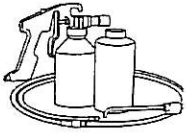



GENERAL PROCEDURES

Restoring Corrosion Protection Following Repair

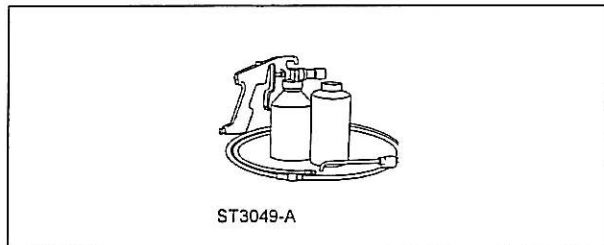
Special Tool(s)

 <p>ST3049-A</p>	<p>Rust Inhibitor Installation Kit 286-00002</p>
 <p>ST3048-A</p>	<p>Undercoating Spray Gun 286-00001</p>

Material

Item	Specification
Motorcraft Metal Surface Prep ZC-31	—
Motorcraft Premium Undercoating PM-25-A	—
Motorcraft Premium Undercoating Quart PM-25-B	—
Motorcraft Rust Inhibitor Aerosol PM-24-A	—
Motorcraft Rust Inhibitor Quart PM-24-B	—

Rust Inhibitor



⚠ WARNING: Always refer to Material Safety Data Sheet (MSDS) when handling chemicals and wear protective equipment as directed. Examples may include but are not limited to respirators and chemically resistant gloves. Failure to follow these instructions may result in serious personal injury.

⚠ WARNING: Always wear protective equipment including eye protection with side shields, and a dust mask when sanding or grinding. Failure to follow these instructions may result in serious personal injury.

⚠ CAUTION: Drilling access holes in body panels is not recommended. Drilling holes will break the original paint finish and promote corrosion.

NOTE: Corrosion protection needs to be restored whenever it is necessary to sand or grind through painted surfaces or E-coat, or when bare metal repairs are made.

NOTE: Rust inhibitor is a wax base product and must be thoroughly stirred before applying to the vehicle. Store product at temperatures above 20°C (68°F) to avoid thickening of the material. If the product has been left in a cold environment, place the container in hot water for 5-10 minutes. Do not let water reach the cap of the container. Stir or shake vigorously before applying.

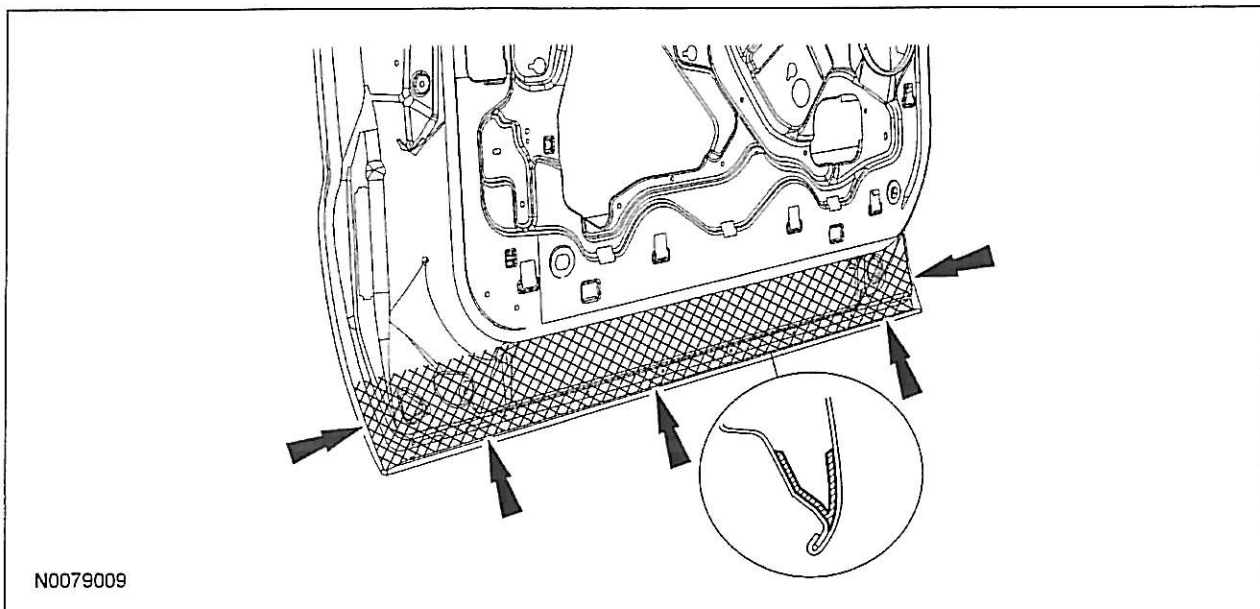
GENERAL PROCEDURES (Continued)

1. The surfaces must be free of oil, dirt and other foreign material. Carry out the process in the following sequence.
 - 1 Thoroughly clean and degrease metal surfaces using a good wax and grease remover and metal surface prep.
 - 2 For best results the vehicle should be at room temperature.
 - 3 Rust inhibitor should be applied after the welding and refinishing process. Product cannot be welded through.
 - 4 Air pressure setting for applicator gun is 448-517 kPa (65-75 psi).
 - Use the long wand when spraying enclosed areas. The spray nozzle provides a 360 degree spray pattern. Insert the wand as far as possible into the access hole, pull the trigger and wait 2-3 seconds and slowly pull the wand out of the access hole.
 - The short, hook-shaped wand sprays in one direction and must be rotated to provide complete coverage.
 - Apply the material in light mist coats.
 - Material displaces moisture.
 - 5 Clean up any overspray with a mild solvent such as mineral spirits or bug and tar remover.

NOTE: The following illustrations provide typical applications of body seams and spot welded flanges and are not vehicle specific.

2. **NOTE:** Door assembly lower view.

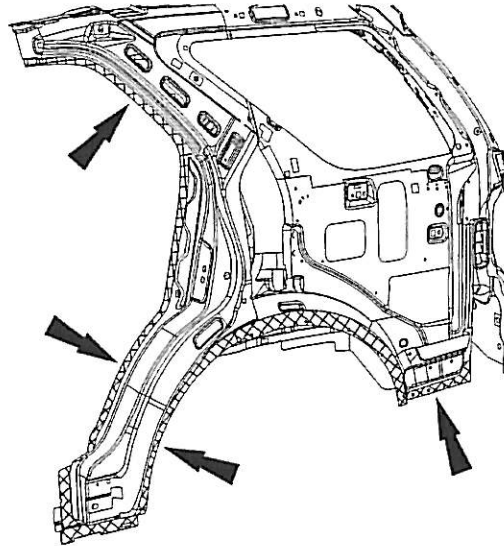
Apply rust inhibitor as shown to the inside of the door shell on all the interior metal surfaces using the most suitable applicator wand. Apply material to the exposed edges after carrying out the welding process. Make sure horizontal surfaces are well protected as they are more susceptible to corrosion.



N0079009

GENERAL PROCEDURES (Continued)3. **NOTE:** Quarter panel inner view.

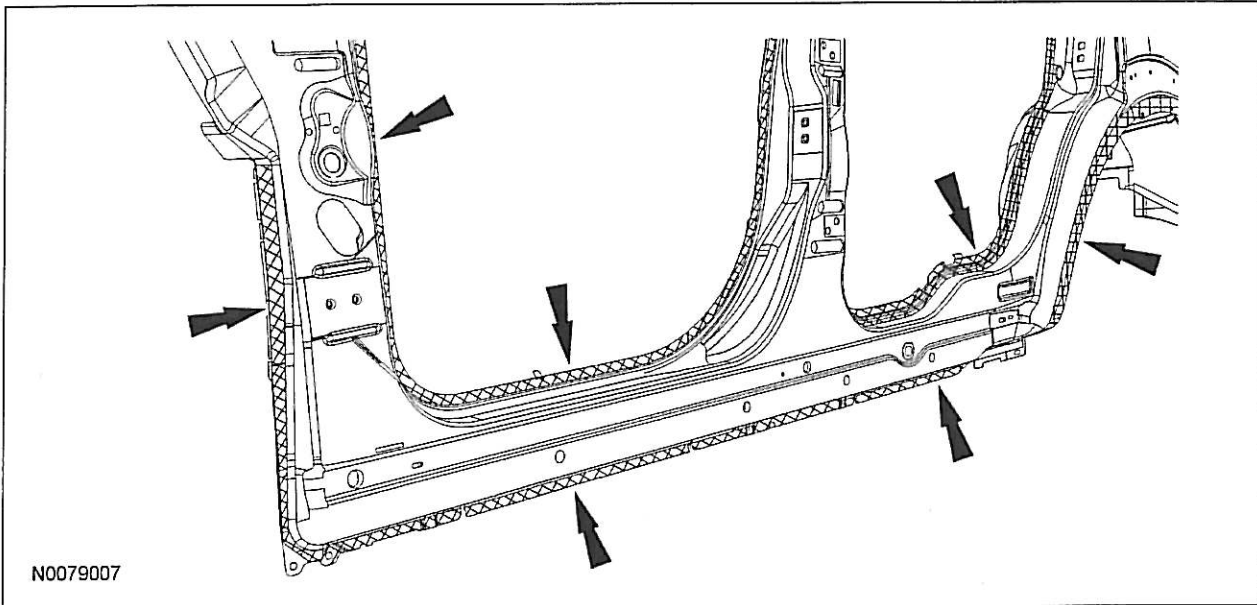
Apply rust inhibitor to the closed channel portion of the spot weld flange areas using the short, hook-shaped wand. Apply material to the exposed edges after carrying out the welding process. Make sure horizontal surfaces are well protected as they are more susceptible to corrosion.



N0079008

GENERAL PROCEDURES (Continued)4. **NOTE:** Door frame opening view.

Apply rust inhibitor to the closed channel portion of the spot weld flange areas using the short, hook-shaped wand. Make sure horizontal surfaces are well protected as they are more susceptible to corrosion.



GENERAL PROCEDURES (Continued)**Body and Frame Undercoating**

1. **⚠ WARNING:** Always refer to Material Safety Data Sheet (MSDS) when handling chemicals and wear protective equipment as directed. Examples may include but are not limited to respirators and chemically resistant gloves. Failure to follow these instructions may result in serious personal injury.

⚠ WARNING: Always wear protective equipment including eye protection with side shields, and a dust mask when sanding or grinding. Failure to follow these instructions may result in serious personal injury.

⚠ CAUTION: Do not allow undercoating on exhaust components, heat shields and driveshafts. Failure to follow these instructions may result in incorrect operation of these components.

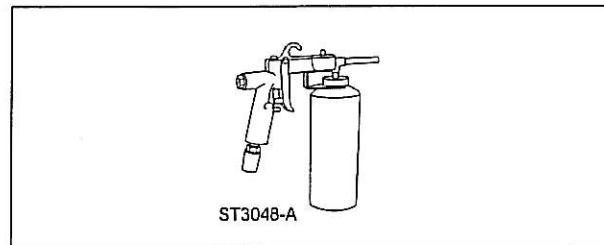
NOTE: Undercoat is a wax base product and must be thoroughly stirred before applying to the vehicle. Store product at temperatures above 20°C (68°F) to avoid thickening of the material. If the product has been left in a cold environment, place the container in hot water for 5-10 minutes. Do not let water reach the cap of the container. Stir or shake vigorously before applying.

NOTE: Avoid high-pressure water spray cleaning to treated underbody area for 24 hours. Wire brush the area and make sure the surfaces are free of oil, dirt and other foreign material. Carry out the undercoating process in the following sequence.

- 1 Thoroughly clean and degrease metal

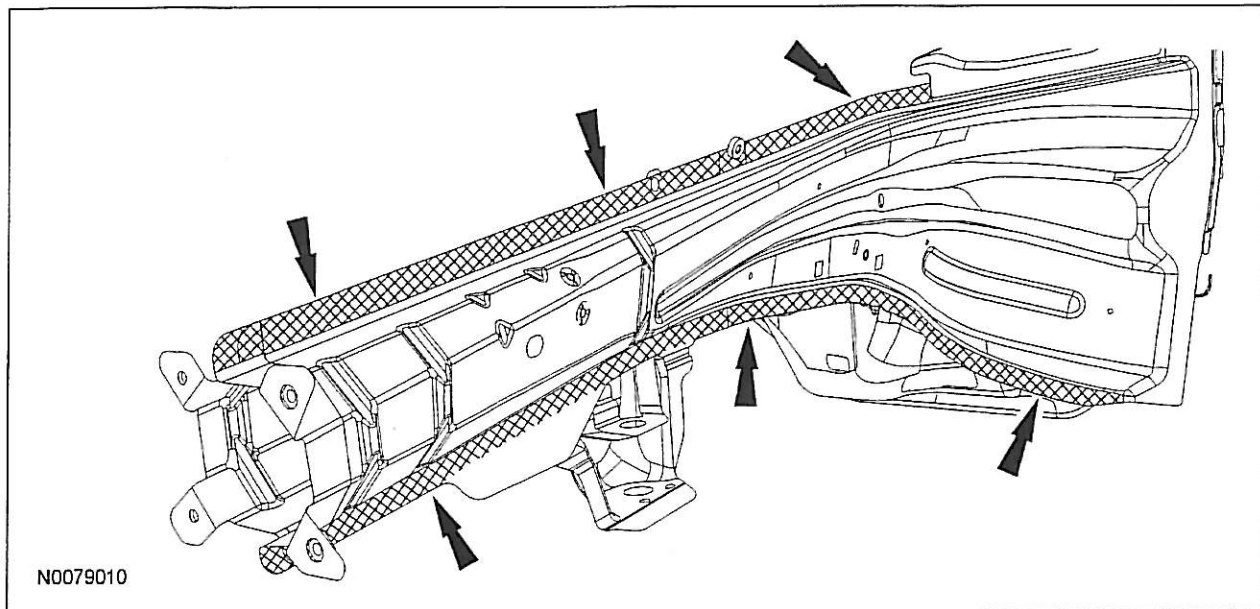
surfaces using a good wax and grease remover and metal surface prep.

- 2 For best results the vehicle should be at room temperature.
 - Bottle attaches directly to the dispensing gun.
- 3 Undercoat should be applied after the welding and refinishing process. Product cannot be welded through.
- 4 Air pressure setting for applicator gun is 552-621 kPa (80-90 psi).
 - Apply light mist coats, applicator sprays in fogging pattern.
 - Material displaces moisture.
- 5 Clean up any overspray with a mild solvent such as mineral spirits or bug and tar remover.



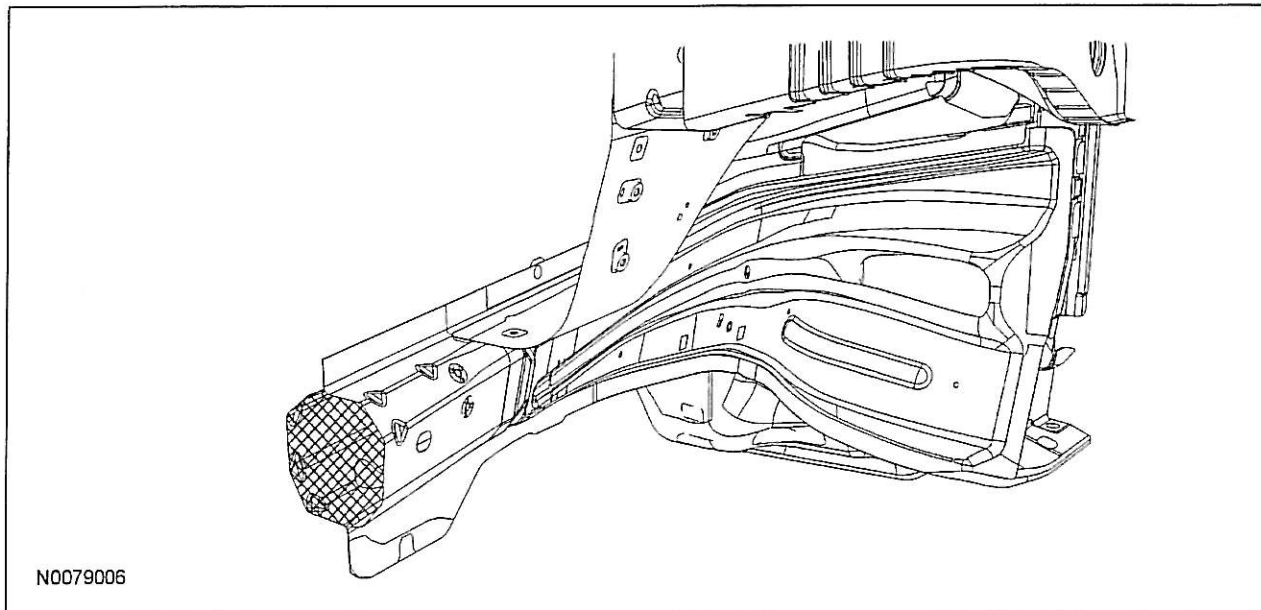
NOTE: The following illustrations provide typical applications to frame rails and are not vehicle specific.

2. **NOTE:** Frame rail exterior spot-weld flange view.
Apply undercoat material to the exterior exposed edges after carrying out the welding and refinishing process.

GENERAL PROCEDURES (Continued)

3. **NOTE:** Cross section view of typical unibody frame rail.

Apply rust inhibitor to the inner surfaces of the rail after carrying out welding process. Use the long wand and insert as far as possible, Depress trigger and wait 2-3 seconds and slowly pull the wand to make sure the area is completely fogged.



GENERAL PROCEDURES (Continued)

4. **NOTE:** Full frame view. Typical front rail to mid rail section repair.

Apply undercoat material to the exposed surfaces after carrying out the welding process. Make sure to completely cover any bare metal areas.

