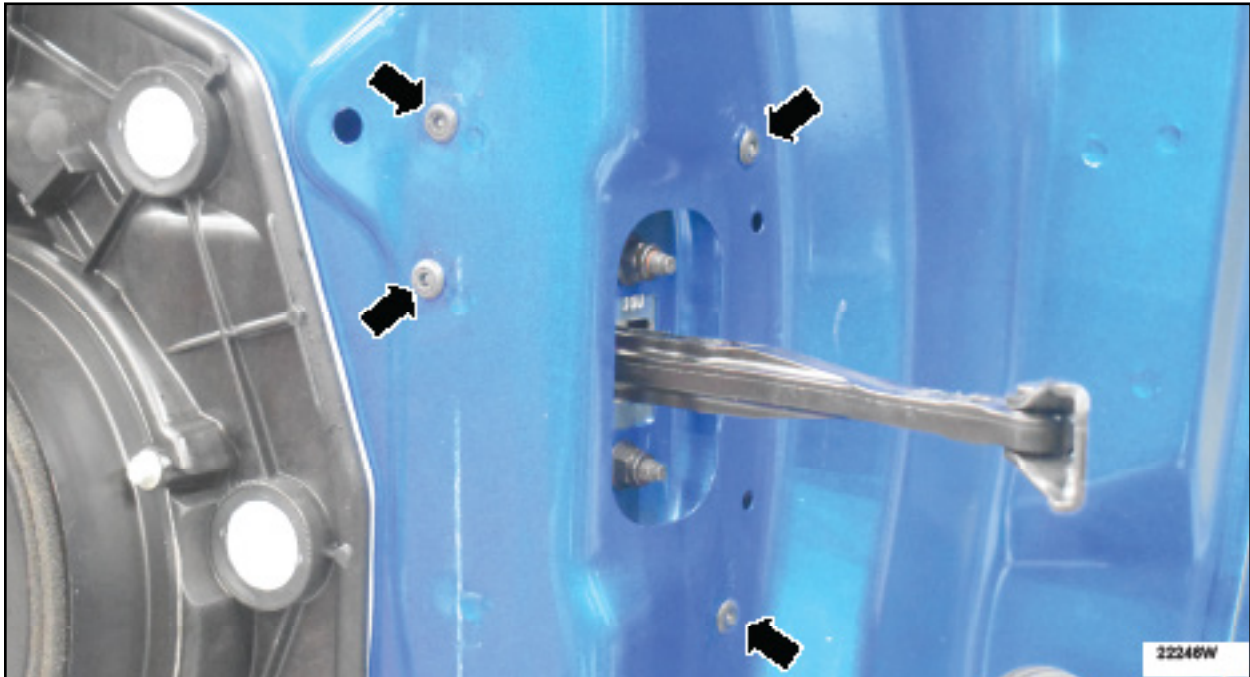


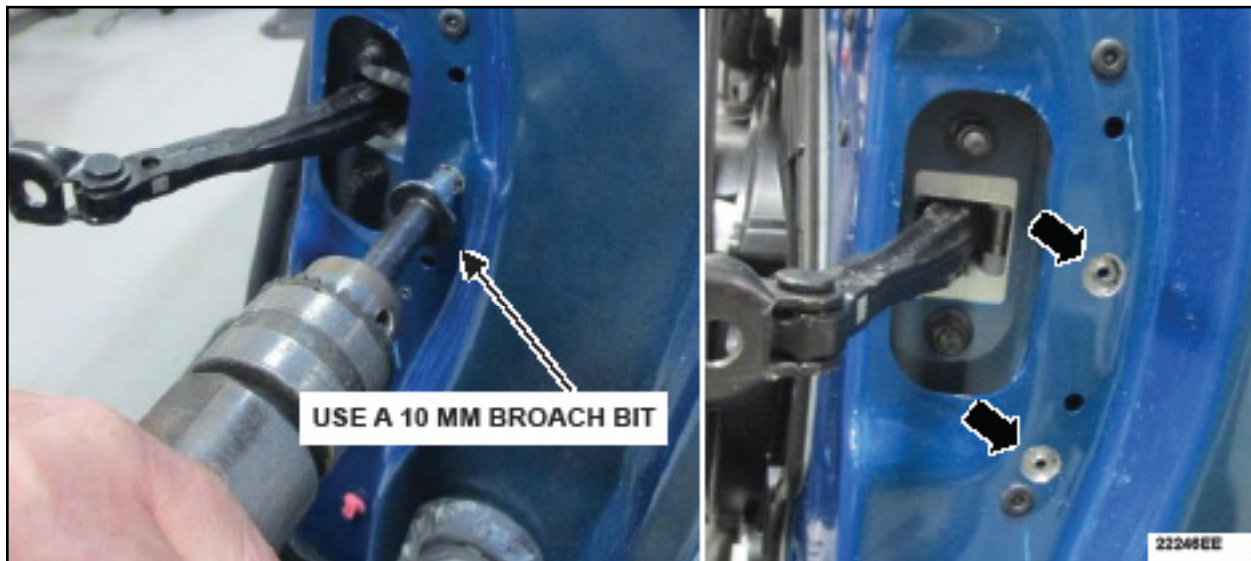
FIGURE 15





**FIGURE 16**

14. For any of the original spot welds that have cracked or separated, use a 10 mm (25/64 in.) broach drill bit and broach each weld as shown in Figure 17. Then, apply Motorcraft® PM-13-A (anti-corrosion coating) to each weld that was broached.



**FIGURE 17**



15. Using two (2) of the supplied push pins, install the check arm rivet plate into the original door push pin locations shown in Figure 18, making sure the rivet plate marking and dimples are facing away from the door sheet metal.

**NOTE:** The push pins supplied can be of any color and are all the same size.

**NOTE:** Make sure the part markings and dimples on the bracket are facing outward away from the door.

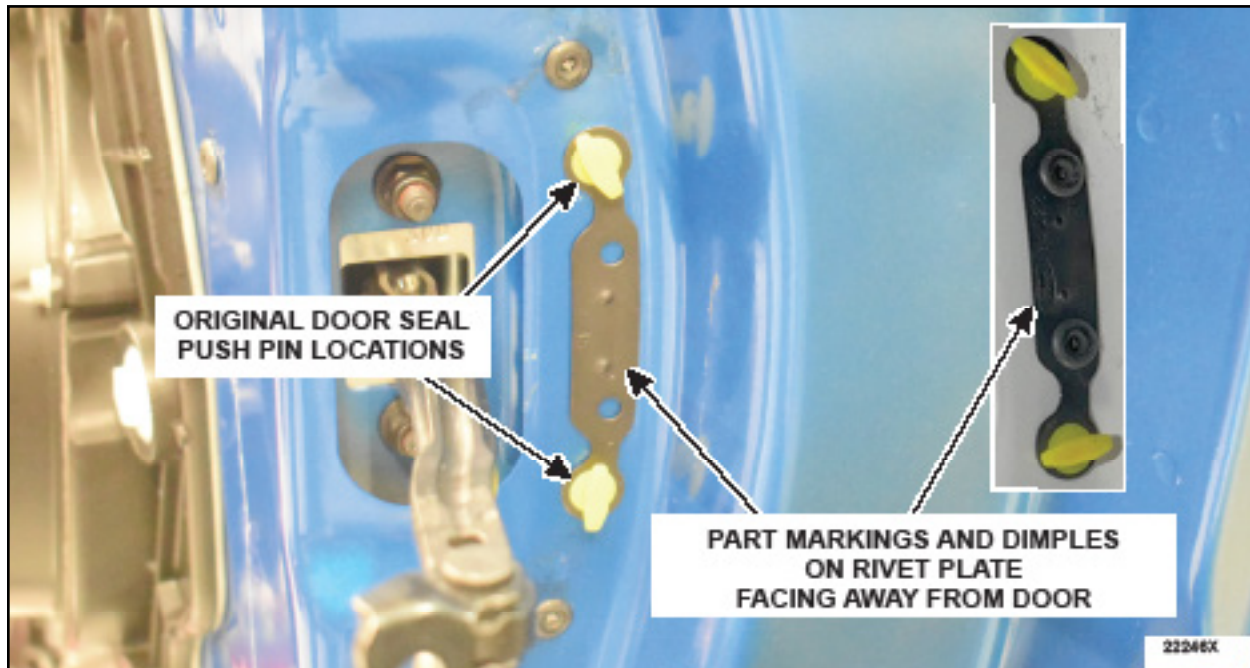
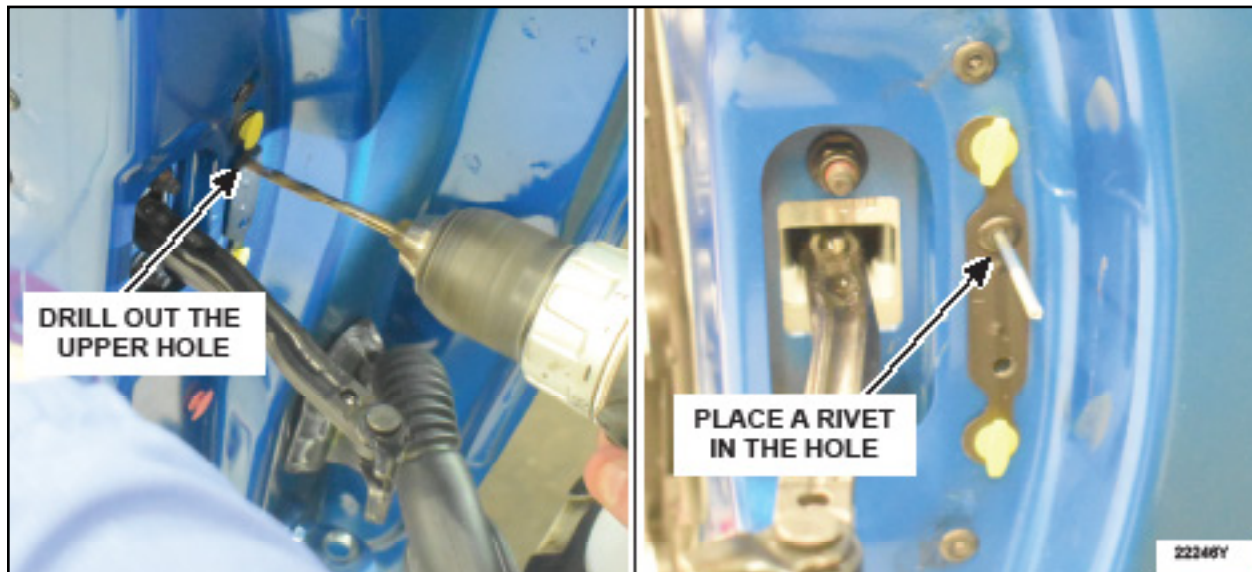


FIGURE 18



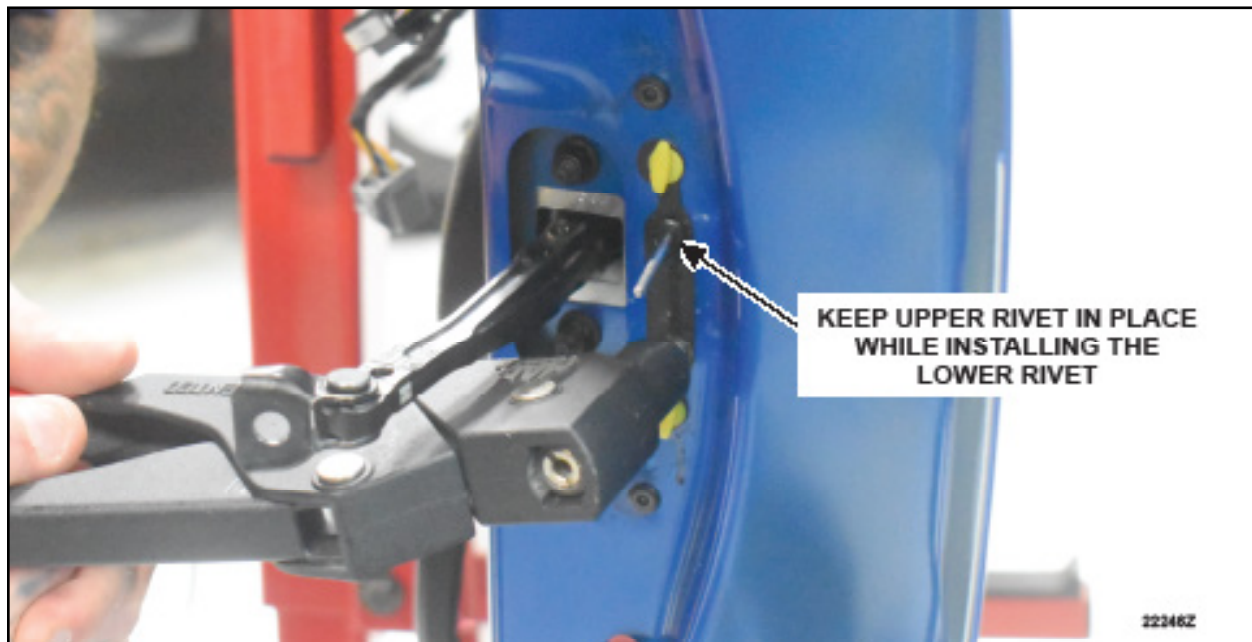


16. Using the rivet plate as a template, center punch the upper plate hole and drill a 5 mm (13/64 in.) hole. Then, place a rivet in the hole but do not tighten at this time. See Figure 19. Proceed to the next step.



**FIGURE 19**

17. Using the rivet plate as a template, center punch the lower rivet plate hole and drill a 5 mm (13/64 in.) hole.
18. Remove both of the rivets to prepare for the next step.
19. Using a brush, apply Motorcraft® PM-13-A (anti-corrosion coating) to the bare metal portion of both holes that were just drilled out.
20. Place a rivet in each hole. Tighten the lower rivet while the upper rivet stays in place. See Figure 20.



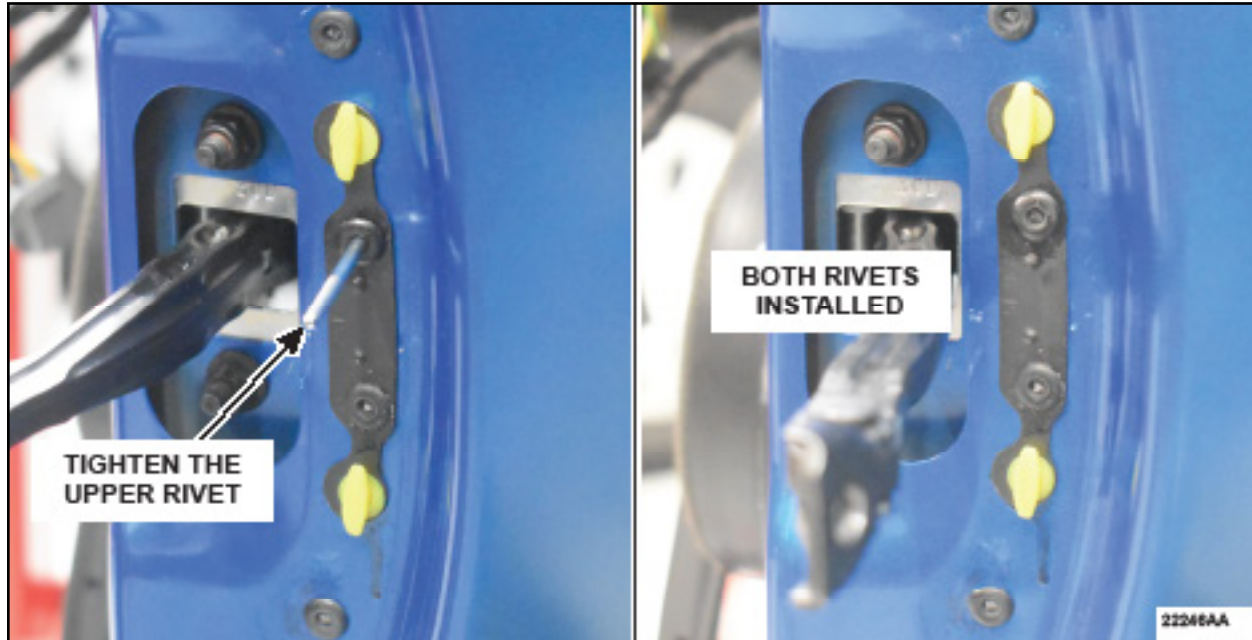
**FIGURE 20**





21. Tighten the upper rivet. See Figure 21.

**NOTE:** Make sure the rivet plate stays flush against the door sheet metal as you are tightening the rivets. No gaps can be between the rivet plate and door sheet metal.

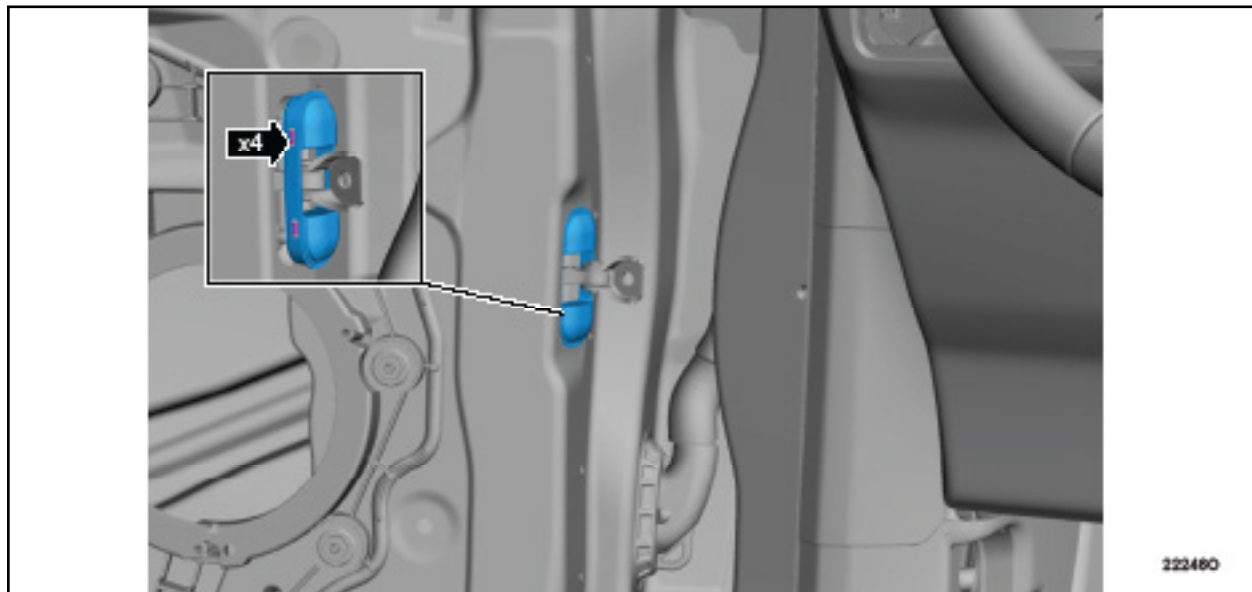


**FIGURE 21**

22. Clean any PM-13-A off that may have dripped down the inner panel.

23. Clean off the line made on the door sheet metal before removing the interior door trim panel.

24. If equipped, install the front door check arm cover. See Figure 22.



**FIGURE 22**



25. If any of the spot welds were broached earlier in this procedure, use the supplied 25 mm (0.99 in.) diameter black tape to cover each one as shown in Figure 23.



**FIGURE 23**

26. Reattach the front door weatherstrip. Make sure the weatherstrip is secured. There are extra push pins in the service kit if any push pins feel loose or become deformed.
27. Install the front door assembly onto the vehicle. Follow the WSM procedures in Section 501-03.
28. Install the front door trim panel. Follow the WSM procedures in Section 501-05.



## CERTAIN 2020-2023 MODEL YEAR ESCAPE VEHICLES — INSPECT FRONT DOOR CHECK-ARM REINFORCEMENT SPOT WELDS

### SERVICE PROCEDURE

**IMPORTANT!** *The Service Technician Specialty Training (STST) Competency 10 certification requirement in the U.S. market only will be enforced starting with repair orders opened on or after August 31, 2024. Field Service Action (FSA) repairs will reject and the claim will not be paid if the repairing technician is not certified in STST Competency 10 FSA. See Electronic Field Communication (EFC)15332 for more details.*

**NOTE:** If you do not have the special tools referenced in the Workshop Manual (WSM) to perform the FSA repair, please contact 1-800 ROTUNDA and choose option 3 to place an order.

**NOTE:** This procedure assumes that the front door check arm welds have separated from the door inner and photos have been sent to the Special Service Support Center (SSSC) with approval to replace the front door assembly.

**NOTE:** Left-hand side shown, right-hand side similar.

1. Paint the jambs and the interior side of the *new* front door assembly.
2. Depower the Supplemental Restraint System (SRS). Follow the Workshop Manual (WSM) procedures in Section 501-20B.
3. Remove the exterior front door handle reinforcement. Follow the WSM procedures in Section 501-14.
4. Remove the front door upper moulding. Follow the WSM procedures in Section 501-08.
5. Remove the front door glass top run. Follow the WSM procedures in Section 501-11.



6. Remove the front door mounted weatherstrip. See Figure 1.

**NOTE:** Transfer any clips back into the weatherstrip that may have stayed attached in the door.

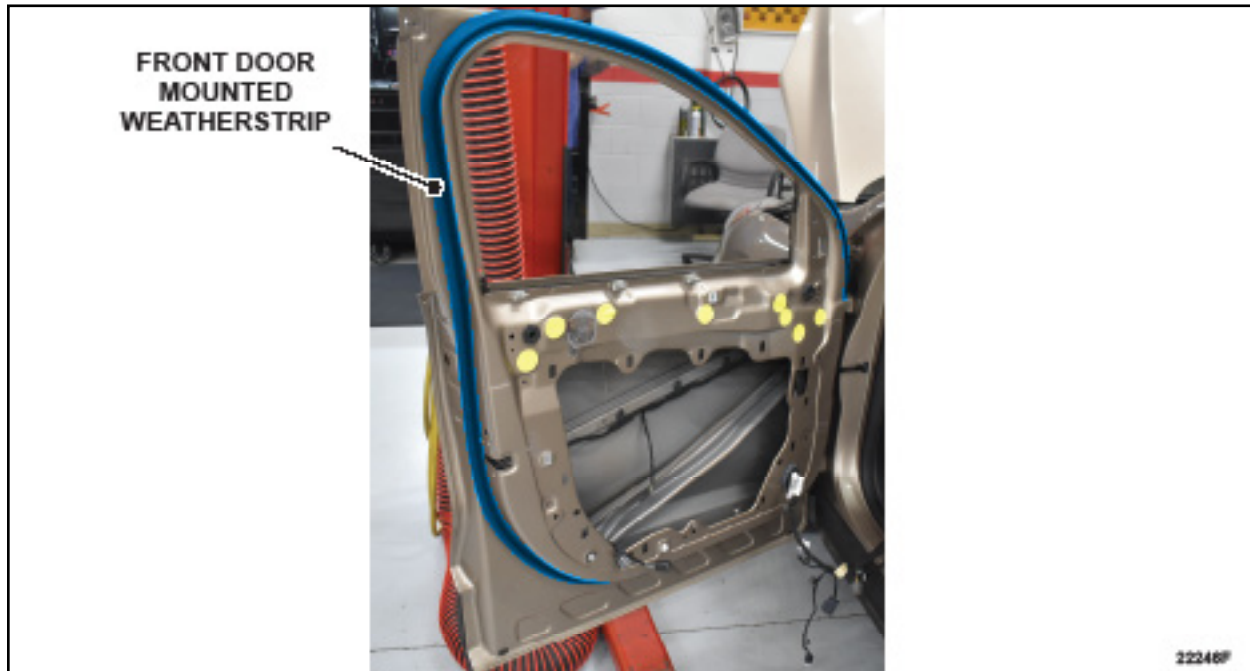


FIGURE 1



7. Remove the front door check arm. Follow the WSM procedures in Section 501-03.

**NOTE:** In the next Step, pay close attention to the orientation of the wiring harness and retaining clips for installation purposes.

8. Remove the main door wiring harness from the door assembly.

- Release the wiring harness retaining clips from the interior of the door. See Figure 2.
- Disconnect the three (3) door to body electrical connectors. See Figure 3.
- Remove the front door wiring harness.

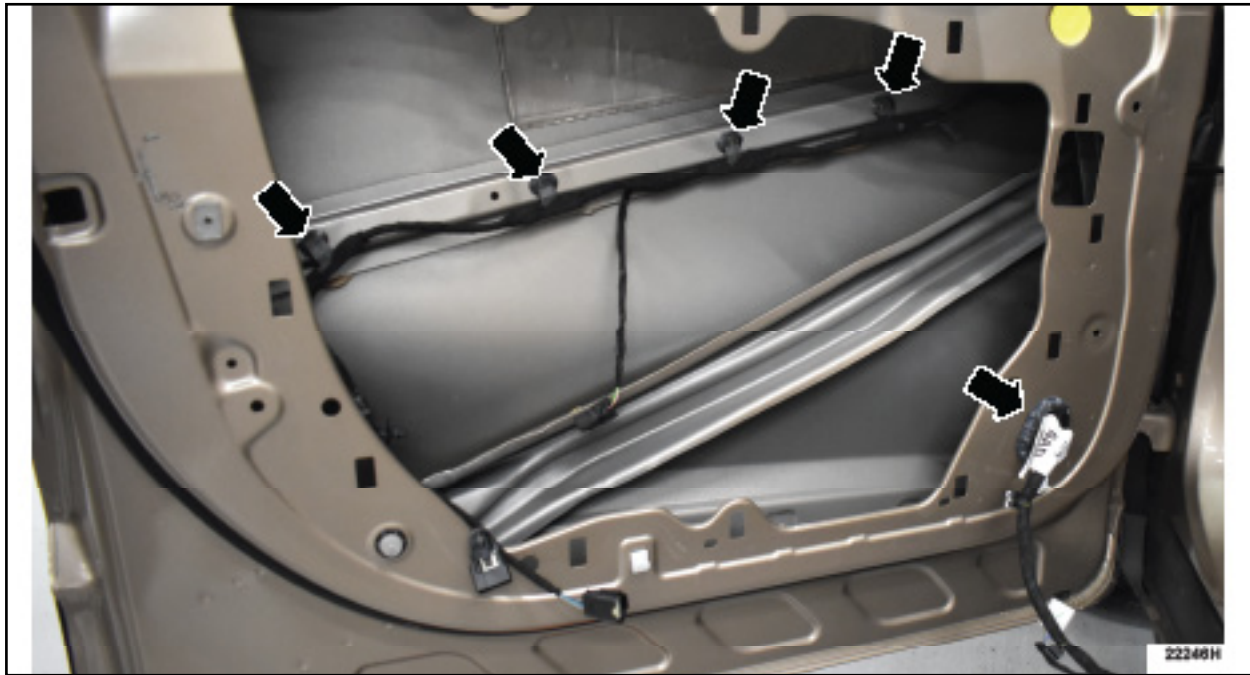


FIGURE 2

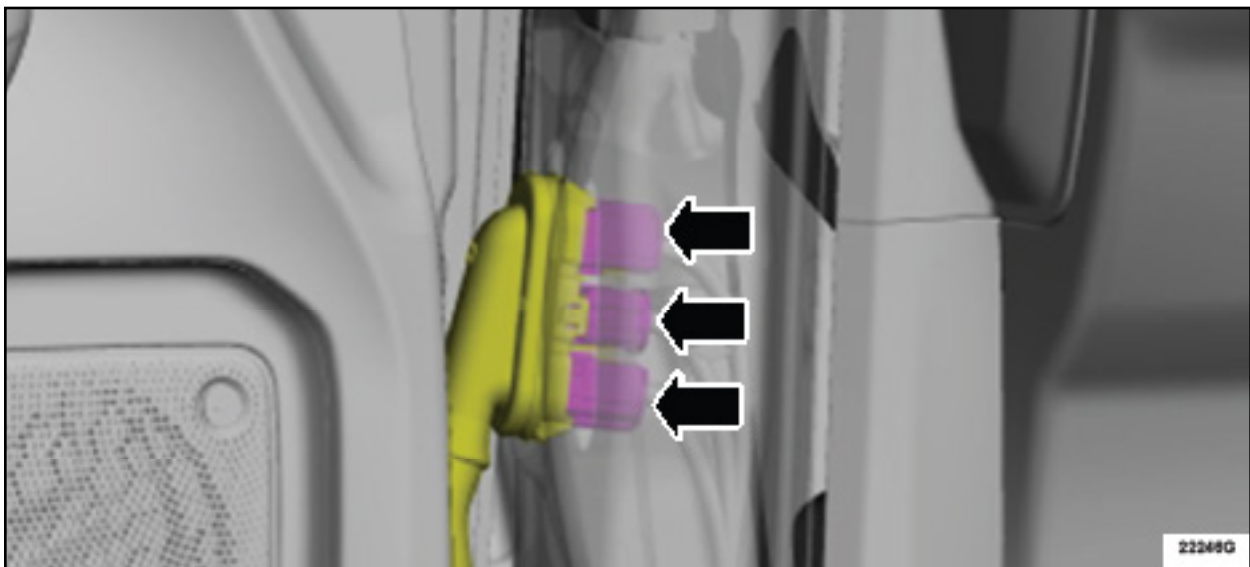


FIGURE 3





9. Remove the front door assembly and position on a work bench. Follow the WSM procedures in Section 501-03.

10. Remove the upper and lower front door mounted hinges. See Figure 4.



**FIGURE 4**

11. Remove the front door moulding. Follow the WSM procedures in Section 501-08.

12. Remove the rear door moulding. Follow the WSM procedures in Section 501-08.

13. Remove the front fender moulding. Follow the WSM procedures in Section 501-08.

14. Once the *new* door assembly has completely dried, install both front door hinges. See Figure 4.

- Torque to: 35 ft lbs (47 Nm).

15. Install the *new* front door assembly to the vehicle. Follow the WSM procedures in Section 501-03.

16. Install the door wiring harness and attach all clips in their original locations. Reverse Step 8 and see the corresponding Figures.

17. Install the front door latch and reinforcement only at this time. Reverse removal Steps 4-7, in the WSM procedures in Section 501-14 - Front Door Latch.

18. Install the front door glass top run. Follow the WSM procedures in Section 501-11.

19. Install the screw for the exterior front door handle reinforcement. Follow WSM procedures in Section 501-14.

20. Install the door lock cylinder. Follow WSM procedures in Section 501-14.

21. Install the front door weatherstrip.



22. Install the front door check arm. Follow the WSM procedures in Section 501-03.
23. Install the front door upper moulding. Follow the WSM procedures in Section 501-08.
24. Install the front door window glass. Follow the WSM procedures in Section 501-11.
25. Perform a front door alignment. Follow the WSM procedures in Section 501-03.
26. Paint the *new* front door outer skin and blend-in the front fender and rear door.
27. Once all painted areas are completely dry, continue with the installation of the exterior front door handle reinforcement. Follow the WSM procedures in Section 501-14.

**NOTE:** Transfer any access hole covers to the *new* door as the components are installed.

28. Install the front fender moulding. Follow the WSM procedures in Section 501-08.
29. Install the rear door moulding. Follow the WSM procedures in Section 501-08.
30. Install the front door moulding. Follow the WSM procedures in Section 501-08.
31. Repower the Supplemental Restraint System (SRS). Follow the WSM procedures in Section 501-20B.
32. Perform the power door window initialization. Follow the WSM procedures in Section 501-11.

**IMPORTANT NOTE:** Federal law prohibits selling motor vehicle parts or components that are under safety, compliance, or emissions recall. Unless a part is requested to be returned to Ford, all parts replaced under this FSA must be scrapped in accordance with all applicable local, state and federal environmental protection and hazardous material regulations. Refer to the Parts Retention, Return, & Scrapping section of the FSA dealer bulletin for further information.

