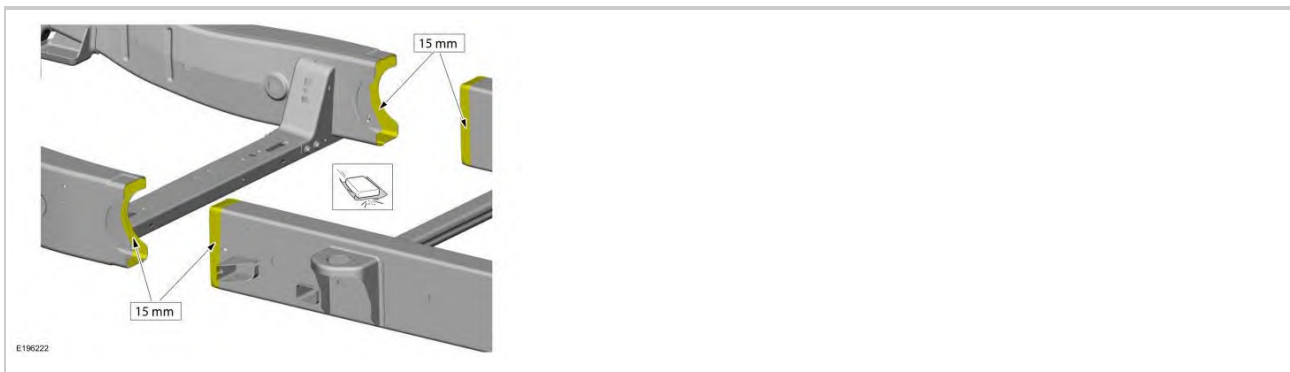




REMOVAL AND INSTALLATION > FRAME MEMBERS-FRONT FRAME SECTION > INSTALLATION

Front Frame Short Section



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

1.

Verify dimensional accuracy **before** performing any welding operations. Refer to: BODY AND FRAME .

2.



NOTE: Check that the Front End Sheet Metal (FESM) body mount bracket lines up with the sheet metal hole for the body mount bolt.

Install the front frame section inside the mid front rail of the frame and tack weld at 4 locations. Refer to: Joining Techniques .

Use the General Equipment: MIG/MAG Welding Equipment

Use the General Equipment: Locking Pliers



3.

Re-check the frame replacement alignment by lowering the body, and then raise it. Weld the joint completely if this alignment is correct.

Use the General Equipment: MIG/MAG Welding Equipment



4.

Metal finish the repair area using typical metal finishing techniques.

5.

Refinish using a Ford approved paint system.

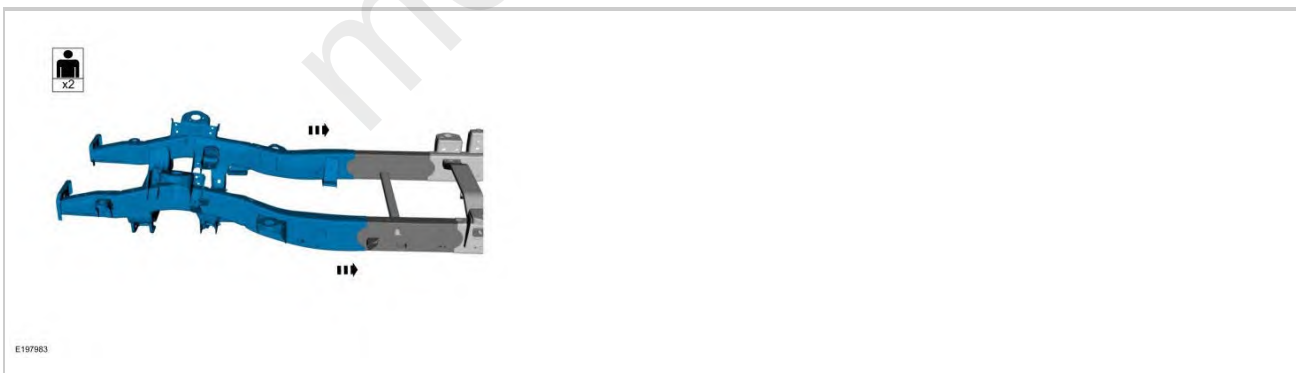
6.

Restore corrosion protection. Refer to: Corrosion Prevention .

Front Frame Section

7.

With the help of an assistant, position the new front frame section into place on the vehicle.



8.

Verify dimensional accuracy **before** performing any welding operations. Refer to: BODY AND FRAME .

9.

Support the new section, and loosely clamp the replacement section in a preliminary position.

Verify correct dimensions, then solid weld the new section to the original on all overlap joints. Refer to: Body and Frame . Refer to: Joining Techniques .

Use the General Equipment: MIG/MAG Welding Equipment

Use the General Equipment: Locking Pliers



10.



NOTE: SuperCrew only, LH side shown in illustration, RH side similar.

If equipped, install the brackets.

Torque

: 76 lb.ft (103 Nm)



11.

Metal finish the repair area using typical metal finishing techniques.

12.

Refinish using a Ford approved paint system.

13.

Restore corrosion protection. Refer to: Corrosion Prevention .

14.