

Rocker Panel Inner Reinforcement - Regular Cab

Special Tool(s) / General Equipment

6.5 mm Drill Bit
Scraper for Straight Edges
Spherical Cutter
Polydrive Bit Socket
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Hot Air Gun
Air Body Saw
MIG/MAG Welding Equipment
Locking Pliers

Materials

Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B	-
Seam Sealer TA-2-B, 3M™ 08308, LORD Fusor® 805DTM	-
Roof Ditch Sealer 3M™ 08307, LORD Fusor® 122EZ	-
Flexible Foam Repair 3M™ 08463, LORD Fusor® 121	-

Removal

NOTICE: Body side sectioning is prohibited within 50 mm of door hinge, door striker and restraints anchoring points.

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.*

NOTE: *The rear portion of the rocker panel reinforcement on the Regular Cab may be sectioned with the use of a backer plate, adhesive and rivets. The following assumes full component replacement.*

NOTE: *Pay particular attention to NVH baffle and foam locations to aid in installation.*

1. Depower the SRS.

Refer to: [Supplemental Restraint System \(SRS\) Depowering](#) (501-20B Supplemental Restraint System, General Procedures).

2. Remove the outer body trim.

Refer to: [Bodyside Moulding](#) (501-08 Exterior Trim and Ornamentation, Removal and Installation).

Refer to: [Rear Quarter Panel Moulding](#) (501-08 Exterior Trim and Ornamentation, Removal and Installation).

Refer to: [Roof Moulding](#) (501-08 Exterior Trim and Ornamentation, Removal and Installation).

3. Remove the pickup box.

Refer to: [Pickup Bed](#) (501-04 Pickup Bed and Platform Body, Removal and Installation).

4. Remove the A-pillar reinforcement.

Refer to: [A-Pillar Outer Panel Section and Reinforcement](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

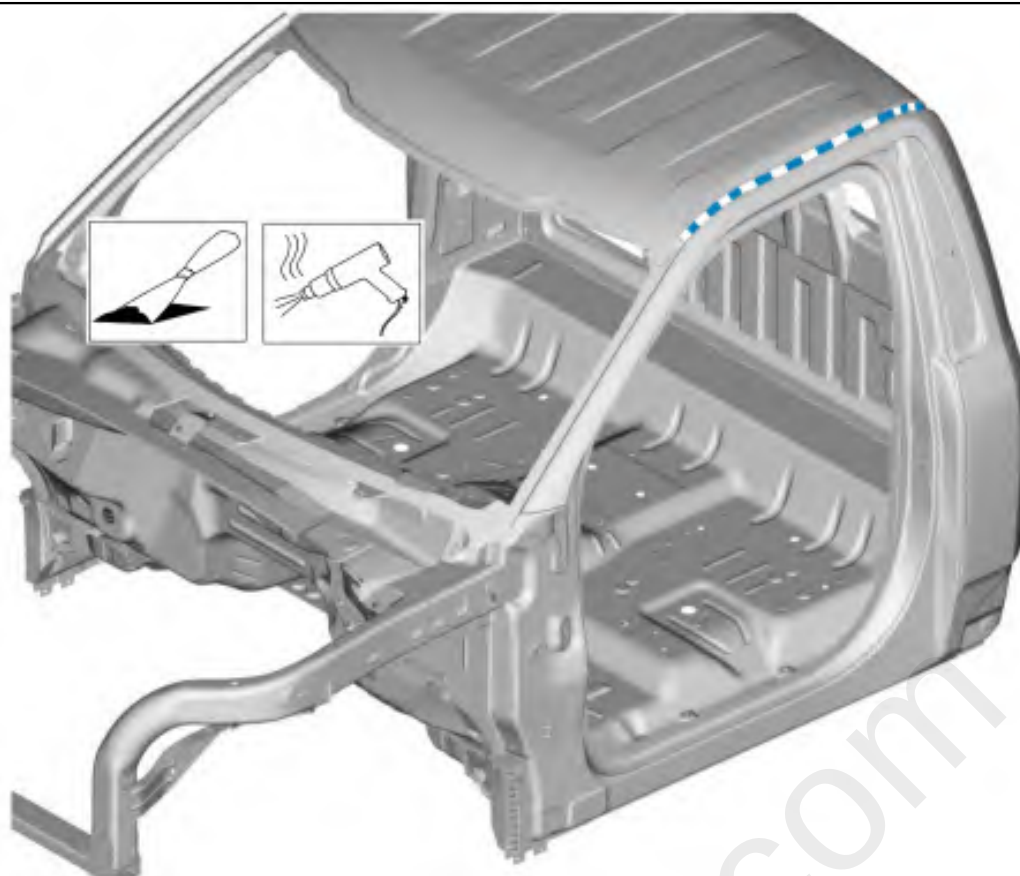
5. Remove the rear window glass.

Refer to: [Fixed Glass](#) (501-11 Glass, Frames and Mechanisms, General Procedures).

6. Remove the roof ditch sealer.

Use the General Equipment: Hot Air Gun

Use the General Equipment: Scraper for Straight Edges



E201530



7. Carefully cut the **outer panel only**.
Use the General Equipment: Air Body Saw
Use the General Equipment: Spherical Cutter



E201722



8. Remove the SPR fasteners.

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

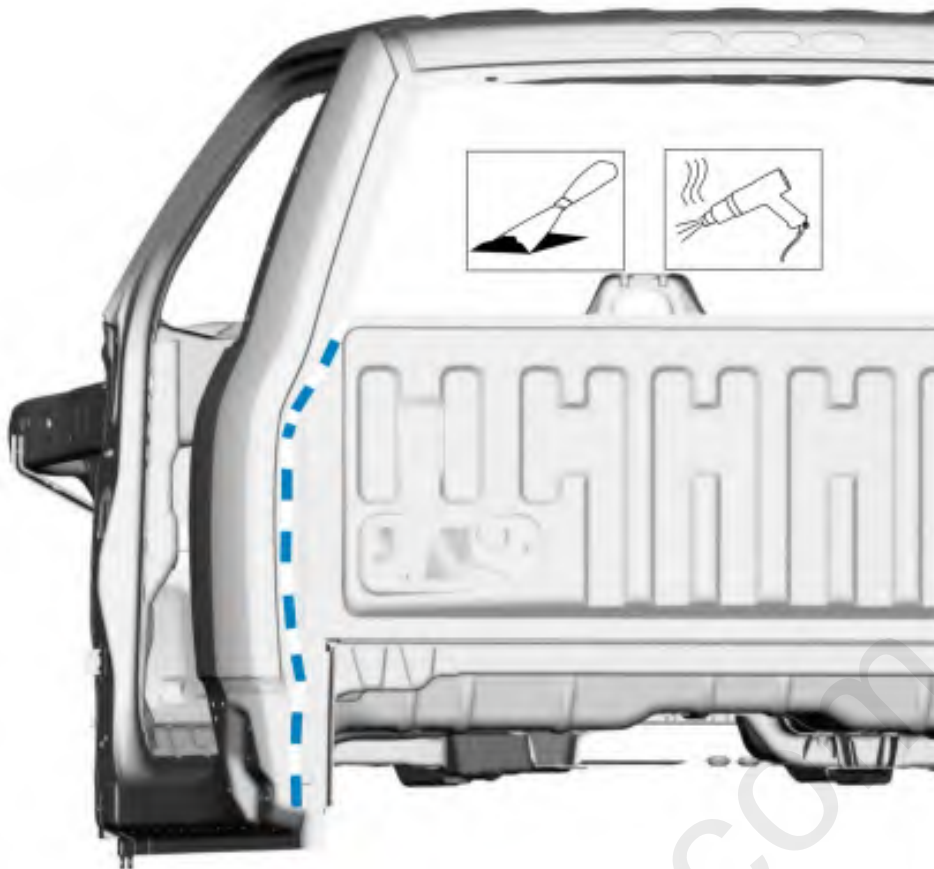
Use the General Equipment: Belt Sander



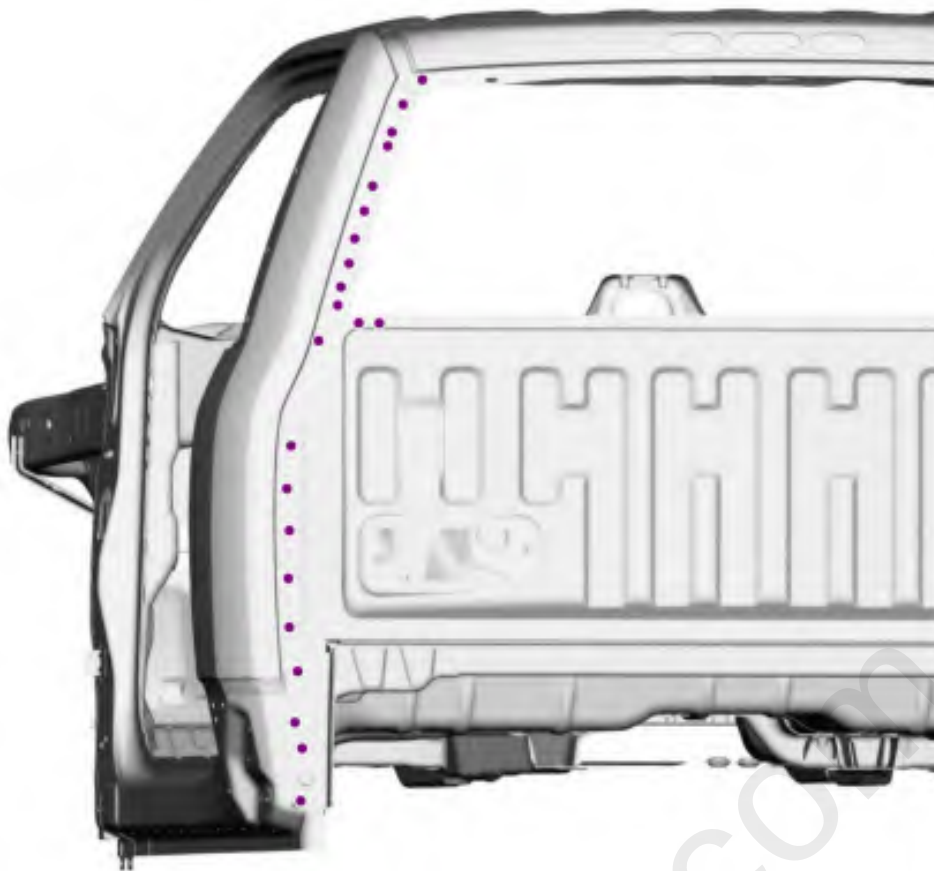
E201723



9. Remove the cab back seam sealer.
Use the General Equipment: Scraper for Straight Edges
Use the General Equipment: Hot Air Gun



10. Remove the cab back to filler panel SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



11. **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.

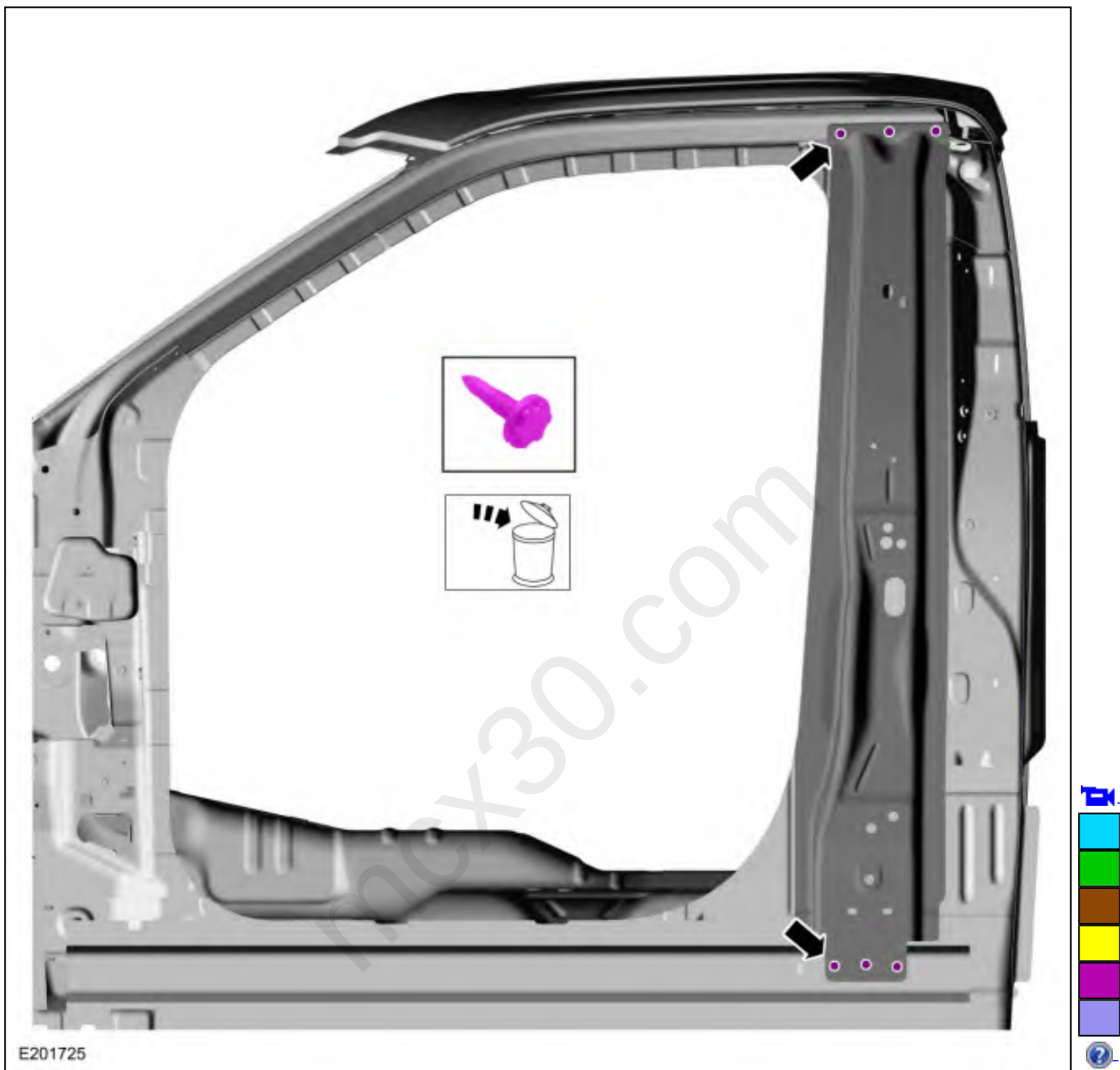
Break the adhesive bond and remove the body side section.
Use the General Equipment: Hot Air Gun



E201724

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





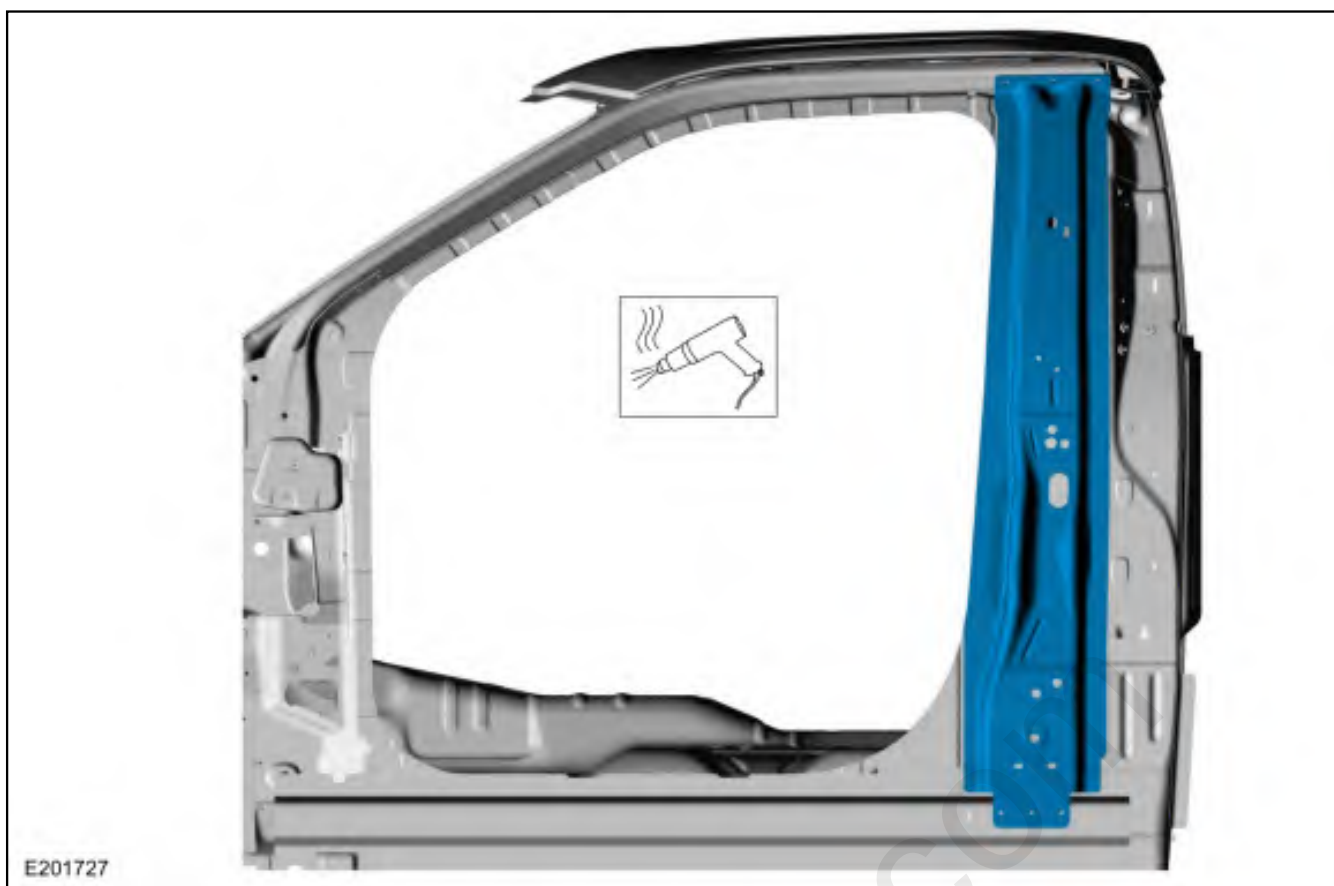
13. Remove the SPR fasteners.

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

Use the General Equipment: Belt Sander



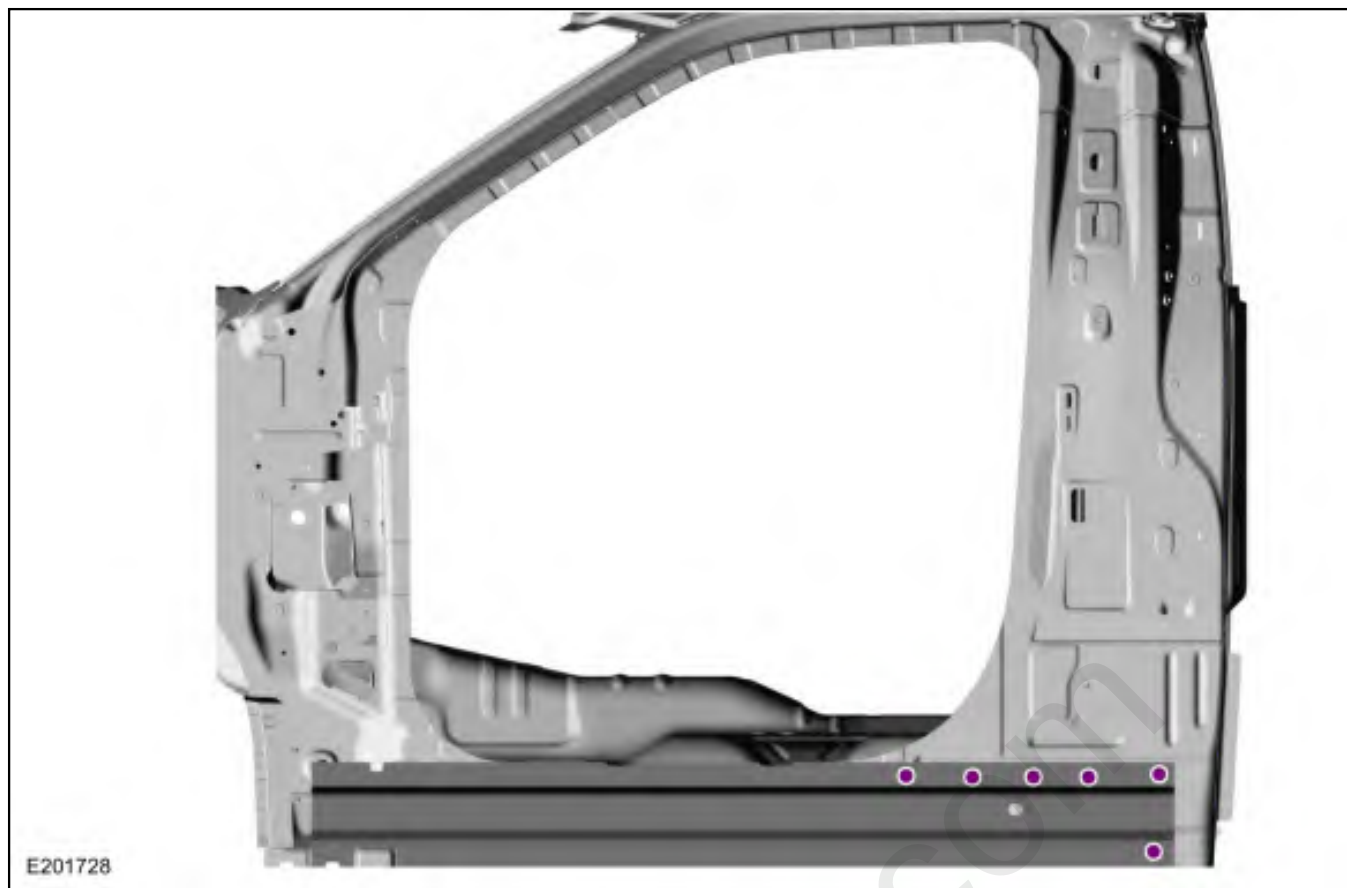
14. Break the adhesive bond and remove the C-pillar reinforcement.
Use the General Equipment: Hot Air Gun



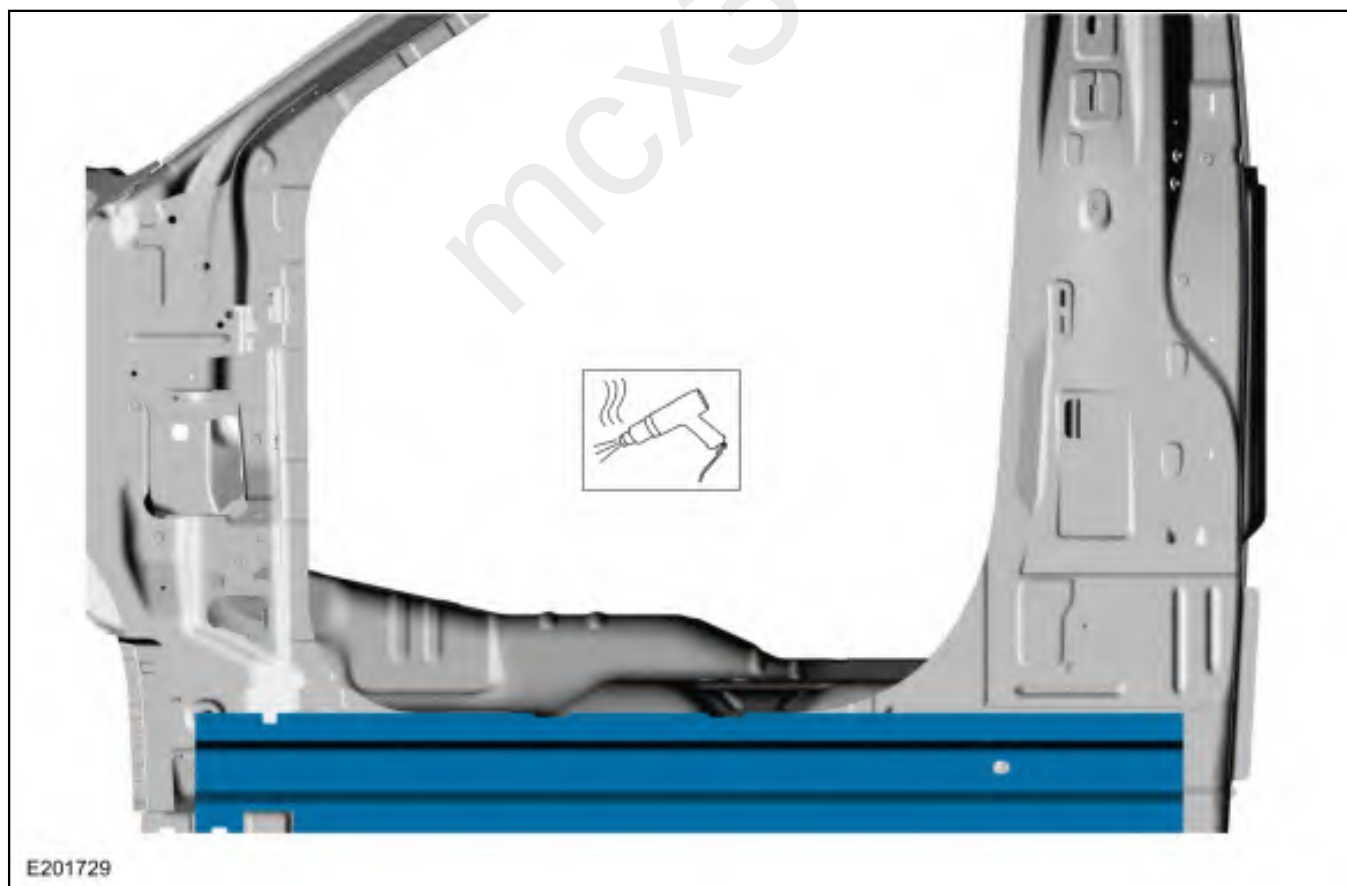
15. Remove the SPR fasteners.

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

Use the General Equipment: Belt Sander



16. Break the adhesive bond and remove the rocker panel reinforcement.
Use the General Equipment: Hot Air Gun



Installation

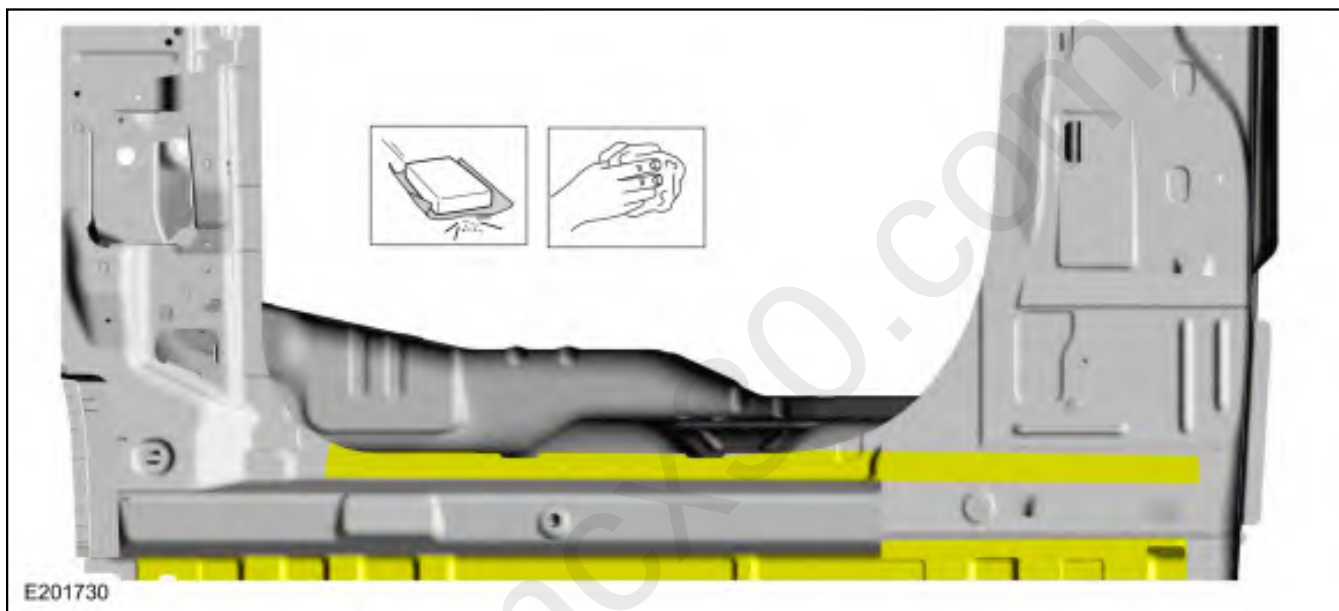
NOTICE: Body side sectioning is prohibited within 50 mm of door hinge, door striker and restraints anchoring points.

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

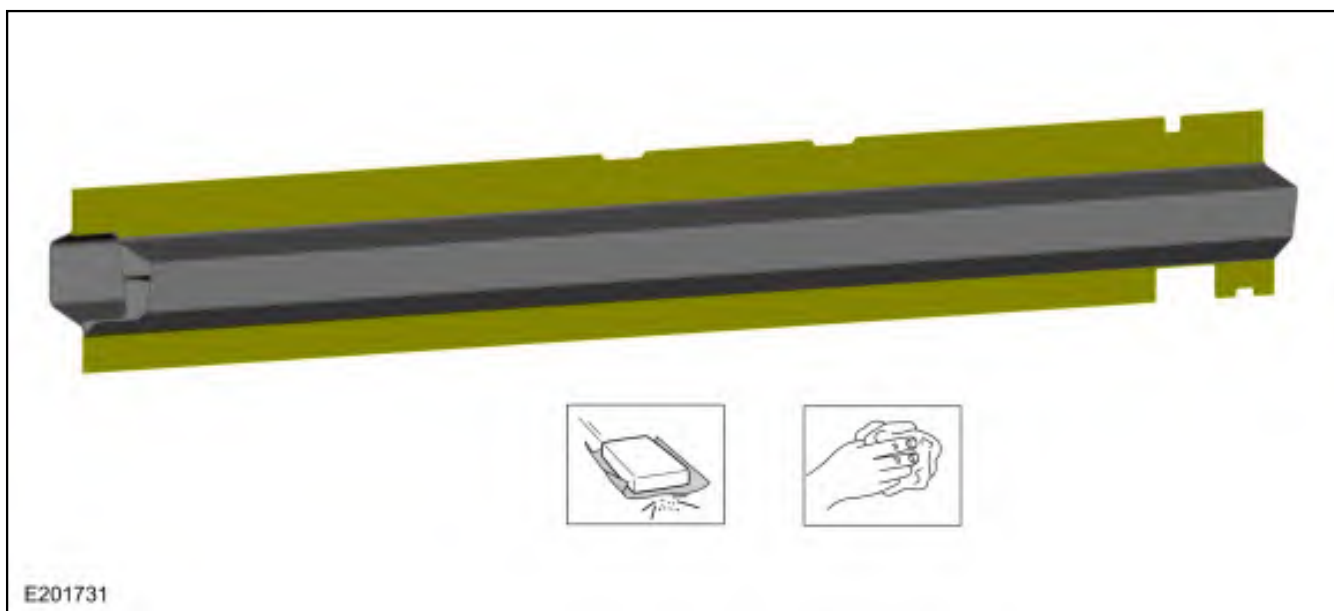
NOTE: Blind or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

NOTE: The use of a backer panel when creating butt welds will produce a stronger and more uniform repair.

1. 80-120 grit sandpaper.
Sand to remove old adhesive and clean.

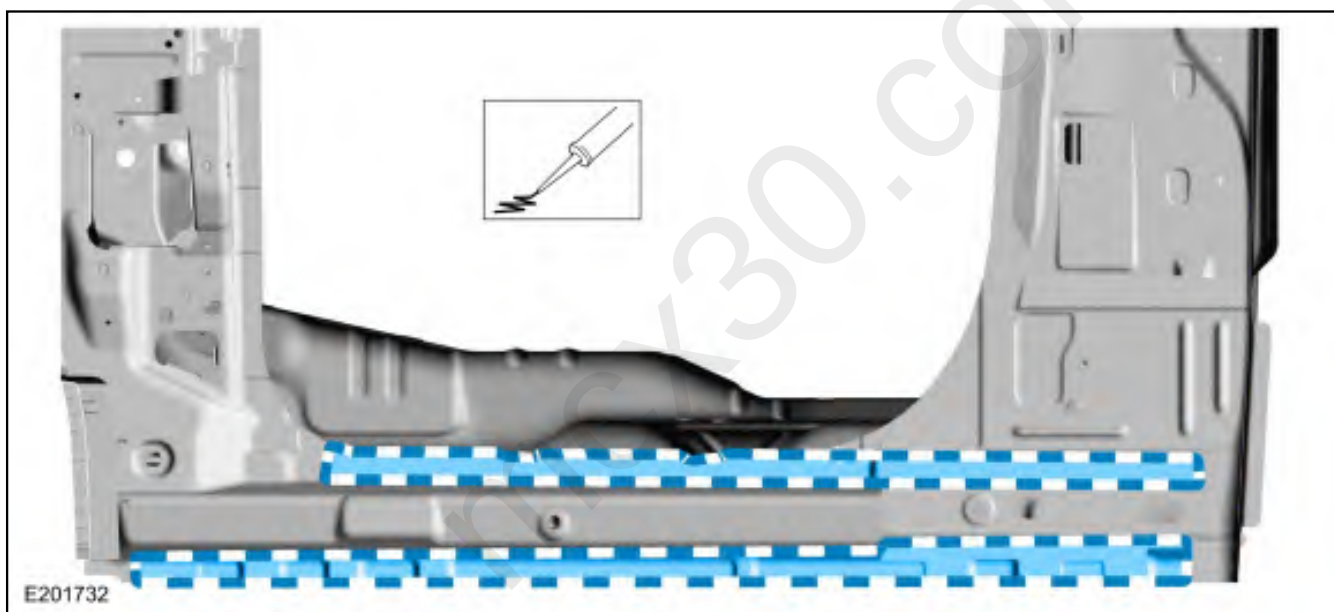


2. 80-120 grit sandpaper.
Sand to remove e-coat and clean.



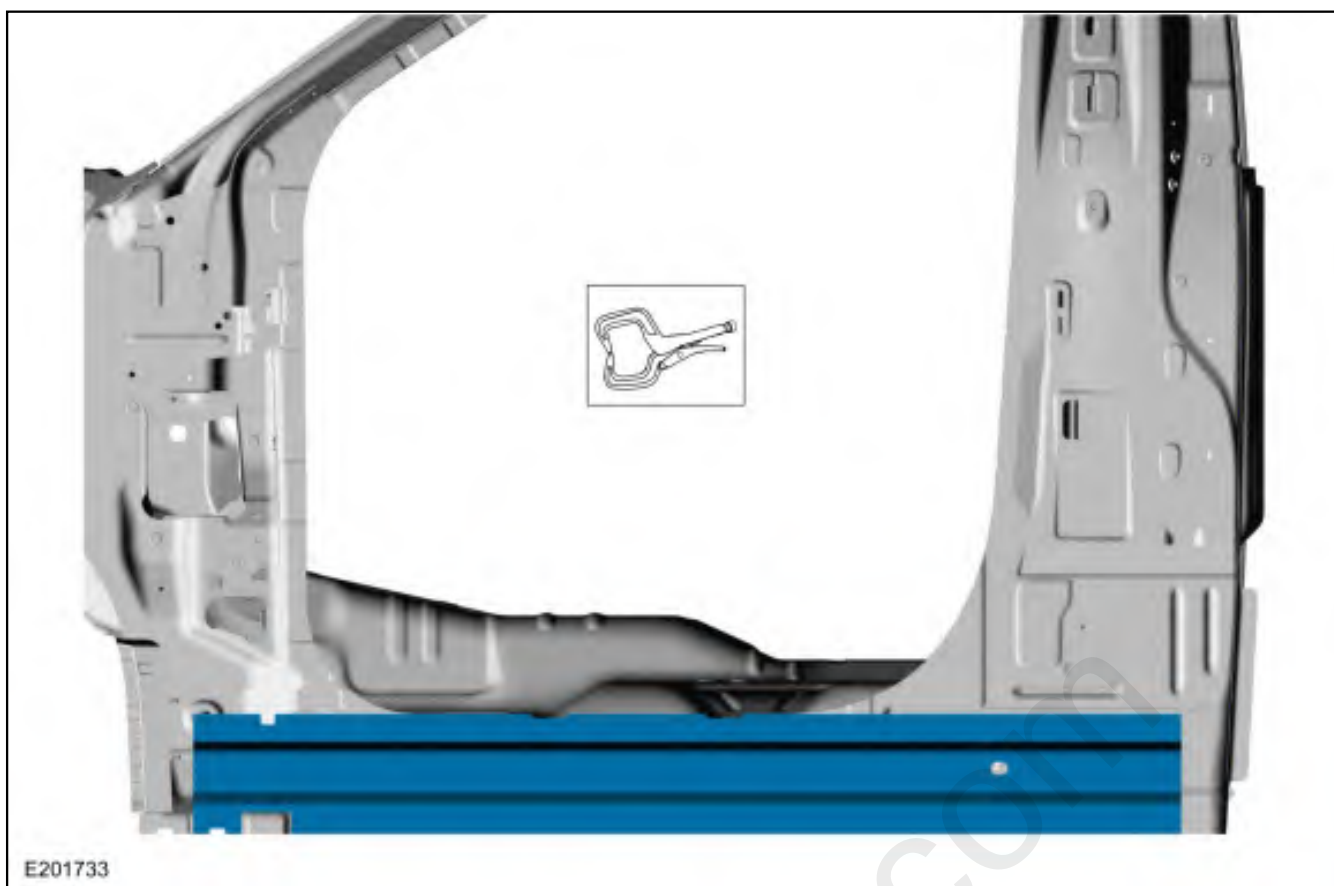
3. Apply adhesive.

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

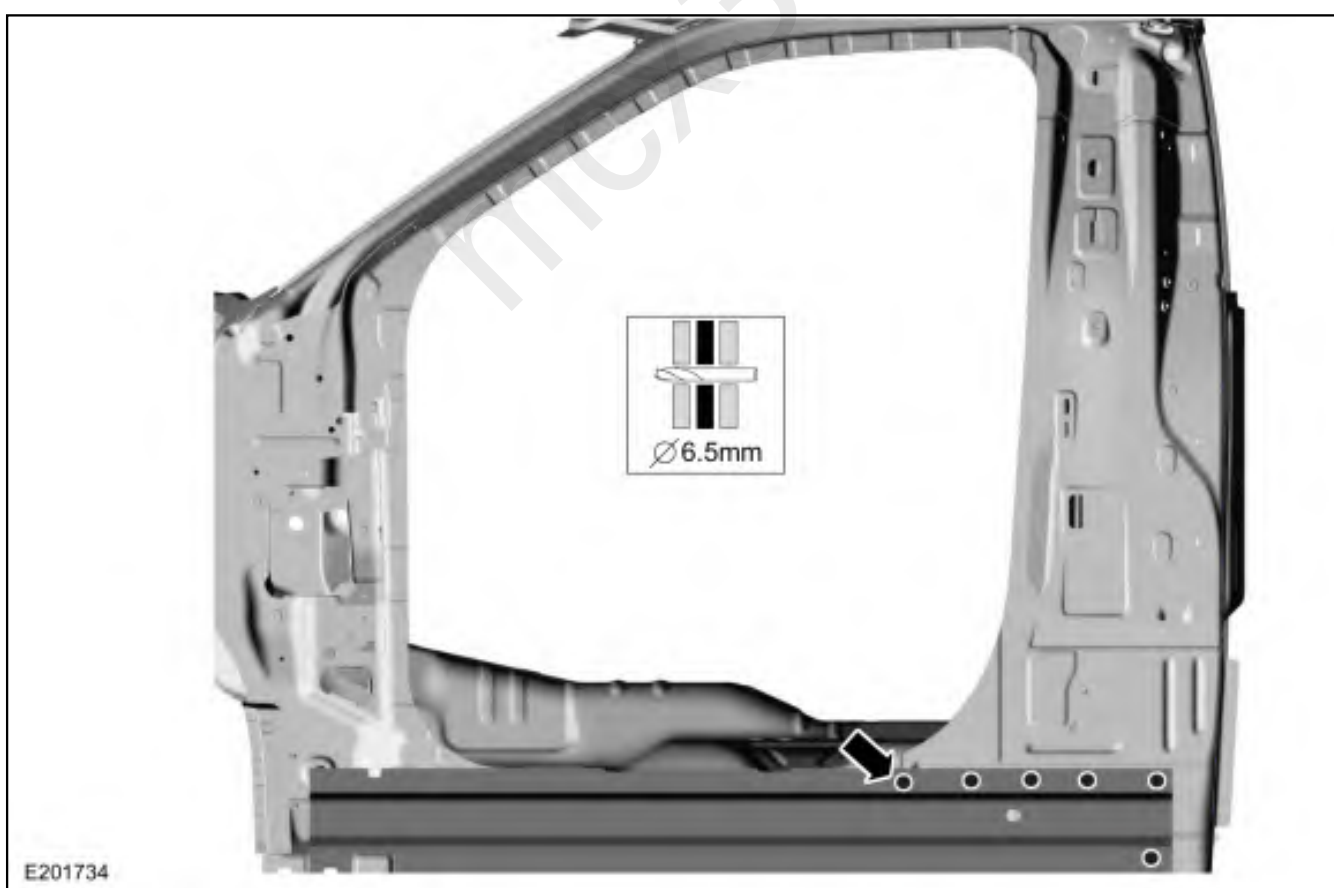


4. Install the reinforcement and clamp in position.

Use the General Equipment: Locking Pliers



5. Drill 6.5 mm holes for blind rivet fasteners.
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.

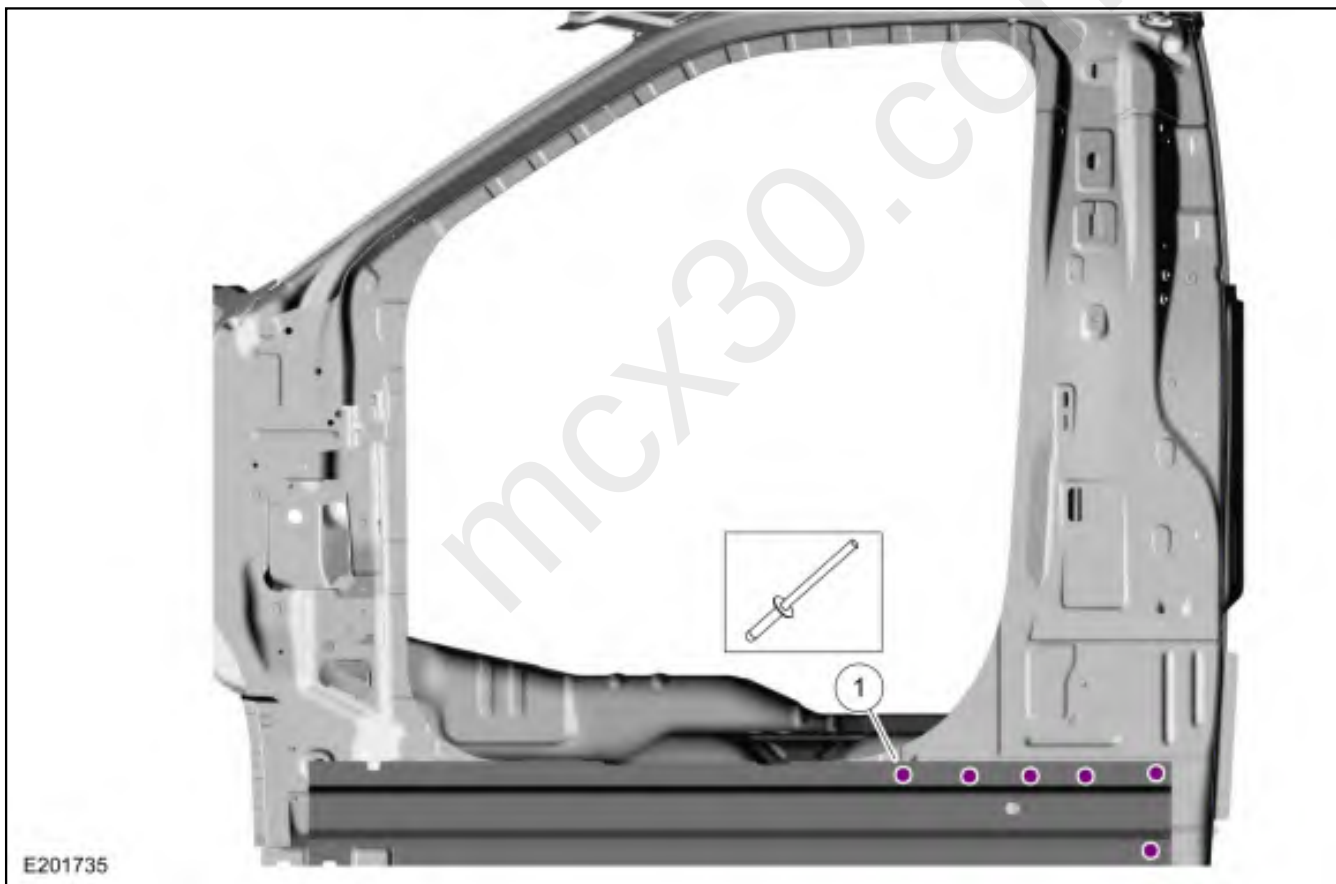
NOTE: Blind or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Install fasteners.

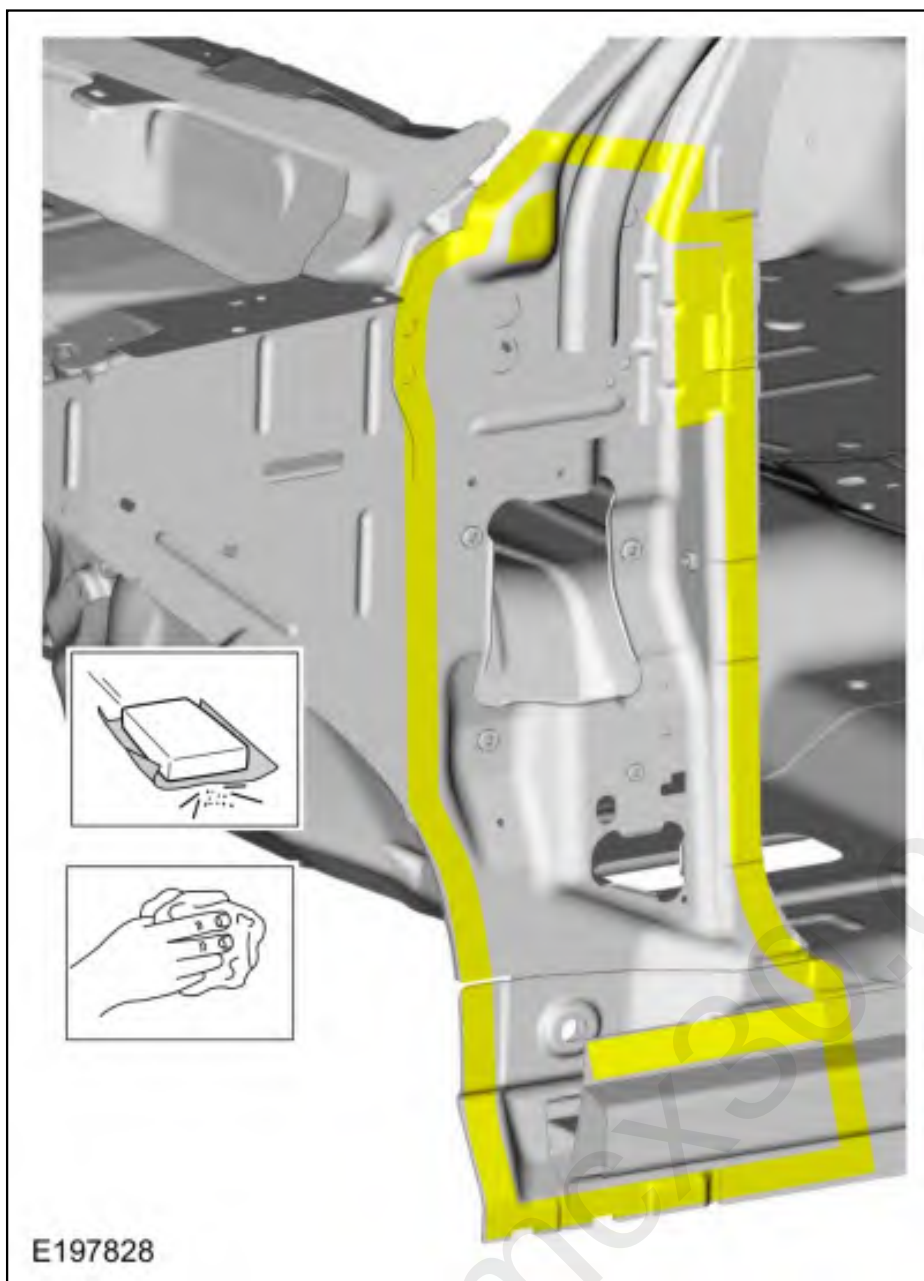
Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W702512-S900C	-	-

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

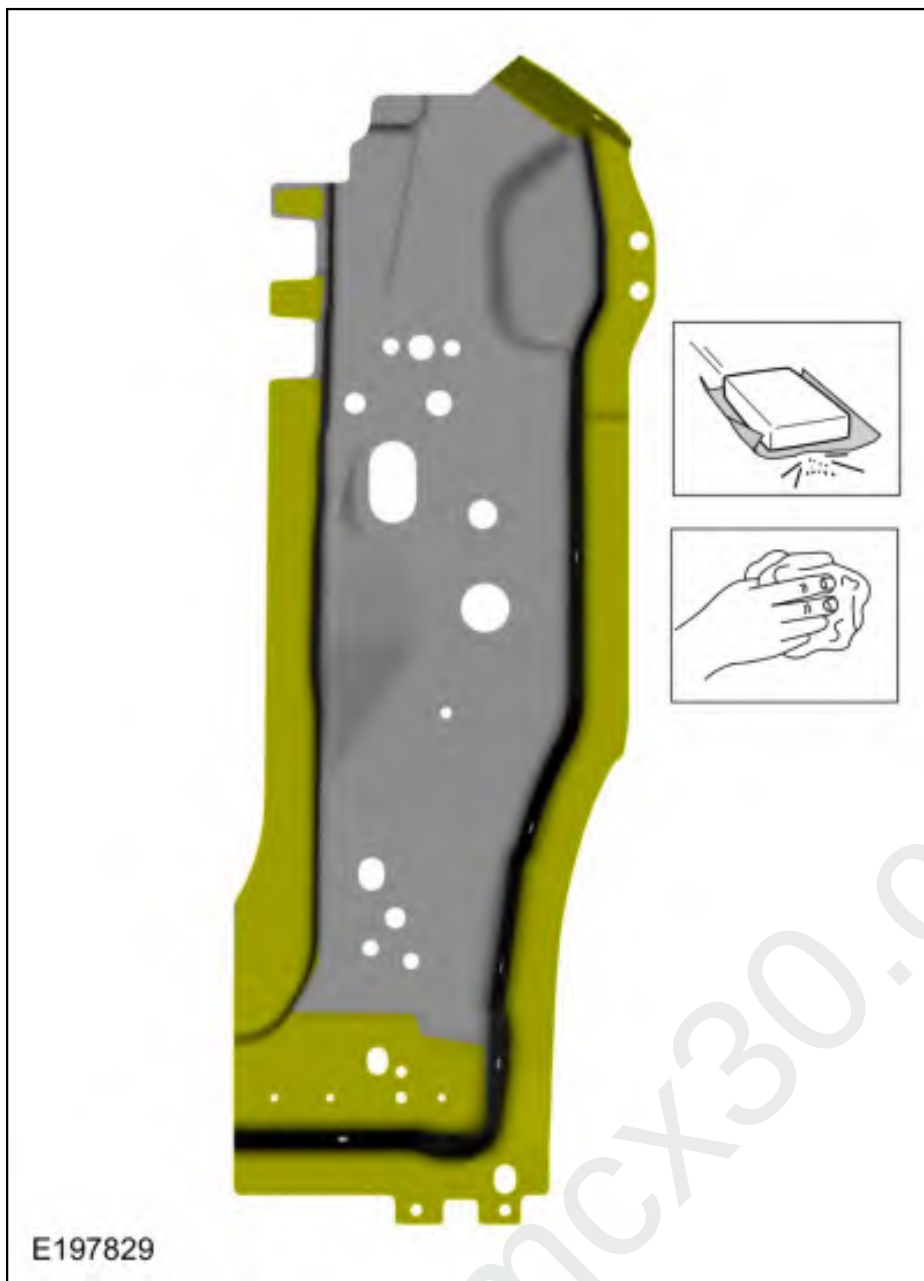
Use the General Equipment: Blind Rivet Gun



7. 80-120 grit sandpaper.
Sand to remove old adhesive and e-coat and clean.

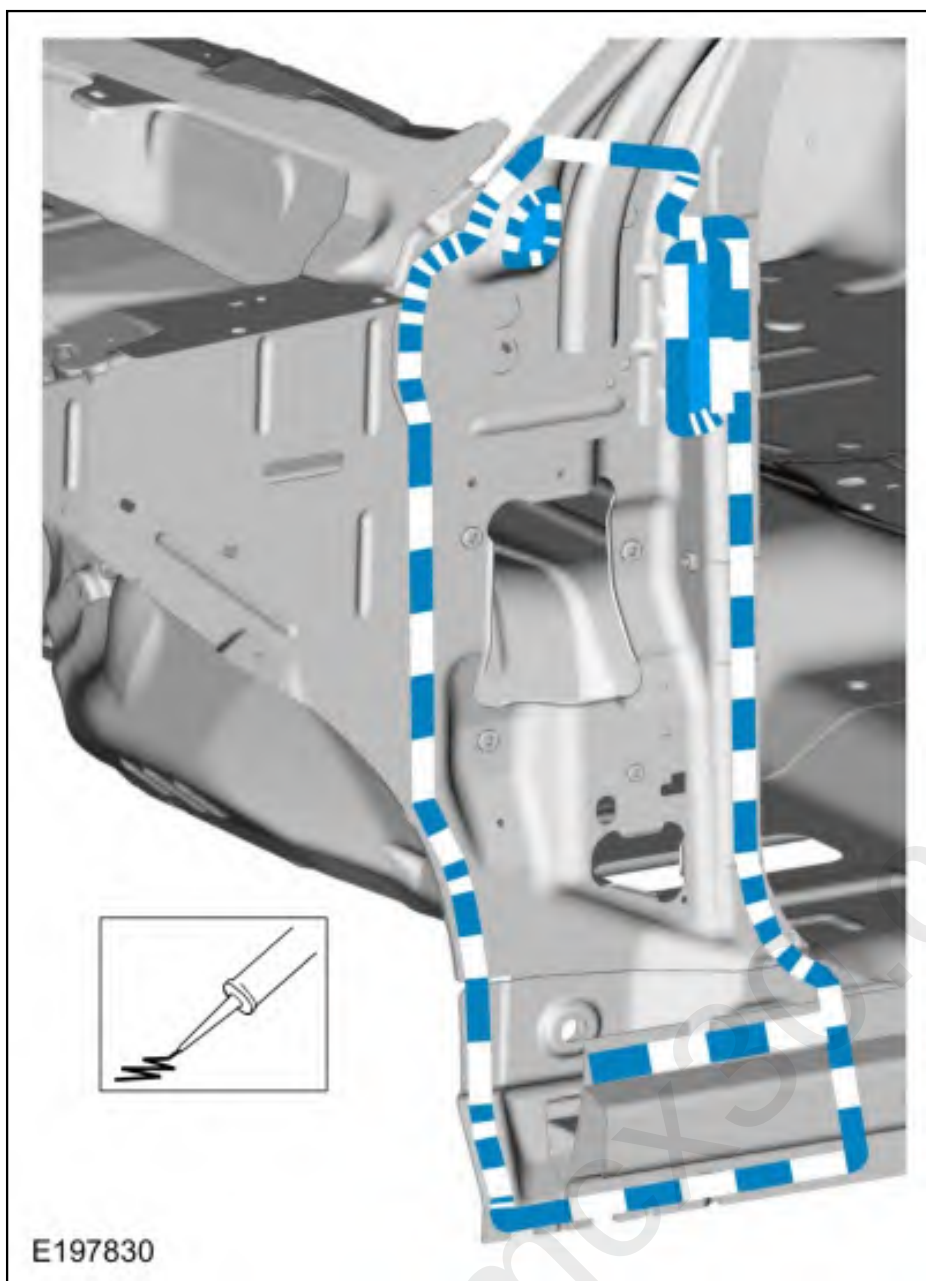


8. 80-120 grit sand paper.
Sand to remove e-coat and clean.

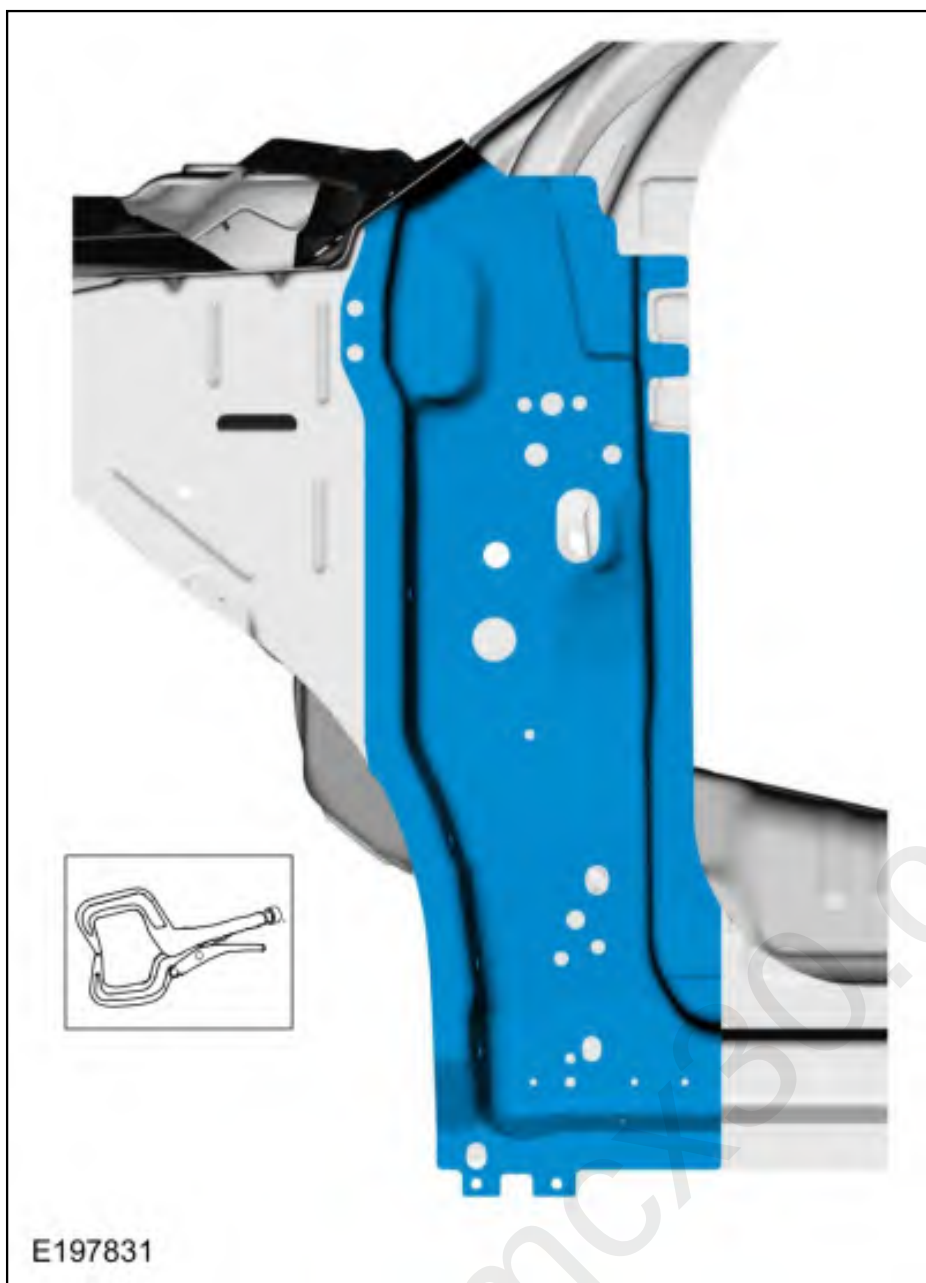


9. Apply adhesive.

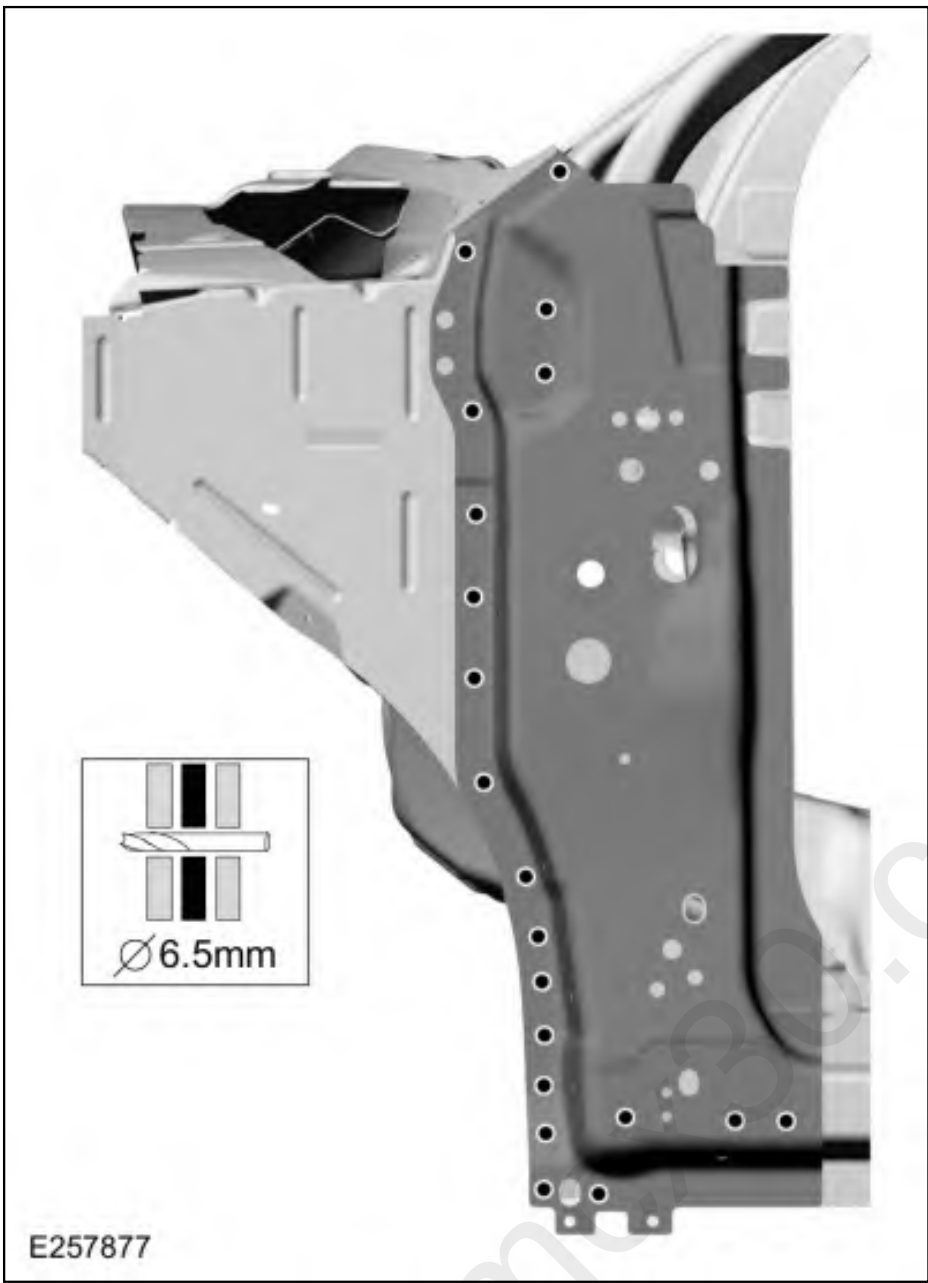
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B



10. Install the A-pillar reinforcement and clamp in position.
Use the General Equipment: Locking Pliers



11. Drill for fasteners.
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.

Install fasteners.

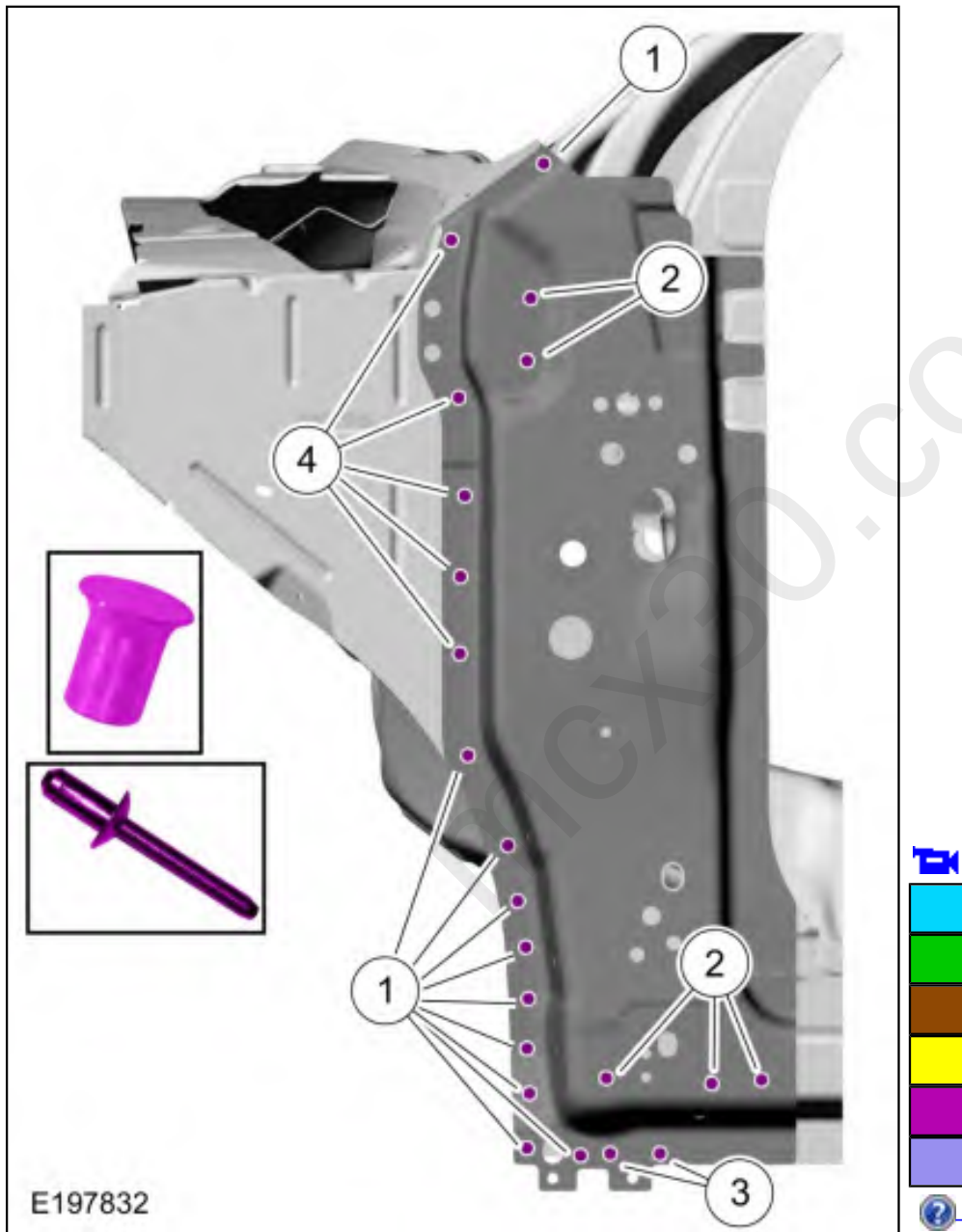
Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W717182-S900	QC	DP10-200/H	SA-0400/SA-0402	W708777-S900C	-	-
2	-	-	-	-	W708777-S900C	-	-

3	W717186-S900	EL	DP11-200/H	SA-0400/SA-0402	W708777-S900C	-	-
4	-	-	-	-	W702512-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



13. Install the reinforcement pad.

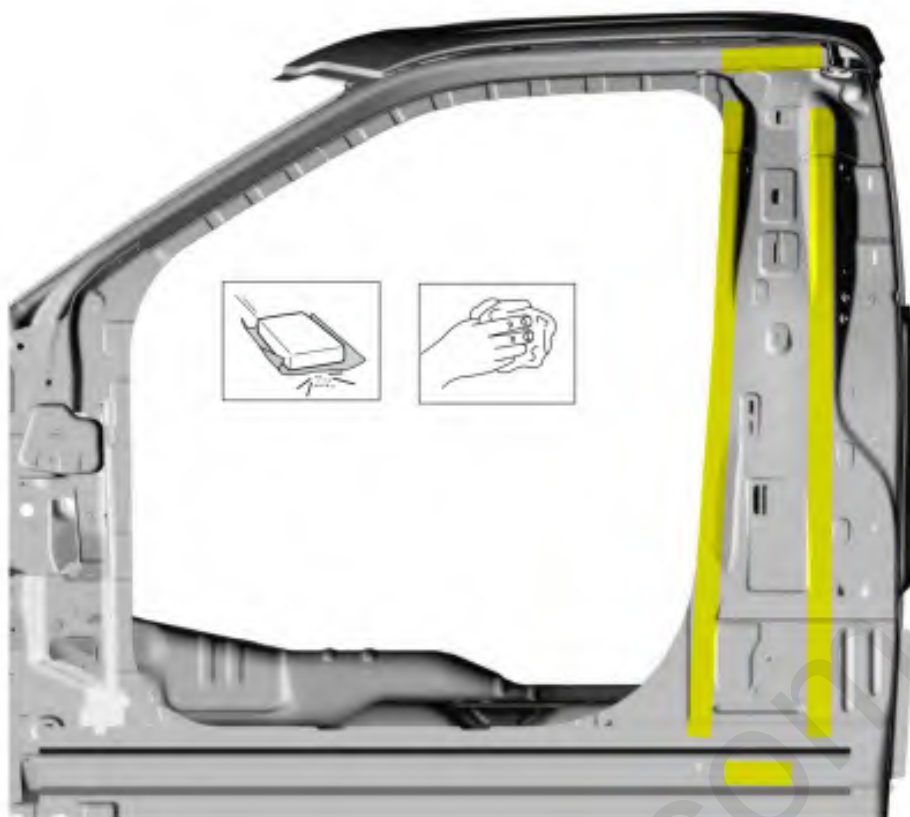


14. Install the fender apron panel.

Refer to: [Fender Apron Panel Reinforcement](#) (501-27 Front End Sheet Metal Repairs, Removal and Installation).

15. 80-120 grit sandpaper.

Sand to remove old adhesive and clean.

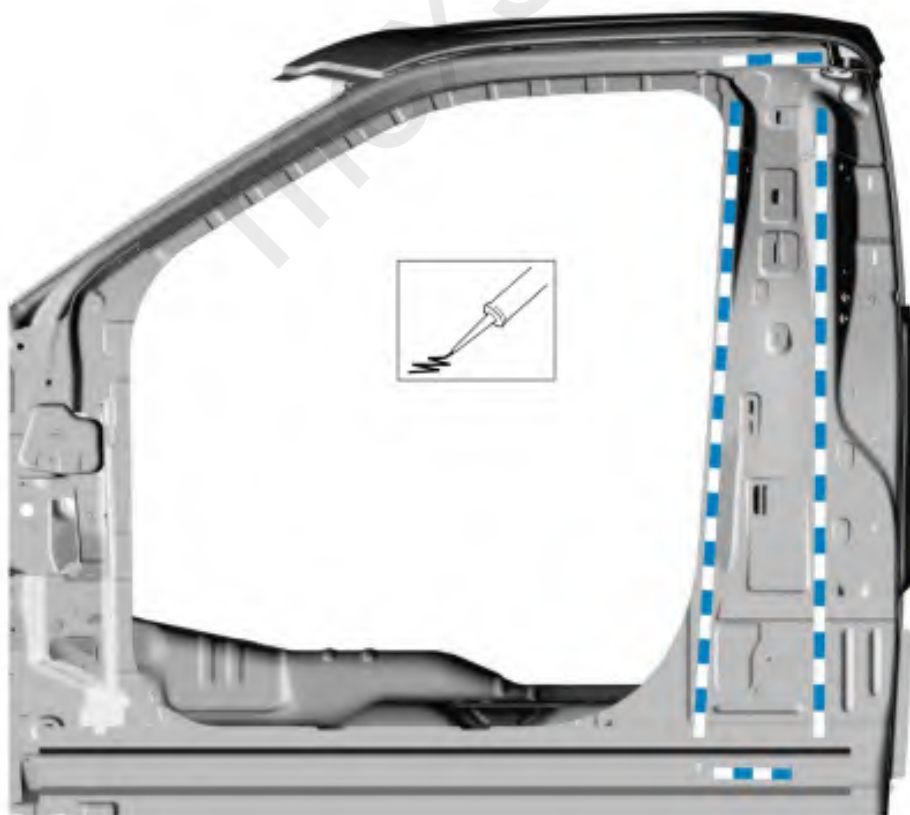


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16. Apply adhesive.

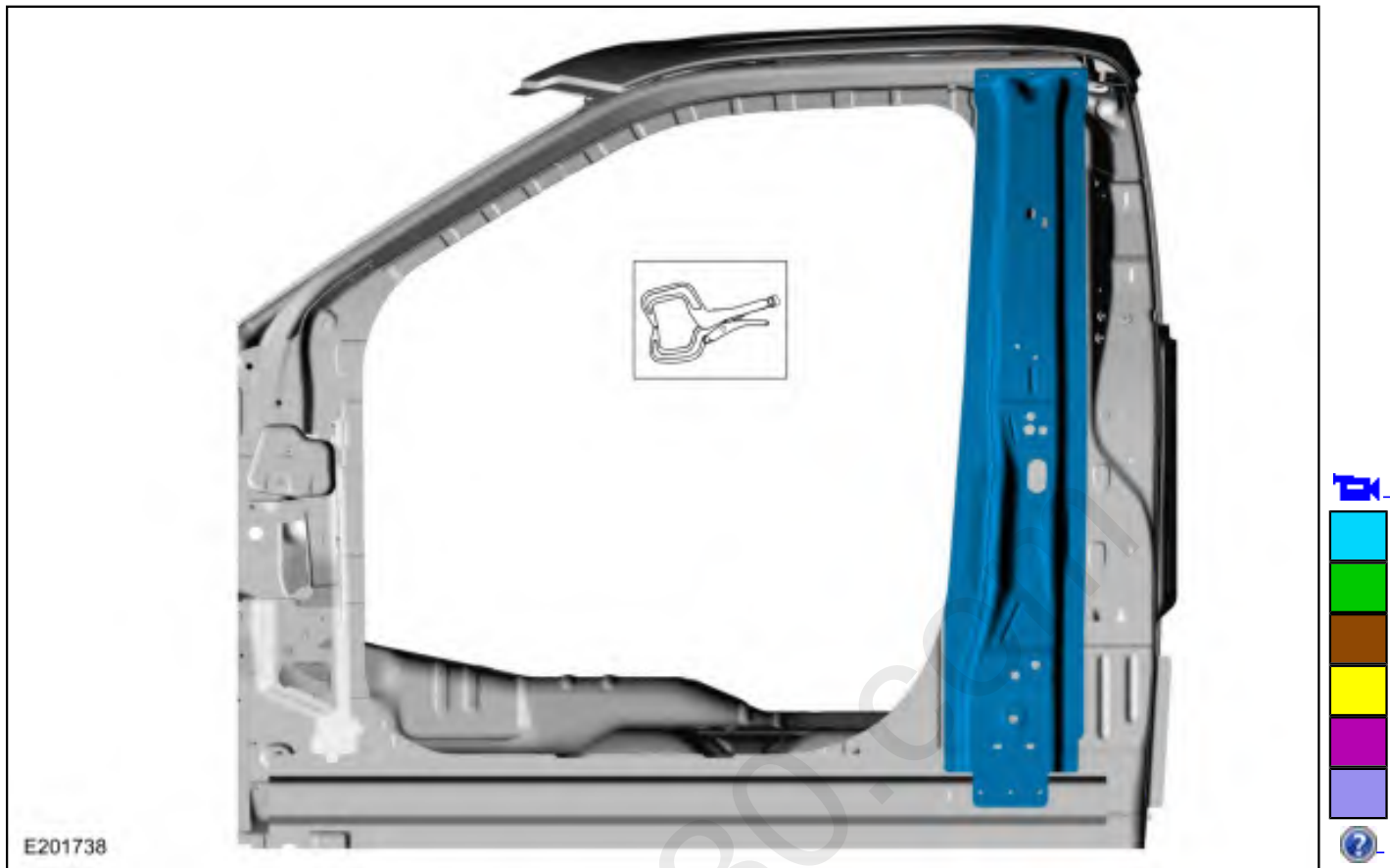
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B



E201737



17. Install the C-pillar reinforcement and clamp in position.
Use the General Equipment: Locking Pliers



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



19. Install blind rivet fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W702554-S900C	-	-

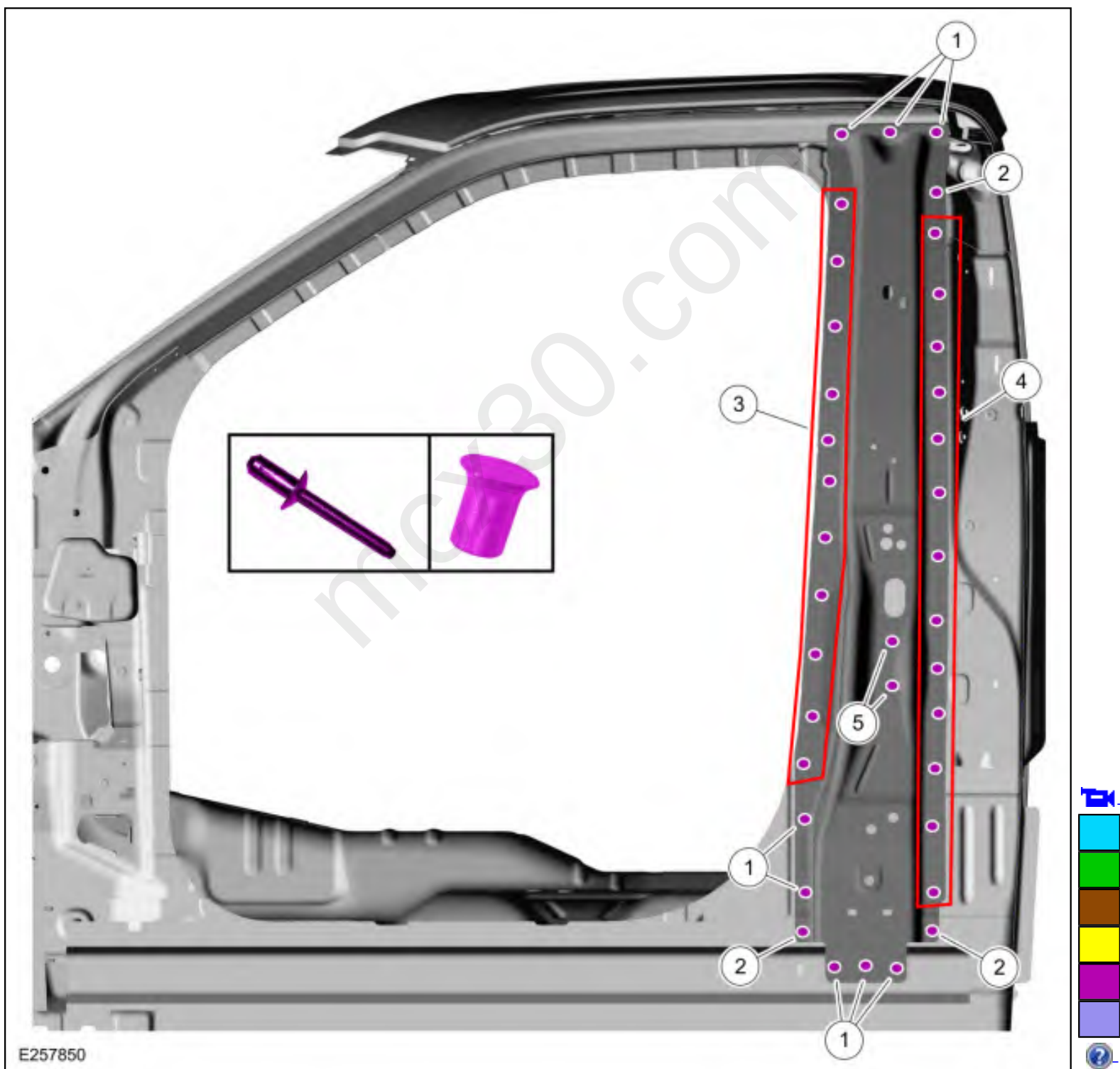
3	W717337-S900	PX	DG10-200/H	SA-0400/SA-0402	-	W790377-S900	-
4	-	-	-	-	W708777-S900C	-	-

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

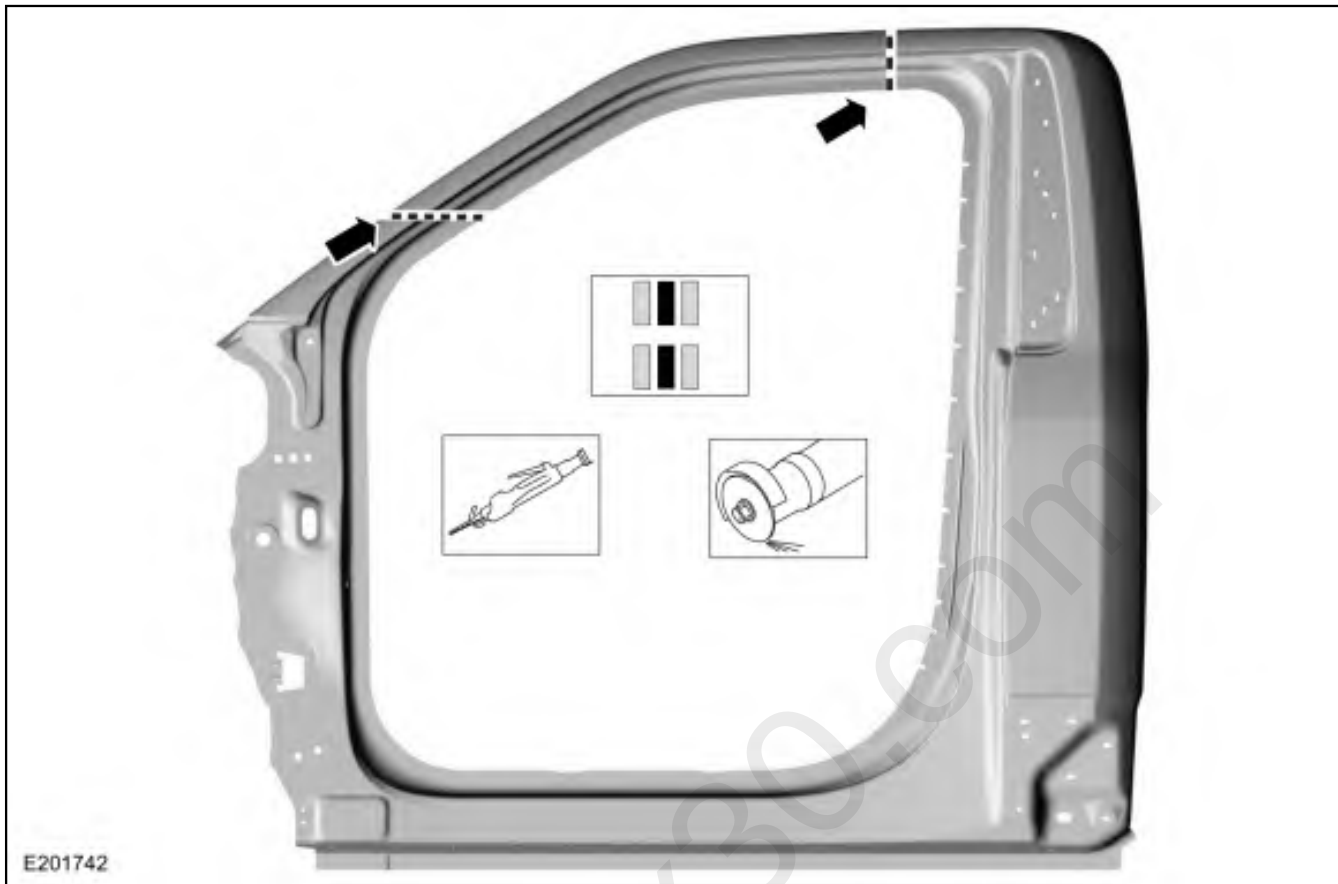
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Blind Rivet Gun

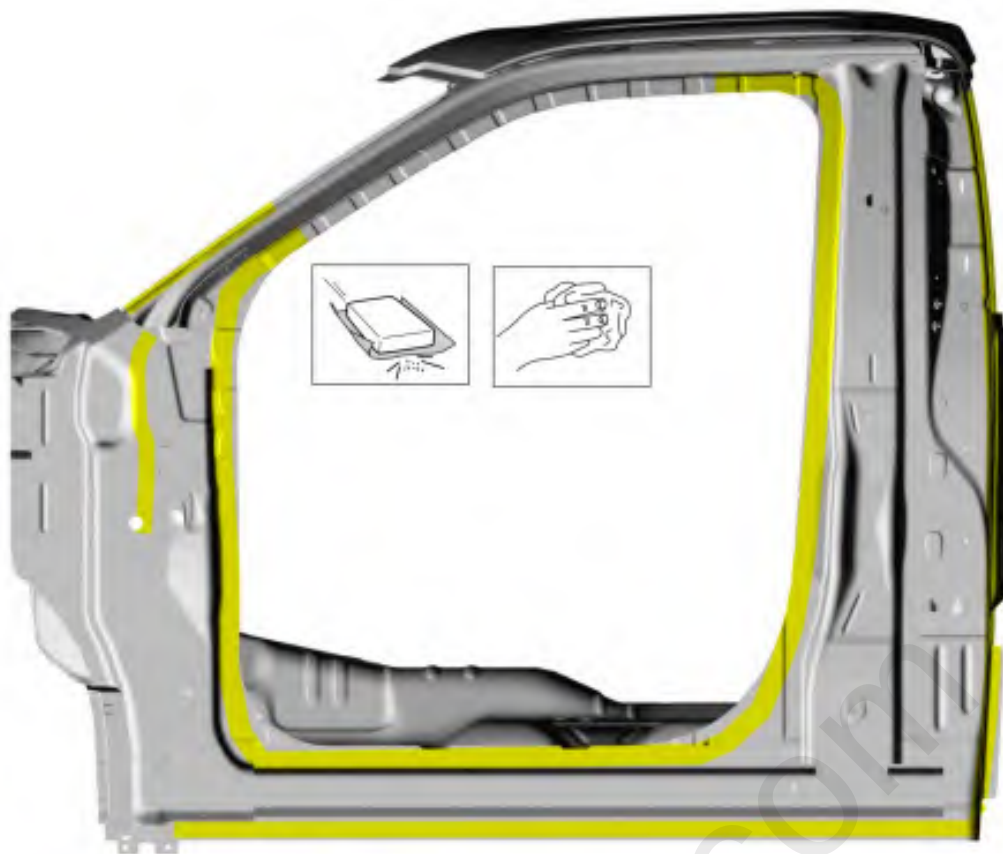
Use the General Equipment: Blind Rivet Gun



20. Cut the body side service panel to fit repair.
Use the General Equipment: Air Body Saw
Use the General Equipment: Spherical Cutter



21. Create backing plates from unused portions of the service panel for each sectioning joint and attach to vehicle.
Refer to: [Joining Techniques](#) (501-25 Body Repairs - General Information, General Procedures).
22. 80-120 grit sandpaper.
Sand to remove old adhesive and e-coat and clean.



E201743



23. 80-120 grit sandpaper.
Sand to remove e-coat and clean.



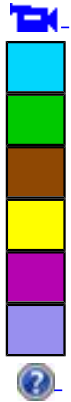
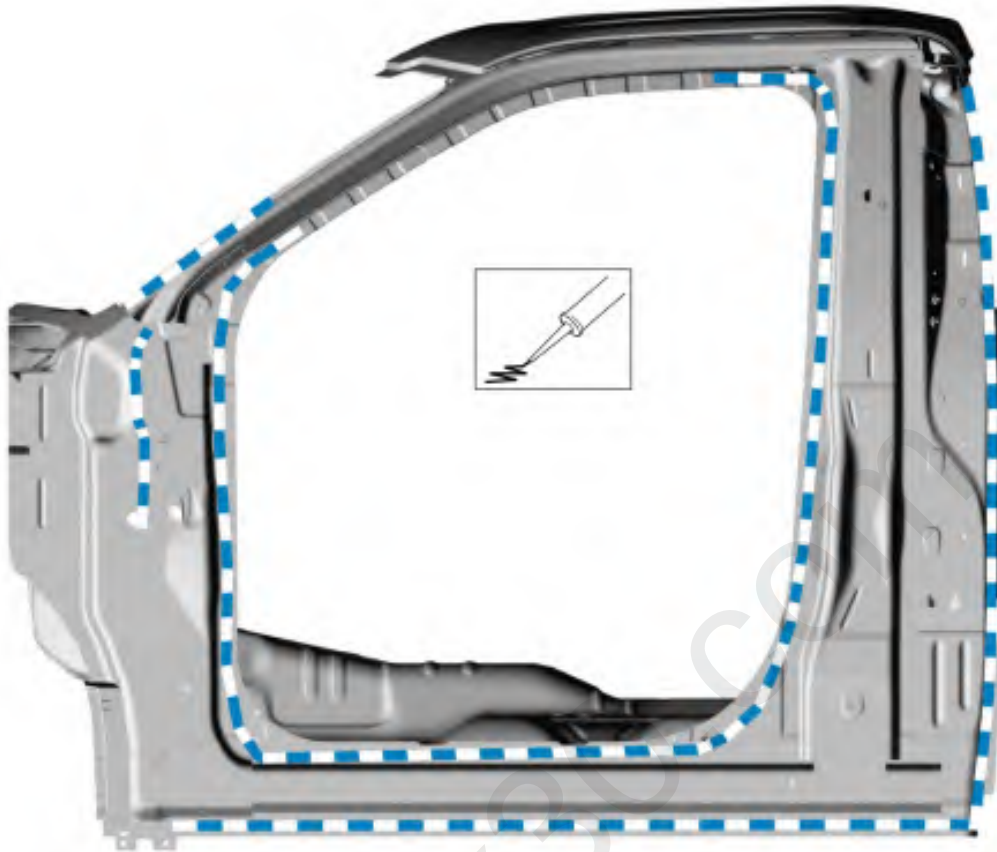
E201744



24. Install all NVH baffles noted during removal.

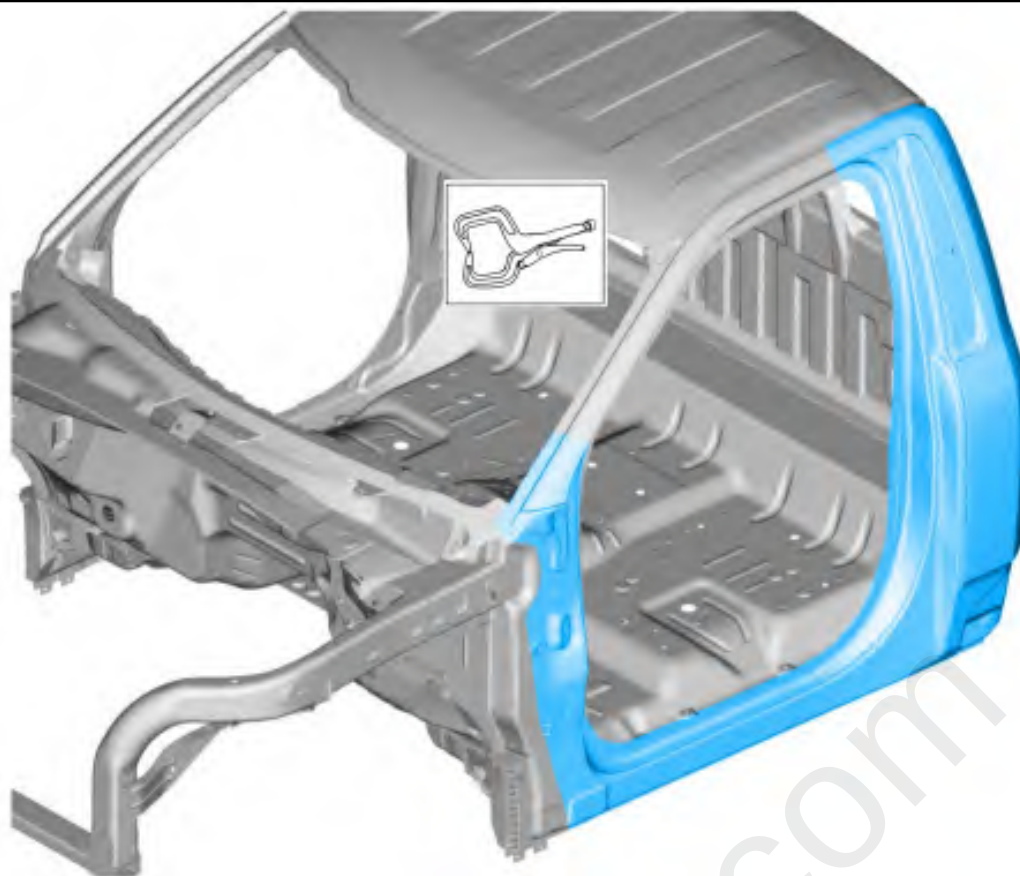
25. Apply adhesive.

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

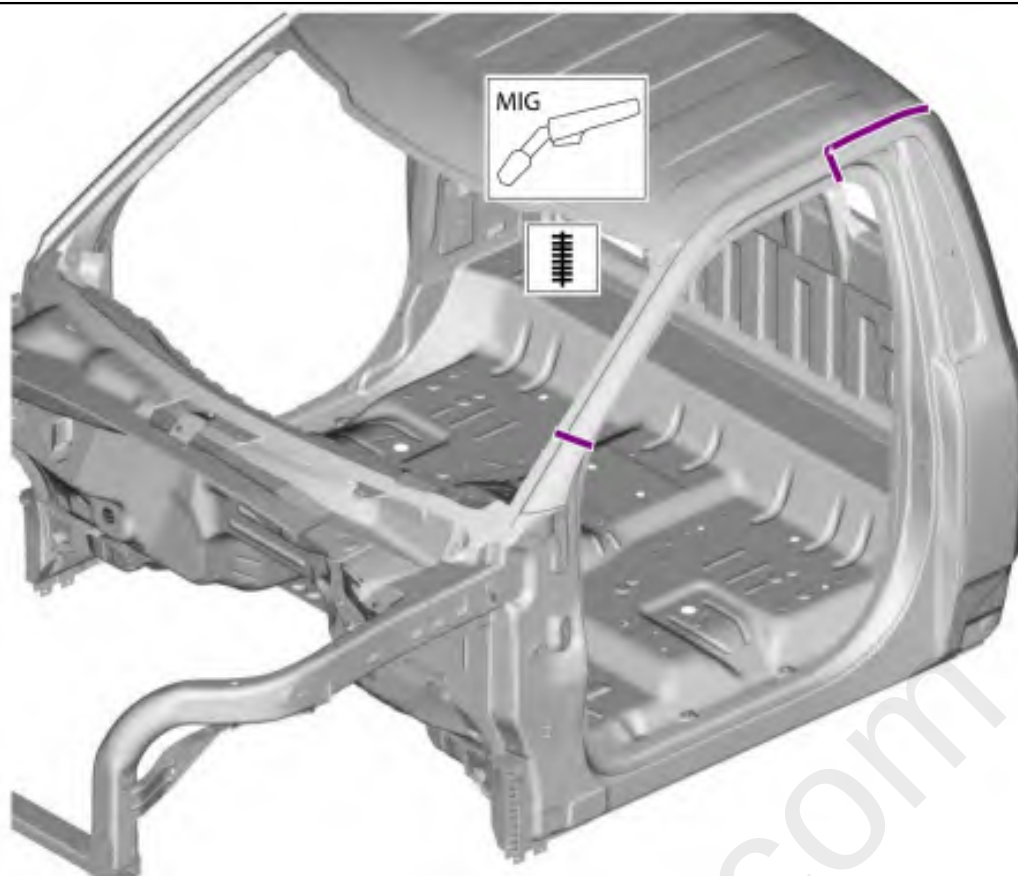


26. Install the body side service panel and clamp in position.

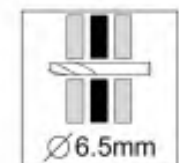
Use the General Equipment: Locking Pliers



27. Complete joining of backer plates to the body side service panel.
Refer to: [Joining Techniques](#) (501-25 Body Repairs - General Information, General Procedures).
Use the General Equipment: MIG/MAG Welding Equipment
28. Completely seam-weld all sectioning joints using a MIG welder set up for aluminum repair.
Use the General Equipment: MIG/MAG Welding Equipment



29. Drill for fasteners.
Use the General Equipment: 6.5 mm Drill Bit



30. **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.

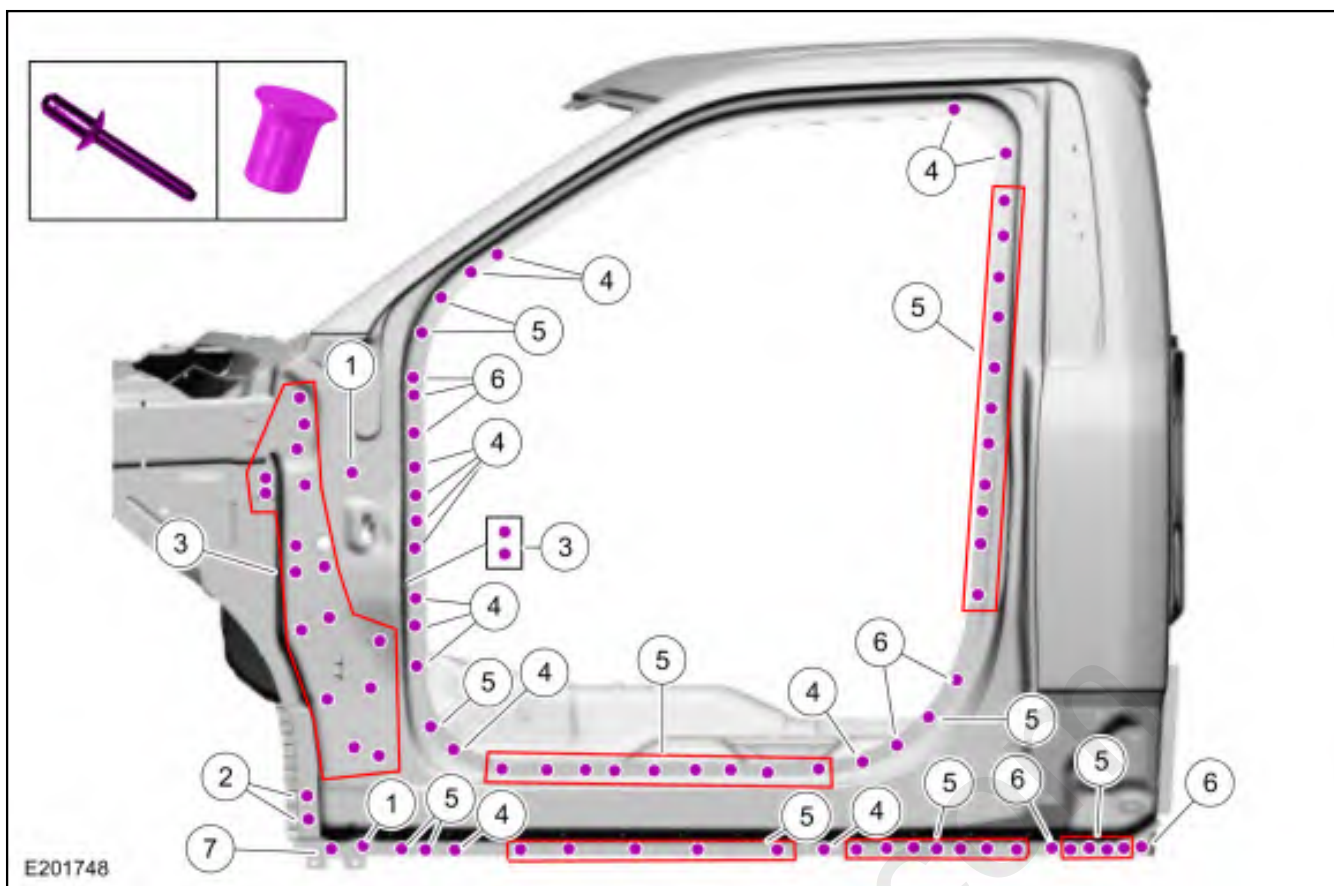
Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W702554-S900C	-	-
3	-	-	-	-	W708777-S900C	-	-
4	W708713-S900	AS	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	
5	W717186-S900	EN	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
6	W708717-S900	AW	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
7	W710246-S900	BN	DP10-200/H	SA-0400/SA-0402	-	W790377-S900	-

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



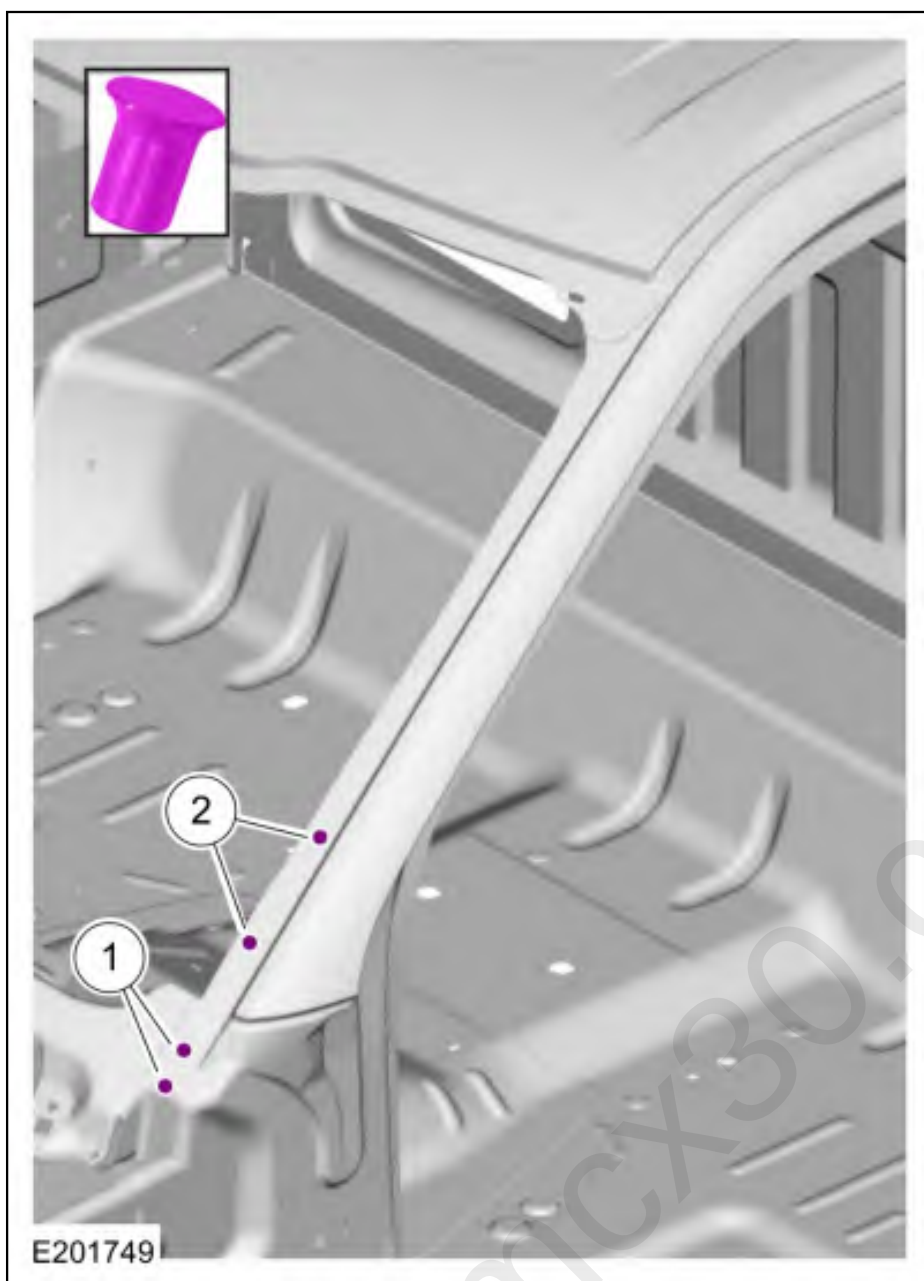
31. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

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

Install fasteners.

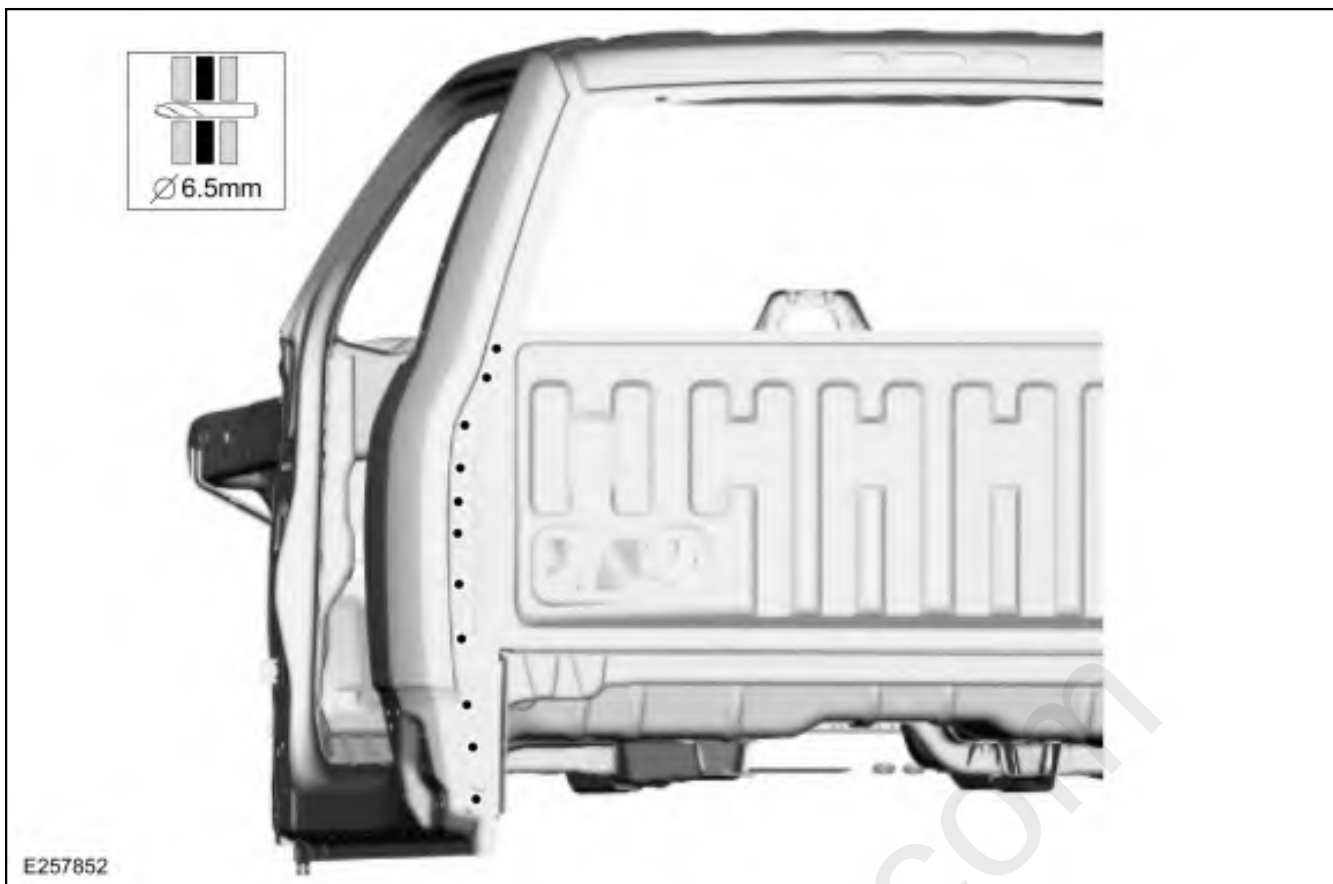
Item,	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
2	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-

Refer to: [Joining Techniques](#) (501-25 Body Repairs - General Information, General Procedures).
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer



32. Drill for fasteners.

Use the General Equipment: 6.5 mm Drill Bit



33. **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.

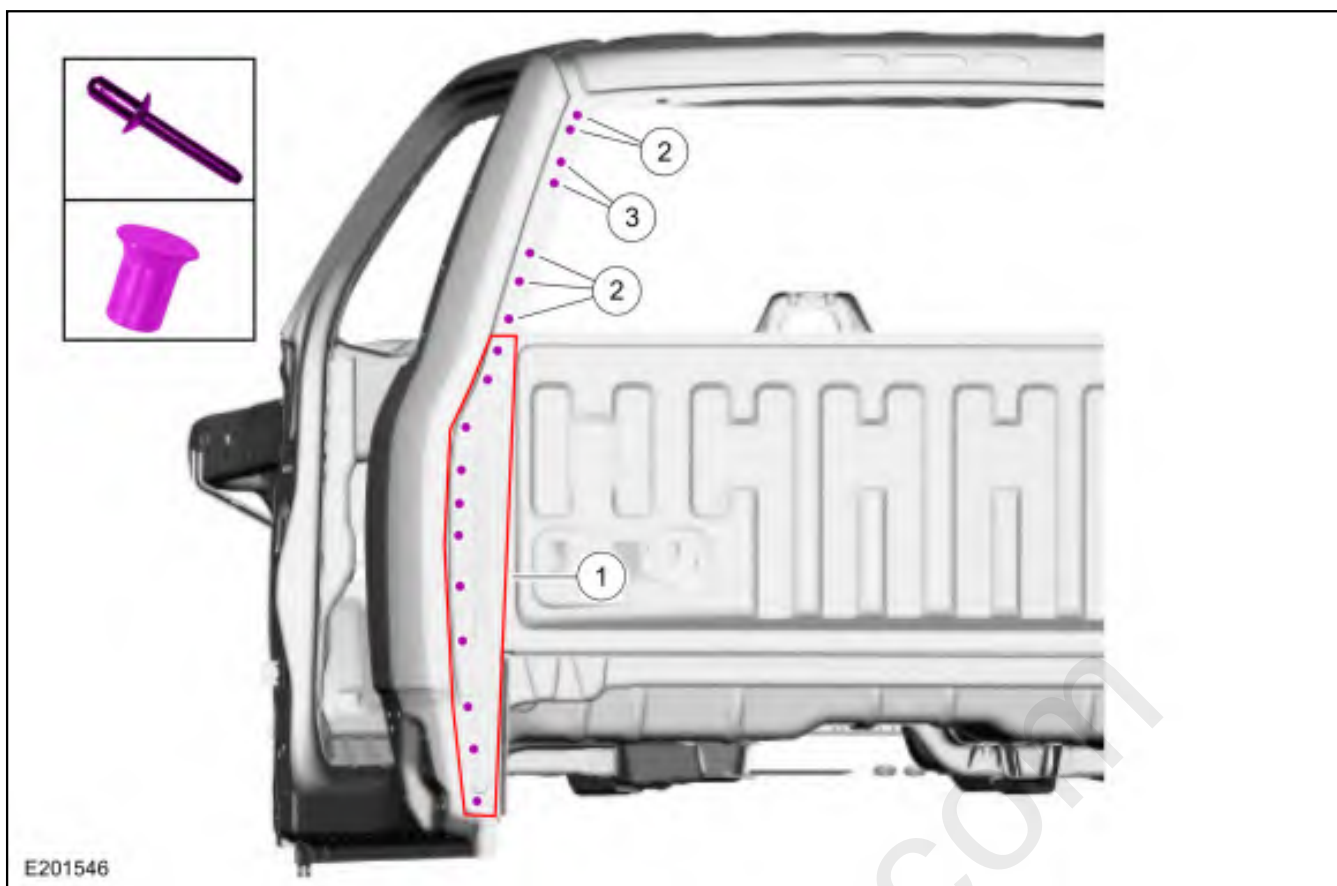
Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-
2	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-
3	W708717-S900	AW	DG10-220/H	SA-0400/SA-0402	-	W790377-S900	-

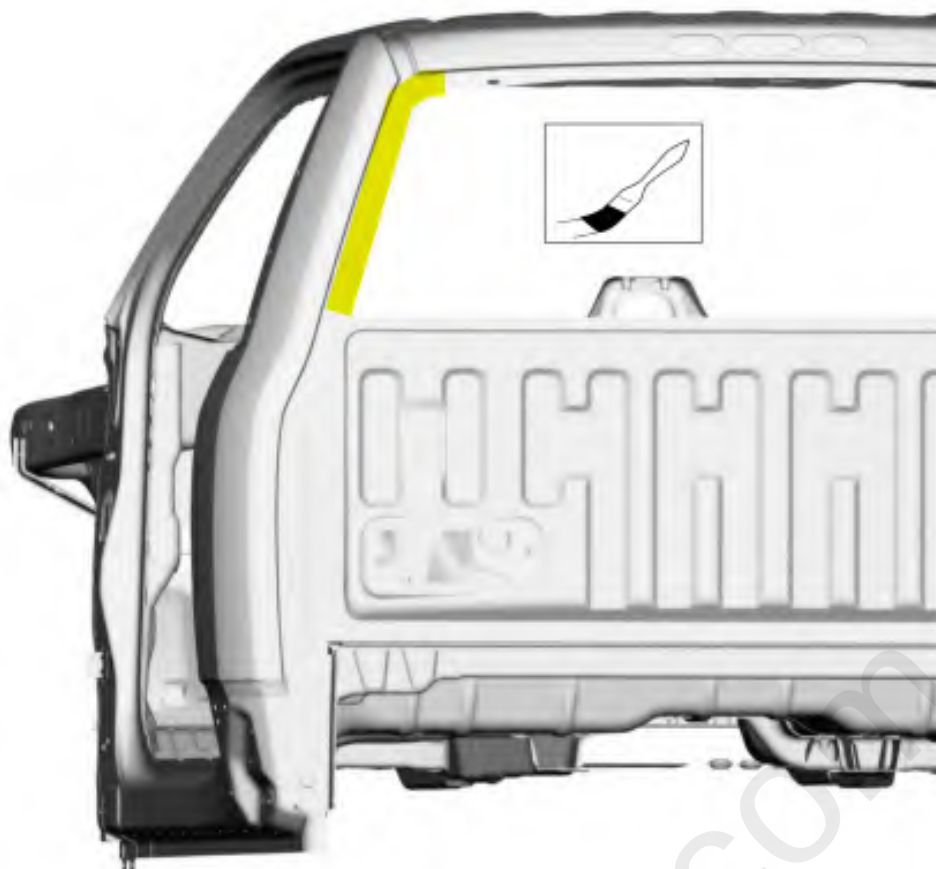
Refer to: [Joining Techniques](#) (501-25 Body Repairs - General Information, General Procedures).

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

Use the General Equipment: Blind Rivet Gun



34. Metal finish all sectioning seams using typical aluminum repair techniques and a fiber-based body filler. Refer to: [Special Repair Considerations for Aluminum Repairs](#) (501-25 Body Repairs - General Information, Description and Operation).
35. Epoxy prime.
Prime the rear window glass opening channel using a Ford approved epoxy-based primer.

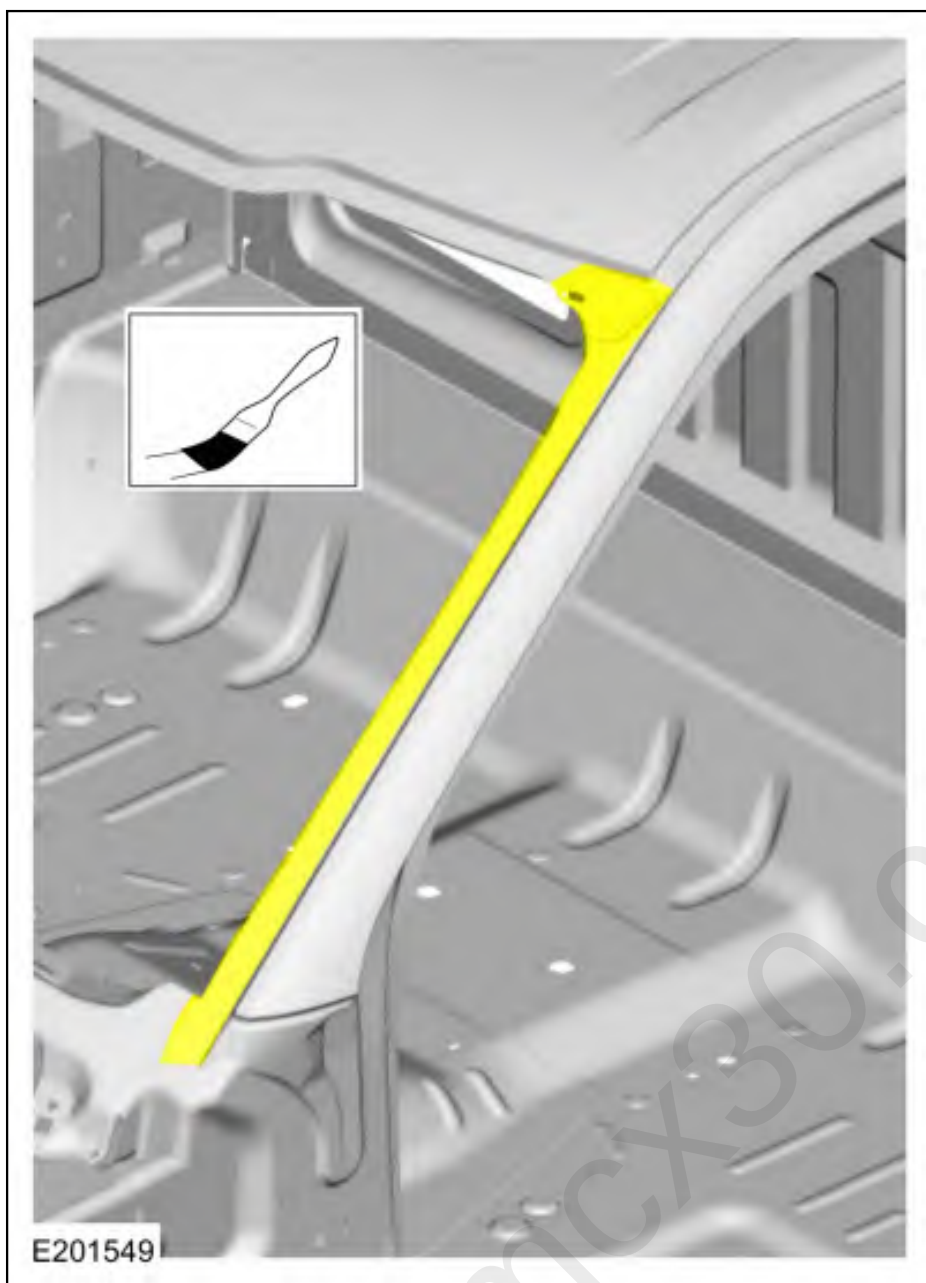


E201548

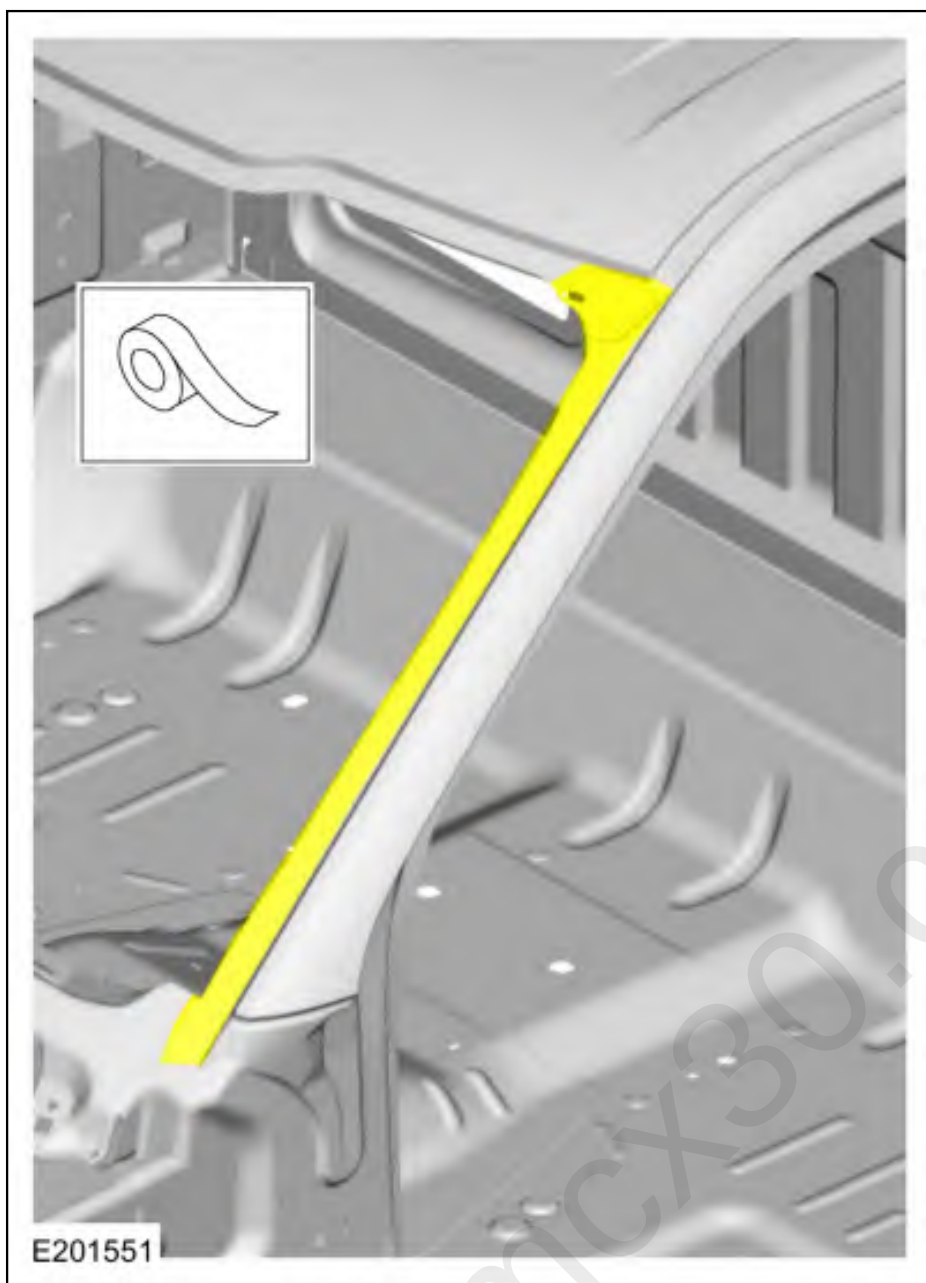


36. Epoxy prime.

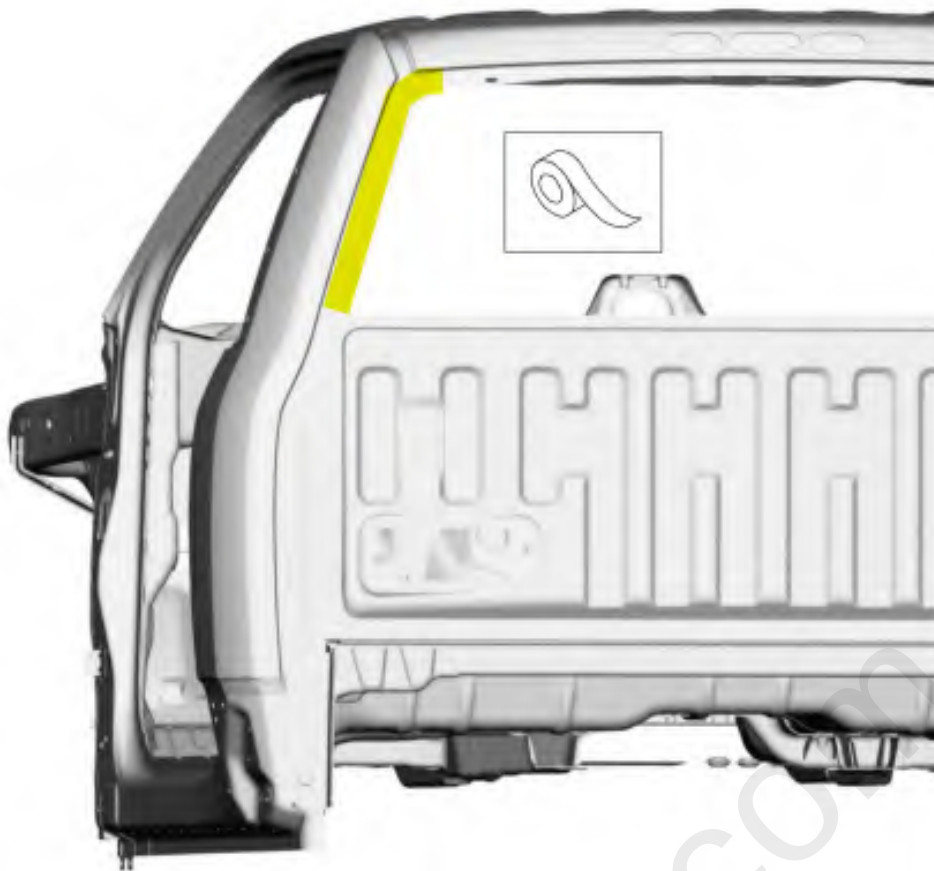
Prime the windshield glass opening channel using a Ford approved epoxy-based primer.



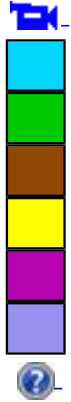
37. Mask the windshield glass opening channel.



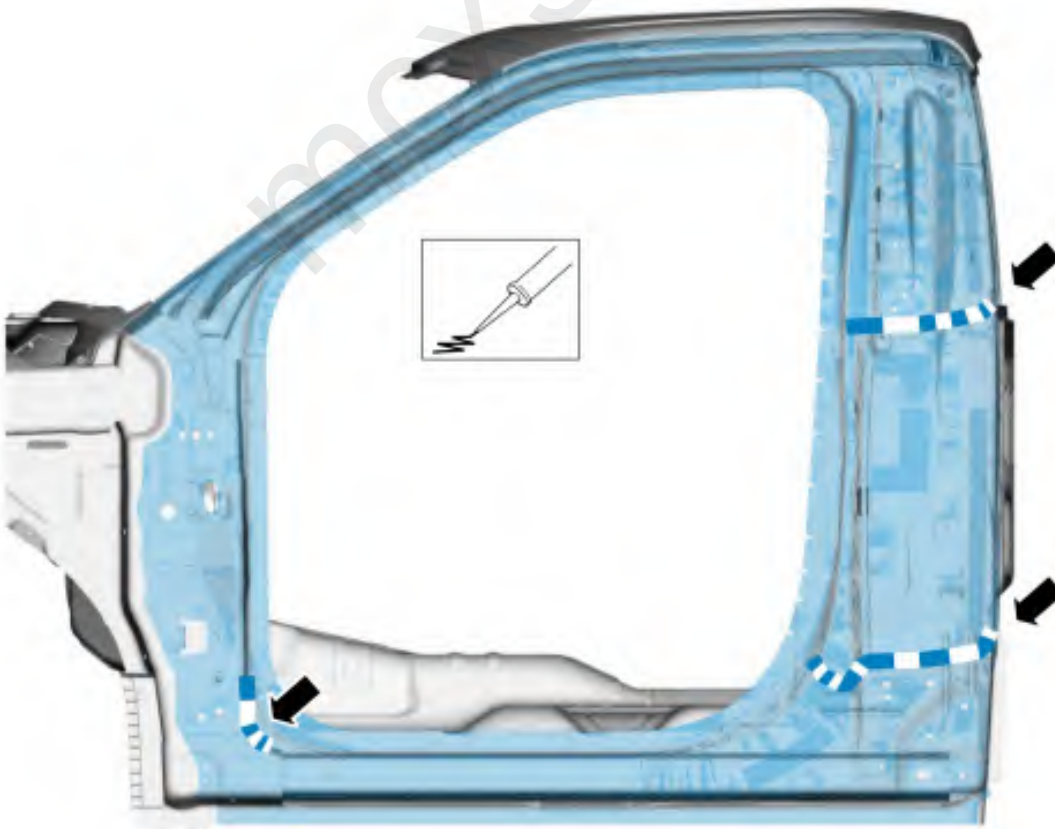
38. Mask the rear window glass opening channel.



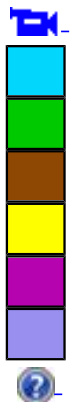
E201550



39. Apply NVH foam to all locations noted during removal to assure complete sealing.
Material: Flexible Foam Repair / 3M™ 08463, LORD Fusor® 121



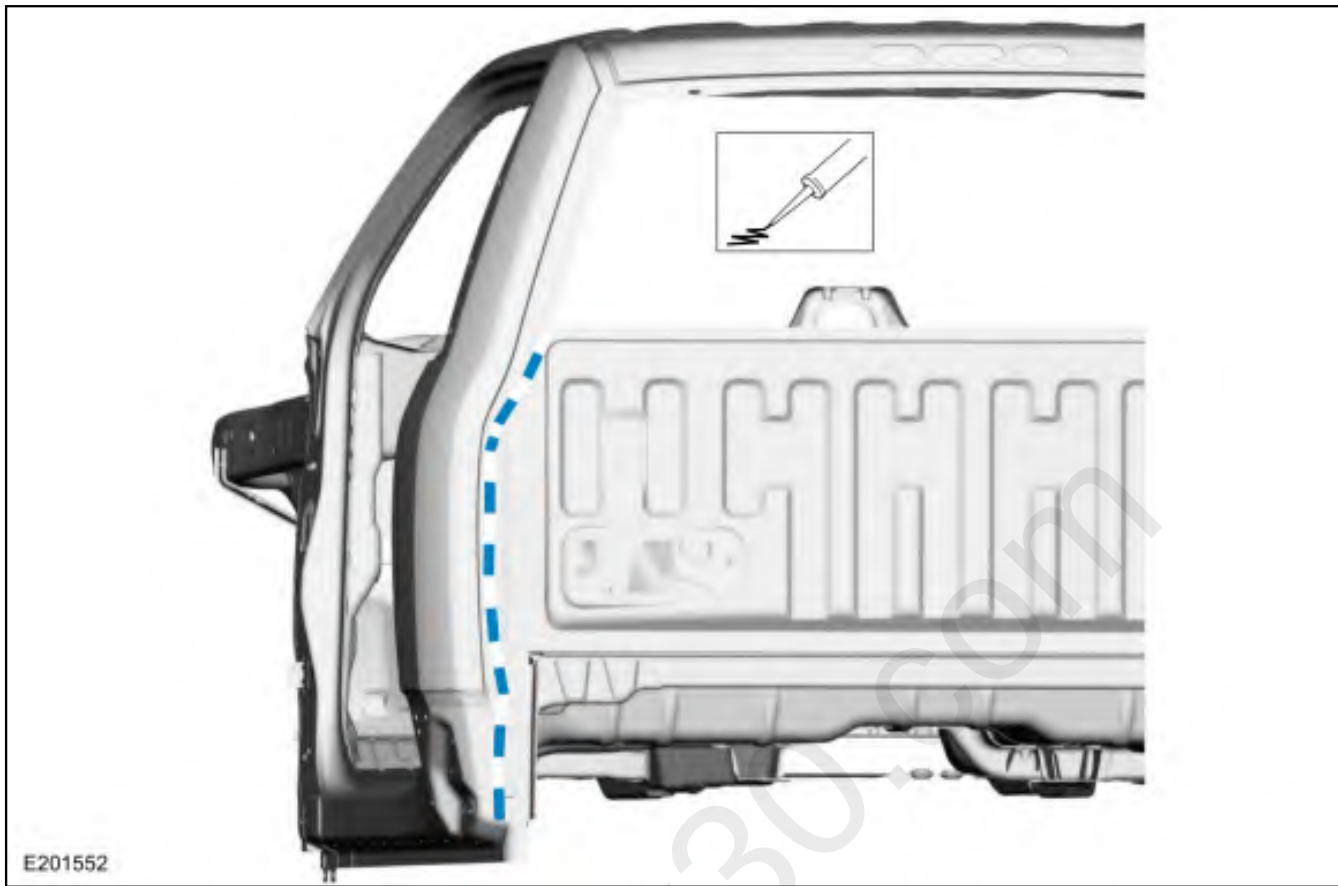
E201553



40. Seam Sealing:

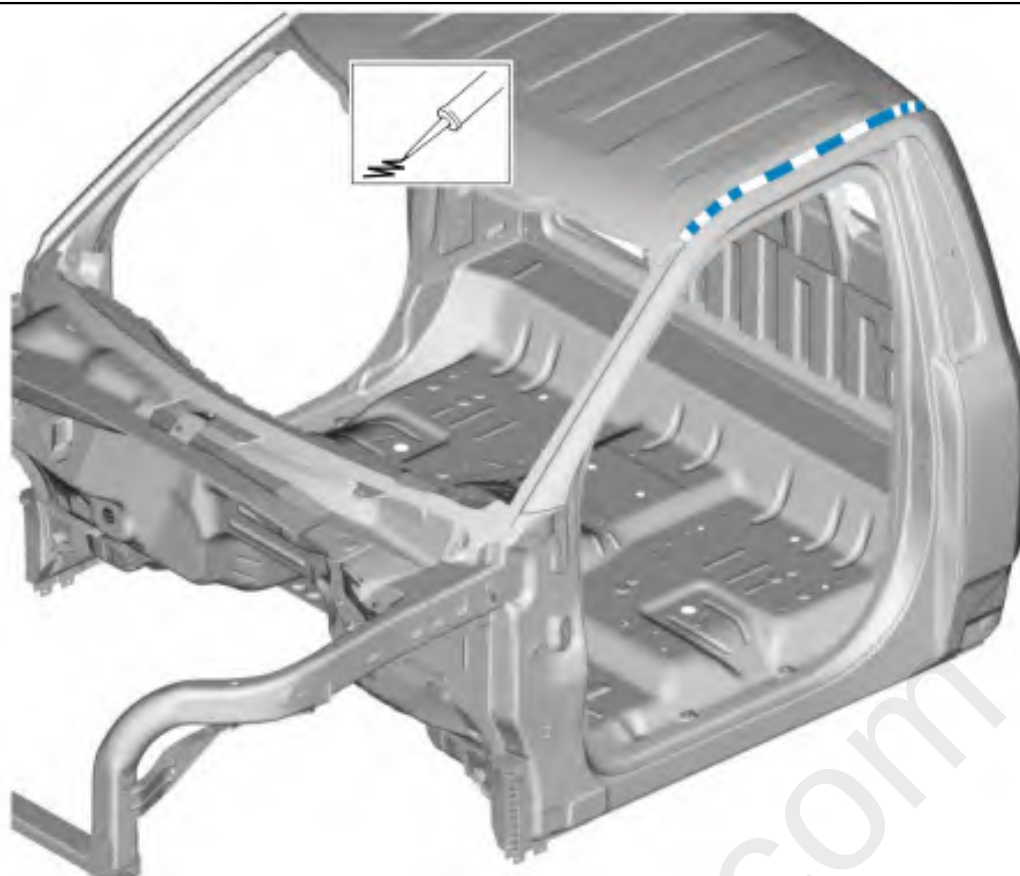
All seams must be sealed to production level.

Material: Seam Sealer / TA-2-B, 3M™ 08308, LORD Fusor® 805DTM



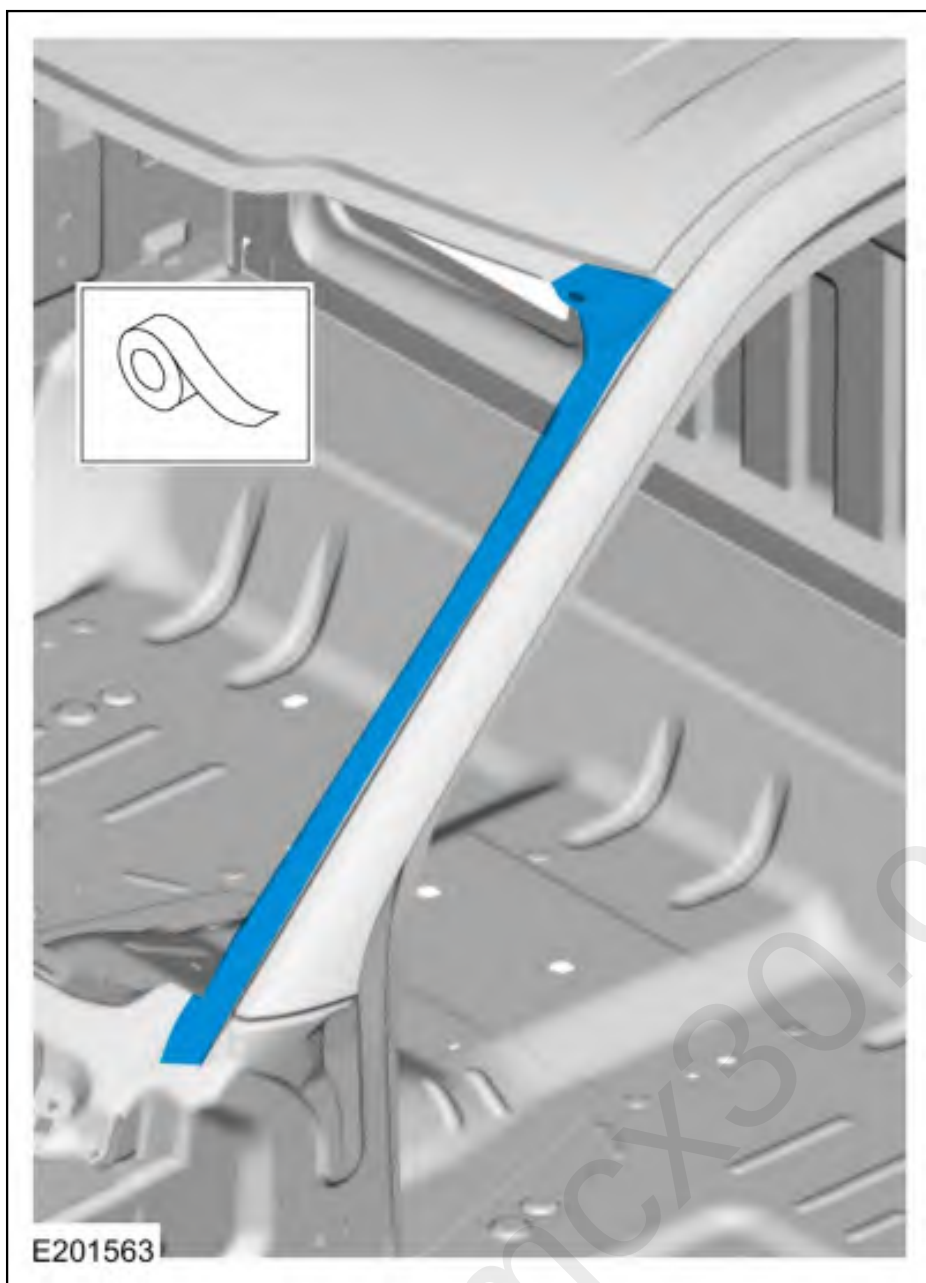
41. Apply roof ditch sealer.

Material: Roof Ditch Sealer / 3M™ 08307, LORD Fusor® 122EZ

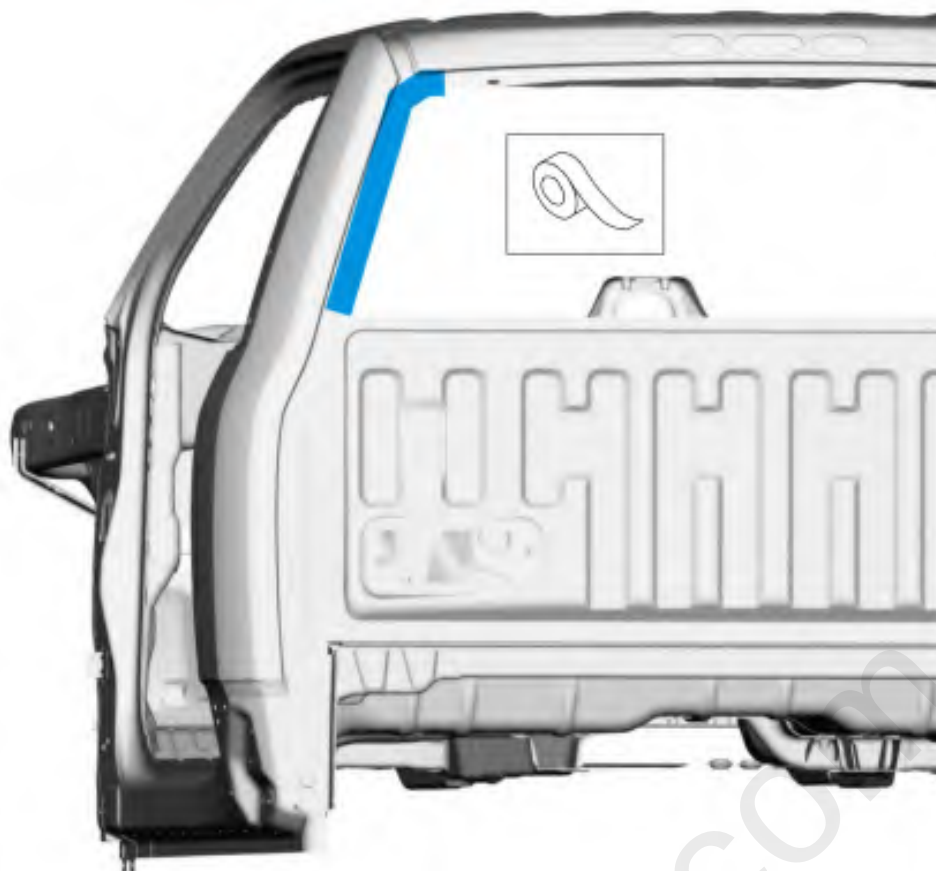


42. Refinish the entire repair using a Ford approved paint system and typical refinishing techniques.

43. Unmask the windshield glass opening channel.



44. Unmask the rear window glass opening channel.



45. Install the side curtain air bag.
Refer to: [Side Curtain Airbag - Regular Cab](#) (501-20B Supplemental Restraint System, Removal and Installation).
46. Install the door opening weather strips and scuff plate.
47. Install the windshield and rear window glass.
Refer to: [Fixed Glass](#) (501-11 Glass, Frames and Mechanisms, General Procedures).
48. Install the door hinges and striker.
 - Door hinges.
Torque: 21 lb.ft (28 Nm)
 - Striker.
Torque: 18 lb.ft (25 Nm)
49. Install the A and C-pillar trim.
Refer to: [A-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: [C-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
50. Install the outer body trim.
Refer to: [Bodyside Moulding](#) (501-08 Exterior Trim and Ornamentation, Removal and Installation).
Refer to: [Rear Quarter Panel Moulding](#) (501-08 Exterior Trim and Ornamentation, Removal and Installation).
Refer to: [Roof Moulding](#) (501-08 Exterior Trim and Ornamentation, Removal and Installation).
51. Install the pickup box.
Refer to: [Pickup Bed](#) (501-04 Pickup Bed and Platform Body, Removal and Installation).

52. Install the fender.

Refer to: [Fender](#) (501-02 Front End Body Panels, Removal and Installation).

53. Install and align the door.

Refer to: [Front Door - Regular Cab/SuperCrew](#) (501-03 Body Closures, Removal and Installation).

Refer to: [Front Door Alignment - Regular Cab/SuperCrew](#) (501-03 Body Closures, General Procedures).

54. Repower the SRS.

Refer to: [Supplemental Restraint System \(SRS\) Repowering](#) (501-20B Supplemental Restraint System, General Procedures).