



TECHNICAL SERVICE BULLETIN

Tailgate Paint Wear

25-2551

17 November
2025

Model:

| |
|---------------------------------|
| Ford 2021-2025 Bronco |
|---------------------------------|

Markets: North American markets only

Issue: Some of the vehicles listed in the model statement above may exhibit paint wearing along on the top inner edge of the tailgate where the rear window weather strip contacts the tailgate. This may be due to the accumulation of dirt between the rear window seal and tailgate.

Action: For vehicles that meet all of the criteria in the Issue and Model statements, follow the Service Procedure to inspect the tailgate inner edge for paint wear, return the tailgate to factory specification, and apply a mylar tape to the edge to prevent future paint wear.

Parts

| Service Part Number | Claim Quantity | Package Order Quantity | Number in Package | Description |
|---------------------|----------------|------------------------|-------------------|-----------------------------------|
| M2DZ-19E523-B | 2 | 2 | 1 | Clear Mylar Tape |
| Obtain Locally | As Needed | As Needed | | Isopropyl Alcohol (Or Equivalent) |
| Obtain Locally | As Needed | As Needed | | Painters Tape |

Parts - Parts To Inspect And Replace Only If Necessary

| Service Part Number | Claim Quantity | Package Order Quantity | Number in Package | Description |
|---------------------|-----------------------------|-----------------------------|-------------------|--------------------------------------|
| M2DZ-7840010-B | Only If Necessary (Up To 1) | Only If Necessary (Up To 1) | 1 | Tailgate |
| M2DZ-78501C06-E | Only If Necessary (Up To 1) | Only If Necessary (Up To 1) | 1 | Hard Top Liftgate Glass Weather Seal |
| M2DZ-7842084-A | Only If Necessary (Up To 1) | Only If Necessary (Up To 1) | 1 | Soft Top Liftgate Glass Weather Seal |

Service part numbers and "number in package" quantity may change after publication, thus also affecting the "package order quantity". Refer to the parts catalog for the latest information.

Claim Quantity refers to the total number of individual pieces required to repair the vehicle.

Package Order Quantity refers to the amount of the service part number package(s) required to repair the vehicle.

Number In Package refers to the number of individual pieces included in a service part number package, also known as unit of issue (UOI).

As Needed indicates the part is necessary but amount of the part may vary and/or is not a whole number. Parts can be billed out as non-whole numbers, including less than 1.

Only If Necessary indicates the part is not mandatory. Refer to the Service Procedure to determine the inspection/inclusion criteria.

Warranty Status: Eligible under provisions of New Vehicle Limited Warranty (NVLW)/Service Part Warranty (SPW)/Service Part New Vehicle (SPNV)/Extended Service Plan (ESP) coverage. Limits/policies/prior approvals are not altered by a TSB. NVLW/SPW/SPNV/ESP coverage limits are determined by the identified causal part and verified using the OASIS part coverage tool.

Labor Times

| Description | Operation No. | Time |
|--|---------------|----------|
| 2021-2025 Bronco: Inspect, Clean And Install Protective Film And Replace The Liftgate Window Glass Weather Strip Following The Service Procedure | 252551A | 0.8 Hrs. |
| Additional Time For Attempt To Install (Fail) Includes Time To Remove Film And Clean Area (Can Be Claimed With A) | 252551B | 0.2 Hrs. |

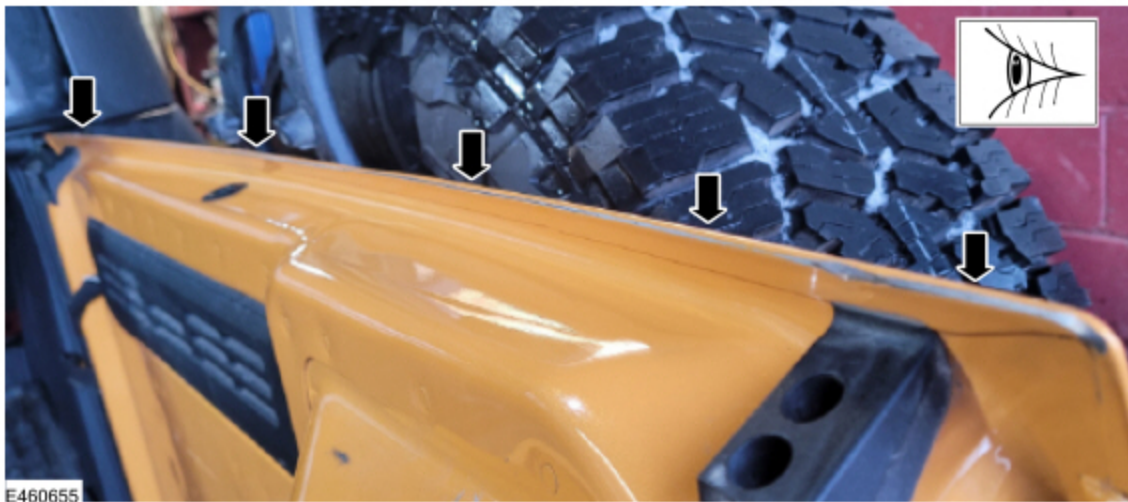
Repair/Claim Coding

| | |
|-----------------|---------|
| Causal Part: | 7840010 |
| Condition Code: | 14 |

Service Procedure

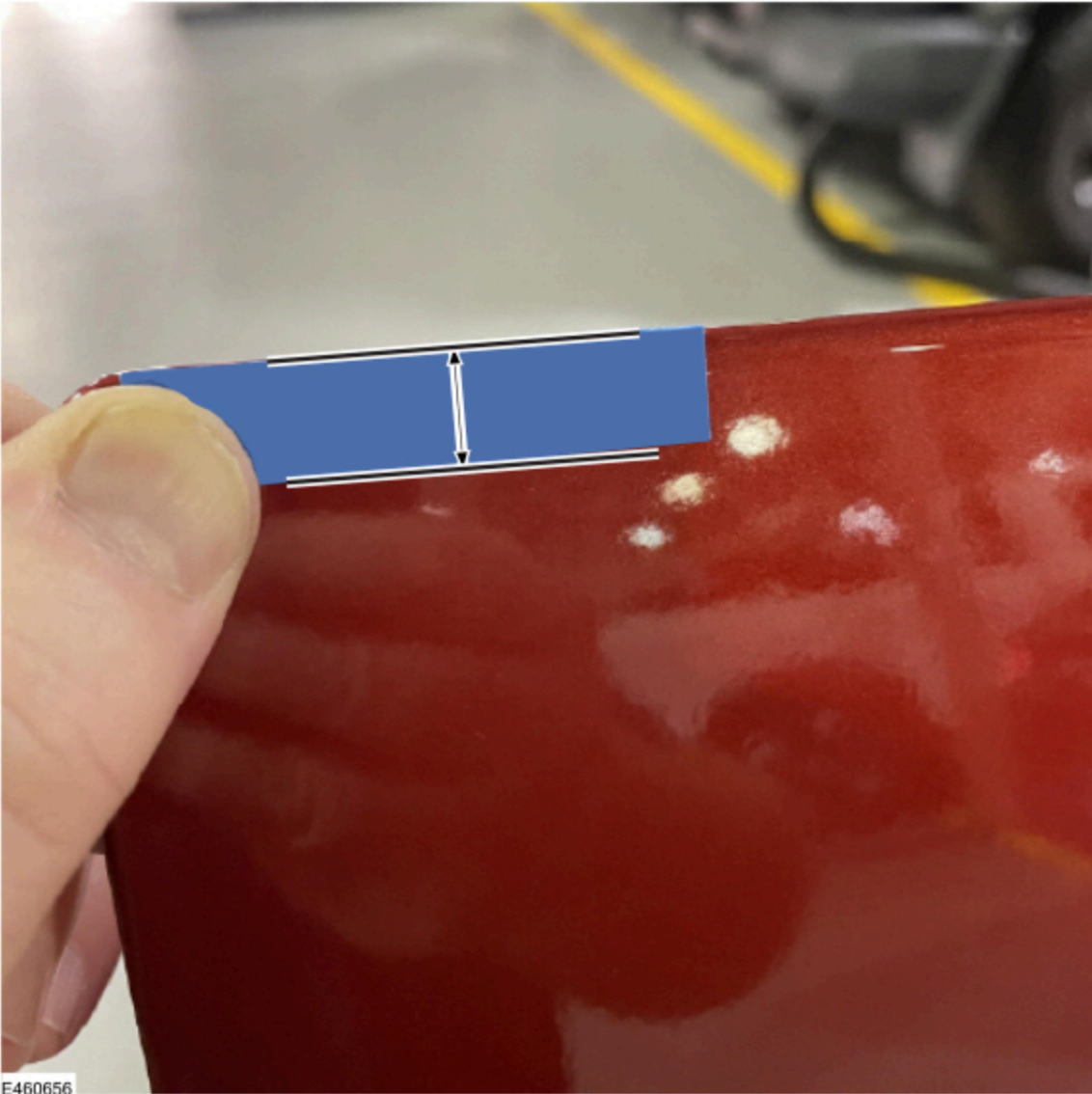
1. Does the top inside edge of the tailgate where the rear window weather strip contacts the tailgate show paint wear similar to Figure 1?

Figure 1



- (1). Yes - proceed to Step 2.
 - (2). No - this article does not apply.
2. Refinish the tailgate as required using a Ford approved refinish system. Repair outside of this article.
 3. Remove the spare tire and spare wheel mounting bracket. Refer to [WSM](#), Section 501-03 Removal and Installation > Spare Wheel Mounting Bracket.
 4. Clean the outside and inside edge of the tailgate to remove any dirt and debris.
 5. Measure 10 mm (0.39 inches) from the top edge of the tailgate and apply a piece of painter's tape down the entire length of the tailgate. This will help with aligning the mylar protective film. (Figures 2-3)

Figure 2



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Figure 3



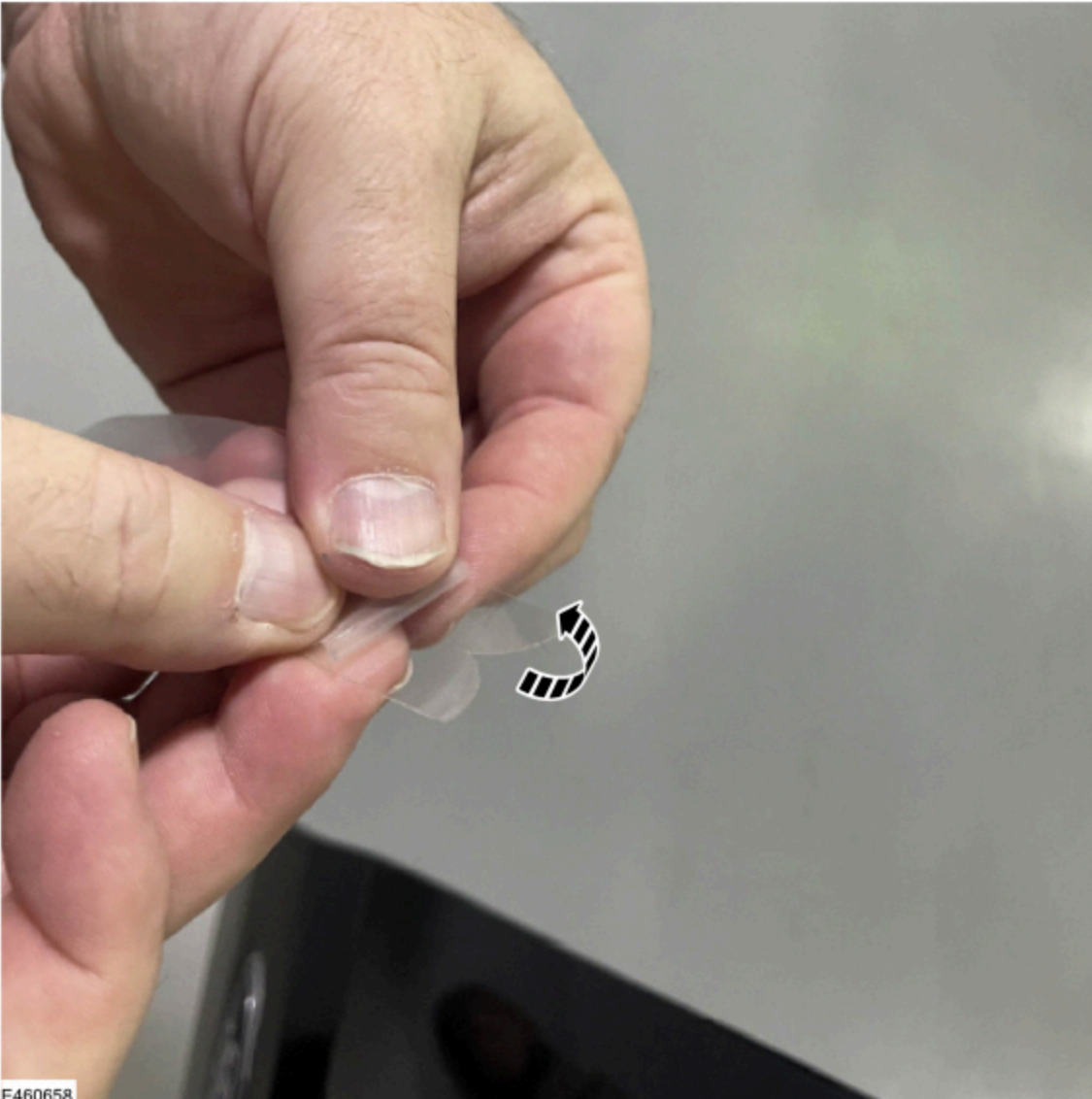
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6. Using isopropyl alcohol or equivalent, prepare the outside and inside surfaces of the tailgate for the mylar protective film.

7. Peel away the backing from the edge of the mylar protective film. (Figure 4)

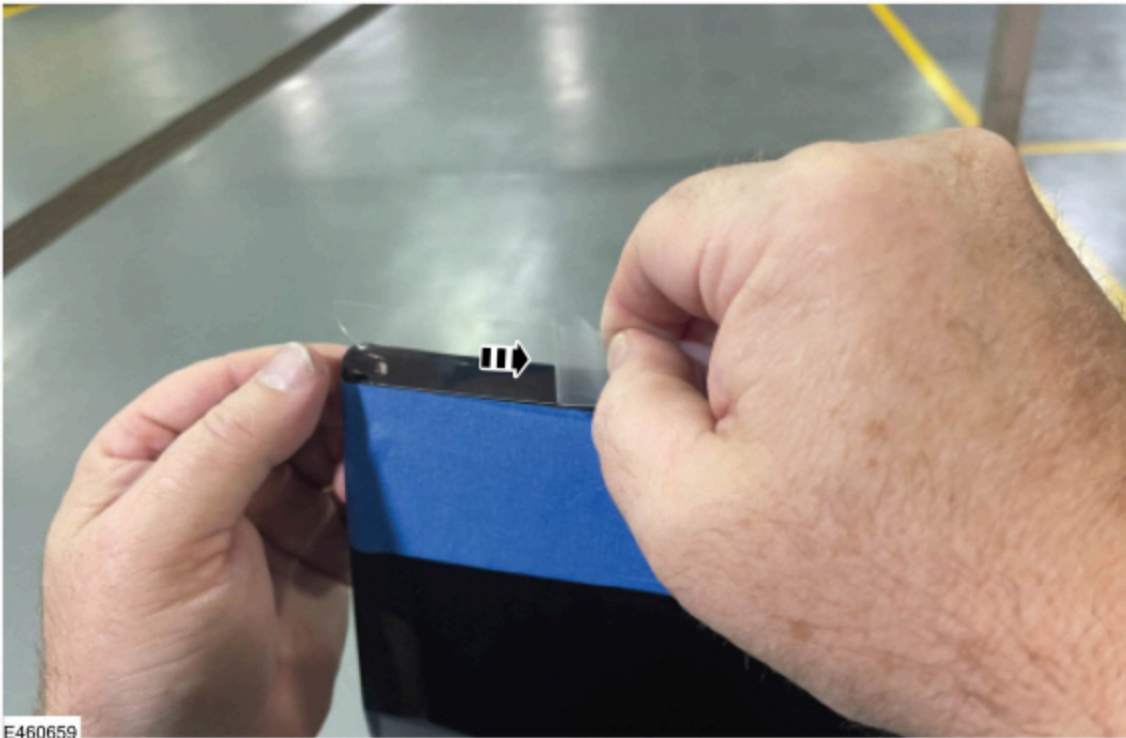
NOTE: Do not touch the adhesive side of the mylar protective film as it will leave fingerprints.

Figure 4



8. Line up the trimmed edge of the mylar protective film to the top left edge of the tailgate and apply the mylar protective film. (Figure 5)

Figure 5



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9. Using the painter's tape as a guide, slowly apply the mylar protective film down the tailgate, working from left to right. Remove the backing from the mylar protective film as the tape is applied. This will reduce the chances of the mylar protective film inadvertently sticking to the tailgate. If the mylar protective film is pulled off once it is stuck to the body it will be deformed and it must be discarded. (Figure 6)

NOTE: Slowly applying the mylar protective film and working from left to right helps ensure there are no air bubbles trapped under the mylar protective film.

NOTE: Do not pull or stretch the mylar protective film as it is applied to the tailgate or it will become deformed and will need to be discarded.

Figure 6



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10. Cut the mylar protective film 8 mm (0.31 inches) before the right-side edge of the tailgate. (Figures 7-8)

Figure 7



Figure 8



11. Once the mylar protective film is applied to the outside of the tailgate, apply pressure to the bottom edge of the mylar protective film on the outside of the tailgate using only finger pressure. Move fingers slowly from the bottom edge of the mylar protective film over the top edge of the tailgate. Continue to slowly work the mylar protective tape over the top edge of the tailgate from left to right. Once this step is complete, the mylar protective film should be over the top of the tailgate sitting at a 90° angle. (Figures 9-10)

Figure 9

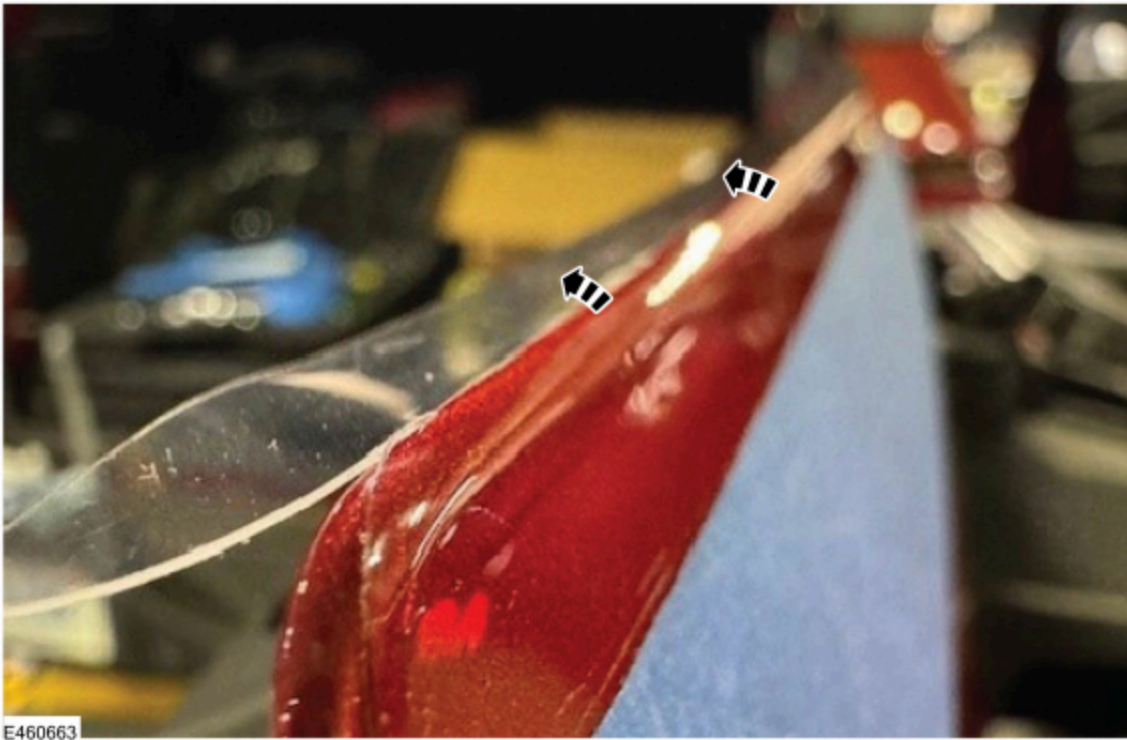


Figure 10



12. Starting on the left outside edge of the tailgate, use finger pressure to work the mylar protective film over the top edge and down the backside of the tailgate 0.125 inch (3 mm). Continue to slowly work the mylar protective tape over the top edge of the tailgate from left to right. Once this step is complete, the mylar protective film should be over the top edge sitting at a 45° angle. (Figure 11)

Figure 11



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13. Starting at the top right edge of the tailgate, use finger pressure to work the mylar protective film down the inside of the tailgate. Continue to slowly work the mylar protective film down the inside of the tailgate working from right to left until it has been fully applied. (Figures 12-13)

Figure 12



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Figure 13



- 14.** Remove the painter's tape from the outside of the tailgate and clean any remaining adhesive residue from the paint.
- 15.** Replace the liftgate window glass weather strip.
- 16.** Reinstall the spare wheel mounting bracket and spare wheel. Refer to [WSM](#), Section 501-03 Removal and Installation > Spare Wheel Mounting Bracket.

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