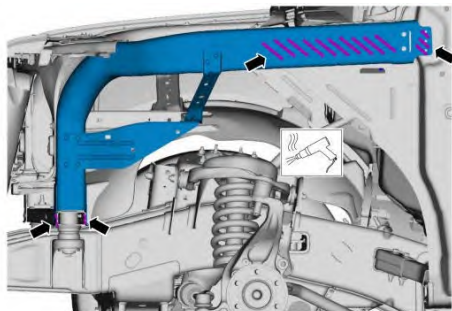




E192345

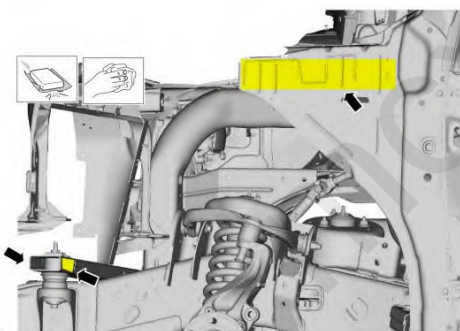
REMOVAL AND INSTALLATION > FENDER APRON PANEL REINFORCEMENT > INSTALLATION

 **NOTE:** The fender apron panel reinforcement must be replaced at the factory seams. No sectioning procedure is approved or permitted.

 **NOTE:** LH side shown in illustration, RH side similar.

1.

Sand to remove old adhesive using 80 grit sandpaper and clean.



E192349

2.

Sand to remove e-coat **in the mating surface area only** using 80 grit sandpaper and clean.



3.

Apply adhesive.

Material

: Metal Bonding Adhesive / TA-1, 3M™ 08115, Fusor® 108B



4.

Install the fender apron panel reinforcement assembly.

Use the General Equipment: Locking Pliers

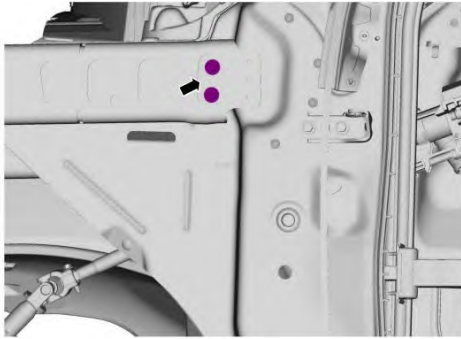


5.

Install the bolts.

Torque

: 22 lb.ft (30 Nm)



6.

Drill rivet holes as indicated.

Use the General Equipment: 6.5 mm Drill Bit



7.

 **NOTE:** Specific technical details including, but not limited to, fastener and adhesive information is included in the Instruction Sheet for each service part (found in the service part packaging). Instruction Sheets can also be found on the PTS (Professional Technician Society) located under the Service Tips tab for this vehicle.

 **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

Install fasteners. Refer to: Joining Techniques .

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

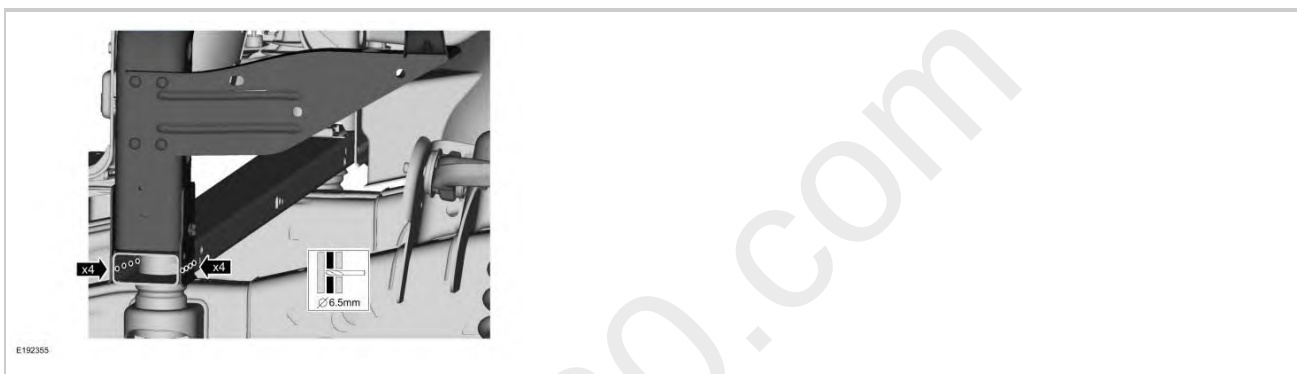
Use the General Equipment: Blind Rivet Gun



8.

Drill rivet holes as indicated.

Use the General Equipment: 6.5 mm Drill Bit



9.

 **NOTE:** Specific technical details including, but not limited to, fastener and adhesive information is included in the Instruction Sheet for each service part (found in the service part packaging). Instruction Sheets can also be found on the PTS (Professional Technician Society) located under the Service Tips tab for this vehicle.

 **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

Install fasteners. Refer to: Joining Techniques .

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

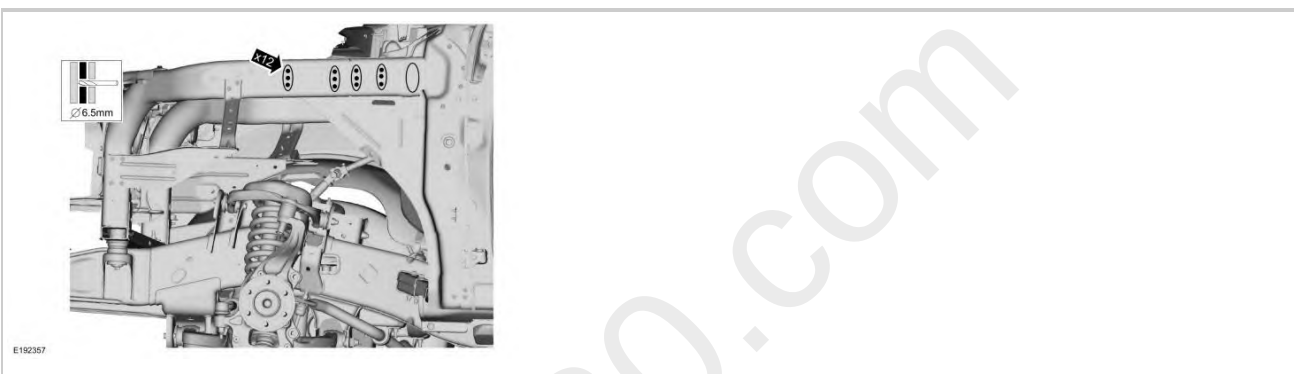
Use the General Equipment: Blind Rivet Gun



10.

Drill rivet holes as indicated.

Use the General Equipment: 6.5 mm Drill Bit



11.

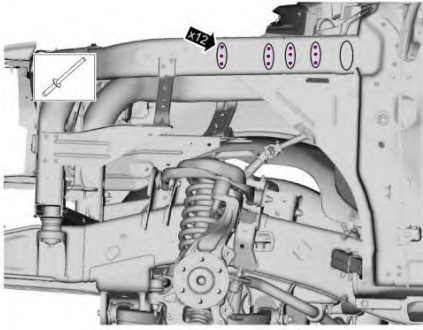
 **NOTE:** Specific technical details including, but not limited to, fastener and adhesive information is included in the Instruction Sheet for each service part (found in the service part packaging). Instruction Sheets can also be found on the PTS (Professional Technician Society) located under the Service Tips tab for this vehicle.

 **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

Install fasteners. Refer to: Joining Techniques .

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Blind Rivet Gun



12.

Sealing work: All areas must be sealed to production level.

13.

Refinish the repair using a Ford approved paint system and typical refinishing techniques.

14.

Install the radiator and bolster assembly. Refer to: COOLING MODULE - 2.7L EcoBoost (238kW/324PS). Refer to: COOLING MODULE - 3.5L Duratec (209kW/284PS). Refer to: COOLING MODULE - 3.5L EcoBoost (272kW/370PS). Refer to: COOLING MODULE - 5.0L 32V Ti-VCT.

15.

Install the lower fender bracket.

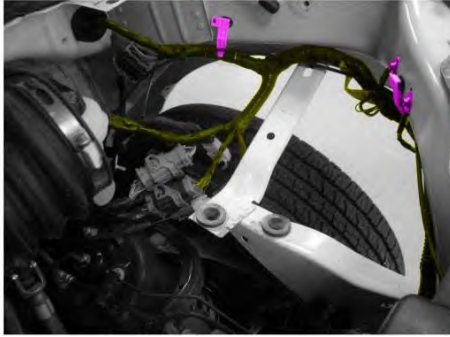
Torque

: 80 lb.in (9.0 Nm)



16.

Reposition the wiring harness assembly.



17.

LH side. Refer to: Battery .

18.

Install the air cleaner assembly. Refer to: AIR CLEANER - 2.7L EcoBoost (238kW/324PS). Refer to: AIR CLEANER - 3.5L Duratec (209kW/284PS). Refer to: AIR CLEANER - 3.5L EcoBoost (272kW/370PS). Refer to: AIR CLEANER - 5.0L 32V Ti-VCT.

19.

Install the front door. Refer to: Front Door - Regular Cab/SuperCrew . Refer to: Front Door - SuperCab .

20.

Install the fender and splash shield. Refer to: Fender . Refer to: Fender Splash Shield .

21.

Install the hood hinge and the hood. Refer to: Hood .

22.

Install the front bumper. Refer to: Front Bumper .