

FORD:
2005 Mustang

ISSUE

Some 2005 Mustang vehicles may exhibit a concern with the front side marker lamp retainer tab breaking in the bumper cover, due to an impact.

ACTION

It may be necessary to repair the side marker lamp retainer tab. Refer to the following Service Procedure.

SERVICE PROCEDURE

INSPECTION PROCEDURE

1. Remove the front bumper cover and the side marker lamps. Refer to Workshop Manual Section 501-19.
2. Inspect the bumper cover for external cracks, broken reinforcements or broken attachment tabs.
3. Inspect the bumper cover for broken or missing side marker lamp retainer tabs.

Feasibility of repairing the bumper should include the following considerations:

- Can the bumper cover be repaired to a customer acceptable level of quality of appearance, fit, and durability
- Will the labor and material cost of the repair meet or exceed the cost of a new replacement bumper cover

If the bumper cover is determined to be repairable, refer to one of the following repair procedures for the repair material brand you will use.

SIDE MARKER RETAINER TAB REPAIR PROCEDURE USING FUSOR BRAND MATERIALS

1. Clean the broken tab with wax and grease remover.

2. Hand sand the repair area with 80 grit sandpaper, and remove any debris with compressed air.
3. Apply Fusor Surface Modifier (602) to the repair area, and let it dry for 10-15 minutes.
4. Measure and cut a patch of Fusor Plastic Fiberglass Cloth (702) large enough to form the front of the tab, then slope back in a wedge shape approximately 2" (51 mm) from original lamp retainer tab.
 - a. If the original lamp retainer tab is completely missing, the opening for the new tab wedge may be fabricated using mild steel wire formed in a channel shape.
5. Prepare the Fusor Plastic Repair Adhesive (143) (5U7Z-19B508-A) per manufacturer's instructions and apply in the form of the wedge outlined earlier, while inserting the tab opening metal reinforcement fabricated in step 4a if needed.
6. Immediately apply the fiberglass cloth into the plastic repair adhesive for reinforcement, apply more plastic repair adhesive for shape and strength as required.
7. Allow 20 minutes to cure. Shape the repair wedge using a small angle sander. Use extreme care to not sand through to the exterior surface.
8. Using a die grinder with a small round cutting bit, shape the opening for the light tab in the repair wedge. Work carefully to not cut through the exterior. Trial fit the light to determine proper engagement.
9. Perform any needed paint repair operations to the bumper cover using Ford approved paint systems.

NOTE: The information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment to do the job properly and safely. It informs these technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The procedures should not be performed by "do-it-yourselfers". Do not assume that a condition described affects your car or truck. Contact a Ford, Lincoln, or Mercury dealership to determine whether the Bulletin applies to your vehicle. Warranty Policy and Extended Service Plan documentation determine Warranty and/or Extended Service Plan coverage unless stated otherwise in the TSB article. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ford Motor Company reserves the right to supersede this information with updates. The most recent information is available through Ford Motor Company's on-line technical resources.

10. Reassemble the lights and the completed bumper cover to the vehicle.

**SIDE MARKER RETAINER TAB REPAIR
PROCEDURE USING 3M BRAND MATERIALS**

1. Clean the broken tab with Wax and Grease remover.
2. Hand sand the repair area with 80 grit sandpaper, and remove any debris with compressed air.
3. Apply a light coat of 3M Automix Polyolefin Adhesion Promoter (05907), let dry for 5 minutes.
4. Measure and cut a patch of Duramix Plastic Contour Sheet (04903) large enough to form the front of the light retainer tab then slope back in a wedge shape approximately 2" (51 mm) from original tab. Allow an extra 1" (26 mm) of the sheet to help form the sides.
 - a. If the original lamp retainer tab is completely missing, the opening for the new tab wedge may be fabricated using mild steel wire formed in a channel shape.
5. Prepare the Duramix Super Fast Plastic Repair Adhesive (04247) per manufacturer's instructions and apply in the form of the wedge outlined earlier, while inserting the tab opening metal reinforcement fabricated in step 4a if needed.
6. Immediately apply the contour sheet to form the wedge shape.
7. Allow 10 minutes to cure. Shape the repair wedge using a small angle sander. Use extreme care to not sand through to the exterior surface.
8. Using a die grinder with a small round cutting bit, shape the opening for the light tab in the repair wedge. Work carefully to not cut through the exterior. Trial fit the light to determine proper engagement.
9. Perform any needed paint repair operations to the bumper cover using Ford approved paint systems.
10. Reassemble the lights and the completed bumper cover to the vehicle.

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