



Collision Position Statement

October 1, 2025

USE OF OEM STRUCTURAL FASTENERS AND ADHESIVES

For all structural and cosmetic body repairs on Lincoln vehicles, including aluminum repairs, technicians should follow the Lincoln original equipment repair procedures by using: Lincoln-original structural rivets, Lincoln-approved structural adhesives, and Lincoln-approved installation tools. Rivets or fasteners not approved by Lincoln, whether self-piercing, blind, solid or flow-drill, have not been tested by Lincoln and could compromise the repair. Each Lincoln-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 Lincoln original equipment guidelines help ensure the vehicle's designed form, fit, performance, durability and safety are fully restored.

Lincoln Approved Fasteners

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

Lincoln Rivet Types & Key Requirements

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

Lincoln Installation Tools & Adhesives

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

Lincoln 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 Lincoln-approved products, applied per the Lincoln original equipment workshop manual repair procedures.

Lincoln Procedure Compliance

- Blind rivets or aluminum plug welds may be required in locations that originally used SPRs. Such variations are normal. Lincoln'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, Lincoln has specified and recommends the exact rivet locations, part numbers, mandrels and tool settings as specified in the Lincoln 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-Lincoln validated parts or procedures will not be covered by or warranted under Lincoln'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 Lincoln's warranty or extended service plan.



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

Support

Lincoln Dealerships: www.fordtechservice.dealerconnection.com

Independent Collision Repairers: www.fordserviceinfo.com

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