



E196657

12.

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



E196658

REMOVAL AND INSTALLATION > REAR DOOR SKIN PANEL - SUPERCREW > INSTALLATION



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.



NOTE: LH side shown, RH side similar.

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.



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3.

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

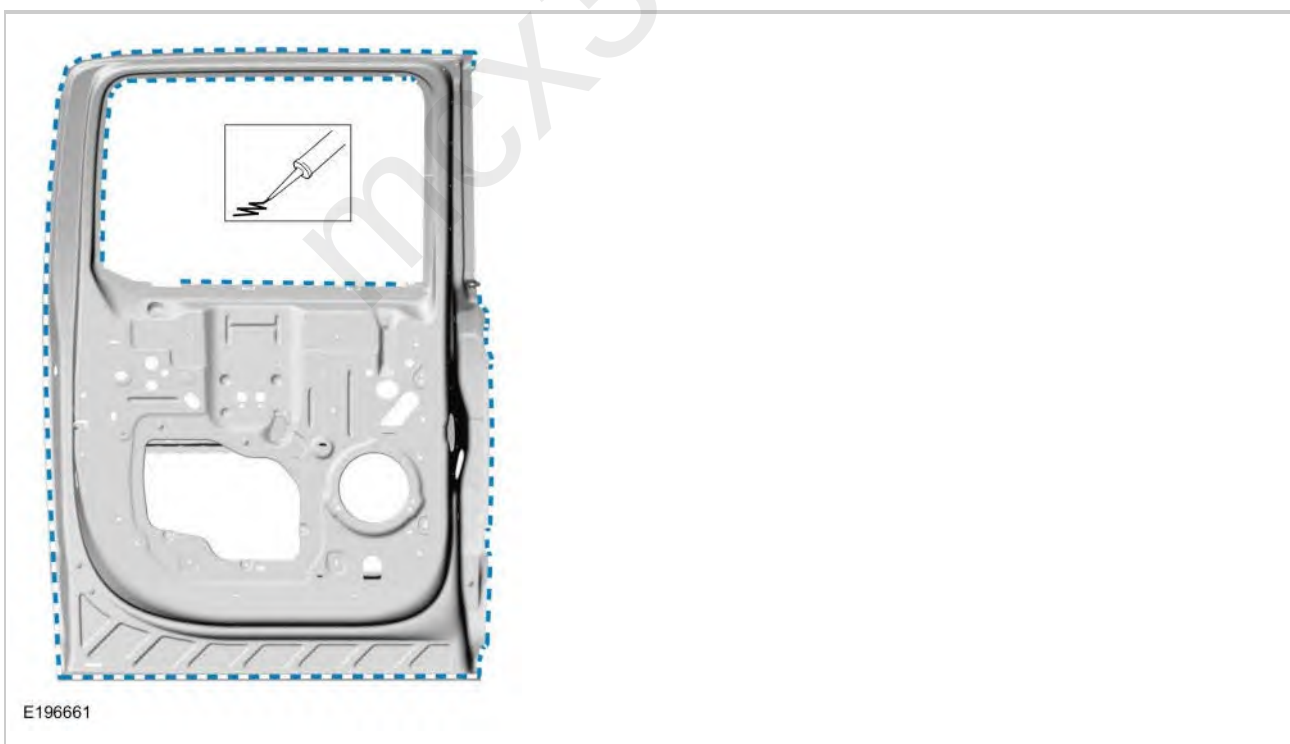


4.

Apply adhesive.

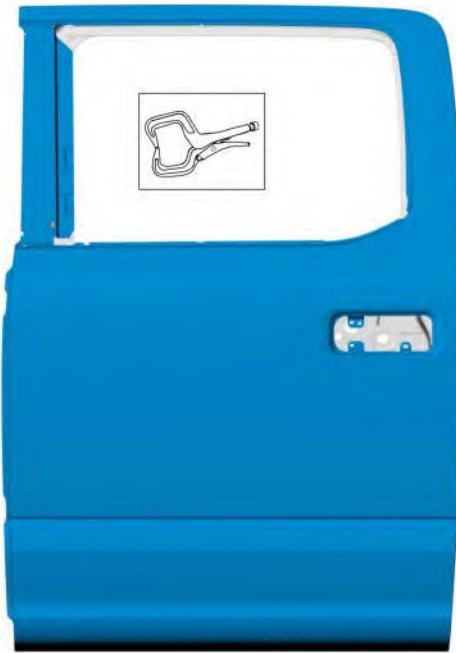
Material

: 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.



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6.

Install the door on the vehicle.



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7.

Check the door panel for proper fit and alignment.



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8.

 **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.

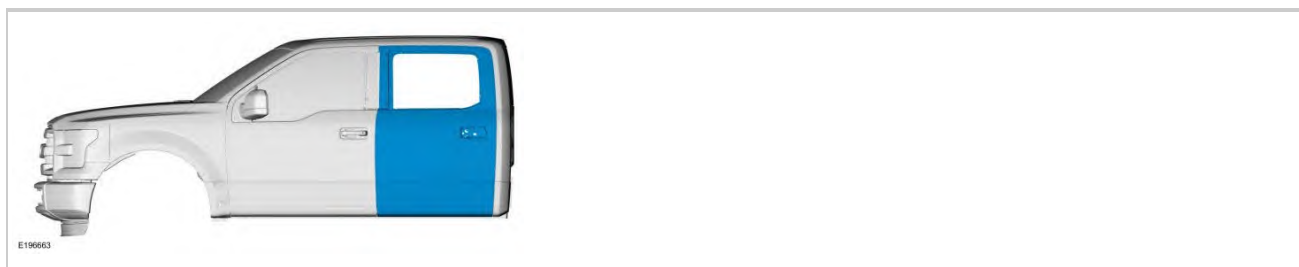
 **NOTE:** Specific technical details including, but not limited to, fastener and adhesive information is included in the Instruction Sheet for each service part (found in the service part packaging).

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



9.

Remove the door from the vehicle.



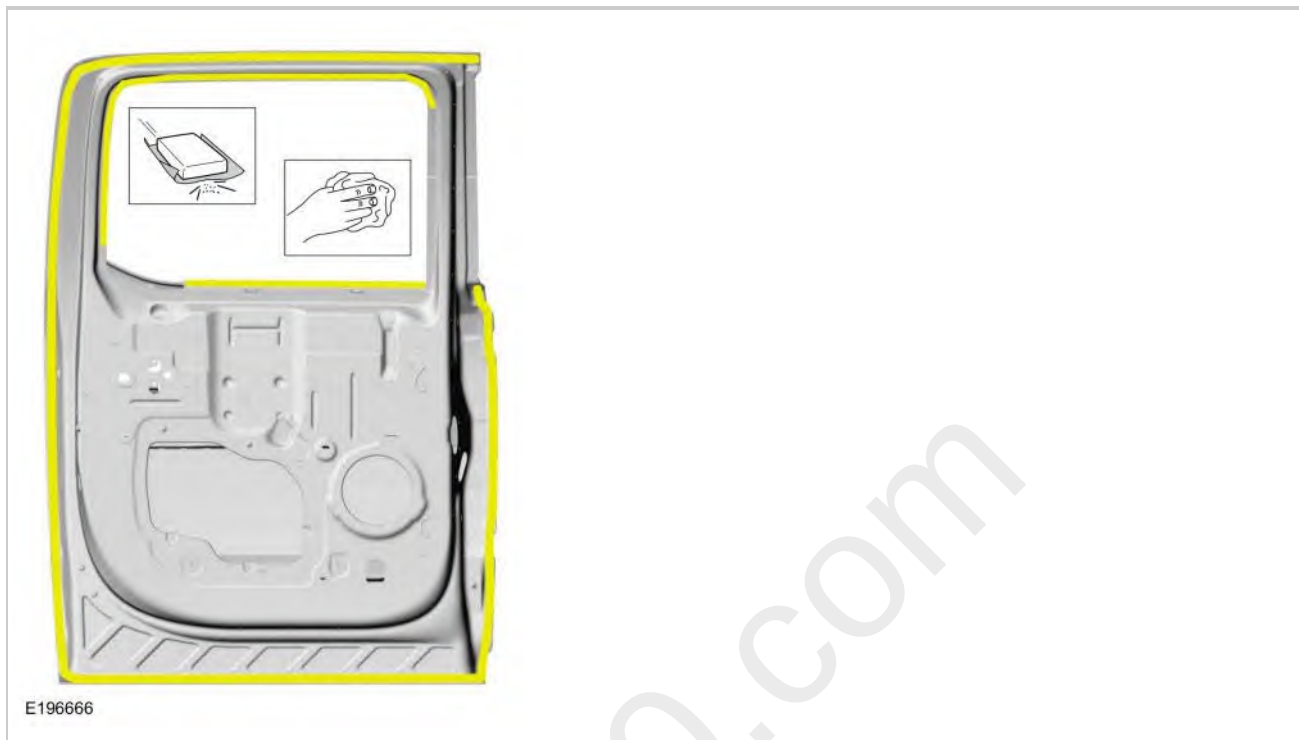
10.

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

Complete the hemming process.

11.

Sand and clean for primer application.



12.

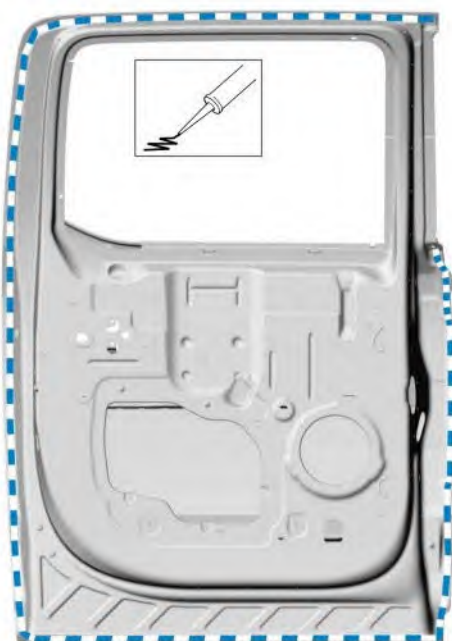
Apply a Ford approved primer to the entire flange repair area.

13.

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

Material

: Seam Sealer / TA-2-B



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14.

Apply an NVH butyl patch as indicated (obtain locally).



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15.

Apply NVH foam as indicated.

Material

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



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16.

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

17.

Install all door weather stripping.



E196652

18.