

Roof Reinforcement - SuperCrew

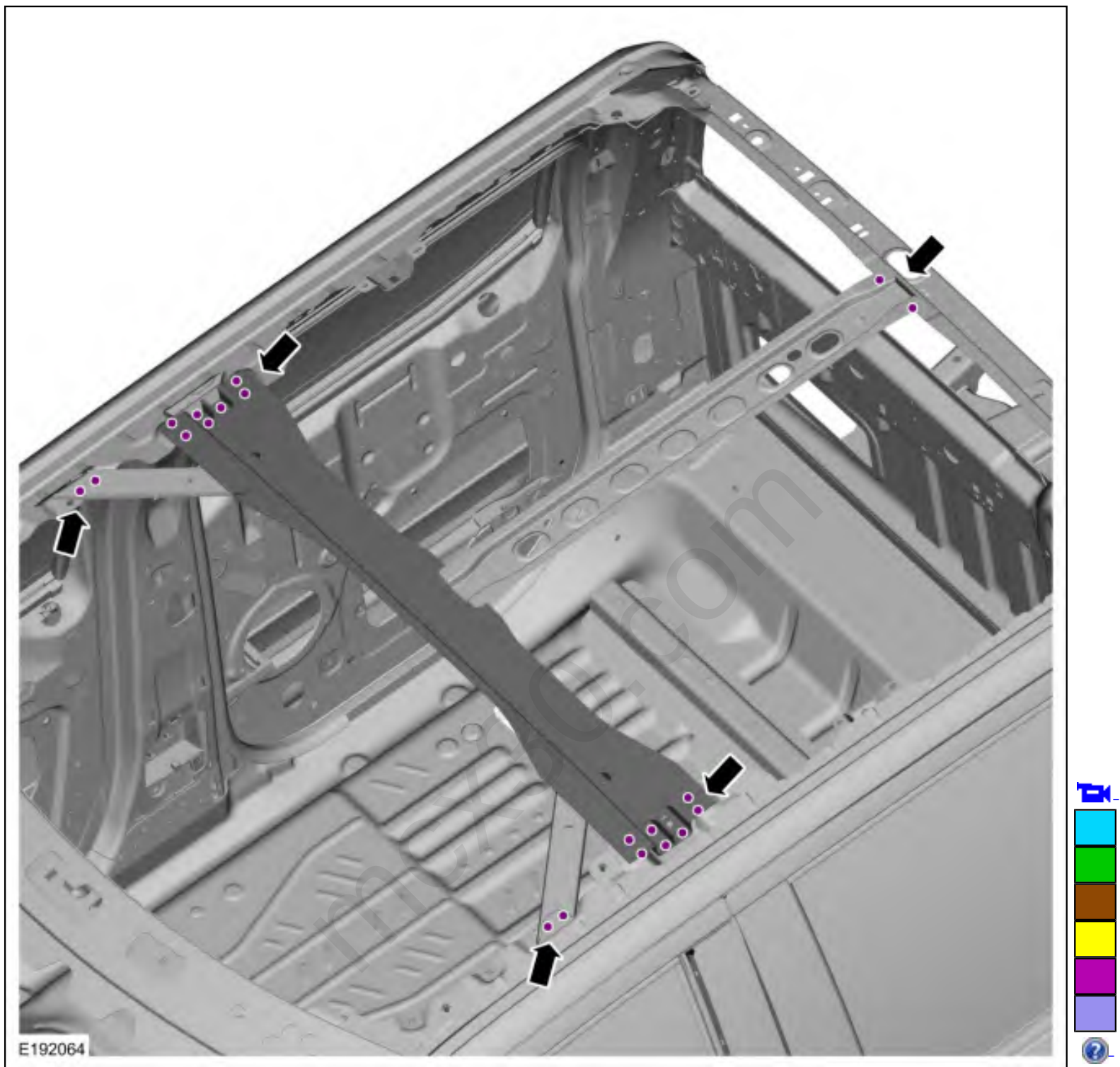
Special Tool(s) / General Equipment

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

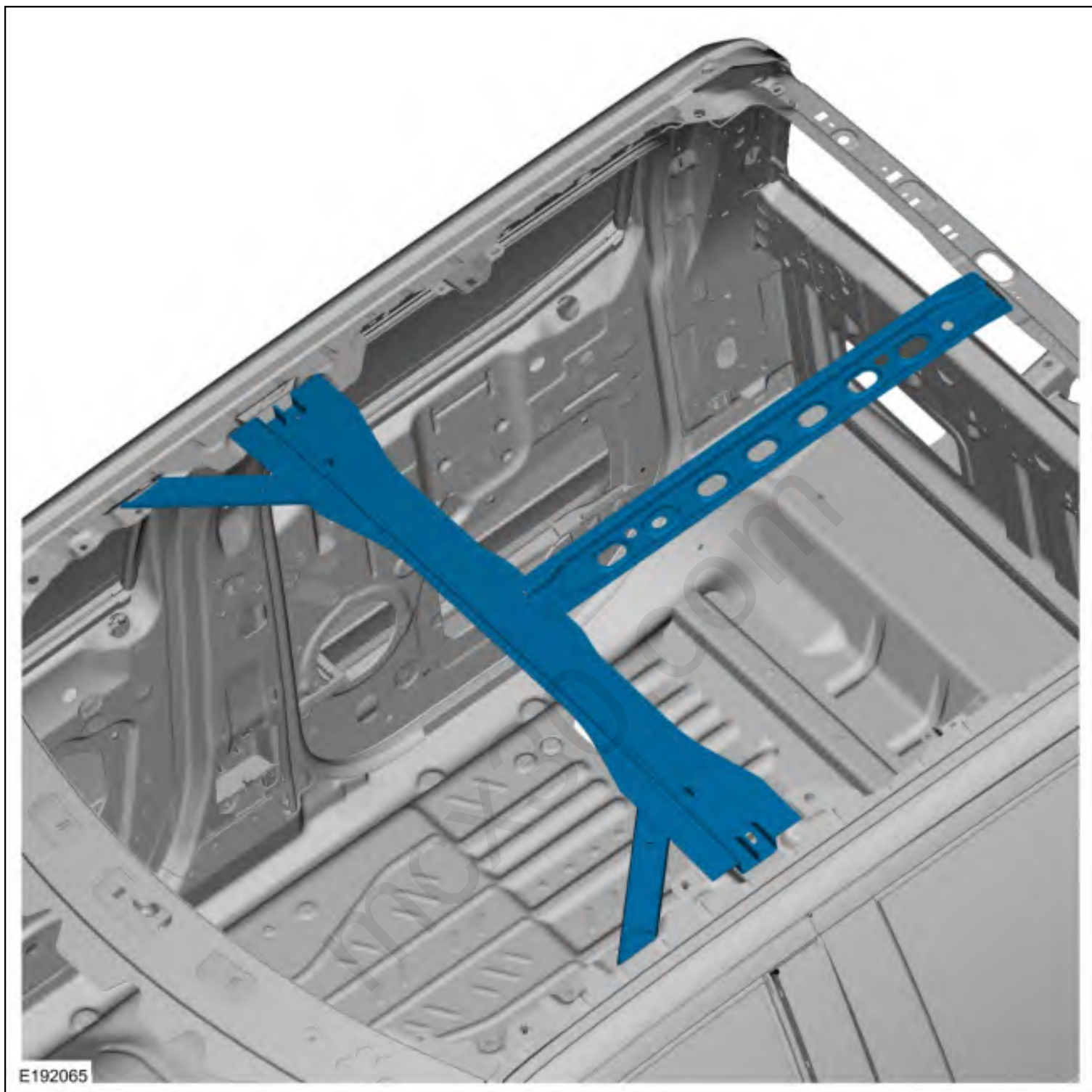
Removal

NOTE: Roof reinforcements are provided as 4 service parts (roof reinforcement, center reinforcement and K-braces), the following procedure assumes all components are to be replaced.

1. Remove the roof outer panel.
Refer to: [Roof Panel - SuperCrew](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).
2. Remove the SPR fasteners as indicated.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



3. Remove the roof reinforcement.

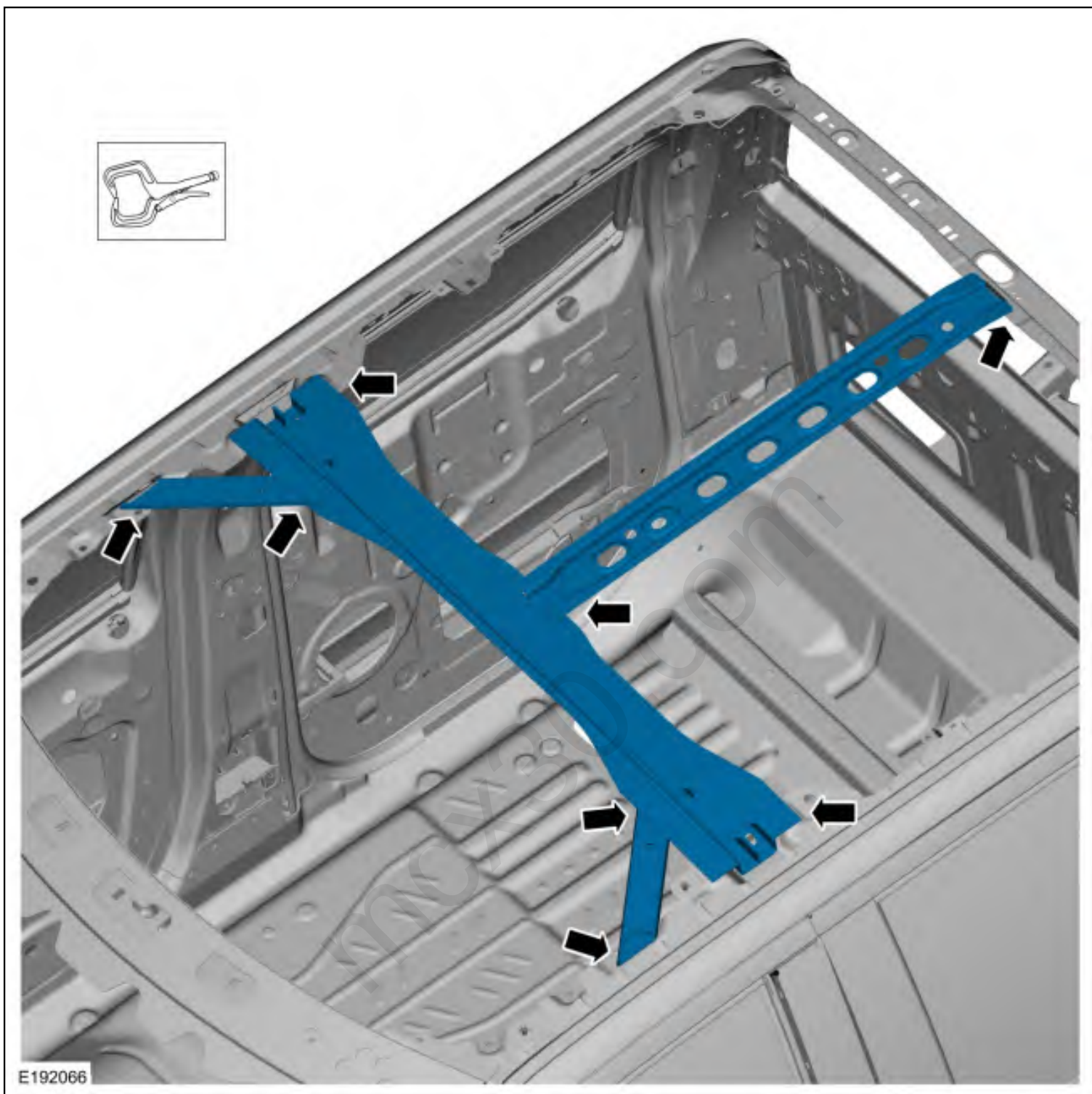


Installation

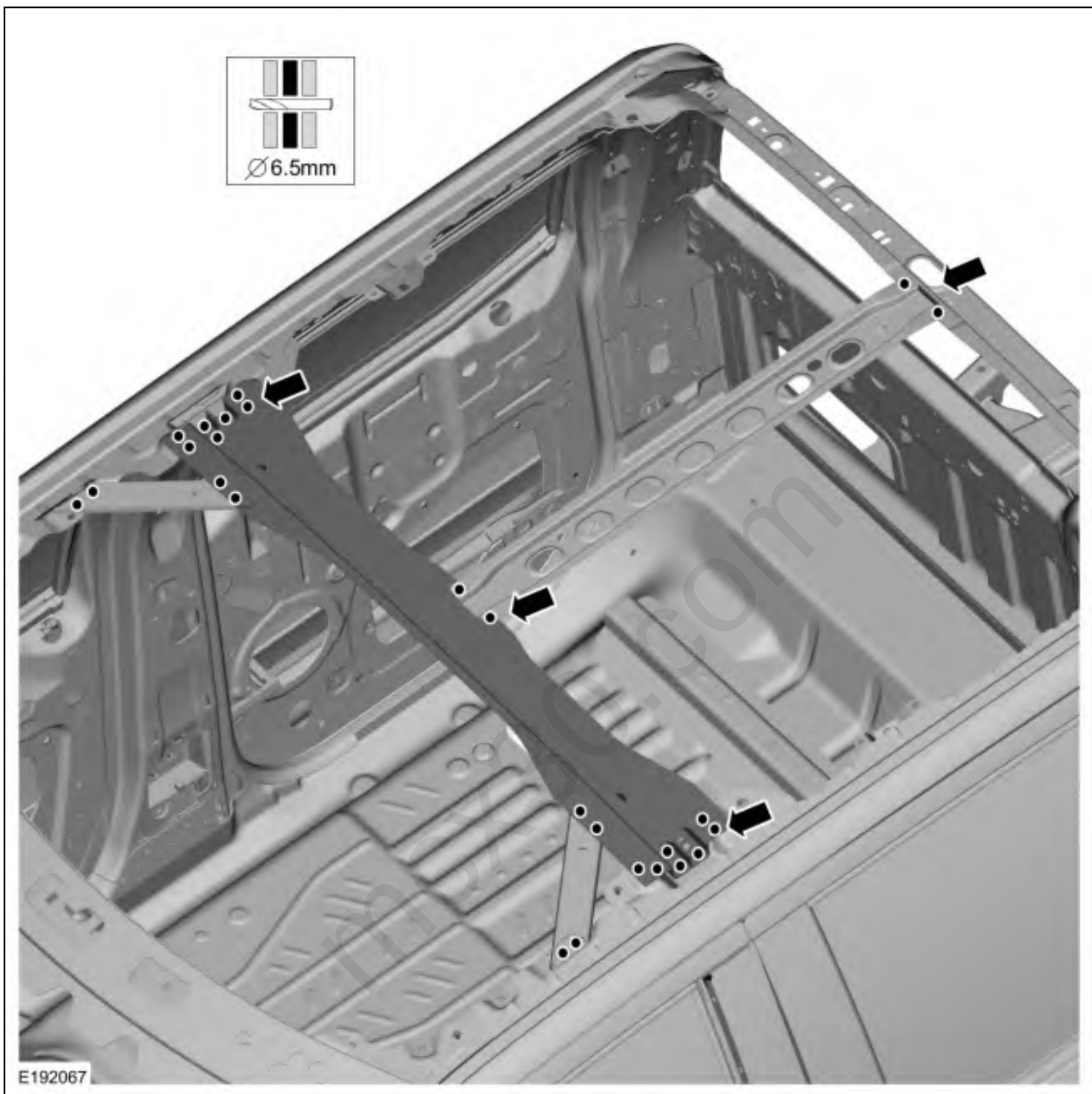
NOTE: *SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.*

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

1. Install the roof reinforcement and clamp in position.
Use the General Equipment: Locking Pliers



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



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

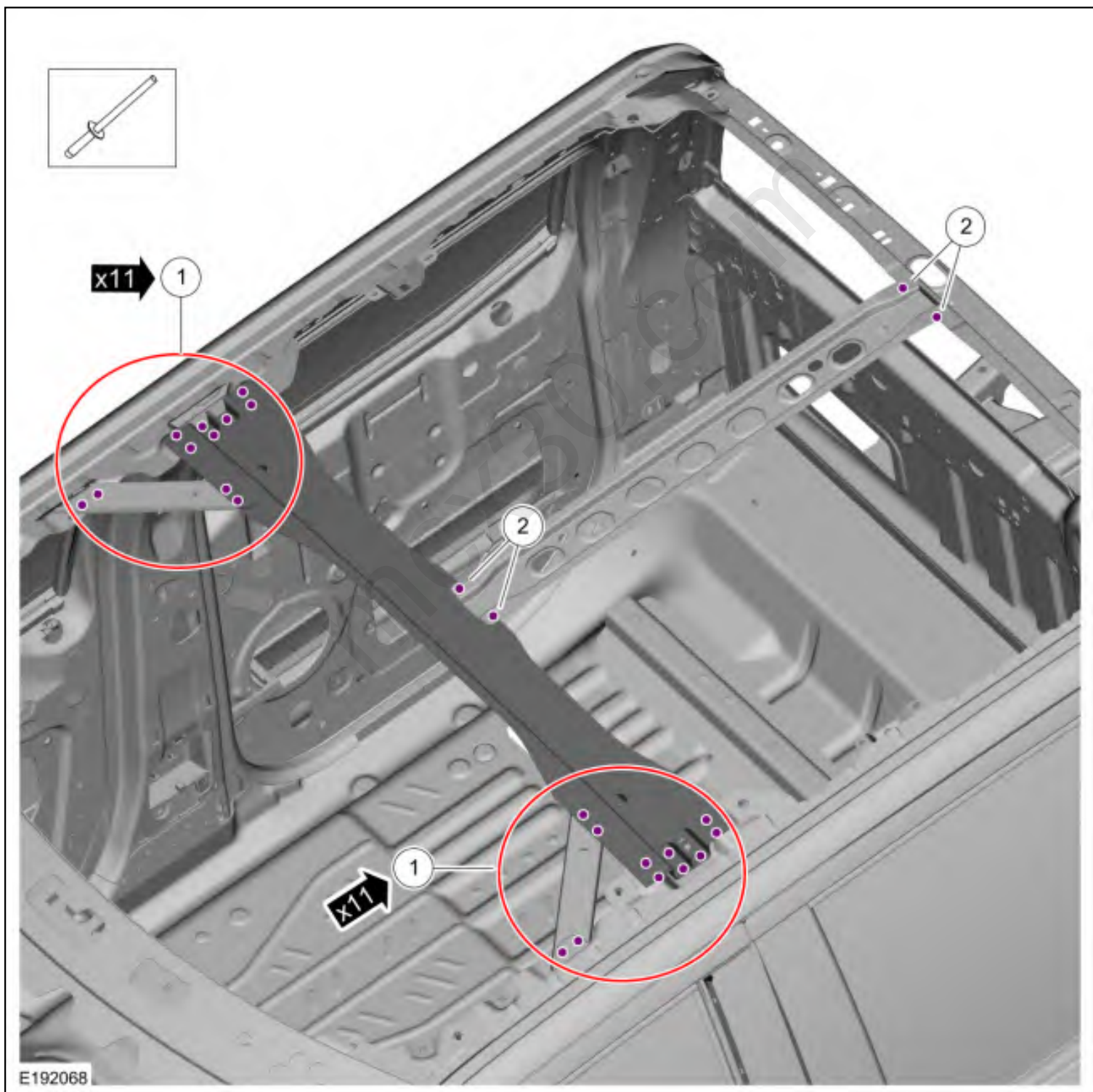
NOTE: Solid rivets or blind fasteners may be used in place of SPR fasteners after enlarging the existing hole to 6.5 mm.

Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W707638-S900C	-	-

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

Use the General Equipment: Blind Rivet Gun



4. Install the roof outer panel.

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

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