



9.

 **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425 ° F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

Break the adhesive bond and remove the B-pillar outer panel



REMOVAL AND INSTALLATION > B-PILLAR OUTER PANEL - SUPERCREW > INSTALLATION

 **NOTE:** Body side sectioning is prohibited within 50mm of door hinge, door striker and restraints anchoring points.

 **NOTE:** Do not install SPR fasteners directly in old SPR fastener location. SPR fasteners must be installed adjacent to the original location matching original quantity.



NOTE: Solid rivets or blind rivet fasteners may be used in place of SPR fasteners after enlarging existing holes to 6.5 mm.



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.

1.

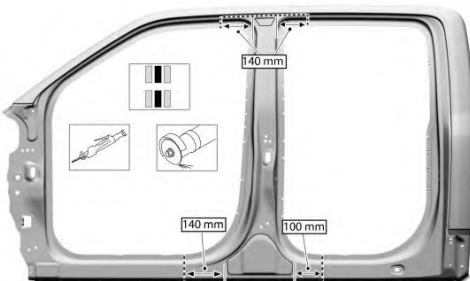
Sand using 80 grit sand paper to remove old adhesive and clean the B-pillar reinforcement mating surfaces.



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2.

Cut the service panel to fit repair. Use the General Equipment: Air Body Saw Use the General Equipment: Spherical Cutter



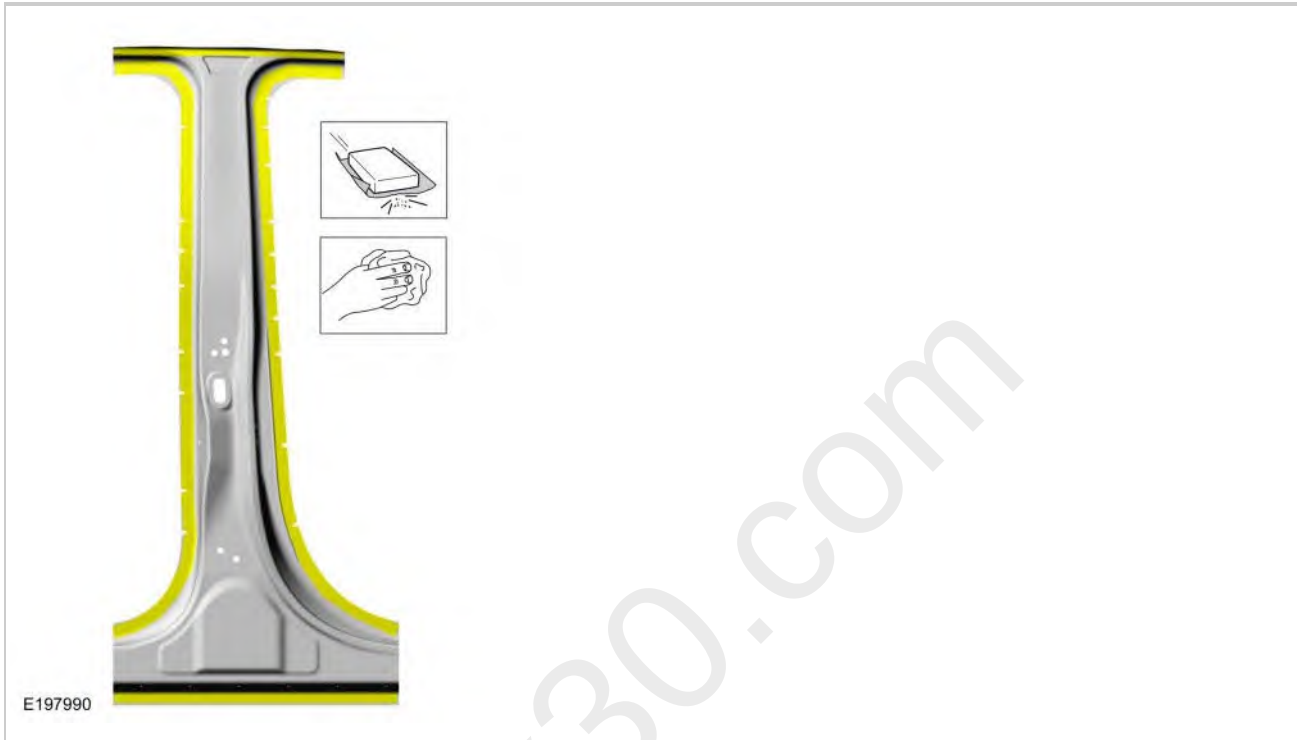
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3.

Sand using 80 grit sand paper to remove e-coat and clean the B-pillar service panel mating surfaces.

Material

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



4.

 **NOTE:** The use of a backer plate when creating butt weld joints will produce a stronger and more uniform repair.

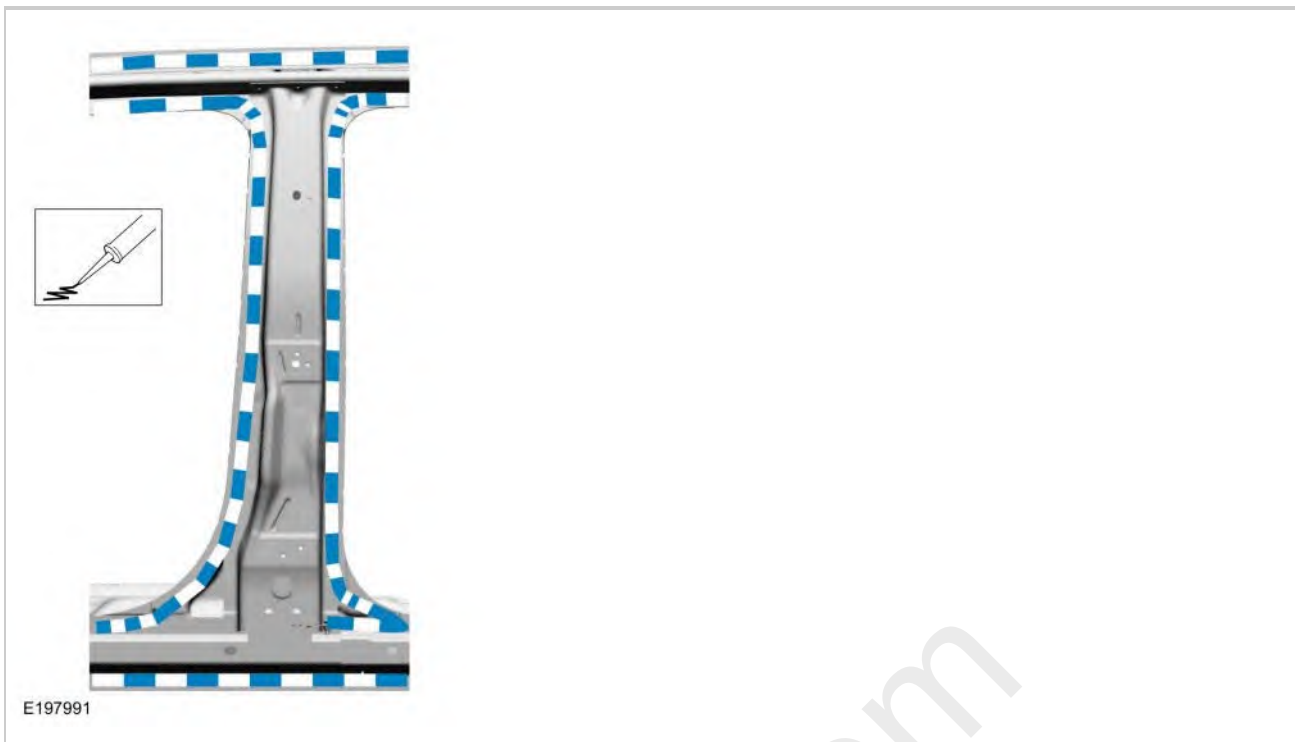
In butt-weld areas: create a backer plate from an unused portion of the old body panel or service replacement panel and install on the vehicle at each sectioning joint. Refer to Joining Techniques .

5.

Apply adhesive to the body side.

Material

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



6.

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



7.

Complete joining of service panel to backer plate and weld the sectioning seams using a MIG welder set up for aluminum. Refer to: Joining Techniques . Use the General Equipment: MIG/MAG Welding Equipment



8.

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



9.

Drill 6.5 mm holes for blind rivet installation. Use the General Equipment: 6.5 mm Drill Bit



10.

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Install blind rivet fasteners. Use the General Equipment: Blind Rivet Gun



11.

Metal finish using typical aluminum metal finishing techniques and a fiber-based body filler. Refer to: Special Repair Considerations for Aluminum Repairs .

12.

Refinish the repair using a Ford approved paint system.

13.

Install the side curtain air bag. Refer to: Side Curtain Airbag - SuperCrew .

14.

Install the front and rear door weather strips and scuff plates.

15.

Install the front door striker and rear door hinges.