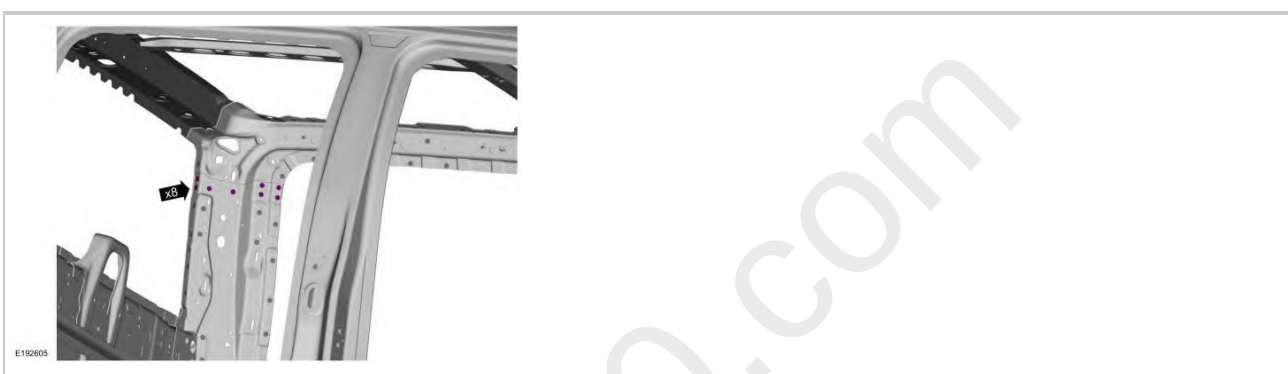




16.

Remove the SPR fasteners on the C-pillar inner panel. Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer Use the General Equipment: Belt Sander



17.

 **NOTE:** The use of heat may aide in the removal of the roof side rail. Do not exceed 425° °F.

Remove the roof side rail reinforcement.



REMOVAL AND INSTALLATION > ROOF SIDE RAIL - SUPERCREW > 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 in the original SPR location after enlarging hole to 6.5 mm.

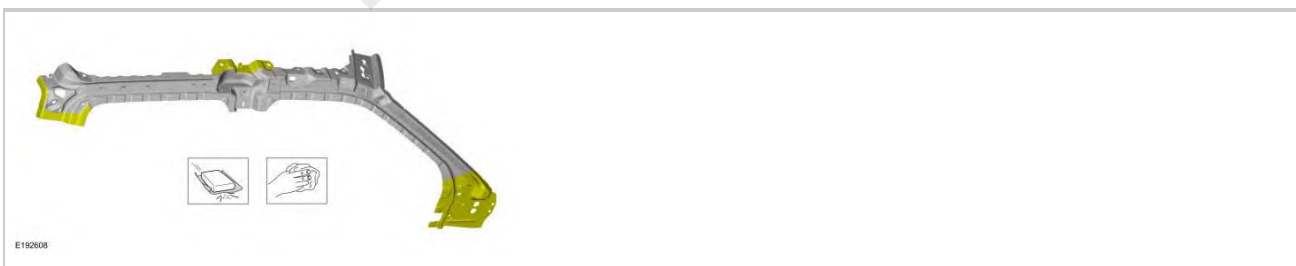
1.

Sand to remove all remaining adhesive on the body side to roof mating surfaces using 80 grit sandpaper and clean.



2.

Sand to remove e-coat on the roof rail to body side roof mating surfaces using 80 grit sandpaper and clean.



3.

Apply adhesive.

Material

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



4.

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



5.

Reposition the B-pillar inner panel, clamp and drill for blind fasteners. Refer to: Joining Techniques . Use the General Equipment: 6.5 mm Drill Bit



6.

 **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).

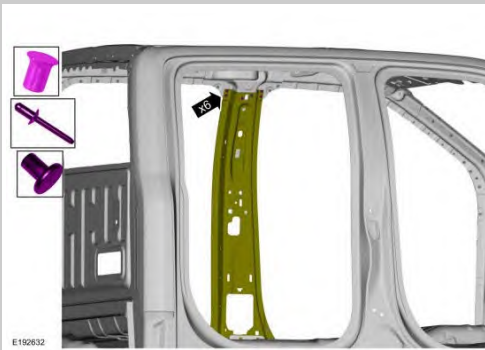
 **NOTE:** SPR fasteners may not be placed directly over original SPR location. They

must be placed adjacent to original location matching original quantity.



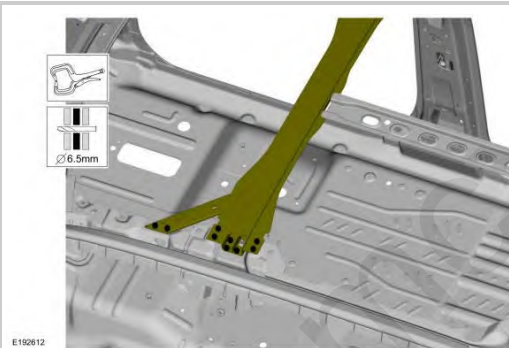
NOTE: Solid rivets or blind fastener rivets may be used in place of SPR fasteners providing the existing rivet hole is enlarged to 6.5 mm.

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



7.

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



8.



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.

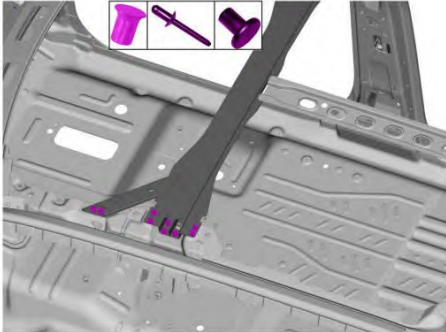


NOTE: SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.



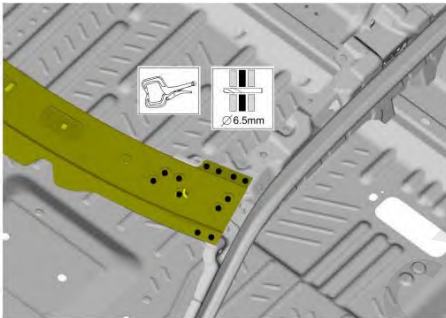
NOTE: Solid rivets or blind fastener rivets may be used in place of SPR fasteners providing the existing rivet hole is enlarged to 6.5 mm.

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



9.

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



10.



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).

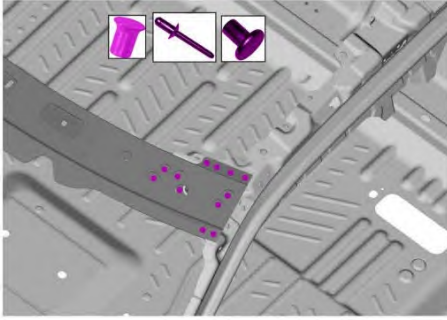


NOTE: SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.



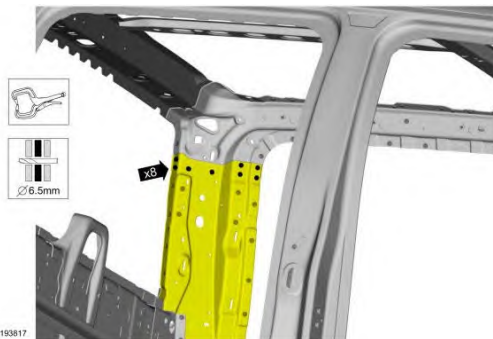
NOTE: Solid rivets or blind fastener rivets may be used in place of SPR fasteners providing the existing rivet hole is enlarged to 6.5 mm.

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



11.

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



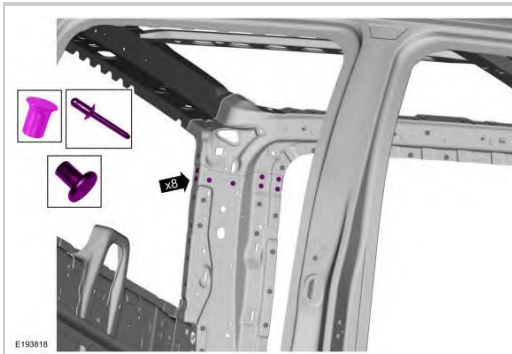
12.

 **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).

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

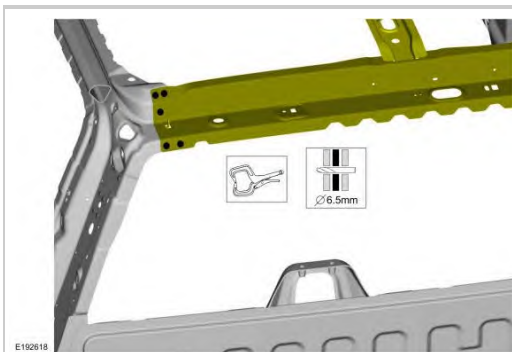
 **NOTE:** Solid rivets or blind fastener rivets may be used in place of SPR fasteners providing the existing rivet hole is enlarged to 6.5 mm.

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



13.

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



14.

 **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).

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

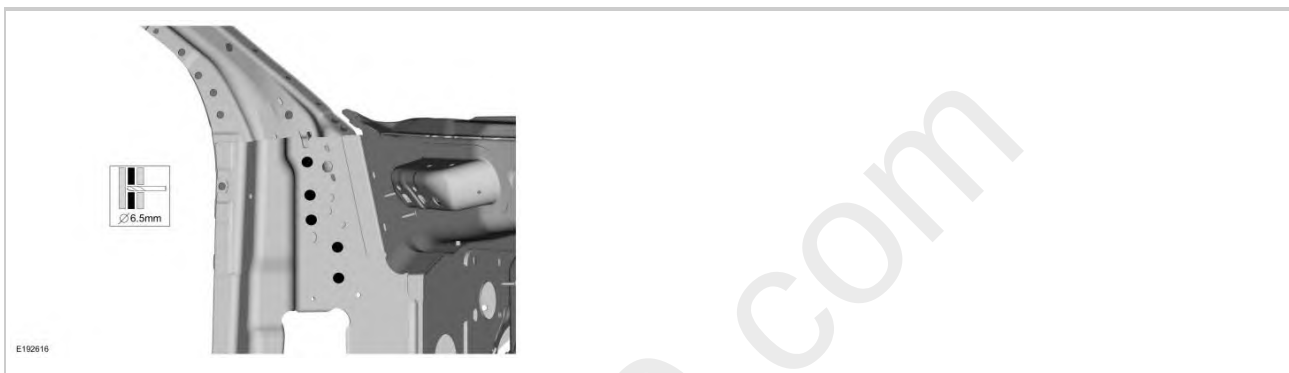
 **NOTE:** Solid rivets or blind fastener rivets may be used in place of SPR fasteners providing the existing rivet hole is enlarged to 6.5 mm.

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



15.

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



16.

 **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).

 **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 fastener rivets may be used in place of SPR fasteners providing the existing rivet hole is enlarged to 6.5 mm.

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



17.

Install the cross-car beam bracket and bolts.

Torque

: 18 lb.ft (25 Nm)



18.

Install the B-pillar reinforcement. Refer to: B-Pillar and Reinforcement - SuperCrew .

19.

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

20.

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

21.