

A-Pillar Outer Panel Section and Reinforcement

Special Tool(s) / General Equipment

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

Materials

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

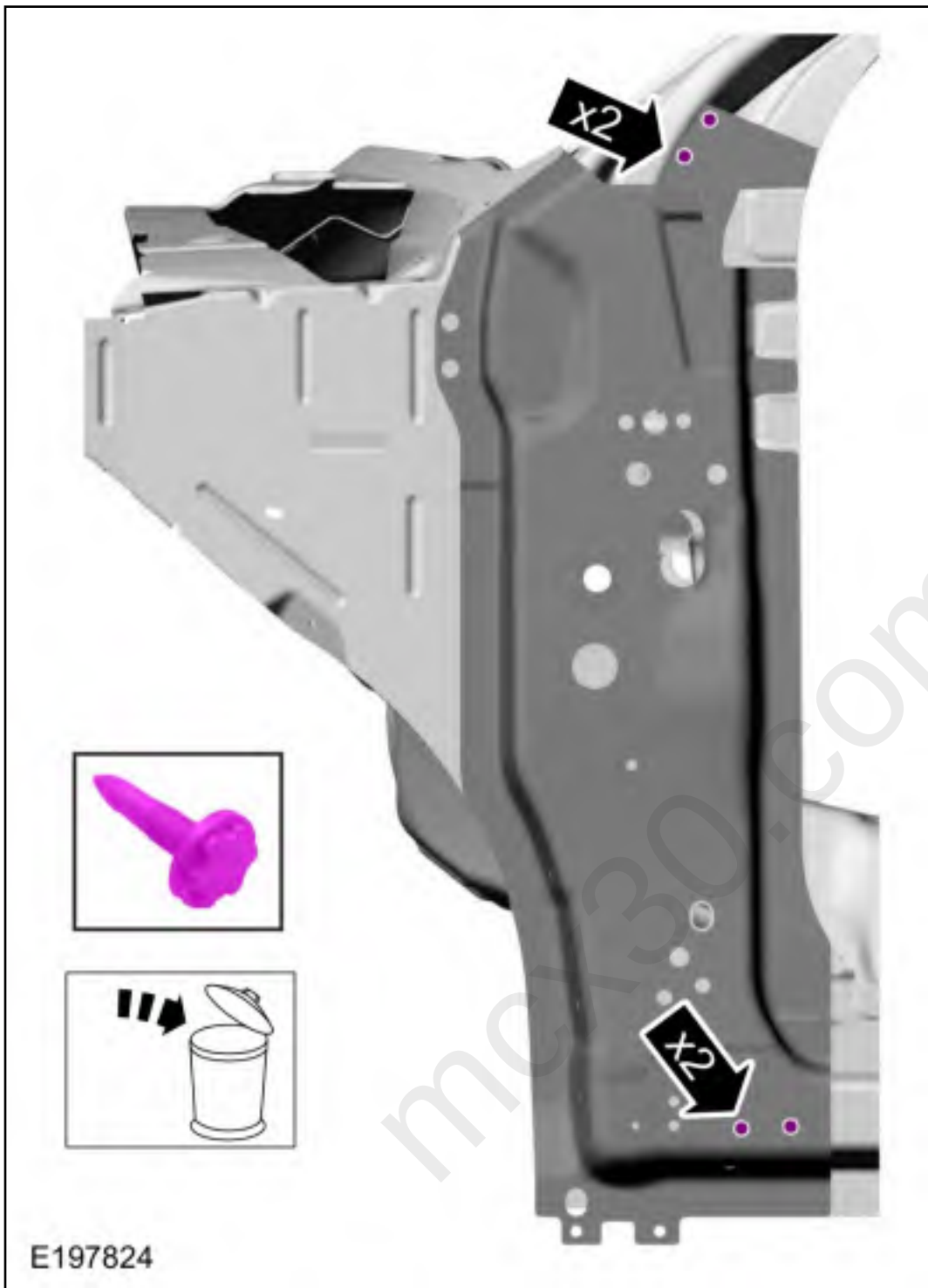
Removal

1. Make sure the vehicle is dimensionally correct.
Refer to: [Body and Frame](#) (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).
2. Remove A-pillar outer panel.
Refer to: [A-Pillar Outer Panel](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
3. Remove the fender apron panel.
Refer to: [Fender Apron Panel Reinforcement](#) (501-27 Front End Sheet Metal Repairs, Removal and Installation).

4. Remove the reinforcement pad.



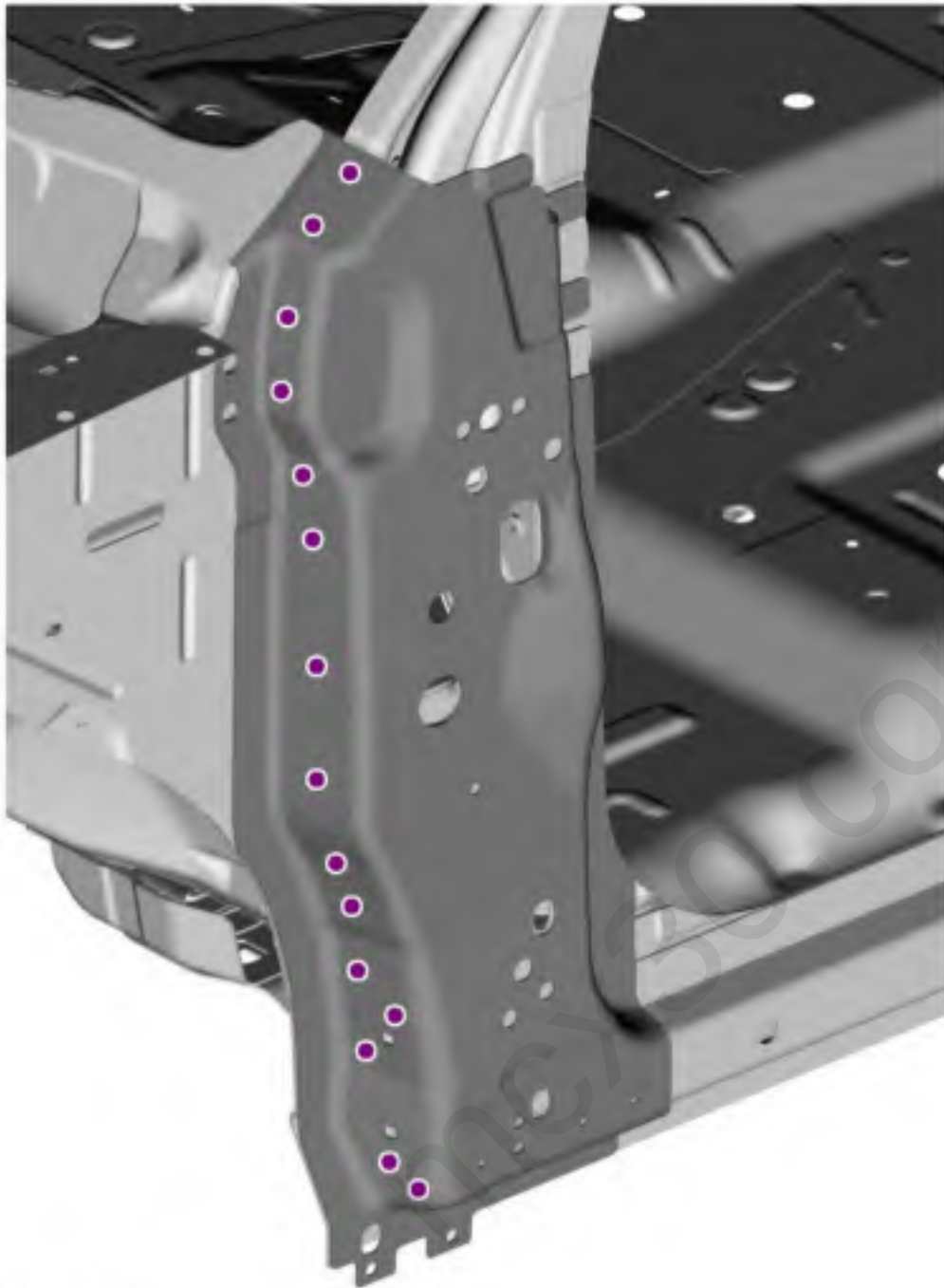
5. Remove and discard the FDS fasteners.
Use the General Equipment: Polydrive Bit Socket



6. Remove the SPR fasteners from the side of the reinforcement.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



7. Remove the SPR fasteners from the front edge of the reinforcement.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander

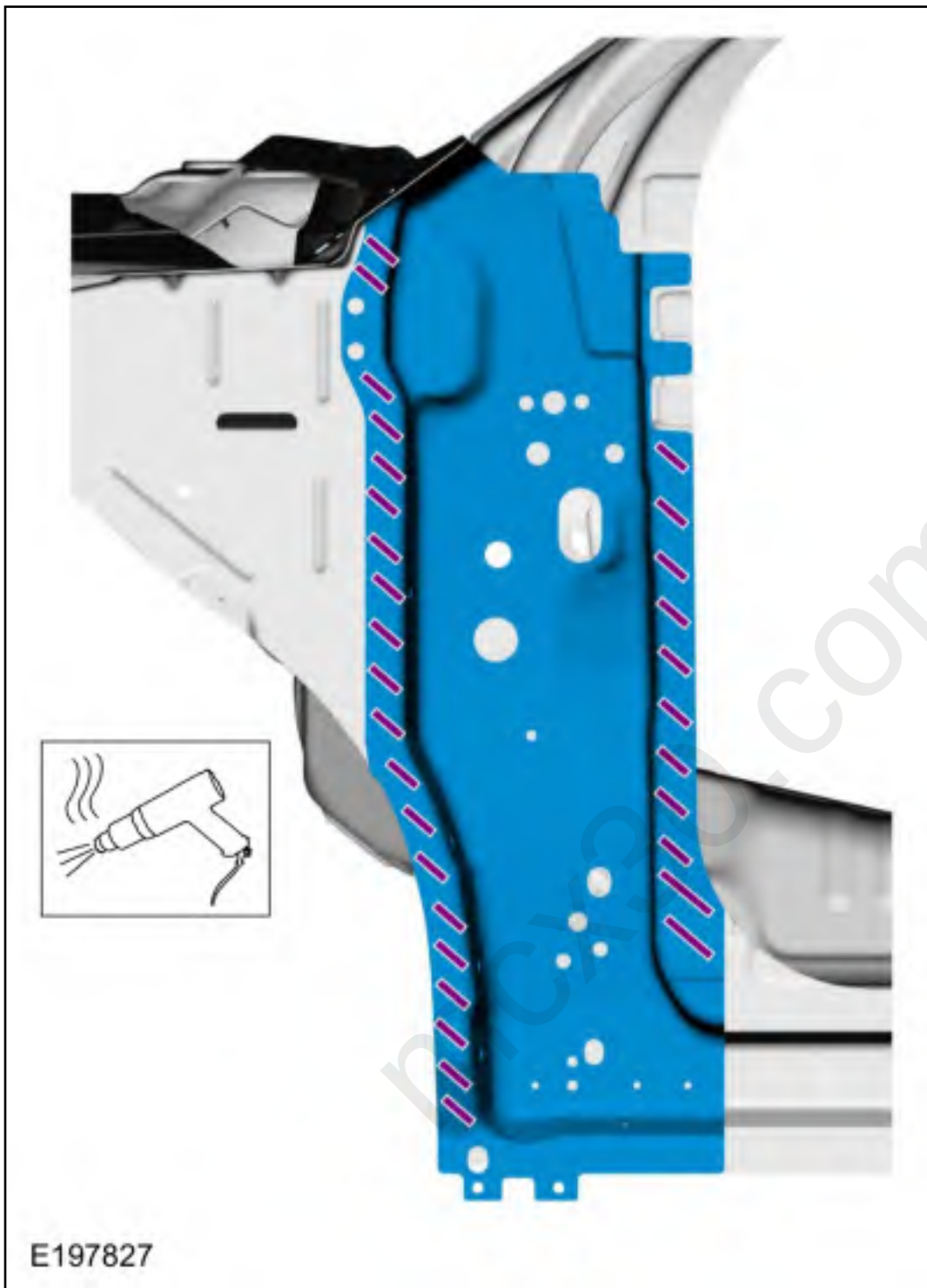


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8. **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated 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 A-pillar reinforcement.
Use the General Equipment: Hot Air Gun

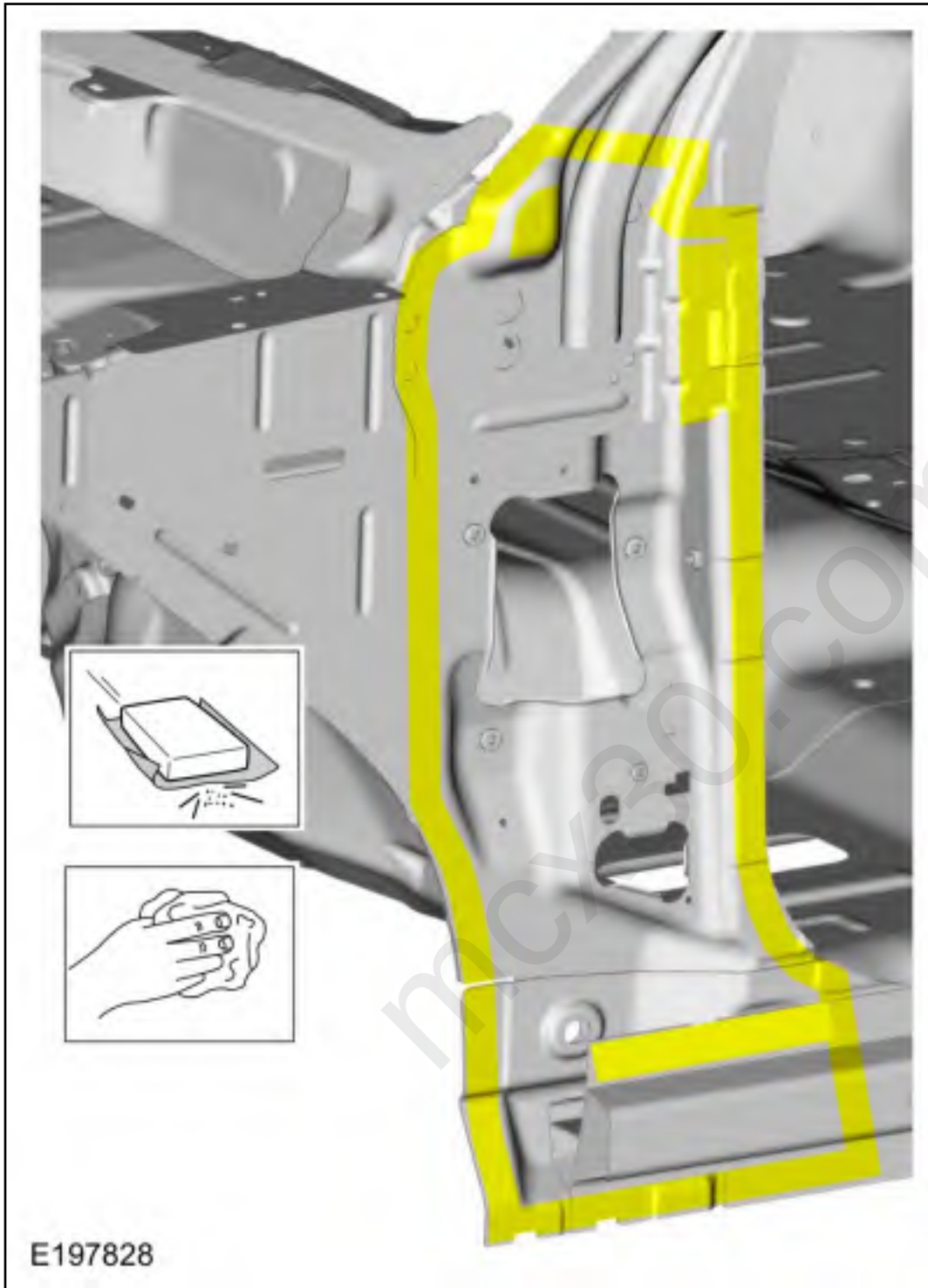


Installation

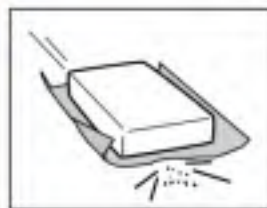
NOTE: Do not install SPR fasteners directly in old SPR fastener location. SPR fasteners must be installed adjacent to the original location matching original quantity.

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

1. Sand with 80 grit sand paper to remove the old adhesive from the body side and clean.



2. Sand with 80 grit sand paper to remove the e-coat from the reinforcement and clean.

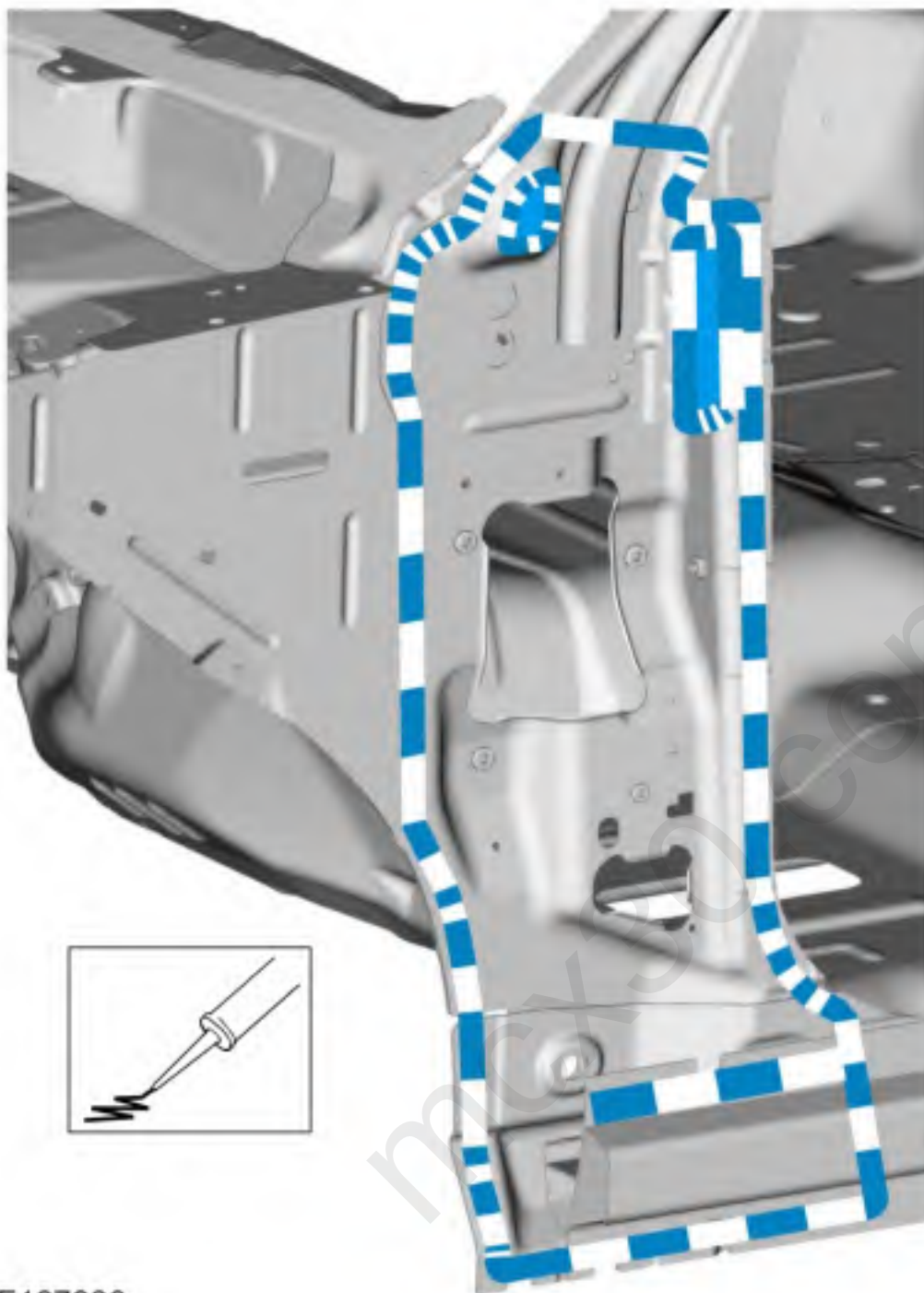


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3. Apply adhesive.

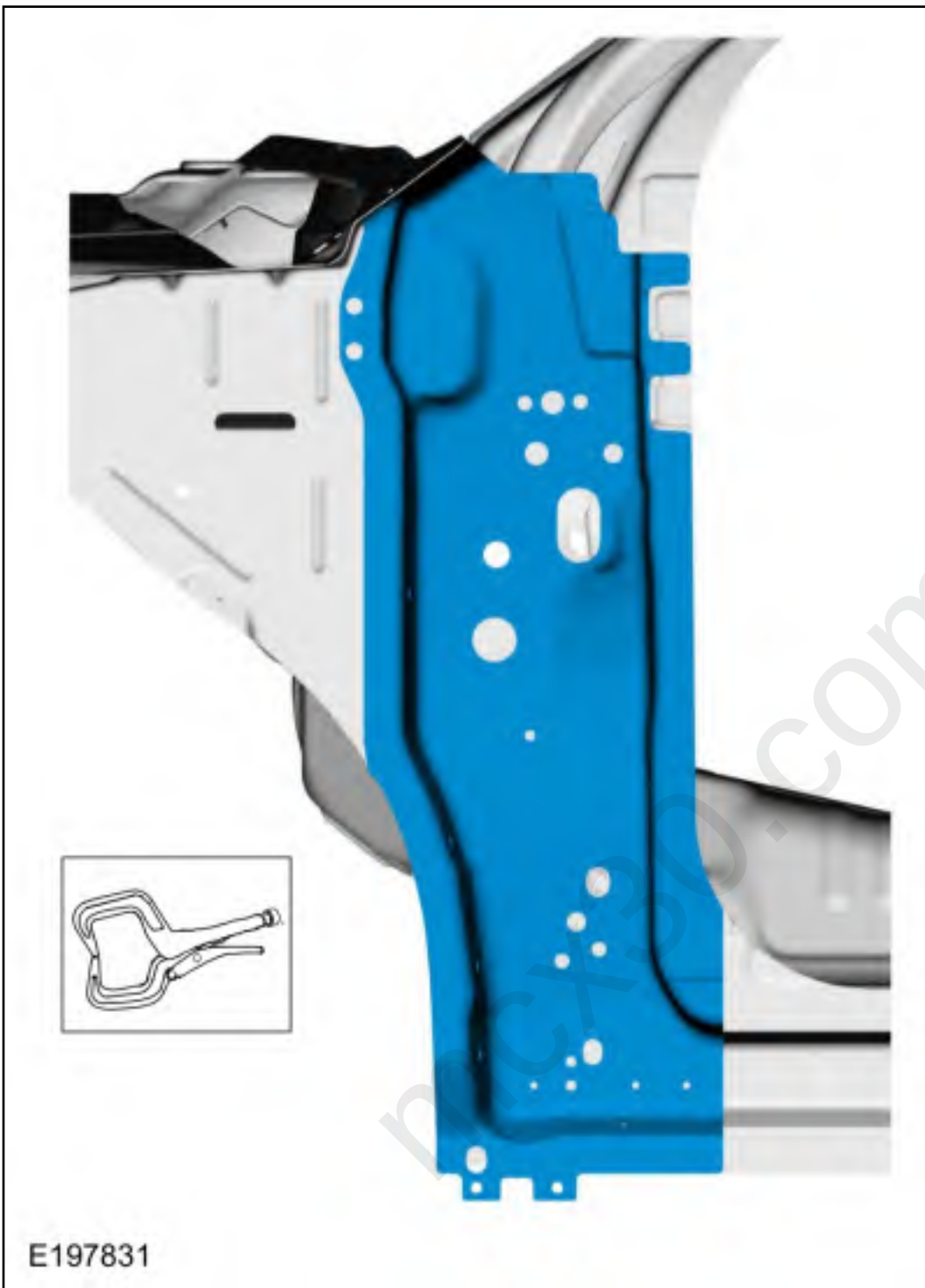
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B



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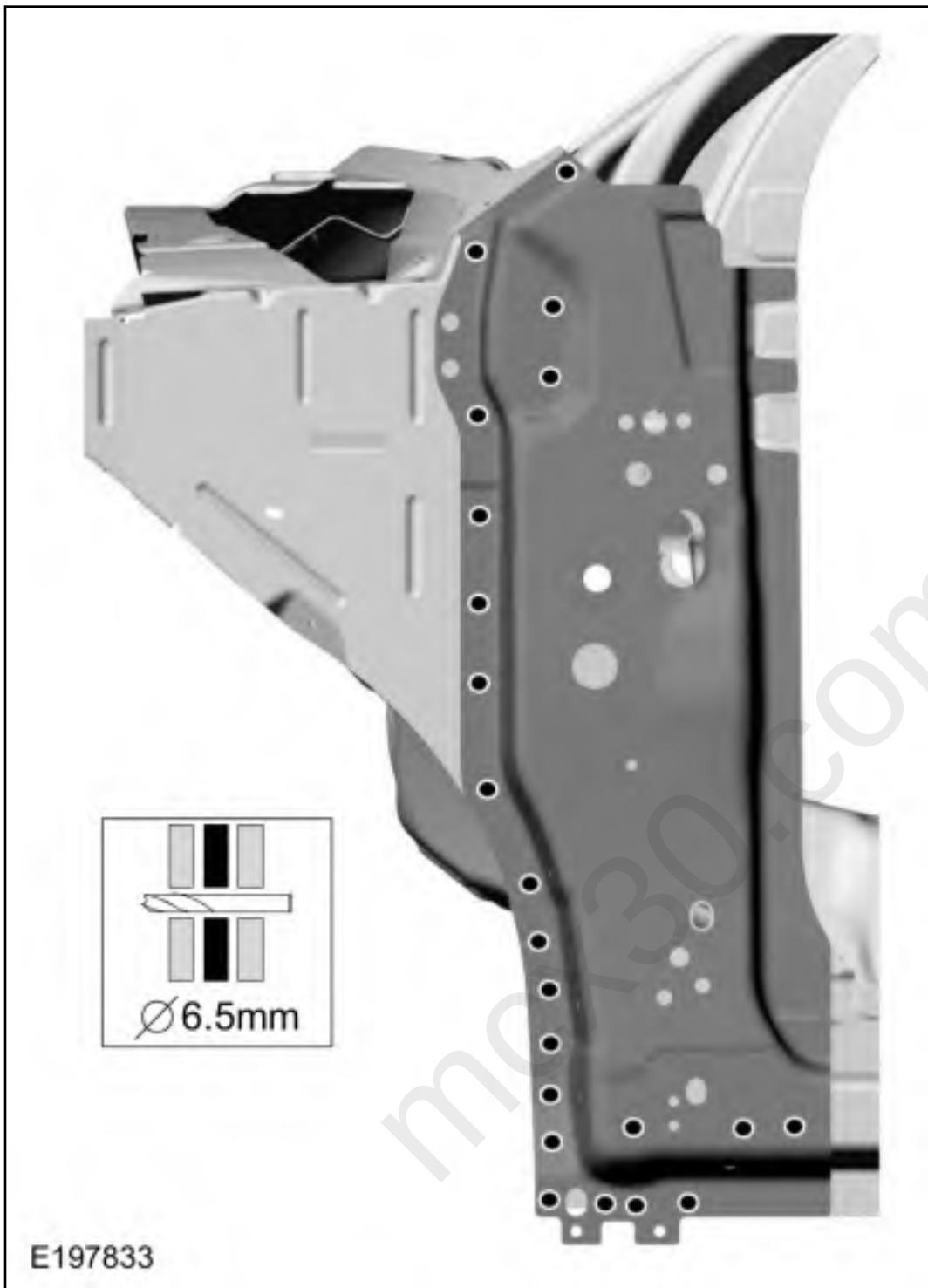


4. Install and clamp the reinforcement.
Use the General Equipment: Locking Pliers



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

Drill 6.5 mm holes in the reinforcement for blind rivet fasteners.
Use the General Equipment: 6.5 mm Drill Bit



6. **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.

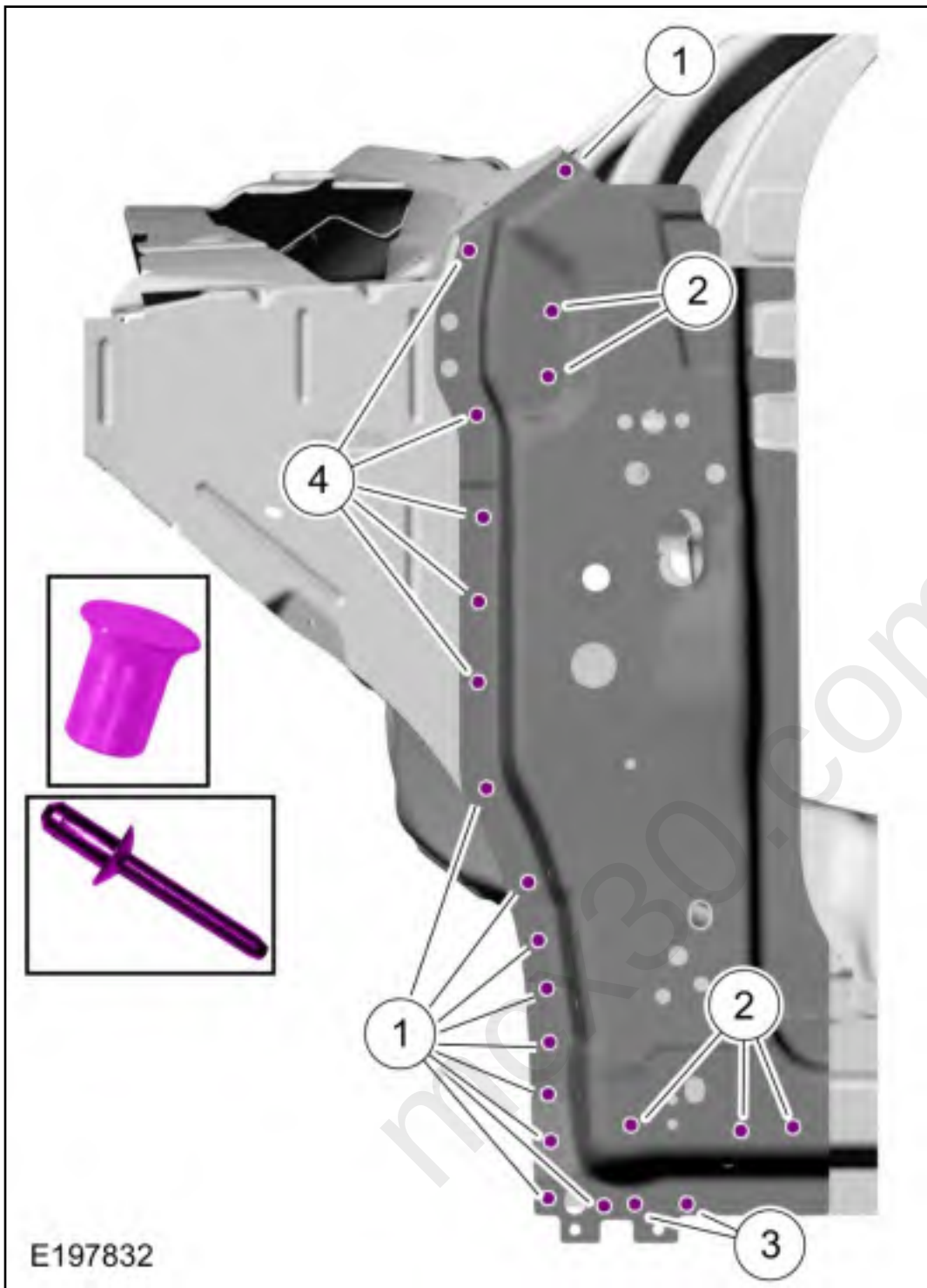
Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W717182-S900	QC	DP10-200/H	SA-0400/SA-0402	W708777-S900C	-	-
2	-	-	-	-	W708777-S900C	-	-
3	W717185-S900	EL	DP11-200/H	SA-0400/SA-0402	W708777-S900C	-	-
4	-	-	-	-	W70251-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



7. Install the reinforcement pad.



8. Install the fender apron panel.
Refer to: [Fender Apron Panel Reinforcement](#) (501-27 Front End Sheet Metal Repairs, Removal and Installation).
9. Install the A-pillar outer panel.
Refer to: [A-Pillar Outer Panel](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

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