

 **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 pickup box front panel.

Use the General Equipment: Hot Air Gun



REMOVAL AND INSTALLATION > PICKUP BOX FRONT PANEL > INSTALLATION

 **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). 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.



2.

Sand using 80 grit sand paper to remove e-coat and clean.



3.

Apply adhesive.

Material

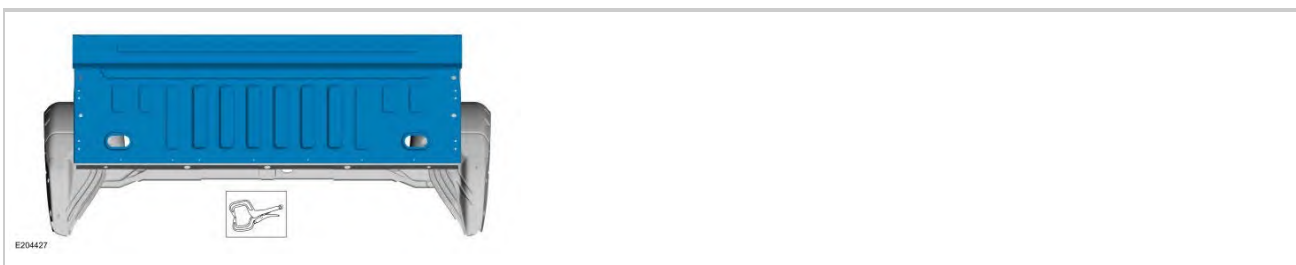
: Metal Bonding Adhesive / TA-1, 3M™ 08115, Fusor® 108B



4.

Install the pickup box front panel and clamp in position.

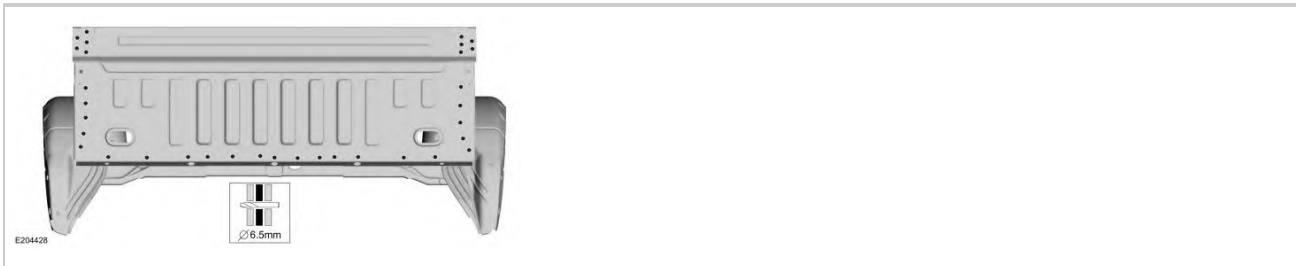
Use the General Equipment: Locking Pliers



5.

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

Drill 6.5 mm holes for fastener installation.



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). Instruction Sheets can also be found on the PTS (Professional Technician Society) located under the Service Tips tab for this vehicle.

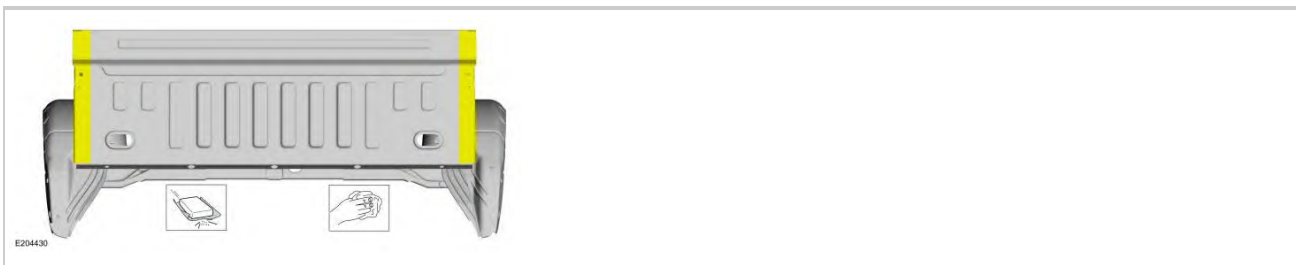
Install blind rivet fasteners.

Use the General Equipment: Blind Rivet Gun



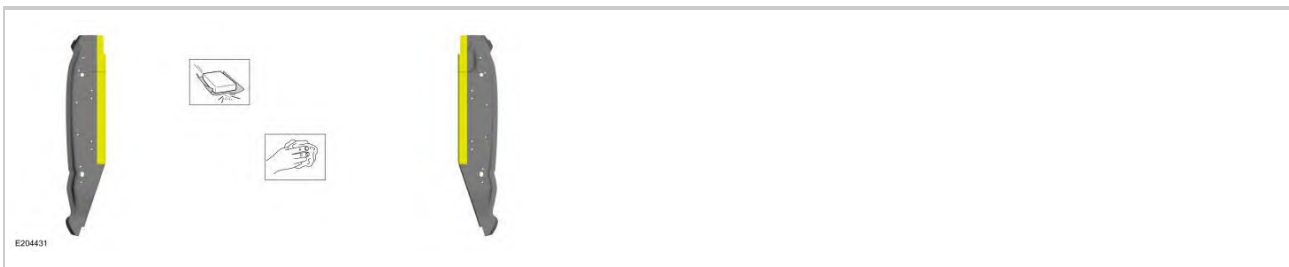
7.

Sand using 80 grit sand paper to remove e-coat and clean.



8.

Sand using 80 grit sand paper to remove e-coat and clean.

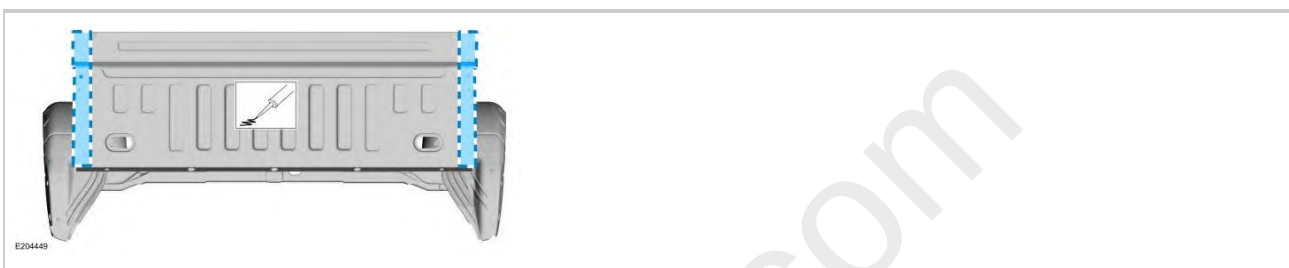


9.

Both Sides: Apply adhesive.

Material

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



10.

Both Sides: Install extensions and clamp in position.

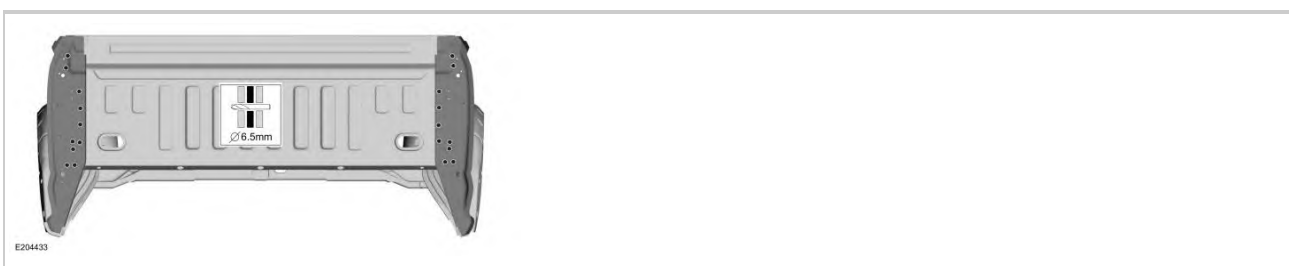
Use the General Equipment: Locking Pliers



11.

Both Sides: Drill 6.5 mm holes for fastener installation.

Use the General Equipment: 6.5 mm Drill Bit



12.