

Roof Front Frame

Special Tool(s) / General Equipment

6.5 mm Drill Bit
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Locking Pliers

Materials

Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B	-

Removal

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.

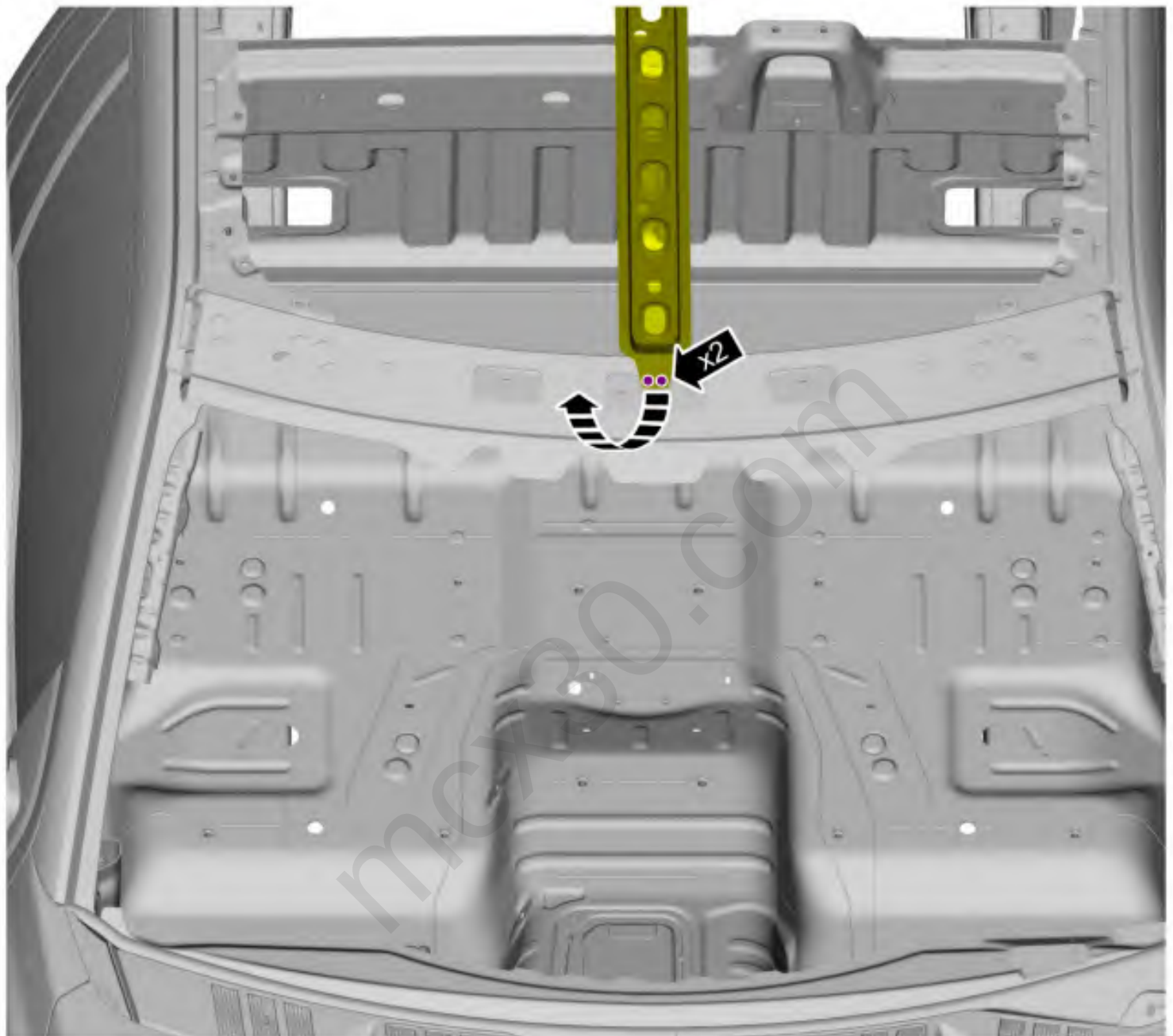
All vehicles

1. Remove the roof outer panel.
Refer to: [Roof Panel - Regular Cab](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).
Refer to: [Roof Panel - SuperCab](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).
Refer to: [Roof Panel - SuperCrew](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).
Refer to: [Roof Panel - SuperCab, Vehicles With: Roof Opening Panel](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).
Refer to: [Roof Panel - SuperCrew, Vehicles With: Roof Opening Panel](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).

Regular Cab

2. Remove the center reinforcement SPR fasteners and position aside.

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

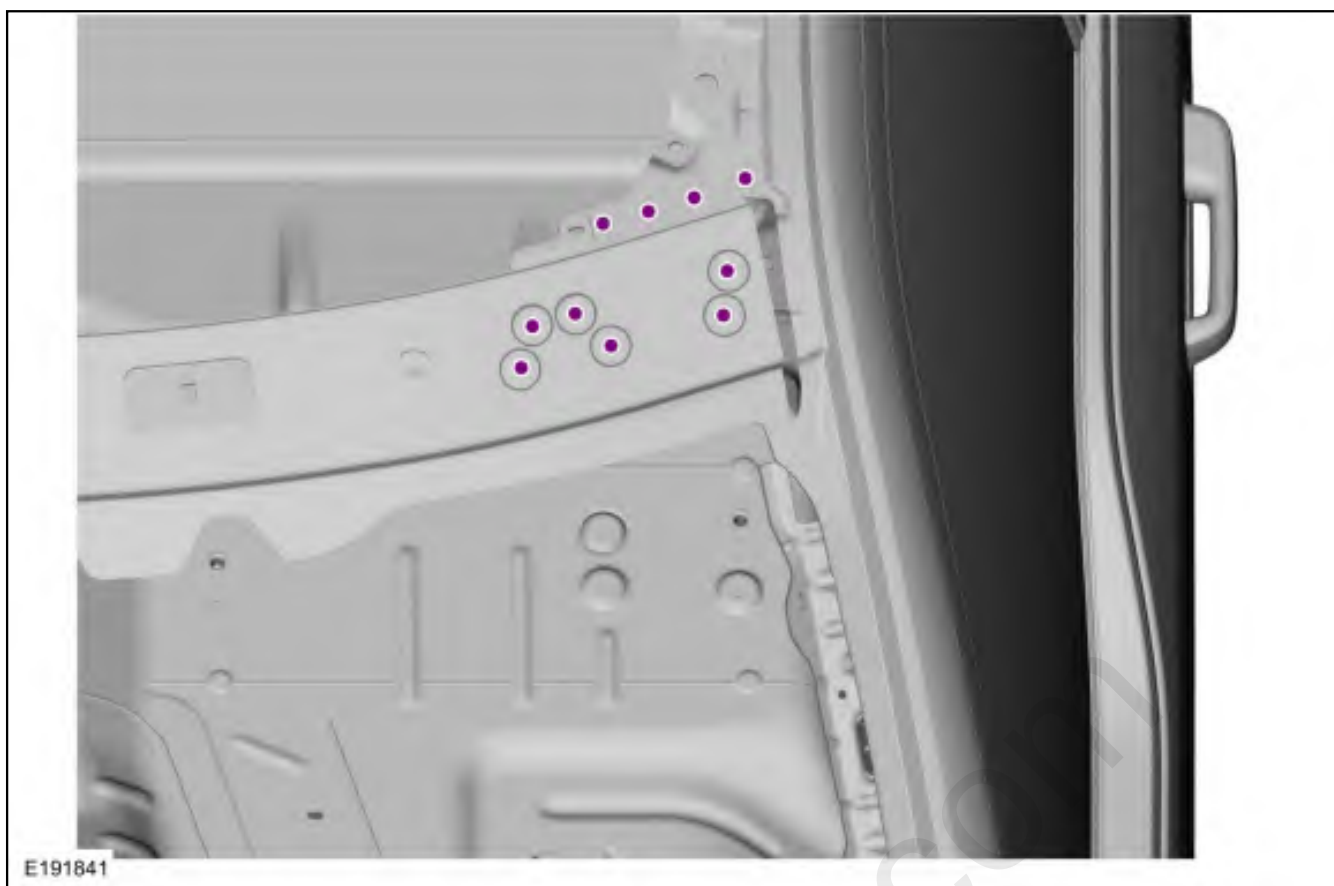


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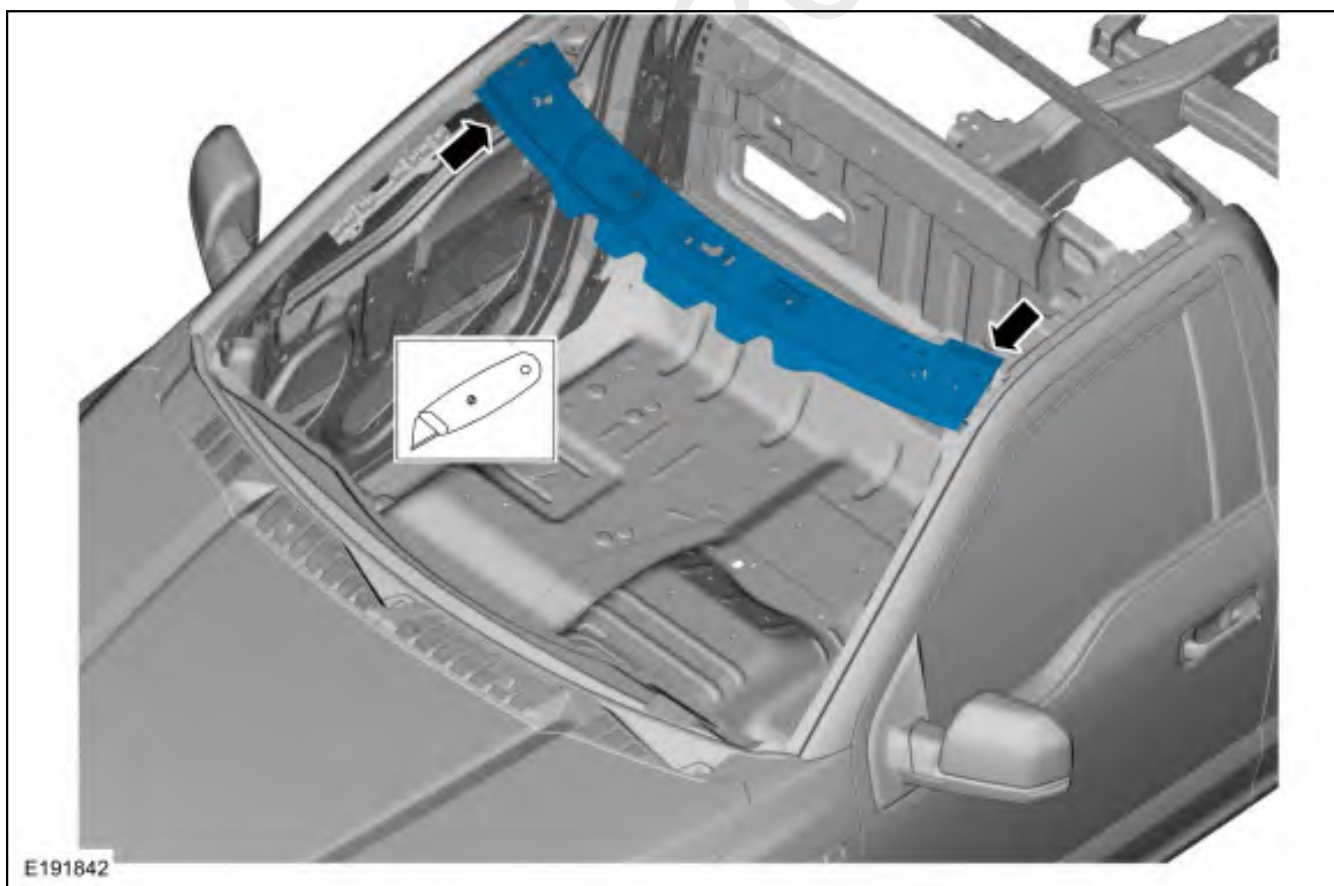


All vehicles

3. Remove the SPR fasteners (both sides).
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



4. Break the adhesive bond and remove the roof front frame.



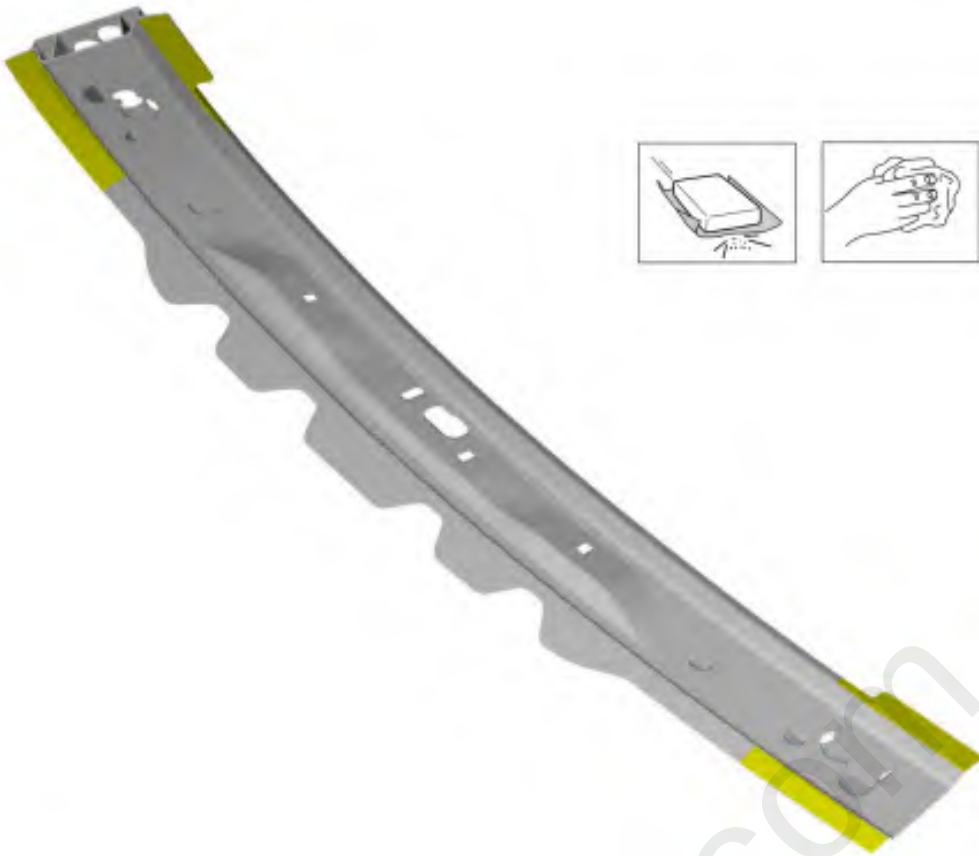
Installation

All vehicles

1. Sand using 80 grit sandpaper to remove all remaining adhesive and clean.



2. Sand the roof front frame using 80 grit sandpaper to remove e-coat and clean.

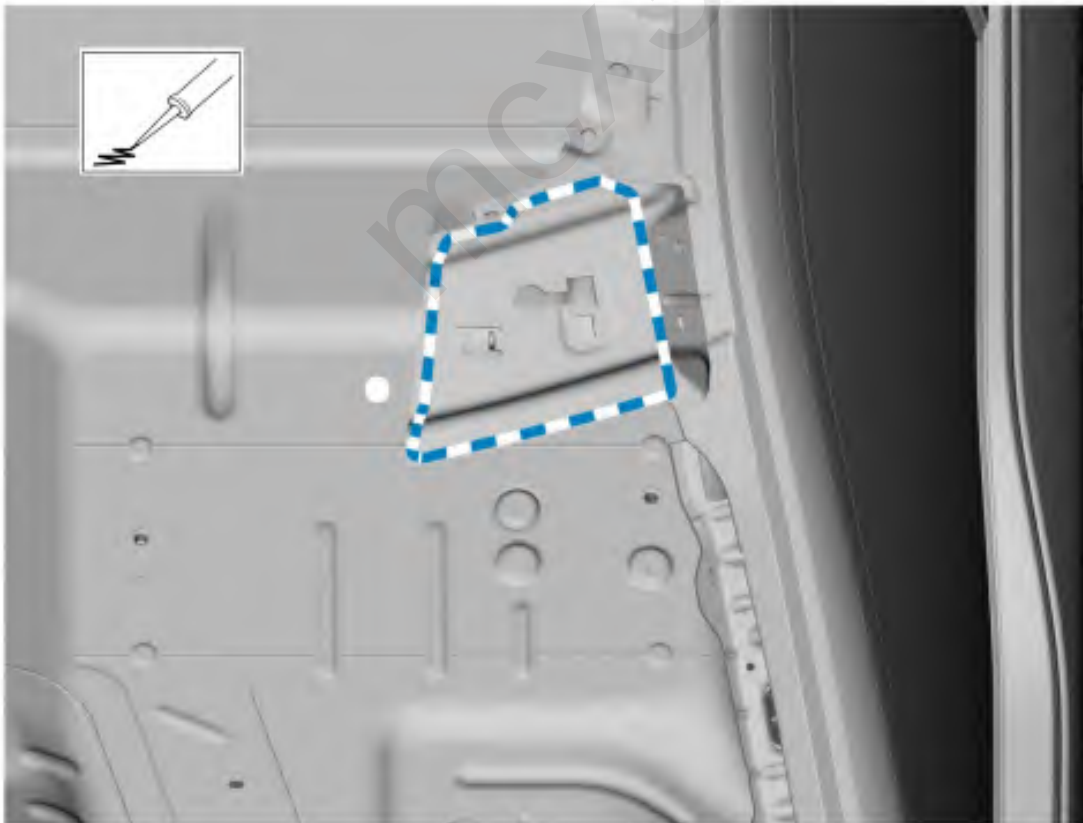


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3. Apply adhesive (both sides).

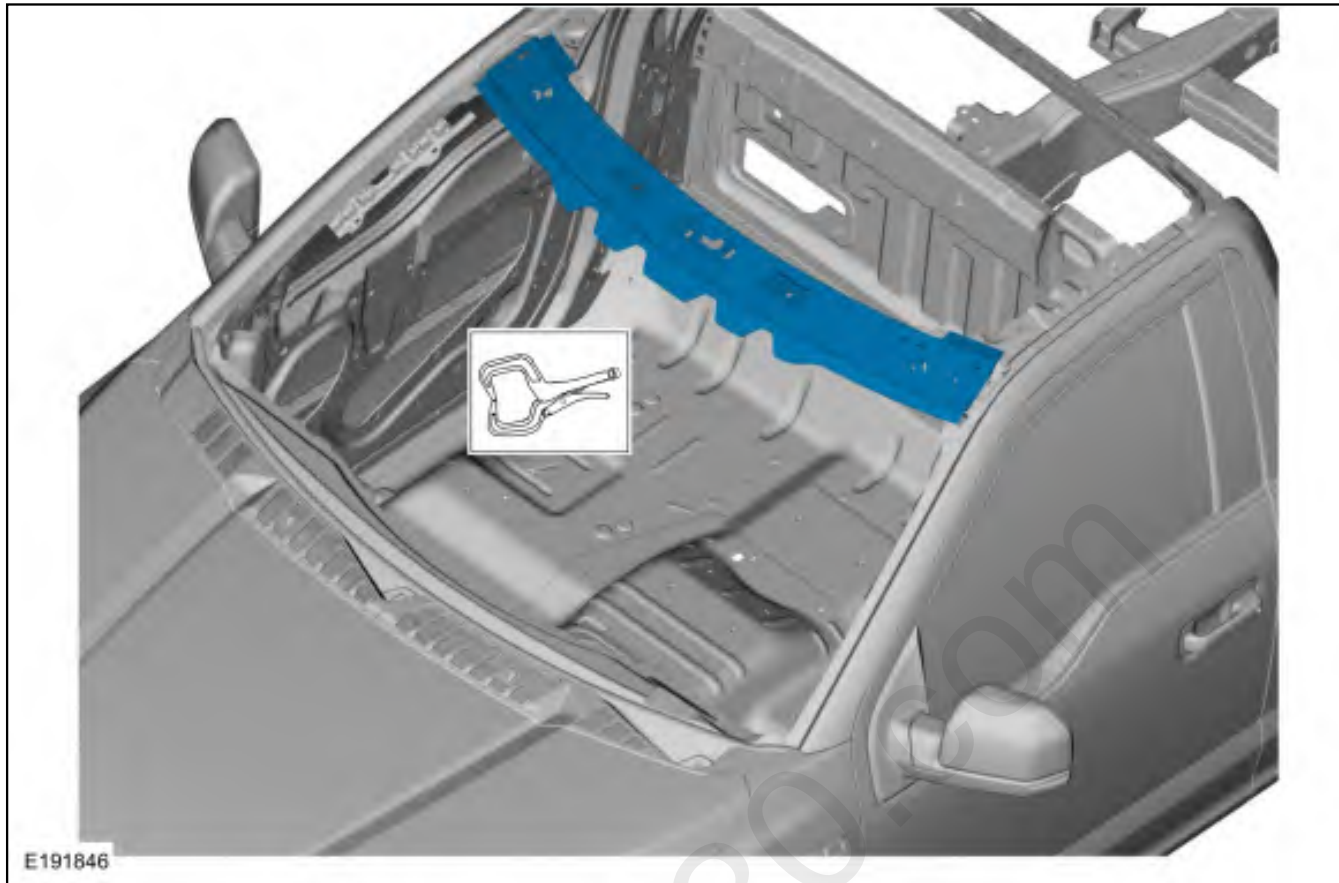
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B



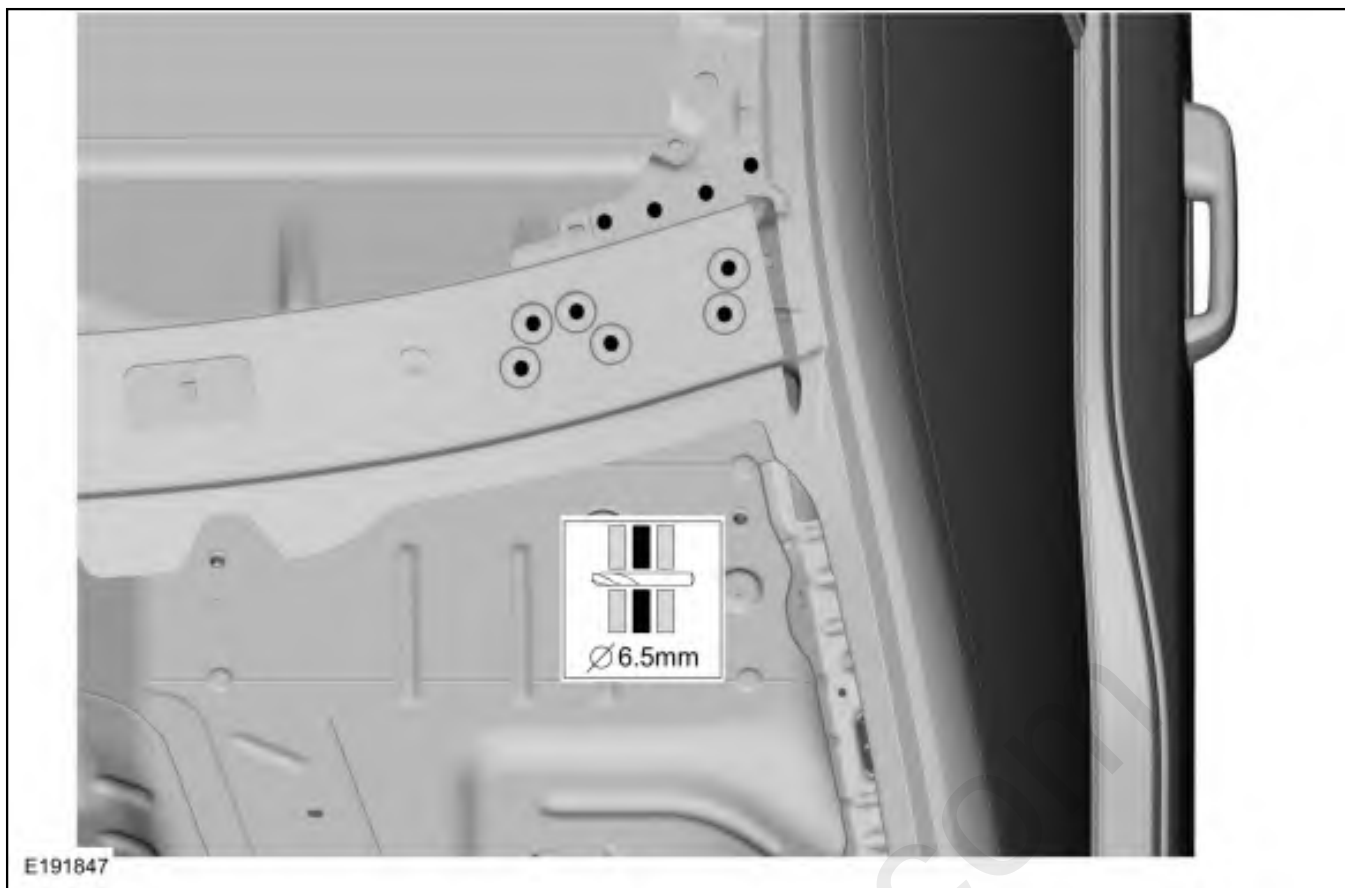
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4. Install and clamp the roof front frame.
Use the General Equipment: Locking Pliers



5. Drill blind fastener holes as indicated (both sides).
Use the General Equipment: 6.5 mm Drill Bit



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

NOTE: Solid or blind rivets may be used in place of SPR fasteners in the original SPR location after enlarging hole to 6.5 mm.

Install fasteners (both sides).

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W710246-S900	BN	DP10-200/H	SA-0400/SA-0402	-	W790377-S900	-
2	-	-	-	-	W708777-S900C	-	-

Use the General Equipment: Blind Rivet Gun



Regular Cab

7. **NOTE:** Blind rivets may be used in place of SPR fasteners in the original SPR location after enlarging hole to 6.5 mm.

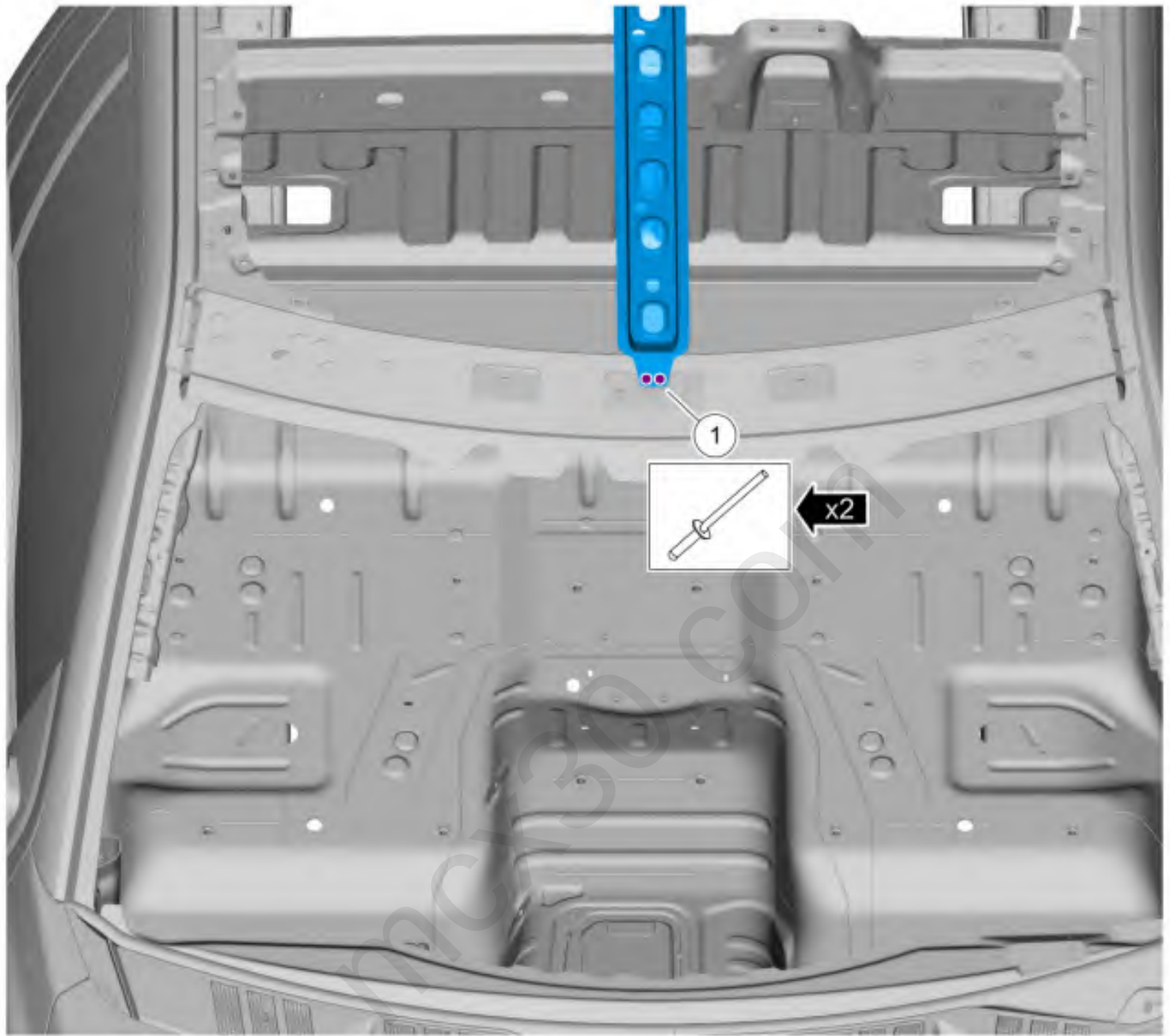
Reposition the center reinforcement and install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	-	-

Refer to: [Joining Techniques](#) (501-25 Body Repairs - General Information, General Procedures).

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

Use the General Equipment: Blind Rivet Gun



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All vehicles

8. Install the roof outer panel.

Refer to: [Roof Panel - Regular Cab](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).

Refer to: [Roof Panel - SuperCab](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).

Refer to: [Roof Panel - SuperCrew](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).

Refer to: [Roof Panel - SuperCab, Vehicles With: Roof Opening Panel](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).

Refer to: [Roof Panel - SuperCrew, Vehicles With: Roof Opening Panel](#) (501-28 Roof Sheet Metal Repairs,

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