



19.

 **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.

Remove the body side panel. Use the General Equipment: Hot Air Gun



REMOVAL AND INSTALLATION > SIDE 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.



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

Partial panel replacement:

Determine repair and trim service panel accordingly.

In butt weld area(s) create a backer plate from unused portion(s) of service panel. Refer to: Joining Techniques .

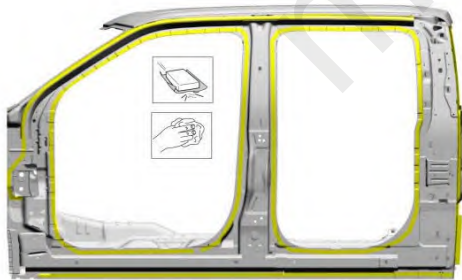
Install backer plate to existing vehicle body panel.

2.



NOTE: Pay particular attention to areas where NVH foam was applied in assembly.

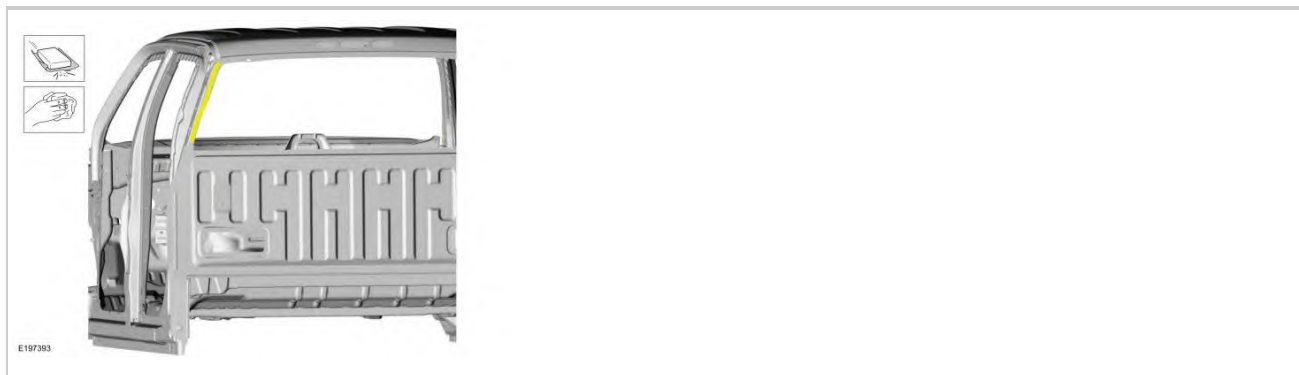
Sand using 80 grit sand paper to remove old adhesive from all mating surfaces and clean.



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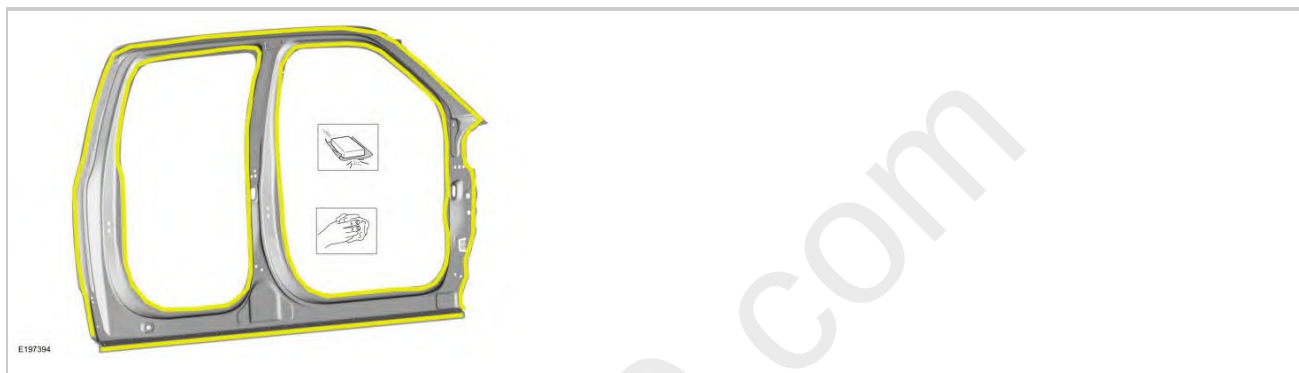
3.

Sand using 80 grit sand paper to remove old adhesive from all mating surfaces and clean.



4.

Sand using 80 grit sand paper to remove e-coat from all mating surfaces and clean.

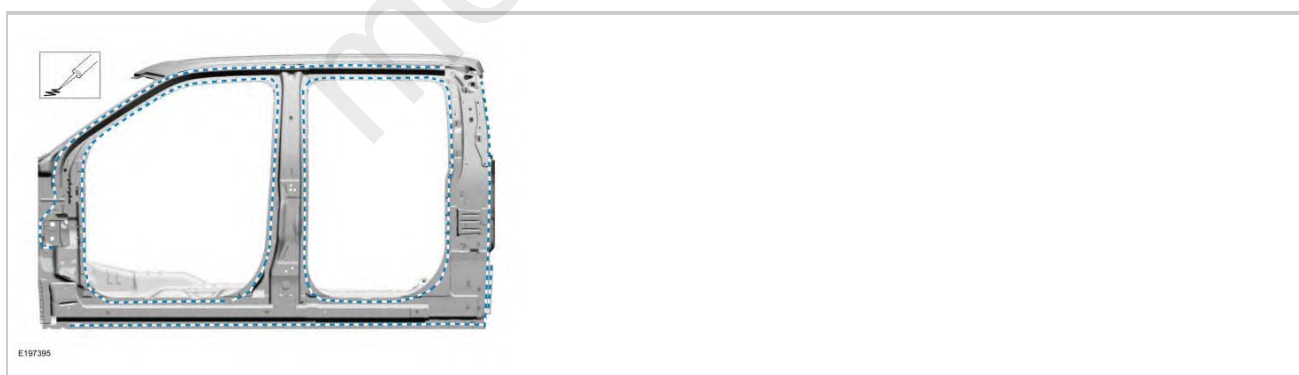


5.

Apply structural adhesive as indicated.

Material

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

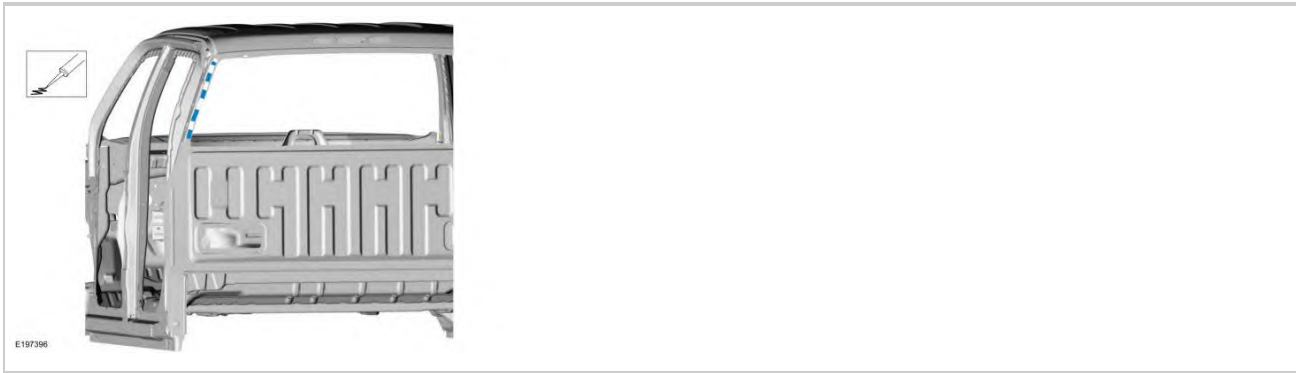


6.

Apply structural adhesive as indicated.

Material

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



7.

Immediately install, align and clamp service panel. Use the General Equipment: Locking Pliers



8.

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

9.

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



10.



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



11.



NOTE: Specific fastener and adhesive information is included on the instruction sheet for the service part and can also be found on the PTS (Professional Technician Society) 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.

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



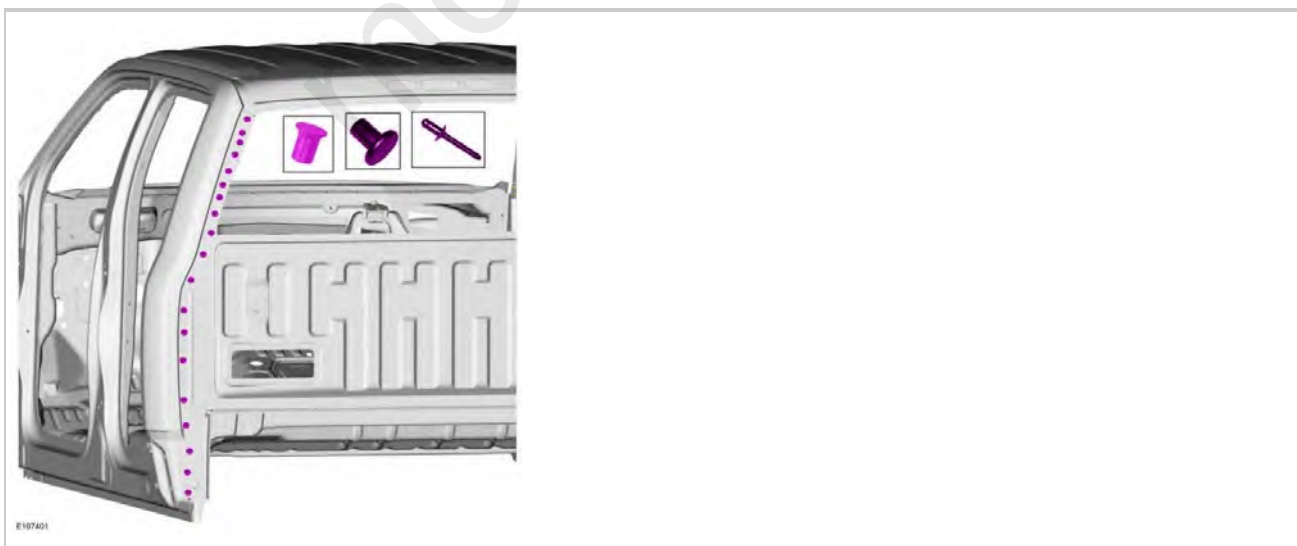
12.

 **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.

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



13.

Using a MIG welder set up for aluminum, weld the roof seam. Use the General Equipment: MIG/MAG Welding Equipment



14.

Metal finish all seams using typical aluminum metal finishing techniques. Refer to: Special Repair Considerations for Aluminum Repairs .

15.

Sand and prime the entire repair using a Ford approved paint system.

16.

Apply NVH foam.

Material

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

17.

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

Material

: Seam Sealer / TA-2-B

18.

Seal the roof joint.

Material

: Roof Ditch Sealer / 3M™ 08307, Fusor ® 122EZ



19.

Refinish the entire repair area using a Ford approved paint system and typical refinishing techniques.

20.

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

21.

Install the windshield and rear window. Refer to: Fixed Glass .

22.

Install the roof moulding and cab corner trim. Refer to: Bodyside Moulding . Refer to: Roof Moulding .

23.

Install the door opening weatherstrips.

24.

Install the A-pillar, B-pillar and C-pillar trim panels. Refer to: A-Pillar Trim Panel . Refer to: B-Pillar Trim Panel - SuperCrew . Refer to: C-Pillar Trim Panel .

25.

Install the front and rear door scuff plates.

26.

Install the front and rear door strikers.

Torque

: 18 lb.ft (25 Nm)



27.

Install the front and rear door hinges to the body.

Front door.

Torque

: 20 lb.ft (27 Nm)

Rear door.

Torque

: 22 lb.ft (30 Nm)



28.

Install the front fender. Refer to: Fender .

29.

Align the doors. Refer to: Rear Door Alignment - SuperCrew . Refer to: Front Door Alignment - Regular Cab/SuperCrew .

30.

Install the pickup bed. Refer to: Pickup Bed .

31.

Repower the SRS. Refer to: Supplemental Restraint System (SRS) Repowering .