

REMOVAL AND INSTALLATION > ROOF SIDE RAIL - SUPERCAB > INSTALLATION

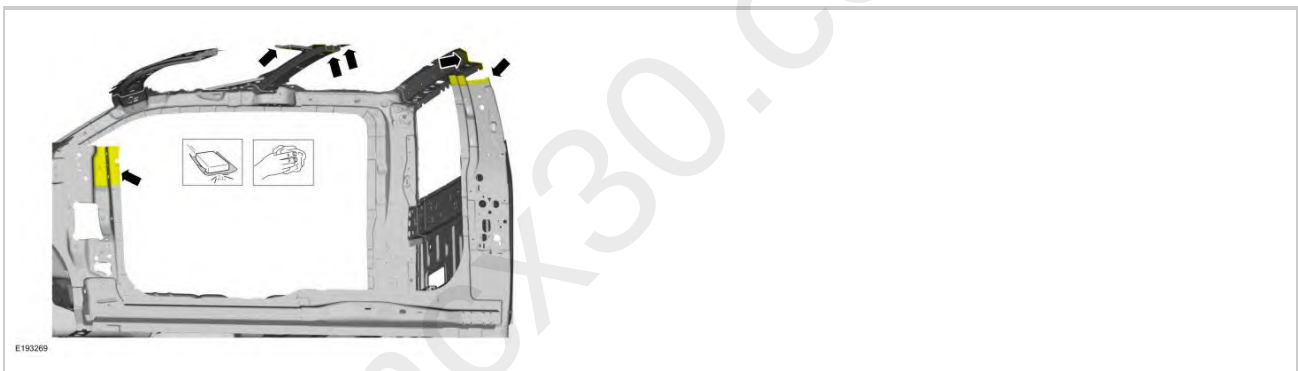
 **NOTE:** Specific technical details including, but not limited to, fastener and adhesive information is included in the Instruction Sheet for each service part (found in the service part packaging). Instruction Sheets can also be found on the PTS (Professional Technician Society) located under the Service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

 **NOTE:** Solid rivets or blind rivet fasteners may be used in place of SPR fasteners in original SPR location after enlarging hole to 6.5mm.

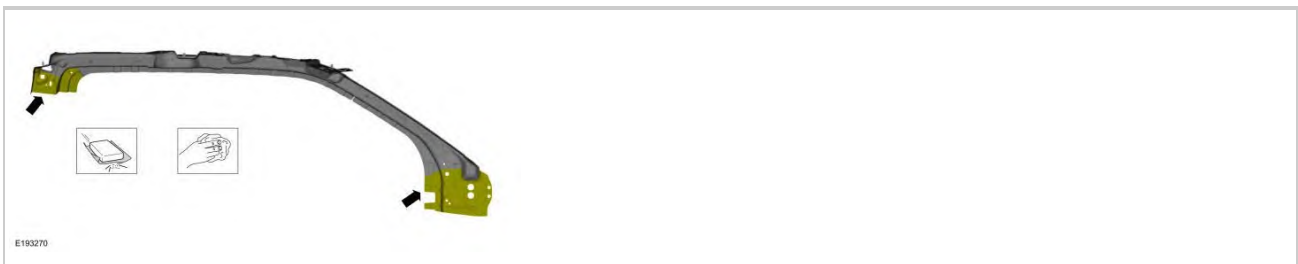
1.

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



2.

Sand to remove e-coat using 80 grit sandpaper and clean.

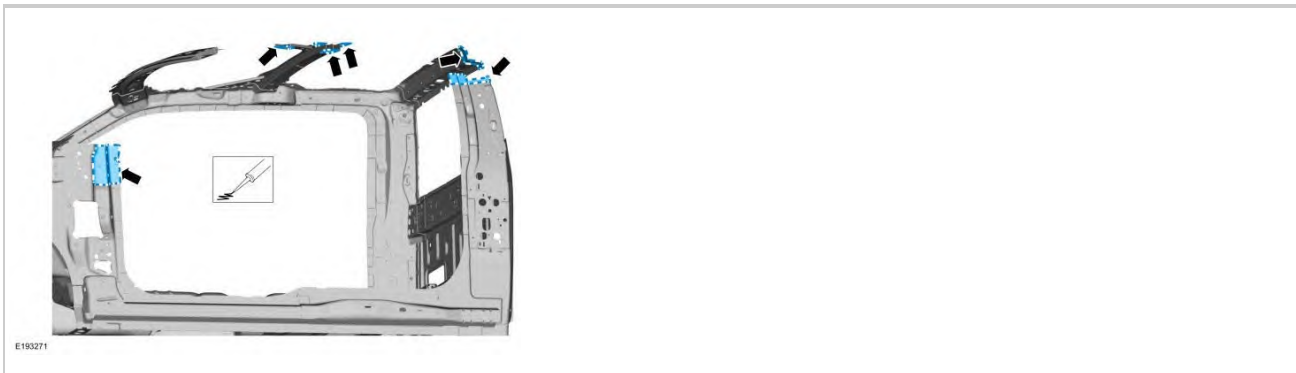


3.

Apply adhesive.

Material

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



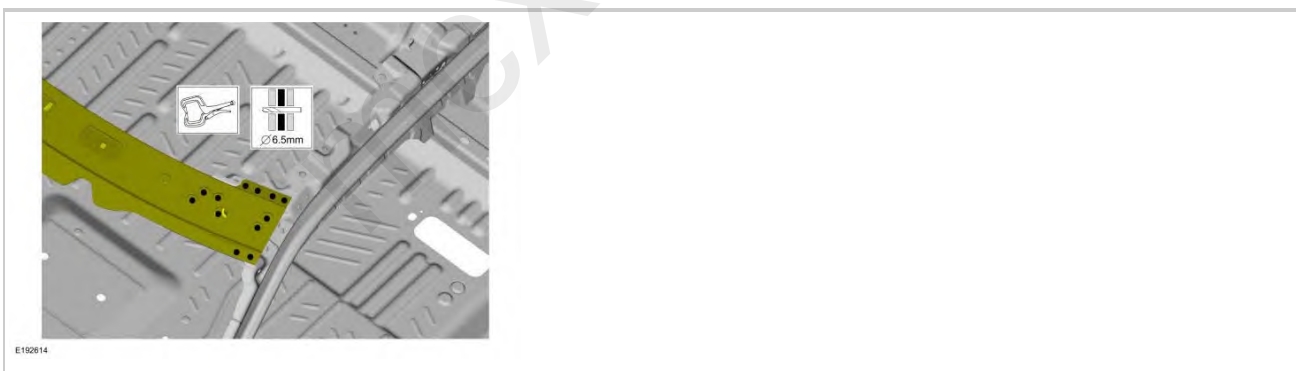
4.

Install and clamp in position. Use the General Equipment: Locking Pliers



5.

Position the windshield header panel, clamp in position and drill as indicated. Use the General Equipment: Locking Pliers Use the General Equipment: 6.5 mm Drill Bit



6.

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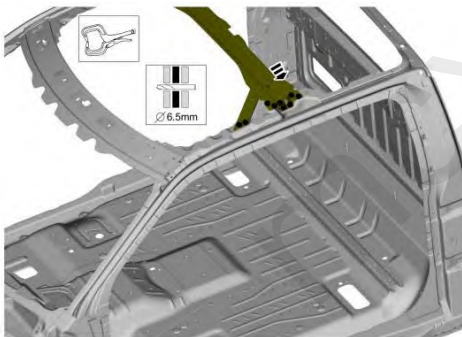
Install the fasteners. Refer to: Joining Techniques . Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer Use the General Equipment: Blind Rivet Gun



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7.

Position, clamp and drill the roof reinforcement. Use the General Equipment: Locking Pliers Use the General Equipment: 6.5 mm Drill Bit



E193273

8.

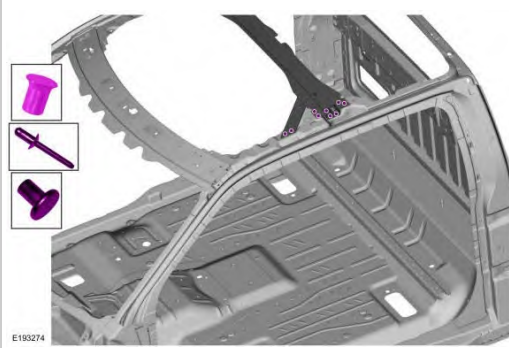
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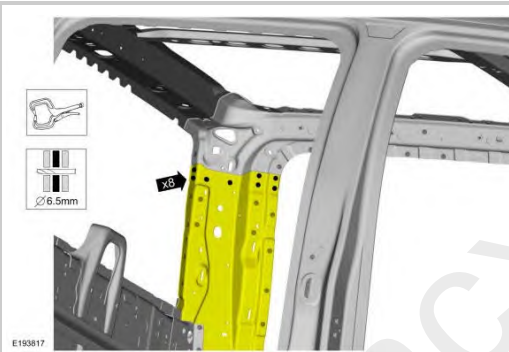
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Install the fasteners. Refer to: Joining Techniques . Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer Use the General Equipment: Blind Rivet Gun



9.

Position, clamp and drill the C-pillar inner panel as indicated. Use the General Equipment: Locking Pliers Use the General Equipment: 6.5 mm Drill Bit



10.



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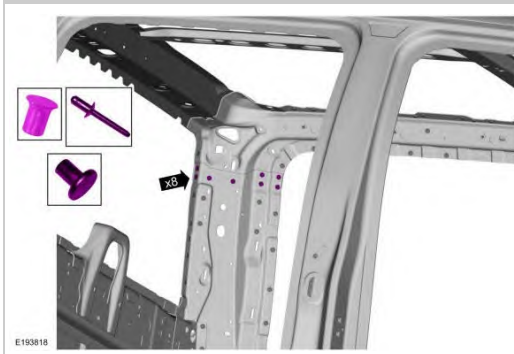


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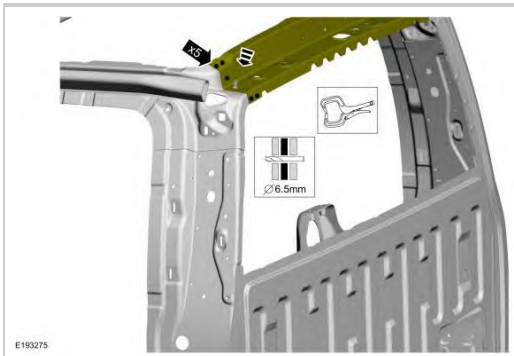
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Install the fasteners. Refer to: Joining Techniques . Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer Use the General Equipment: Blind Rivet Gun



11.

Position the rear window glass header panel, clamp in position and drill as indicated. Use the General Equipment: Locking Pliers Use the General Equipment: 6.5 mm Drill Bit



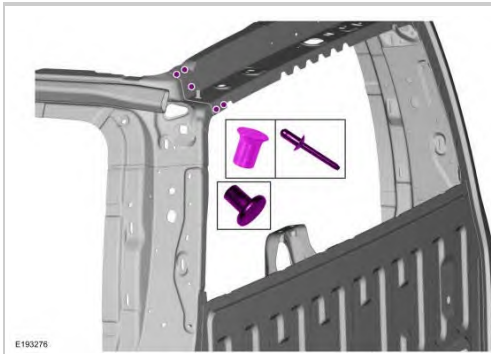
12.

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Install the fasteners. Refer to: Joining Techniques . Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer Use the General Equipment: Blind Rivet Gun



13.

Position, clamp and drill the roof rail to C-pillar reinforcement as indicated. Use the General Equipment: Locking Pliers Use the General Equipment: 6.5 mm Drill Bit



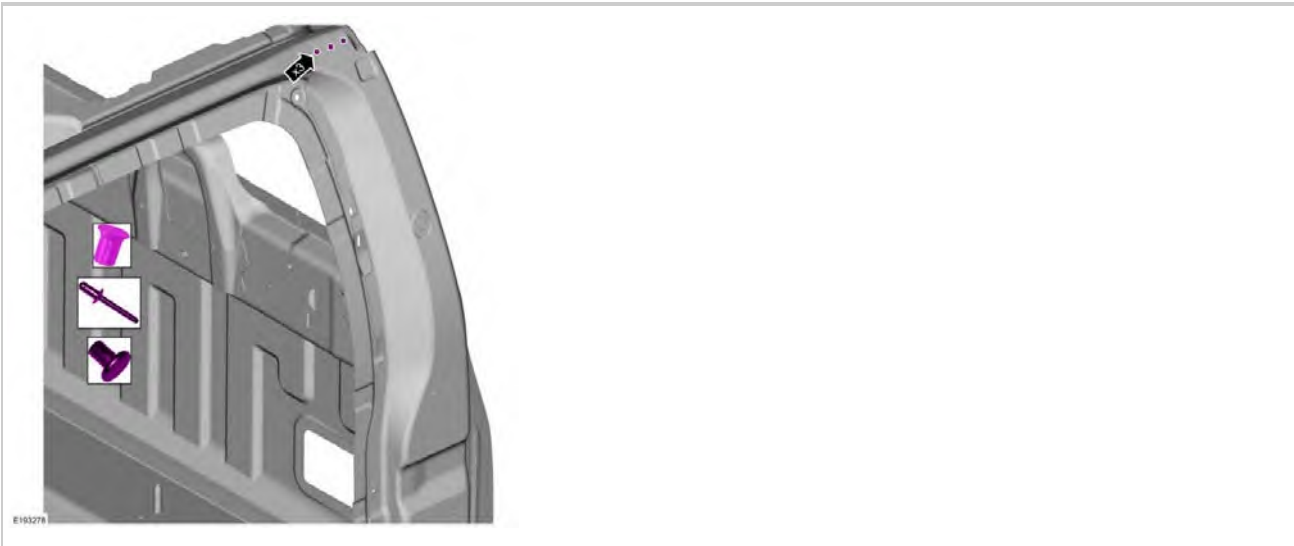
14.

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Install the fasteners. Refer to: Joining Techniques . Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer Use the General Equipment: Blind Rivet Gun



15.

Install the A-pillar reinforcement. Refer to: A-Pillar Outer Panel Section and Reinforcement .

16.

Install the body side outer panel. Refer to: Body Panel Sectioning . Refer to: Joining Techniques .

17.

Install the roof outer panel. Refer to: Roof Panel - SuperCab . Refer to: Roof Panel - SuperCab, Vehicles With: Roof Opening Panel .

18.

Metal finish using typical repair techniques.

19.

Seam sealing: All seams must be sealed to production level.

Material

: Seam Sealer / TA-2-B

20.



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Enlarge old FDS holes as indicated. Use the General Equipment: 6.5 mm Drill Bit



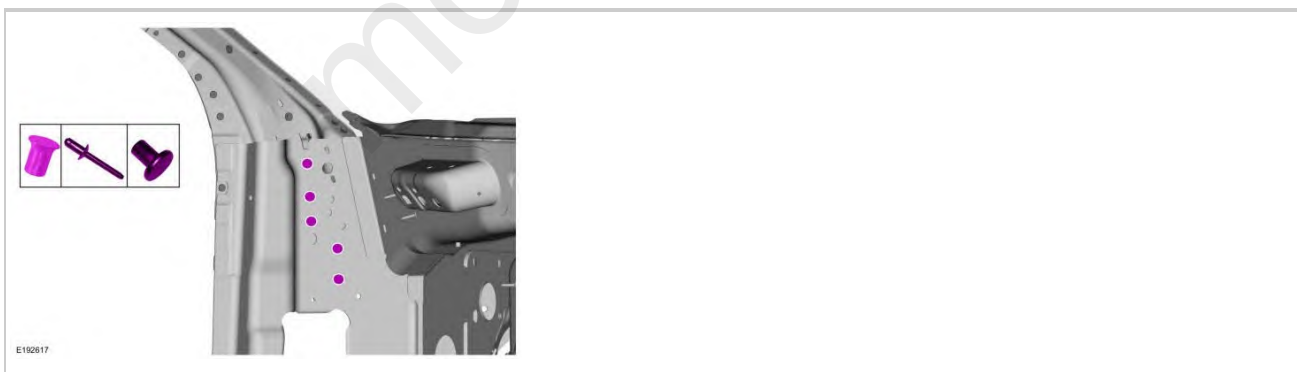
21.

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22.

Refinish the repair area using a Ford approved paint system.

23.

Install the cross-car beam bracket and bolts.

Torque