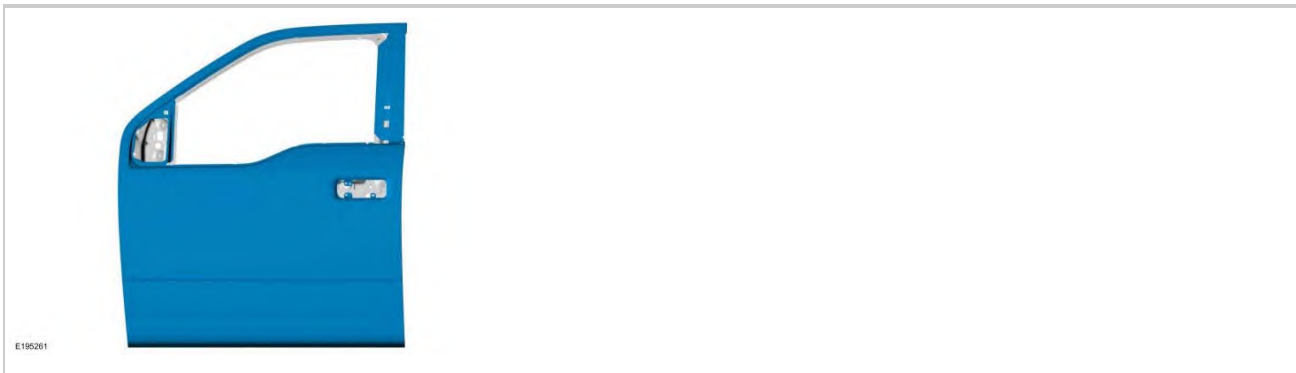




12.

Remove the remaining portion of the door outer panel hem flange. Use the General Equipment: Knife Use the General Equipment: Hot Air Gun



REMOVAL AND INSTALLATION > FRONT DOOR SKIN PANEL > INSTALLATION



NOTE: Do not install SPR fasteners directly in old SPR fastener location. SPR fasteners must be installed adjacent to the original location. Failure to follow this direction may compromise the structural integrity of the repair.



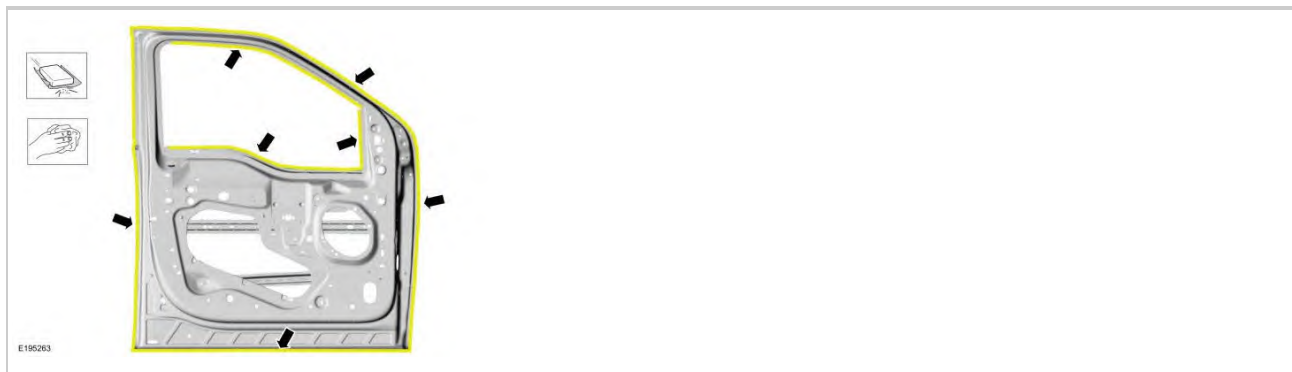
NOTE: Solid rivets or blind rivet fasteners may be used in place of SPR fasteners after enlarging existing holes to 6.5 mm.

1.

Using a hammer and dolly dedicated to aluminum repair, straighten any door shell distortion as necessary.

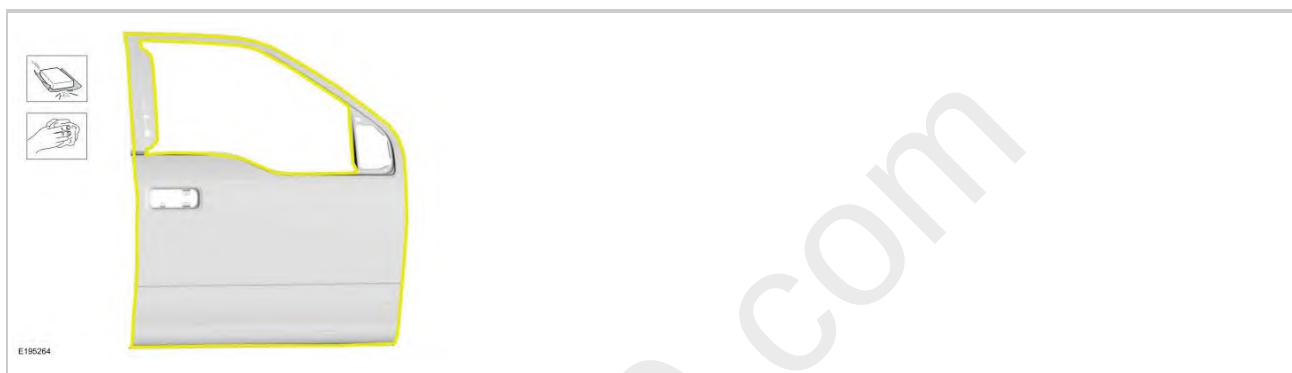
2.

Sand to remove all adhesive using 80 grit sandpaper from the contact area and clean.



3.

Sand to remove the e-coat using 80 grit sandpaper from the mating surface and clean.

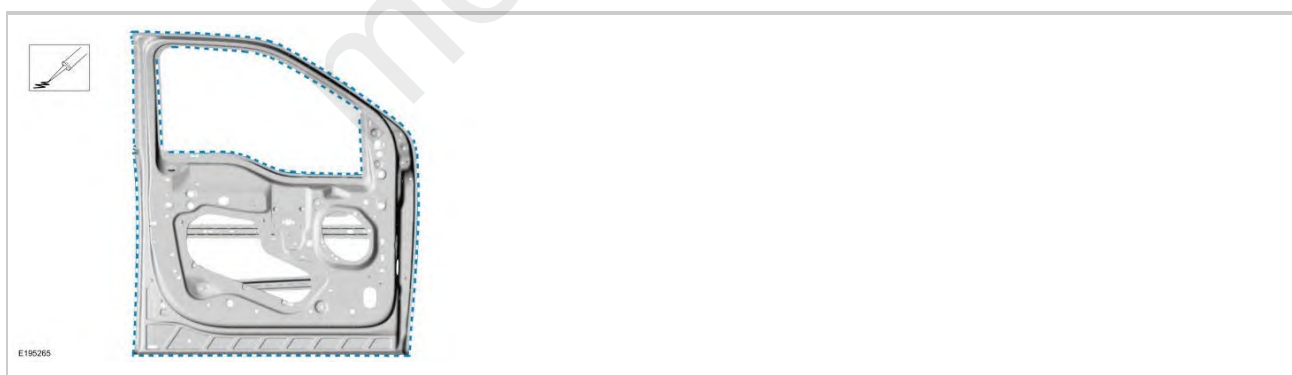


4.

Apply adhesive.

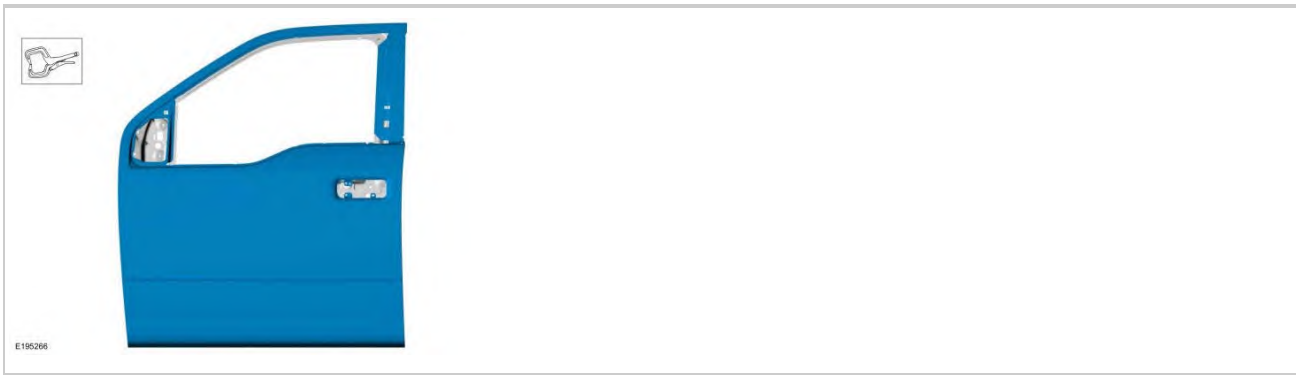
Material

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



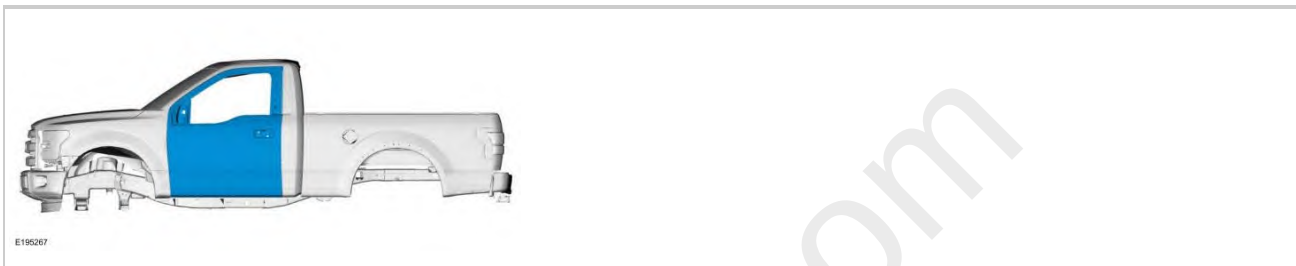
5.

Install, clamp and partially close the flange. Remove the clamp after partially closing the flange. Use the General Equipment: Locking Pliers



6.

Install the door on the vehicle.



7.

Check the door panel for proper fit and alignment.



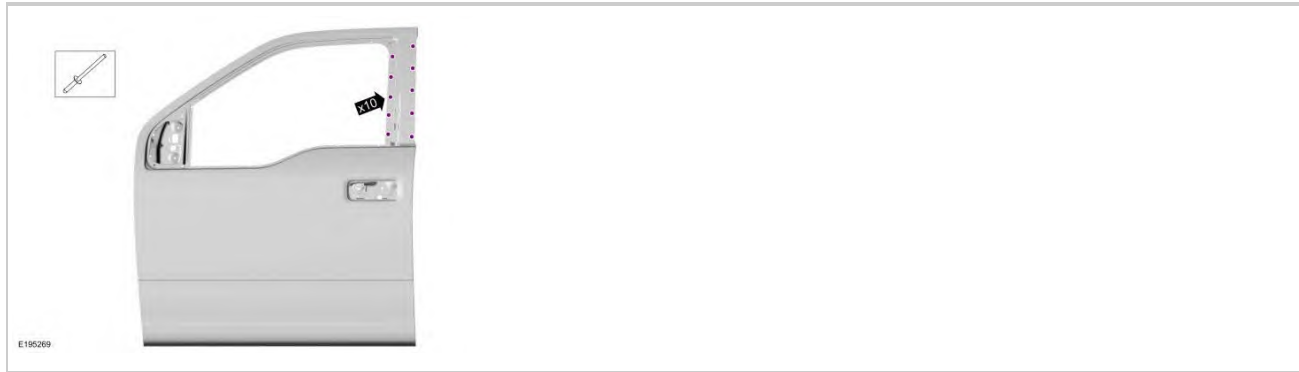
8.

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

 **NOTE:** Blind rivet or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

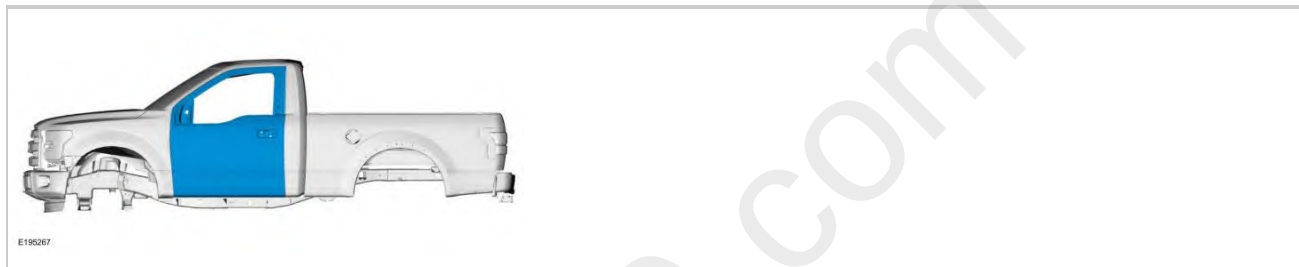
 **NOTE:** Specific technical details including, but not limited to, fastener and adhesive information is included in the Instruction Sheet for each service part (found in the service part packaging).

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



9.

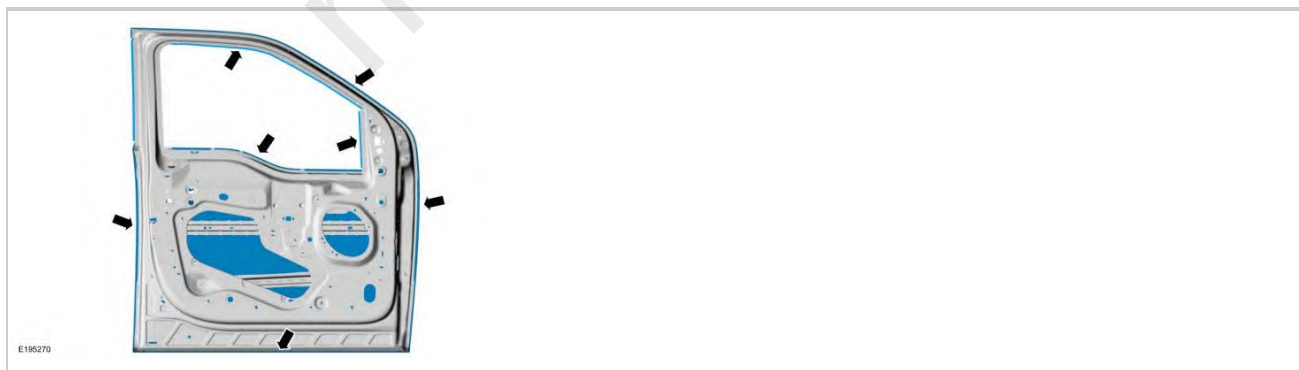
Remove the door from the vehicle.



10.

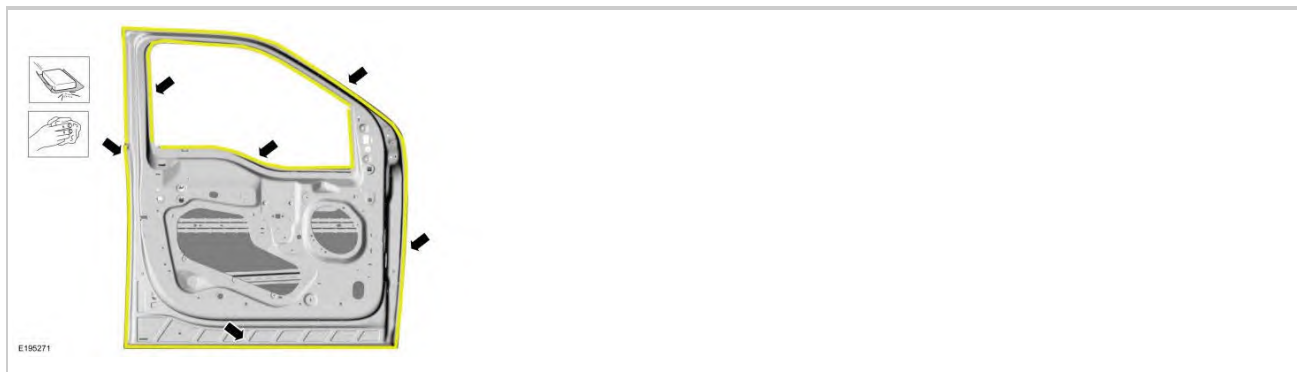
 **NOTE:** Smooth any residual adhesive squeeze-out in to the seam to act as a sealer.

Complete the flanging process.



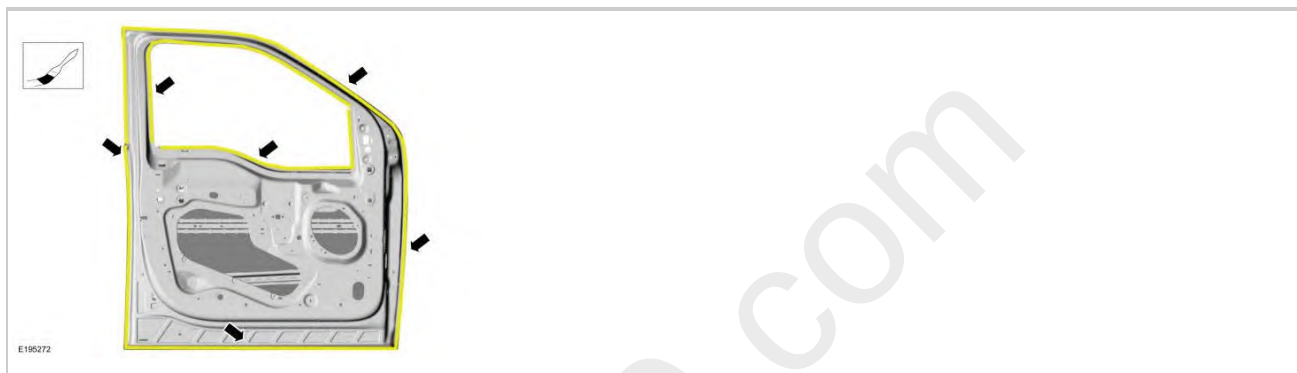
11.

Sand and clean for primer application.



12.

Apply a Ford approved primer to the flange area.

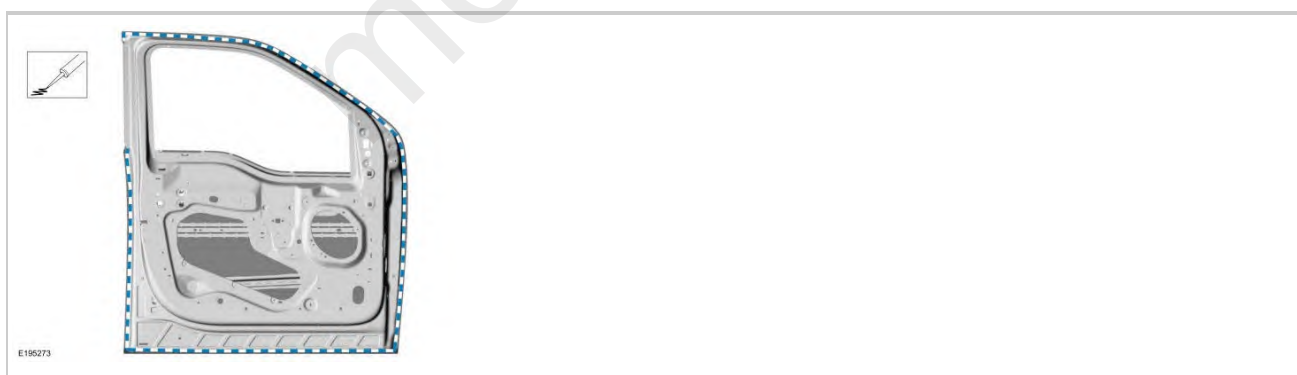


13.

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

Material

: Seam Sealer / TA-2-B



14.

Refinish the door shell flange using a Ford approved paint system and typical refinishing techniques.

15.

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

16.

Apply NVH foam as indicated.

Material

: Fusor ® Flexible Foam Repair / 3M™ 08463, Fusor ® 121



17.

Install a butyl NVH patch as indicated (obtain locally).



18.

Sand and refinish the exterior repair area using a Ford approved paint system.

19.

Install the door weather stripping.