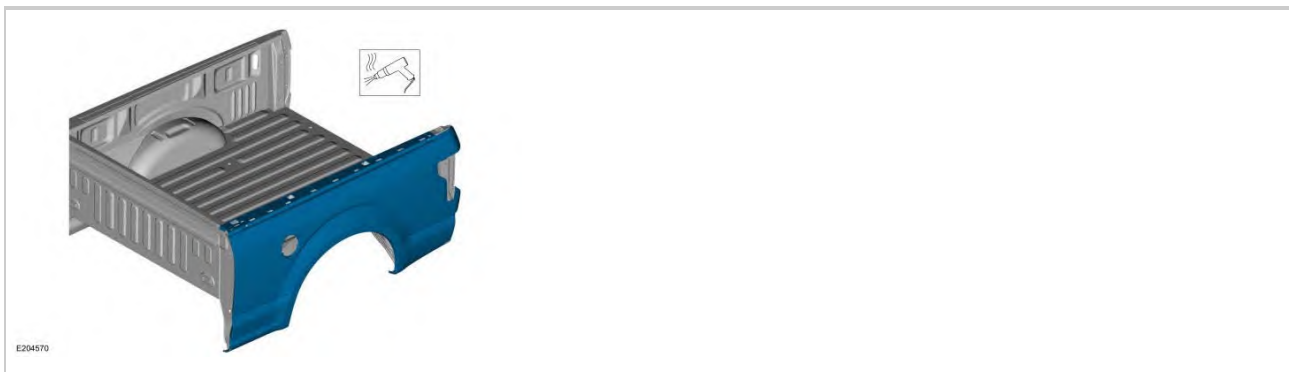




REMOVAL AND INSTALLATION > PICKUP BOX OUTER SIDE PANEL > INSTALLATION



NOTE: 6.5 foot pickup box shown in illustration, 5.5 foot and 8 foot pickup box similar.



NOTE: LH side shown in illustration, RH side does not include fuel fill.



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



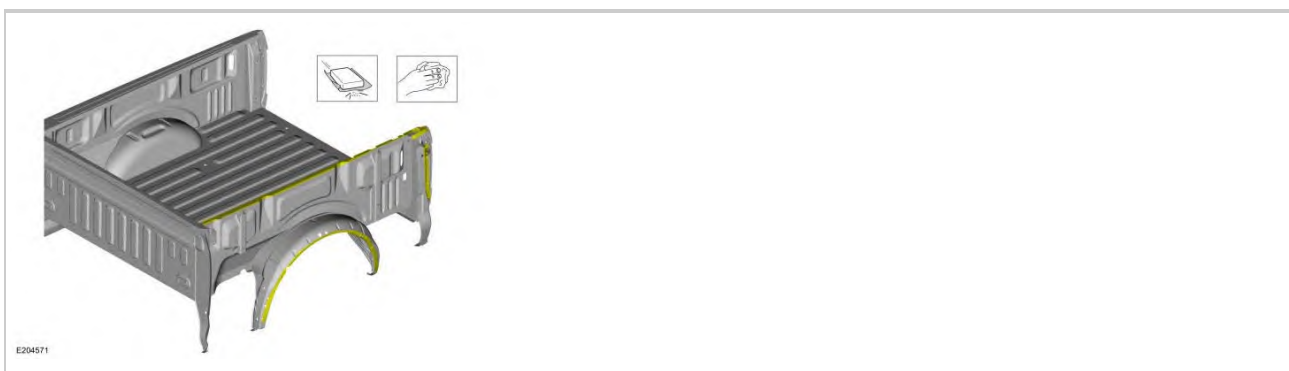
NOTE: Blind or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.



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 NVH sealer and clean.



2.

Sand using 80 grit sand paper to remove old adhesive and clean.



3.

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



4.

Install NVH pads.

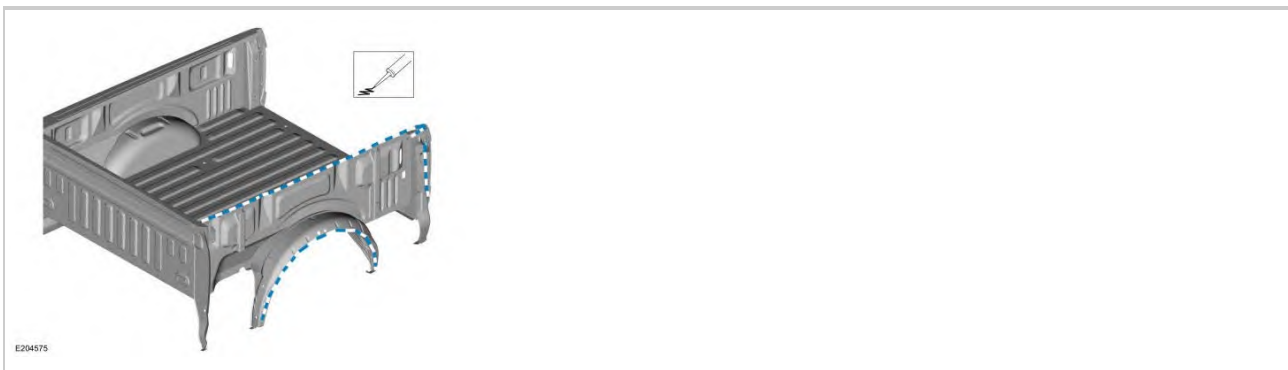


5.

Apply adhesive.

Material

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



6.

Apply adhesive.

Material

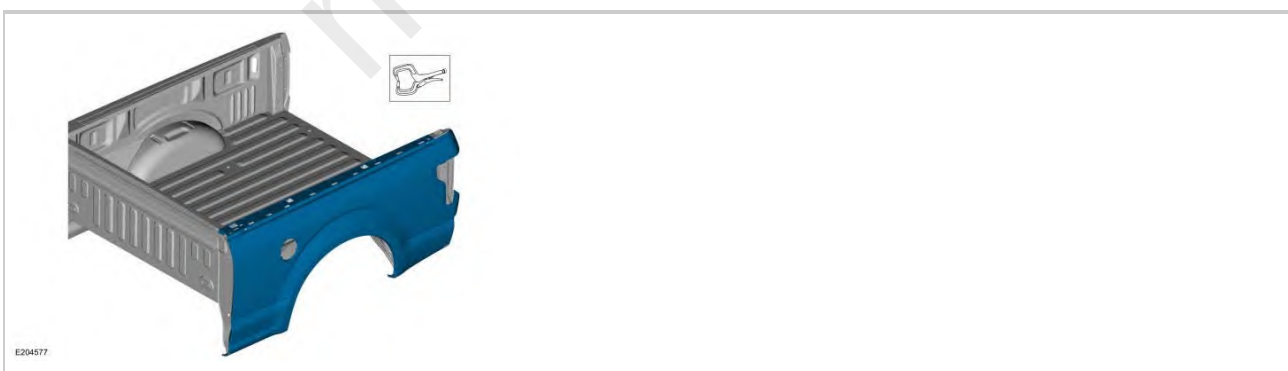
: Metal Bonding Adhesive / TA-1, 3M™ 08115, Fusor® 108B



7.

Install the replacement pickup box outer side panel and clamp in position.

Use the General Equipment: Locking Pliers



8.

 **NOTE:** Blind 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 blind rivet fastener installation.

Use the General Equipment: 6.5 mm Drill Bit



9.

 **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 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.

Install blind rivet fasteners. Refer to: Joining Techniques .

Use the General Equipment: Blind Rivet Gun



10.

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

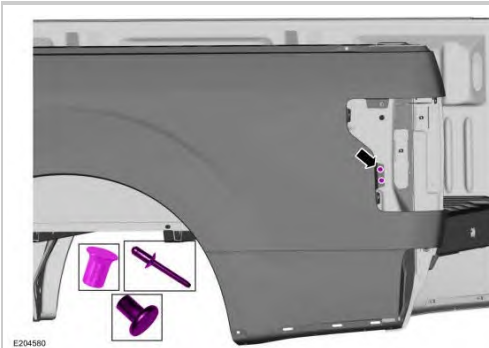


NOTE: Specific technical details including, but not limited to, fastener and adhesive information is included in the Instruction Sheet for each service part (found in the service part packaging). Instruction Sheets can also be found on the PTS (Professional Technician Society) located under the Service Tips tab for this vehicle.

Install fasteners. Refer to: Joining Techniques .

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Blind Rivet Gun



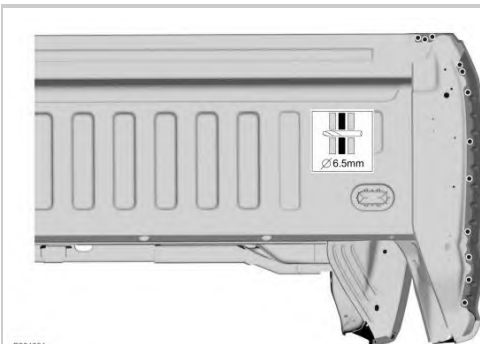
11.



NOTE: Blind 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 blind rivet fastener installation.

Use the General Equipment: 6.5 mm Drill Bit



12.

 **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 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.

Install blind rivet fasteners. Refer to: Joining Techniques .

Use the General Equipment: Blind Rivet Gun



13.

 **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 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.

Install fasteners. Refer to: Joining Techniques .

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Blind Rivet Gun



14.

 **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 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.

Install fasteners. Refer to: Joining Techniques .

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Blind Rivet Gun

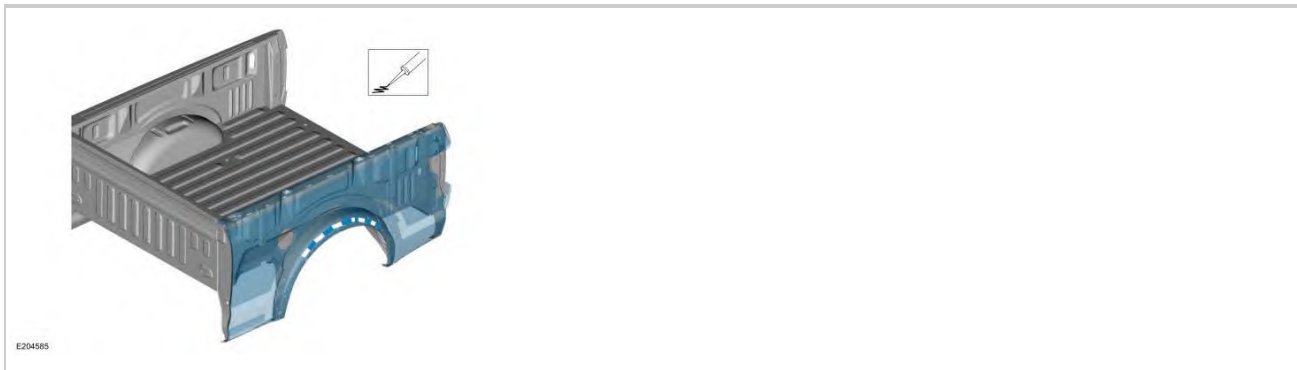


15.

Apply NVH foam in locations noted during removal.

Material

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



16.

Install the screw

Torque

: 177 lb.in (20 Nm)



17.

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

18.

Install the pickup bed. Refer to: Pickup Bed .

19.

LH side only: Install the fuel fill door and fuel fill cup. Refer to: Fuel Filler Door Assembly .

20.

Install the tail lamp assembly. Refer to: Rear Lamp Assembly .

21.