



Collision Position Statement

October 1, 2025

USE OF OEM STRUCTURAL FASTENERS AND ADHESIVES

For all structural and cosmetic body repairs on Ford Motor Company vehicles, including aluminum repairs, technicians should follow the Ford Motor Company original equipment repair procedures by using: Ford Motor Company-original structural rivets, Ford Motor Company-approved structural adhesives, and Ford Motor Company-approved installation tools. Rivets or fasteners not approved by Ford Motor Company, whether self-piercing, blind, solid or flow-drill, have not been tested by Ford Motor Company and could compromise the repair. Each Ford Motor Company-original rivet is engineered for a specific location (with its own part number, mandrel and tool specification) to achieve the correct depth, spread and bond. Adhering to these Ford Motor Company original equipment guidelines help ensure the vehicle's designed form, fit, performance, durability and safety are fully restored.

Ford Motor Company Approved Fasteners

- Ford does not support the use of non-Ford OEM structural rivets (self-piercing, blind, solid) and flow-drill screws. Ford OEM parts are critical for maintaining the vehicle's design specifications.
- Aftermarket or universal rivets have not been validated by Ford for use in structural repairs.

Ford Motor Company Rivet Types & Key Requirements

- **Self-Piercing Rivets (SPRs)** - SPRs are not universal. Ford Motor Company has developed and tested dozens of different types of SPRs and placement should not deviate from the Ford Motor Company original equipment repair procedures.
 - ☐ To meet Ford Motor Company's specifications, location-specific part numbers and mandrels should be used
 - ☐ Ford Motor Company original SPRs are compatible with Ford Motor Company approved adhesives and sealants
 - ☐ For proper installation, SPRs should be installed to the exact depth/spread per Ford Motor Company's original equipment procedure
 - ☐ Ford Motor Company's approved SPRs installation tools are the only tools tested by Ford Motor Company to meet Ford Motor Company's specifications
- **Blind Rivets**
 - ☐ Blind rivets are designed by Ford Motor Company to meet Ford Motor Company's material, dimensional and crush specifications
 - ☐ Location and installation methods should adhere to Ford Motor Company's repair guide



- **Solid Rivets**

- ☐ Solid rivets utilize the same stringent material, size and crush requirements as blind rivets
- ☐ Collision centers should carry out placement and installation per Ford Motor Company's repair procedures to maintain structural integrity

- **Flow-Drill Screws (FDS)**

- ☐ Used in select factory joints; cannot be reused in repairs
- ☐ Should be replaced with the exact Ford Motor Company-specified rivet types to maintain structural integrity

Ford Motor Company Installation Tools & Adhesives

- Proper installation of SPR rivets requires installation tools that can perform correct and repeatable SPR rivet installations. The following SPR installation tools are the only tools Ford Motor Company has tested and approved to be used in the repair of Ford Motor Company vehicles.

Ford Motor Company Approved SPR Riveting Systems	
Henrob Self-Pierce Riveting Kit	Spanesi SPR Gun
Pro Spot Electro-Hydraulic SPR Rivet Gun Kit	TKR Group PNP90 UN 2.0 (6-ton)
Car-O-Liner PNP90 (6-ton)	TKR Group PNP90 SNW XT (10-ton)
Car-O-Liner PNP90 XT2 (10-ton)	TKR Group VAS 6790 (6-ton)
CMO SPR Gun	Wielander and Schill XPress 800
Chief Basic Rivet Gun Kit	

- Structural adhesives should be Ford Motor Company-approved products, applied per the Ford Motor Company original equipment workshop manual repair procedures.

Ford Motor Company Procedure Compliance

- Blind rivets or aluminum plug welds may be required in locations that originally used SPRs. Such variations are normal. Ford Motor Company's original equipment workshop manual procedures are critical to selecting the correct fasteners; deviations can impair structural integrity and safety systems.
- For optimal structural restoration, Ford Motor Company has specified and recommends the exact rivet locations, part numbers, mandrels and tool settings as specified in the Ford Motor Company original equipment workshop manual procedures.
- Deviating from these procedures may compromise the structural integrity and safety of the vehicle.



- Any specific repair performed with unapproved or non-Ford Motor Company validated parts or procedures will not be covered by or warranted under Ford Motor Company's warranty or extended service plan if the unapproved/ non-validated part or procedure directly causes a subsequent failure resulting in damage. The resulting damage or repair may also not be covered under Ford Motor Company's warranty or extended service plan.

By using Ford Motor Company-approved rivets, adhesives and tools—and strictly adhering to the Ford Motor Company original equipment repair procedures—you ensure that the repaired vehicle meets Ford Motor Company's original standards for strength, structural integrity, durability and safety. Ford Certified Collision Centers are required to use Ford Motor Company original equipment parts. Shops that choose to become certified agree to use 100% Ford Motor Company original equipment parts, follow our proprietary repair procedures, and invest in our specific training and tools.

Support

Ford Dealers: www.fordtechservice.dealerconnection.com

Independent Collision Repairers: www.fordserviceinfo.com

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