

C-Pillar Reinforcement

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	-

Removal

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

All vehicles

1. Depower the SRS.
Refer to: [Supplemental Restraint System \(SRS\) Depowering](#) (501-20B Supplemental Restraint System, General Procedures).
2. Remove the side curtain air bag.

Refer to: [Side Curtain Airbag - Regular Cab](#) (501-20B Supplemental Restraint System, Removal and Installation).

Refer to: [Side Curtain Airbag - SuperCab](#) (501-20B Supplemental Restraint System, Removal and Installation).

Refer to: [Side Curtain Airbag - SuperCrew](#) (501-20B Supplemental Restraint System, Removal and Installation).

Regular Cab and SuperCrew Cab

3. Remove the door striker (front door on regular cab, rear door on SuperCrew cab).



SuperCab and SuperCrew Cab

4. Remove the rear seat.

Refer to: [Rear Seat LH - SuperCab](#) (501-10B Rear Seats, Removal and Installation).

Refer to: [Rear Seat LH - SuperCrew](#) (501-10B Rear Seats, Removal and Installation).

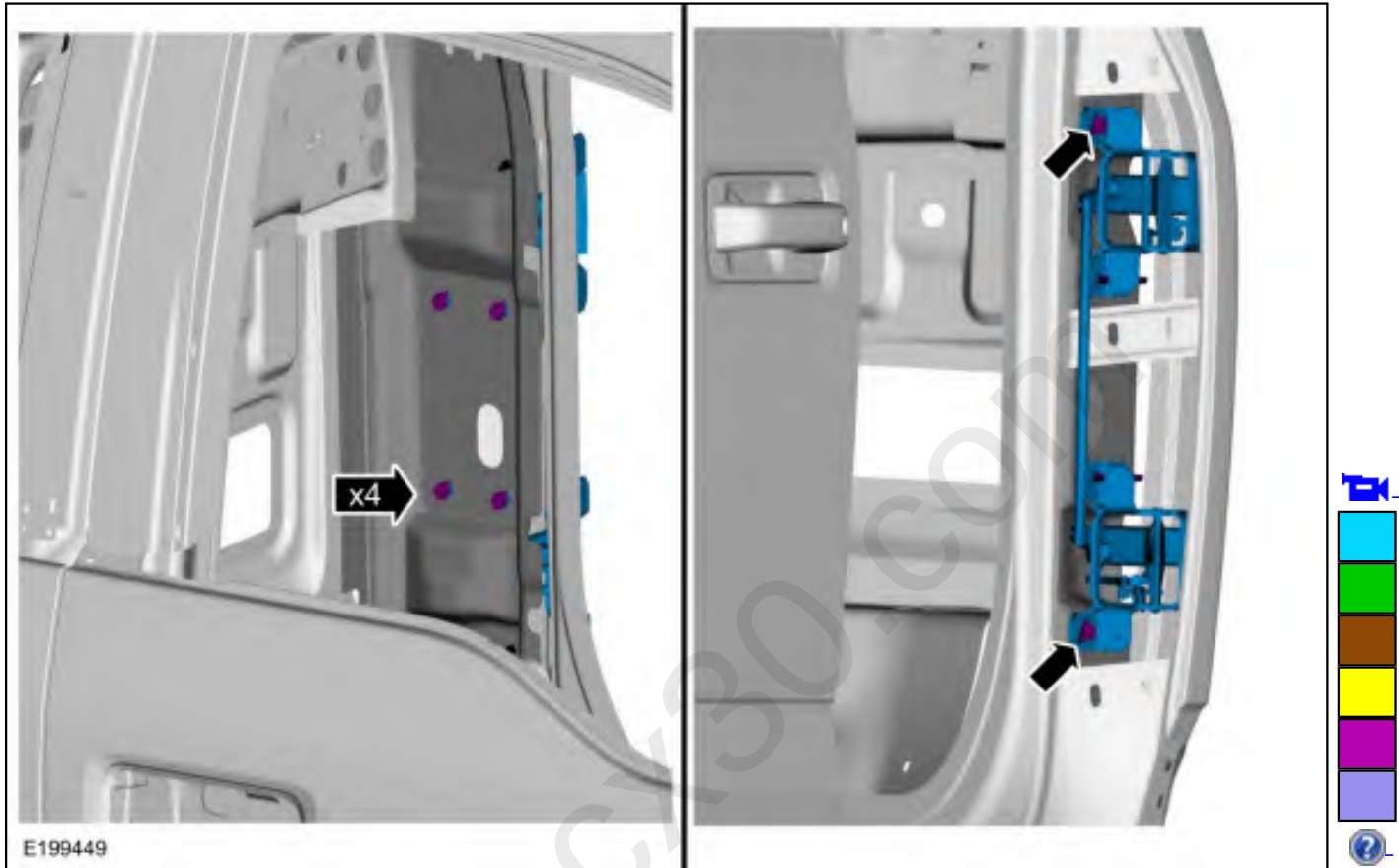
Regular Cab

5. Remove the front seat.

Refer to: [Front Seat](#) (501-10A Front Seats, Removal and Installation).

SuperCab

6. Remove the rear door hinge.



All vehicles

7. Remove the pickup bed.

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

8. Remove the exterior trim.

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

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

9. Remove the safety belt.

Refer to: [Front Seatbelt Retractor and Pretensioner - Regular Cab](#) (501-20A Seatbelt Systems, Removal and Installation).

Refer to: [Seatbelt Shoulder Height Adjuster - Regular Cab](#) (501-20A Seatbelt Systems, Removal and Installation).

Refer to: [Rear Outer Seatbelt Lower Retractor - Vehicles With: Inflatable Seatbelts](#) (501-20A Seatbelt Systems, Removal and Installation).

Refer to: [Rear Outer Seatbelt Upper Retractor - Vehicles With: Inflatable Seatbelts](#) (501-20A Seatbelt Systems,

Removal and Installation).

10. Remove the door opening scuff plate and position the carpeting and wiring harness aside.

11. Remove the door opening weather strip.

12. Remove the loadspace trim panel.

Refer to: [Loadspace Trim Panel - Regular Cab](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).

Refer to: [Loadspace Trim Panel - SuperCab/SuperCrew](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).

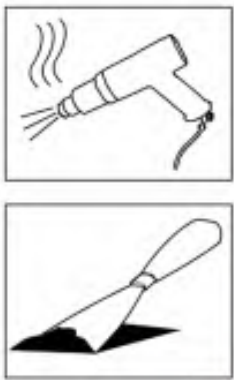
13. Remove the rear window glass.

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

14. Remove the cab back seam sealer.

Use the General Equipment: Hot Air Gun

Use the General Equipment: Scraper for Straight Edges



E199450



15. Remove the SPR fasteners.

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

Use the General Equipment: Belt Sander



E199451



16. Remove the SPR fasteners.

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

Use the General Equipment: Belt Sander



E199452



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

NOTE: Body cut lines are approximate and may be adjusted for conditions.

Carefully cut the **outer panel only**.

Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter



E199453

18. **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.



E199454



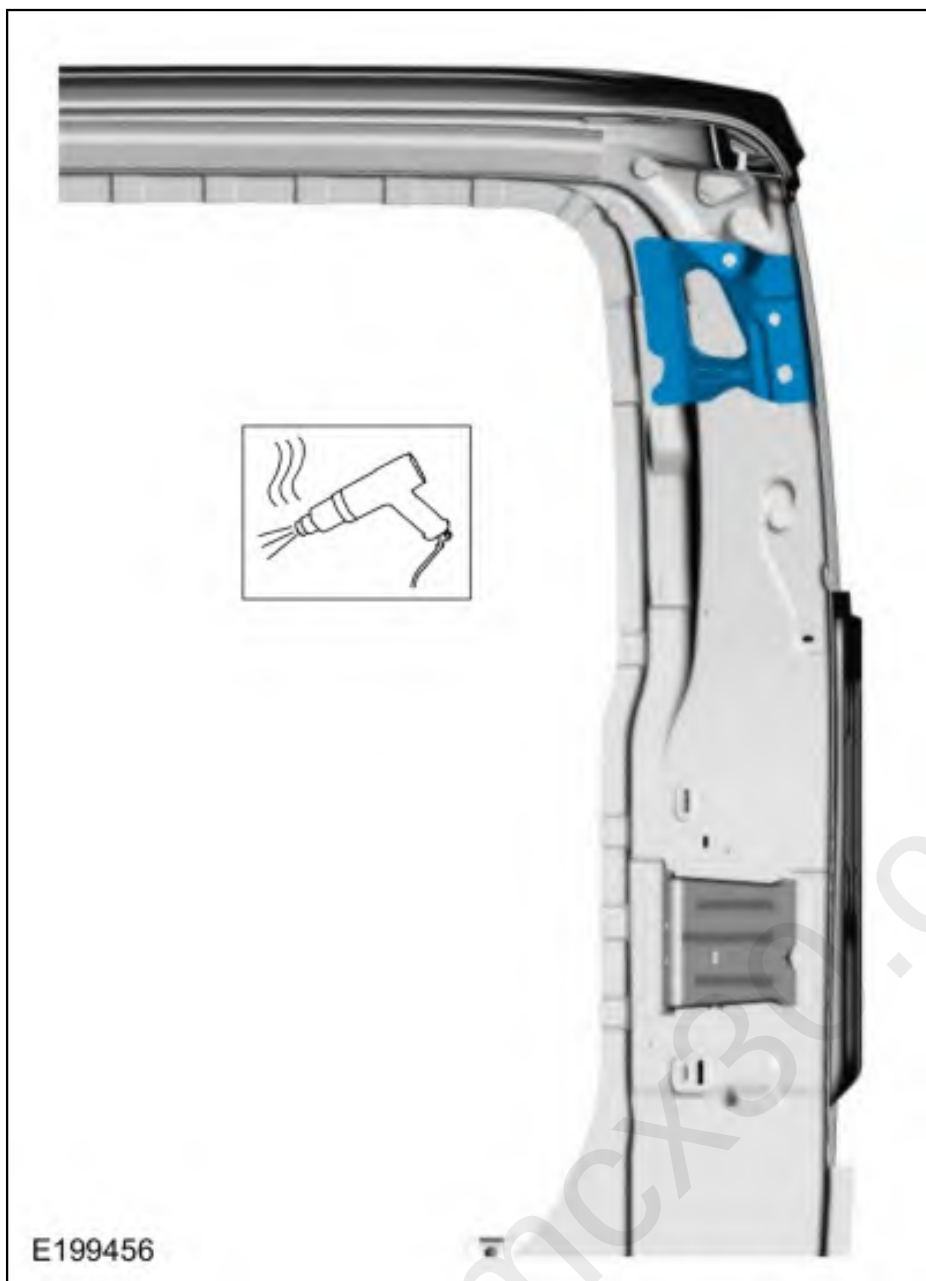
SuperCrew Cab

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



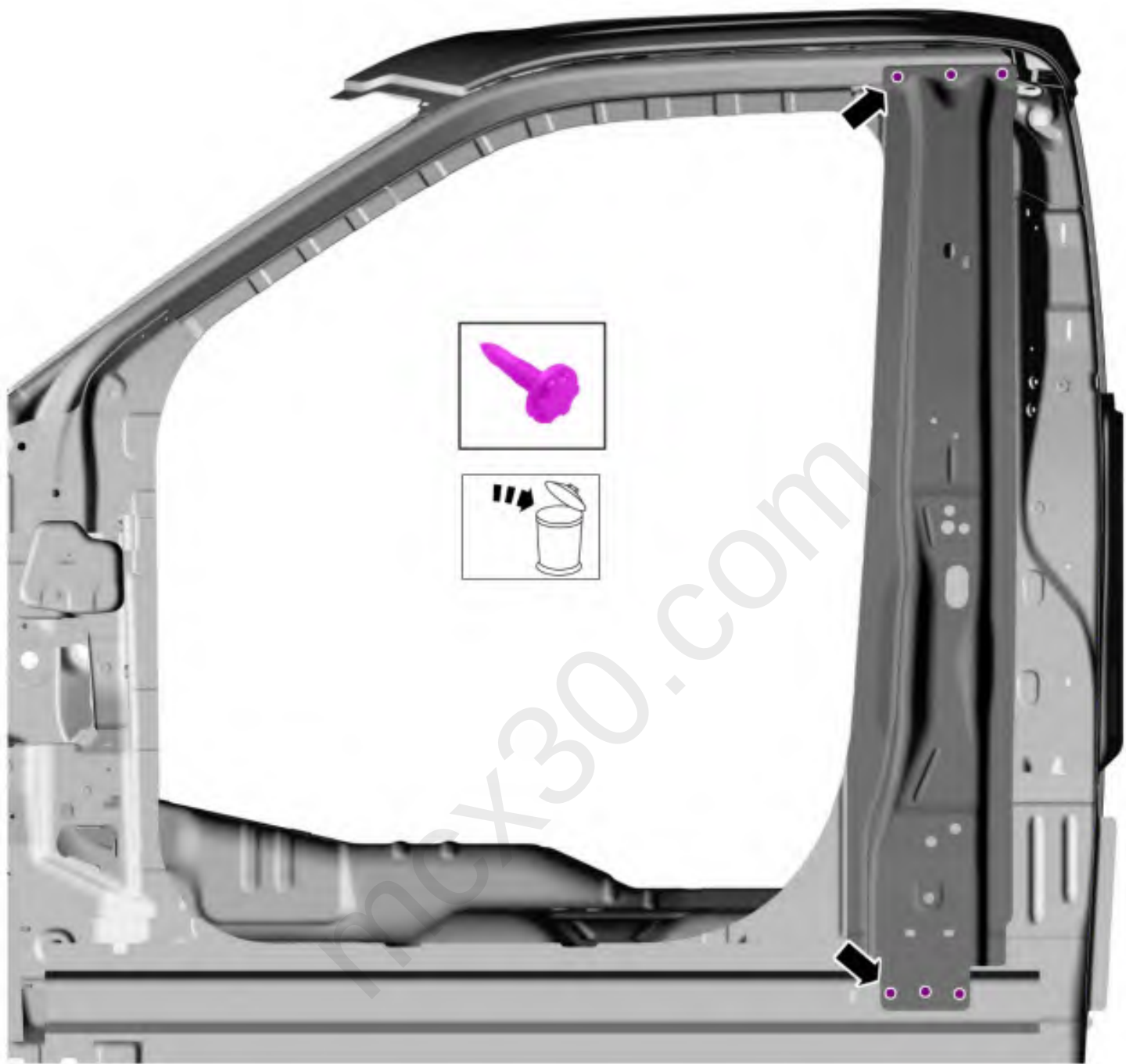
20. **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many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



All vehicles

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



E201725

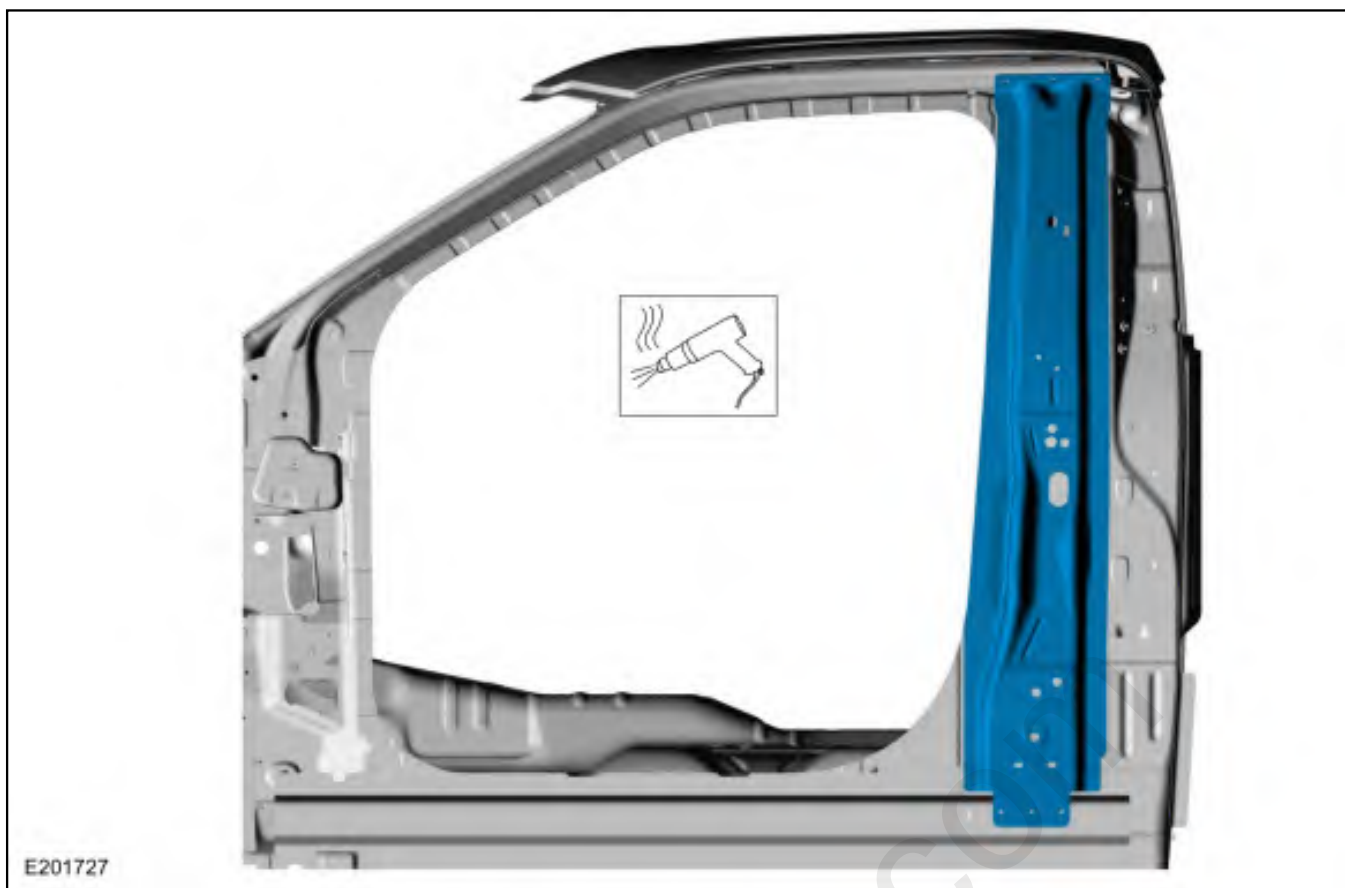


22. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander

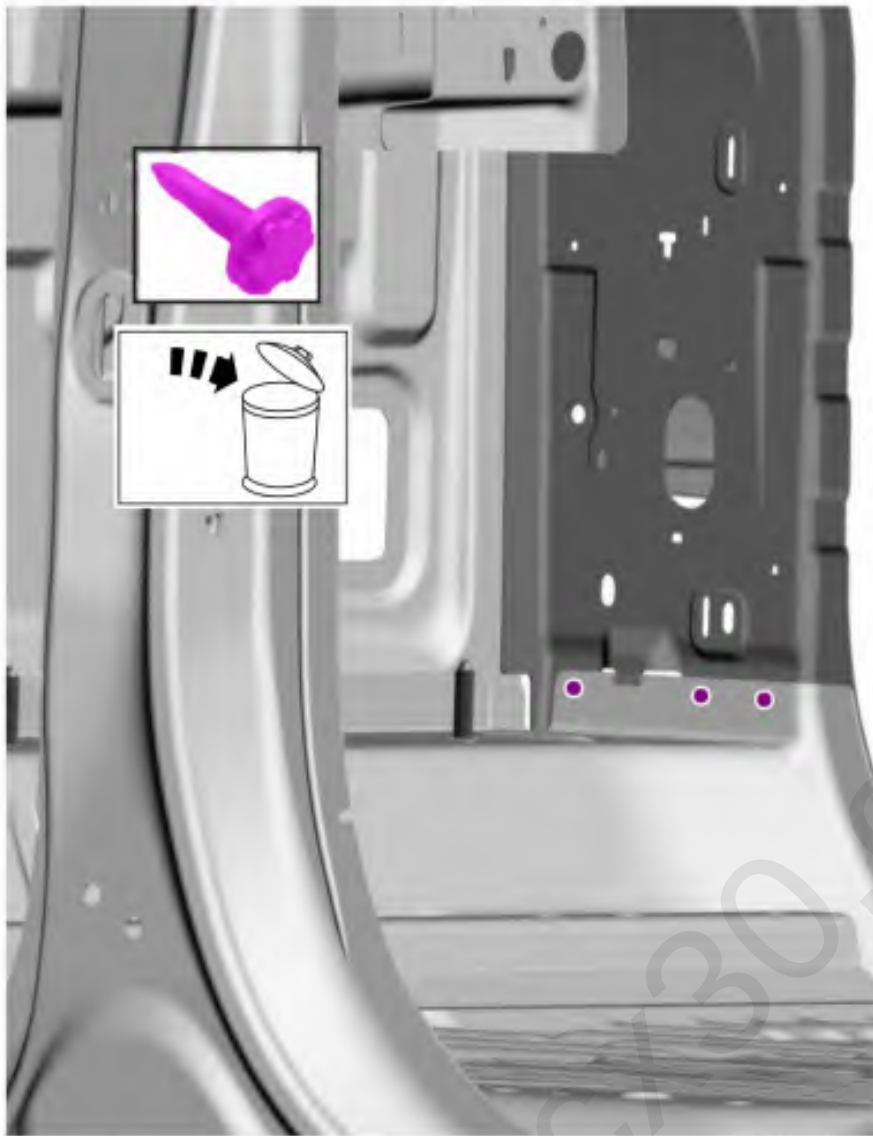


23. **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many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



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



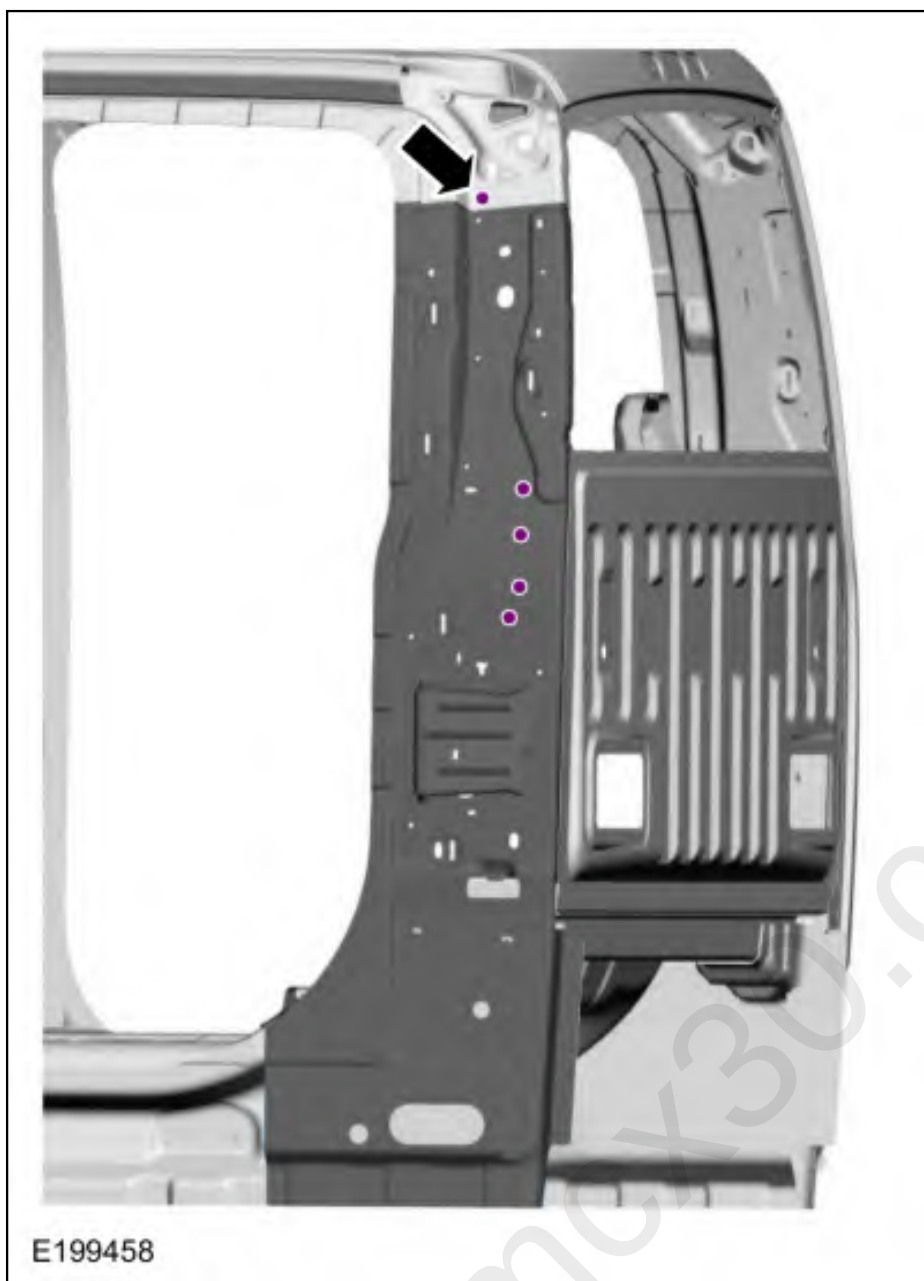
E199457



25. Remove the fasteners.

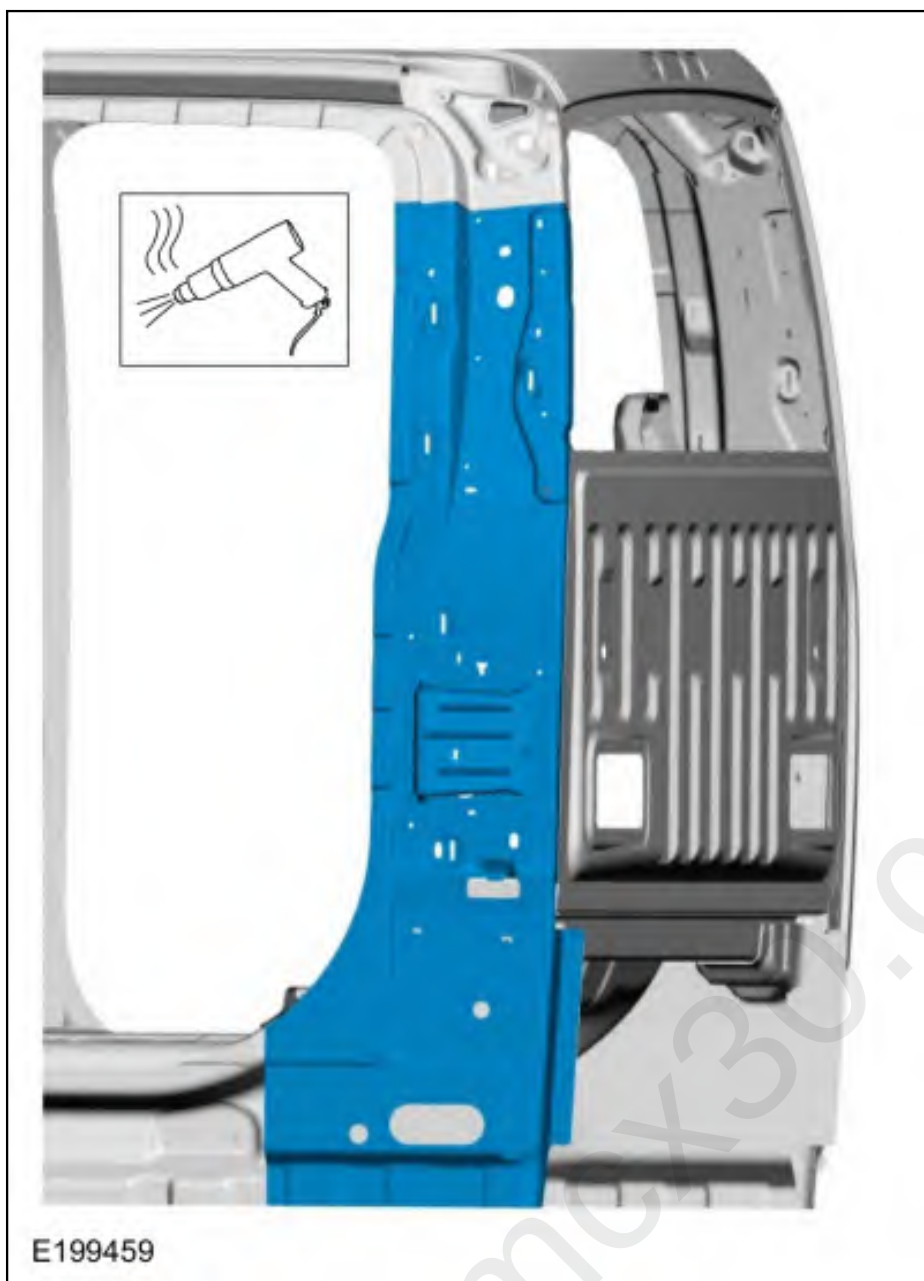
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Belt Sander



26. **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 C-pillar.
Use the General Equipment: Hot Air Gun



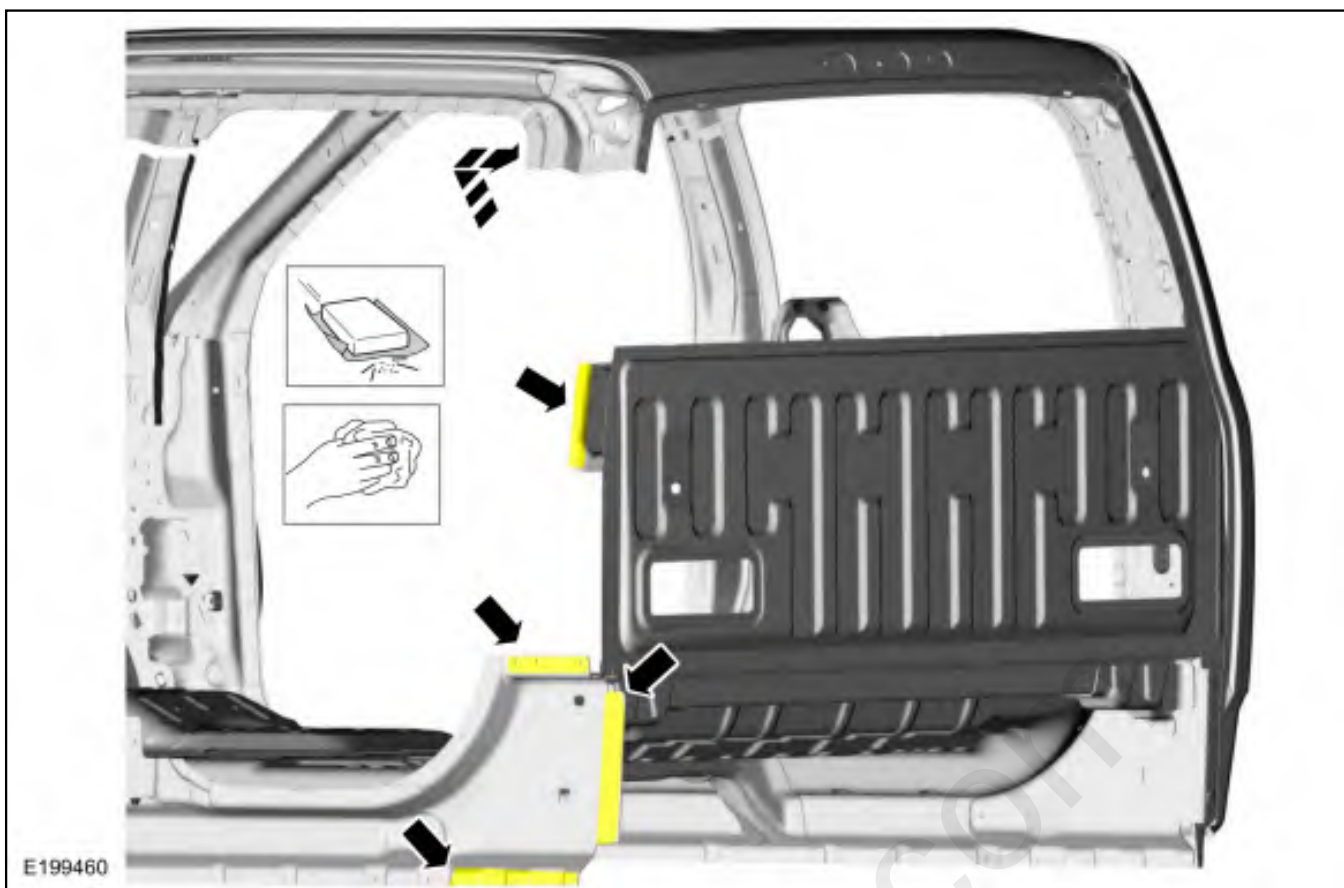
Installation

NOTICE: Body side sectioning is prohibited within 50mm 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.

All vehicles

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



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



E199461



3. Apply adhesive to the service part mating surfaces.

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



E199462

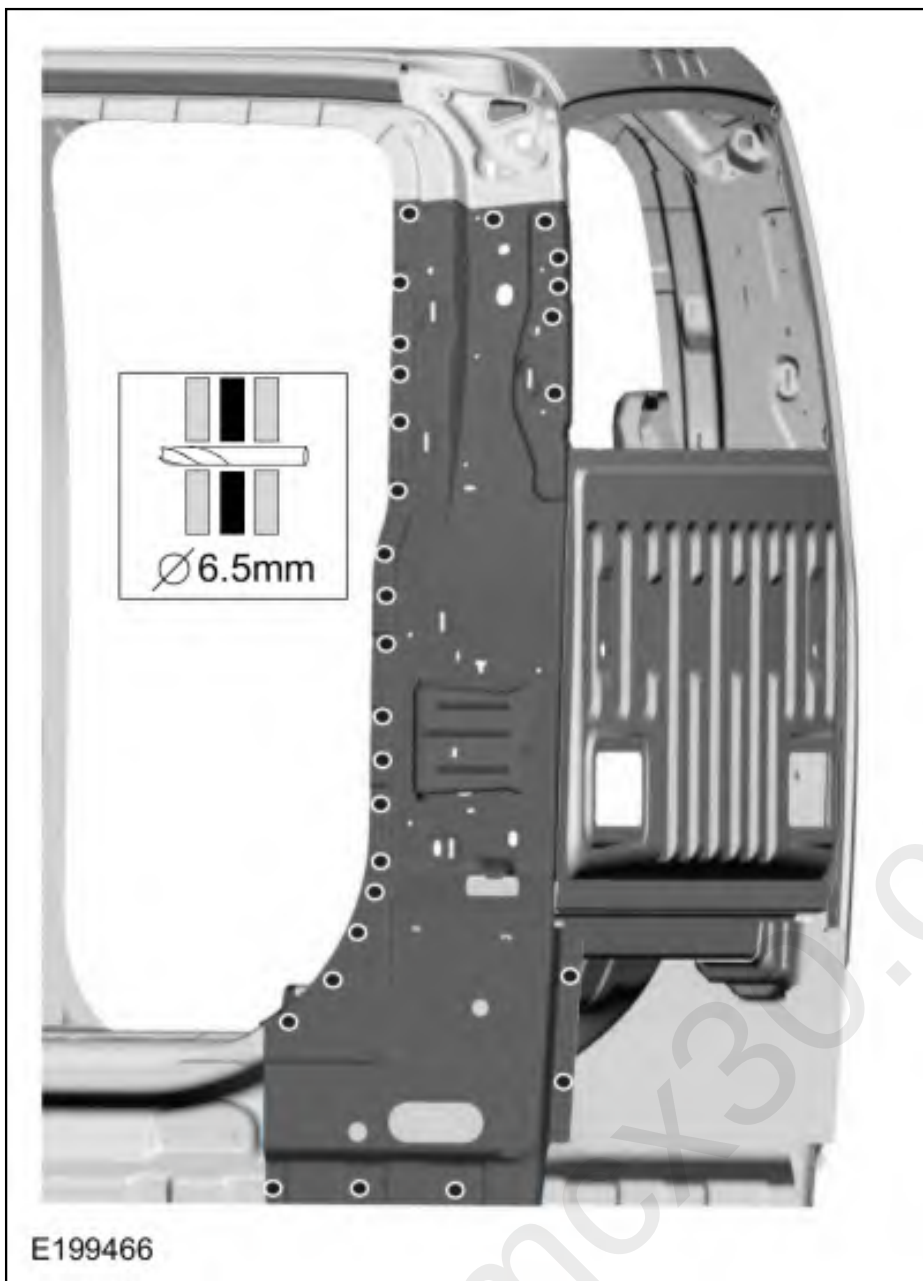


4. Install the C-pillar reinforcement and clamp in position.
Use the General Equipment: Locking Pliers



Regular Cab/SuperCrew

5. Drill 6.5 mm holes for fastener installation.
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.

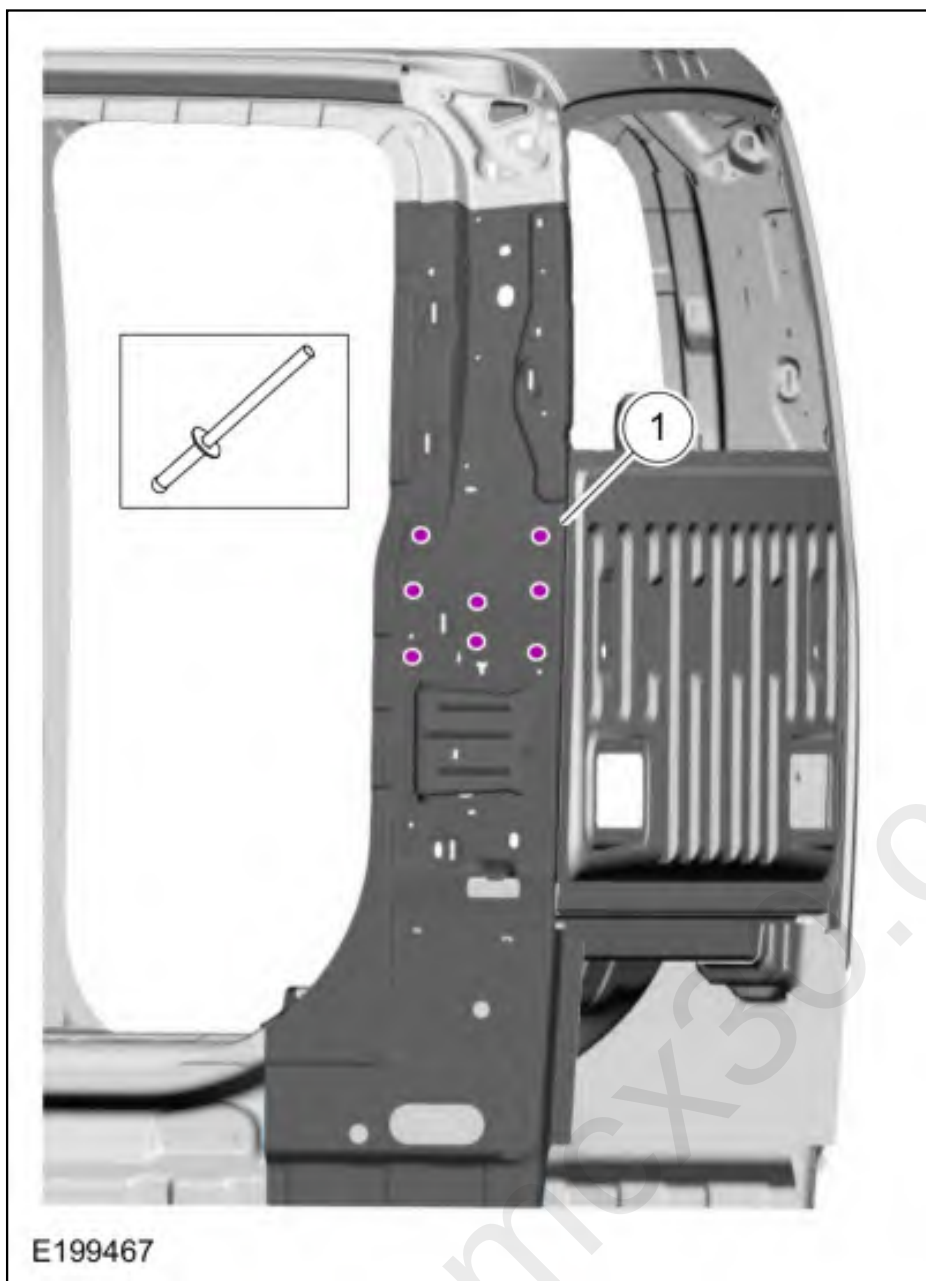
Install the fasteners.

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

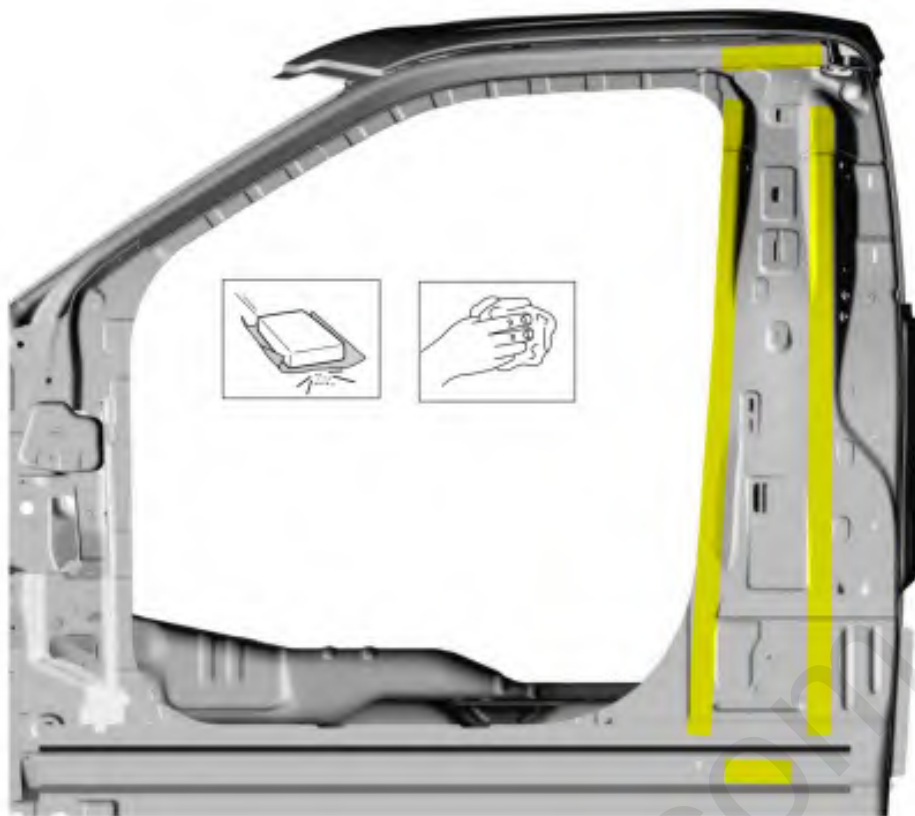
Refer to: [Joining Techniques](#) (501-25 Body Repairs - General Information, General Procedures).

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

Use the General Equipment: Blind Rivet Gun



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

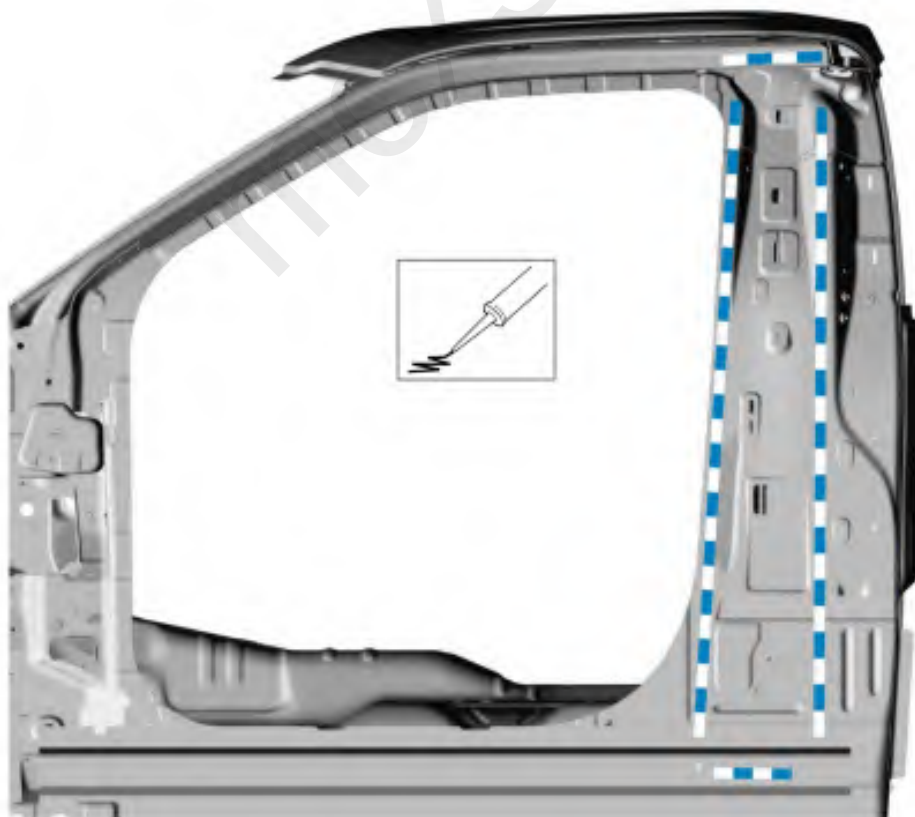


E201736



8. Apply adhesive.

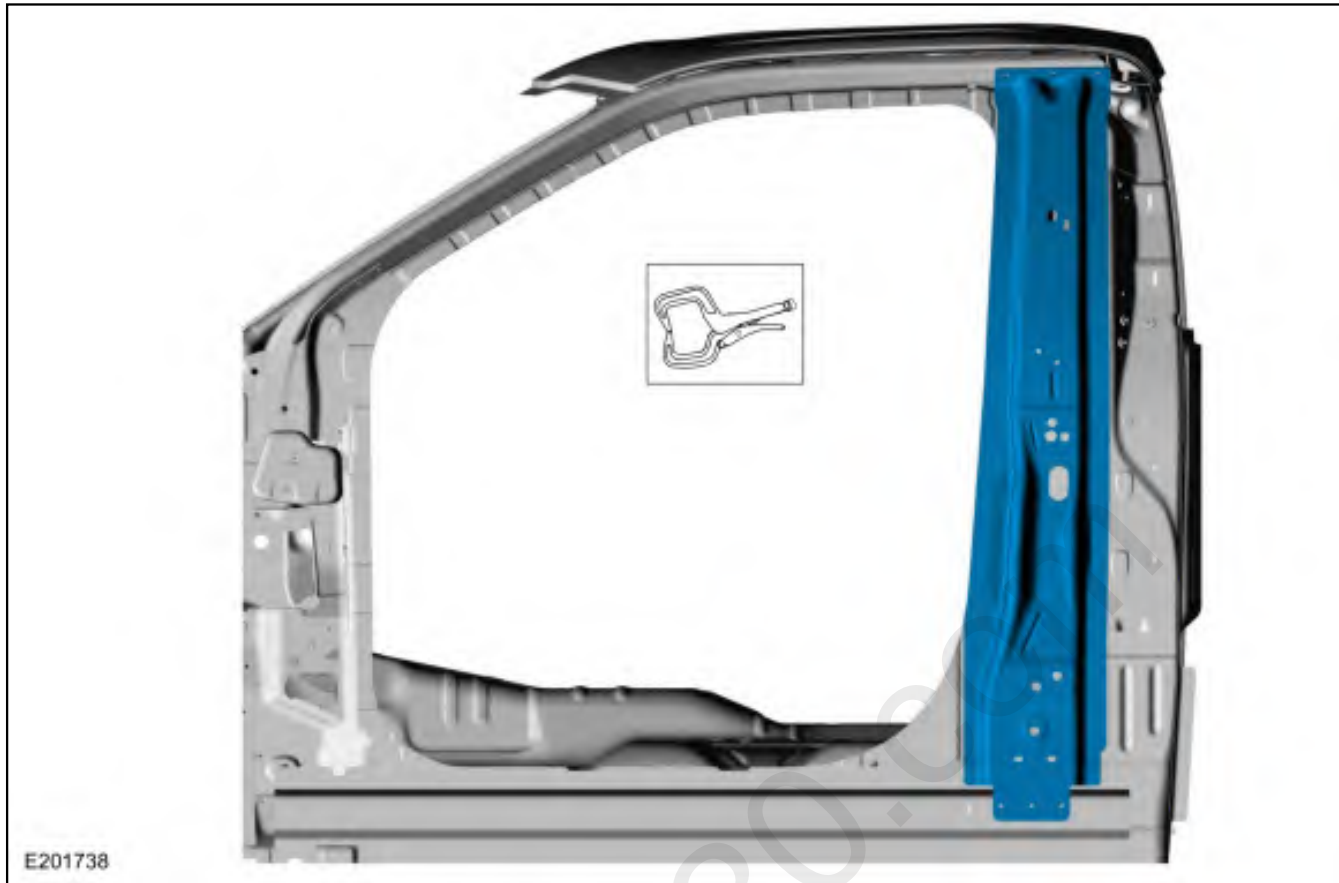
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B



E201737



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



10. Drill 6.5 mm holes for blind rivet fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



11. Install blind rivet fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W702512-S900C	-	-

Use the General Equipment: Blind Rivet Gun



E201740

SuperCab

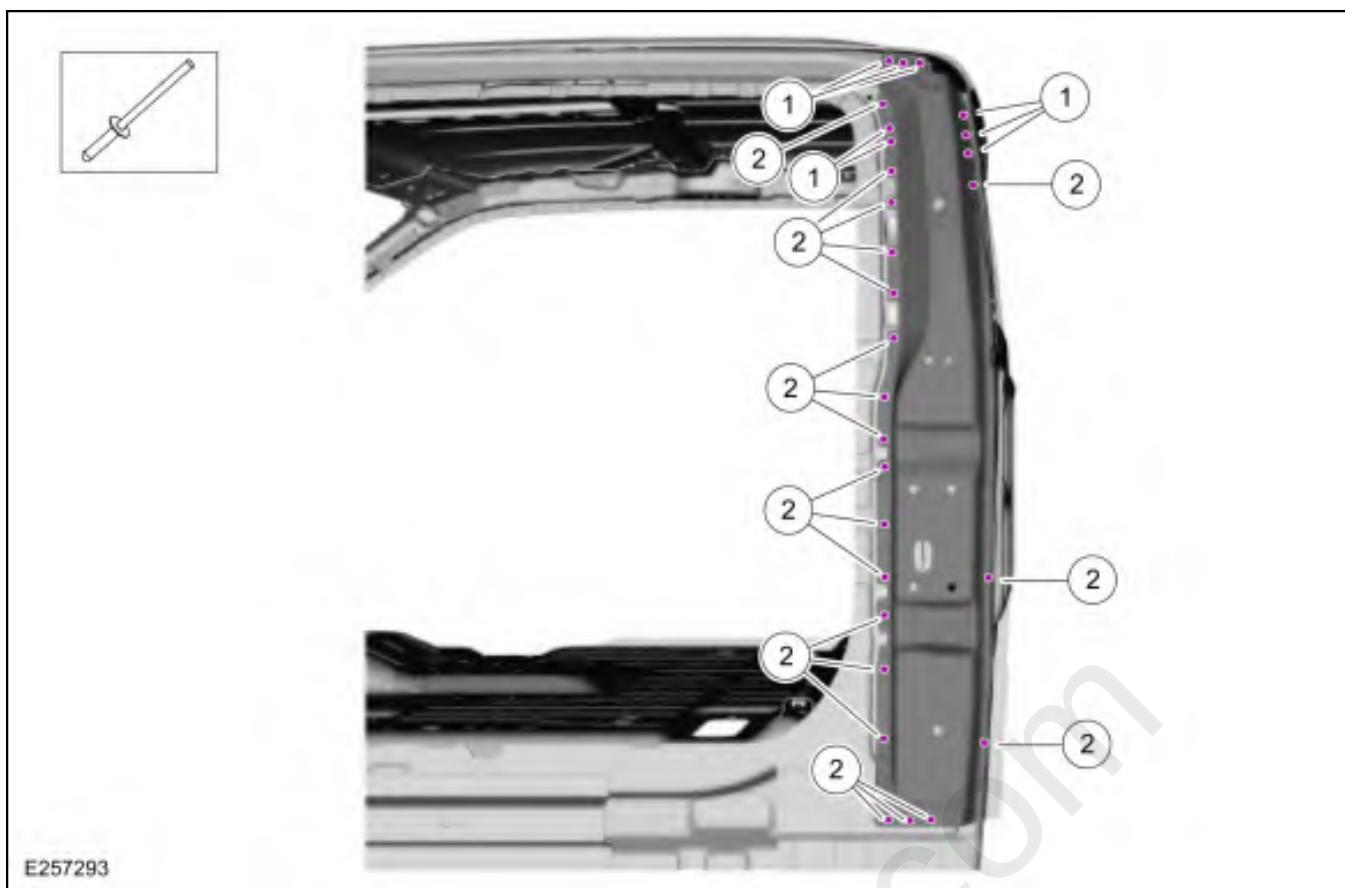
12. Drill for fasteners.
Use the General Equipment: 6.5 mm Drill Bit



13. Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W702512-S900C	-	-

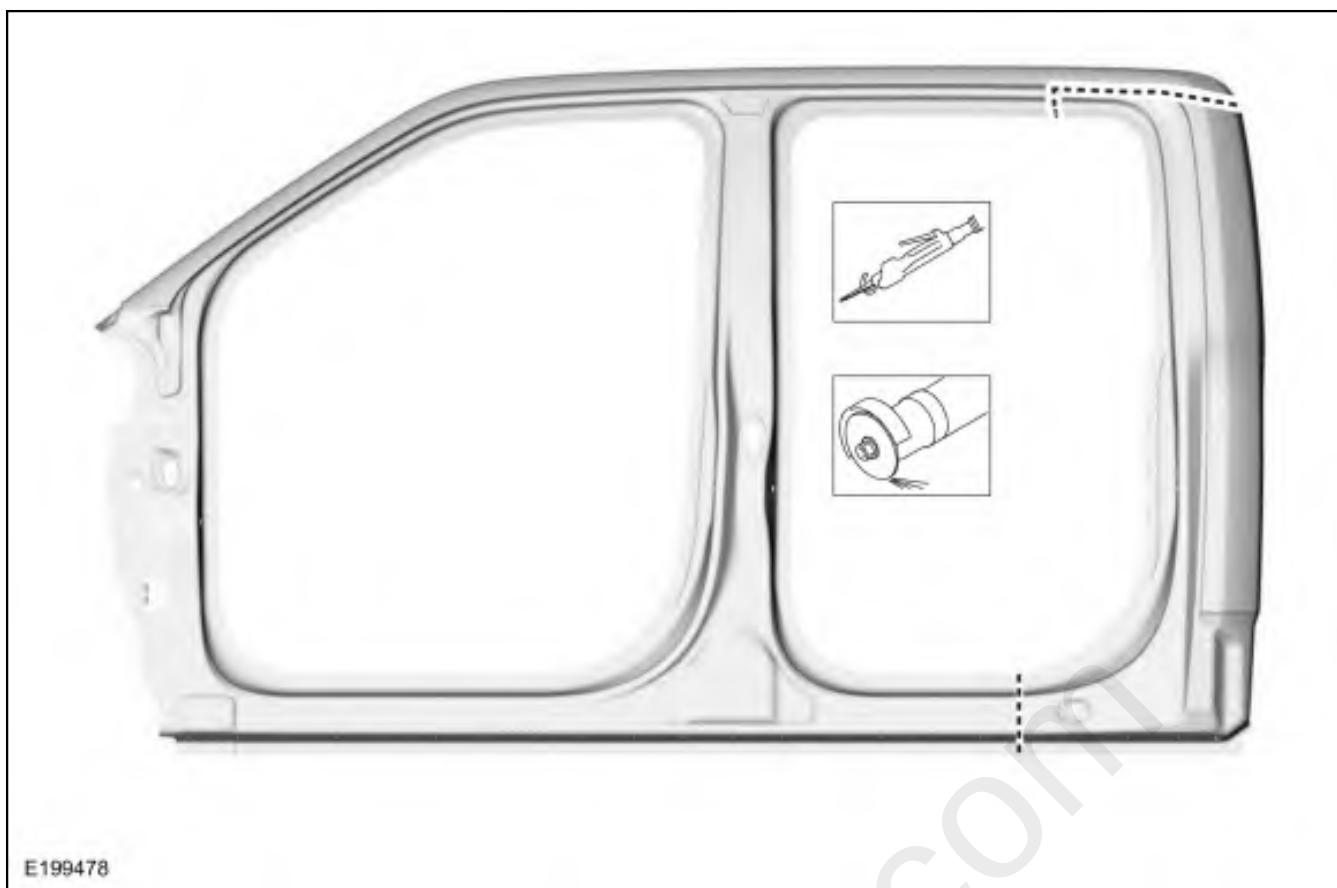
Use the General Equipment: Blind Rivet Gun



All vehicles

14. **NOTE:** *SuperCrew cab shown, regular and SuperCab similar.*

Cut the service panel to fit repair area.

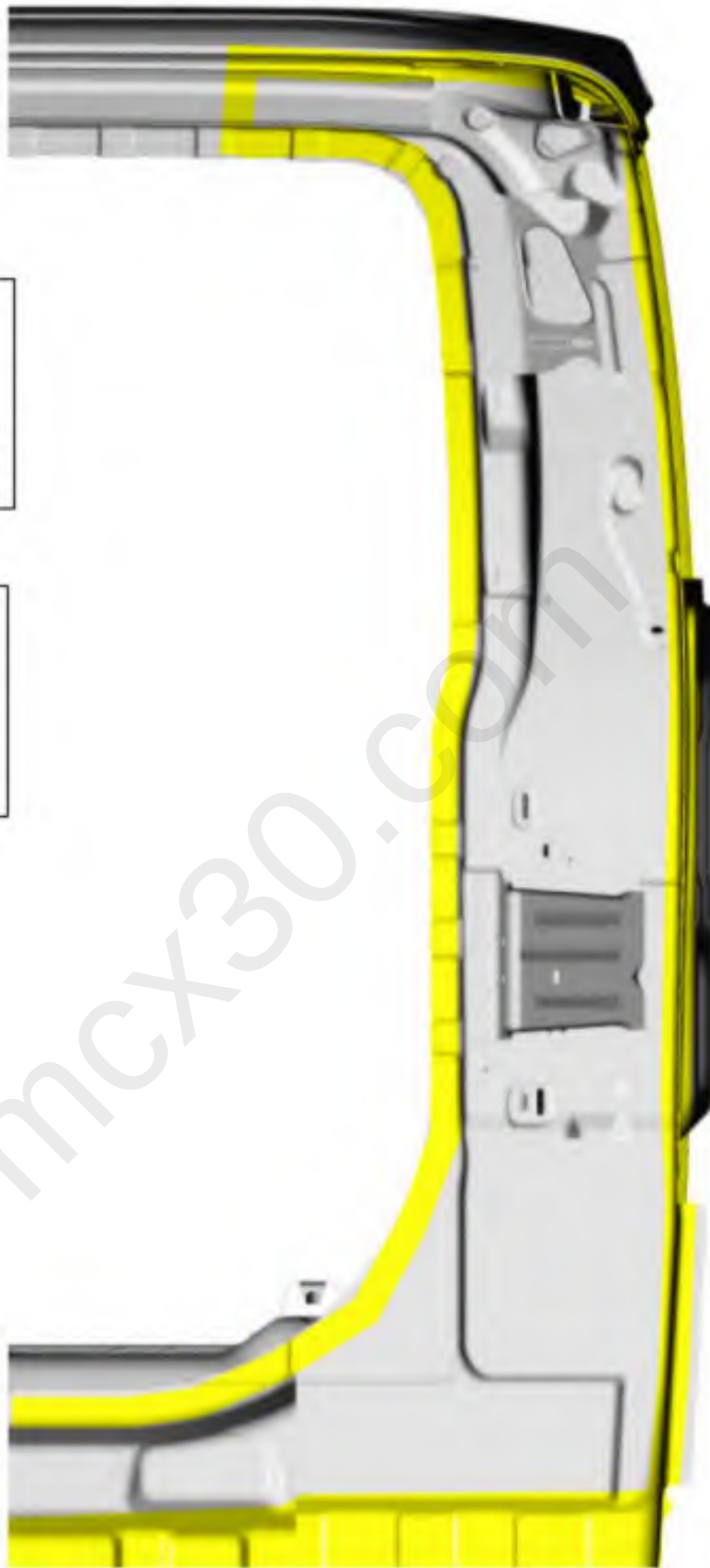


15. **NOTE:** *The use of a backer plate when creating butt-weld joints will produce a stronger and more uniform repair.*

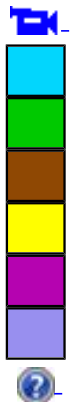
In butt-weld areas: Create a backer plate from an unused portion of the old body panel or replacement service panel and install on the vehicle at each sectioning joint.

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

16. Sand using 80 grit sand paper to remove old adhesive or e-coat and clean.



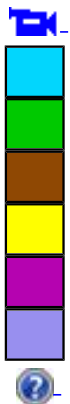
E199479



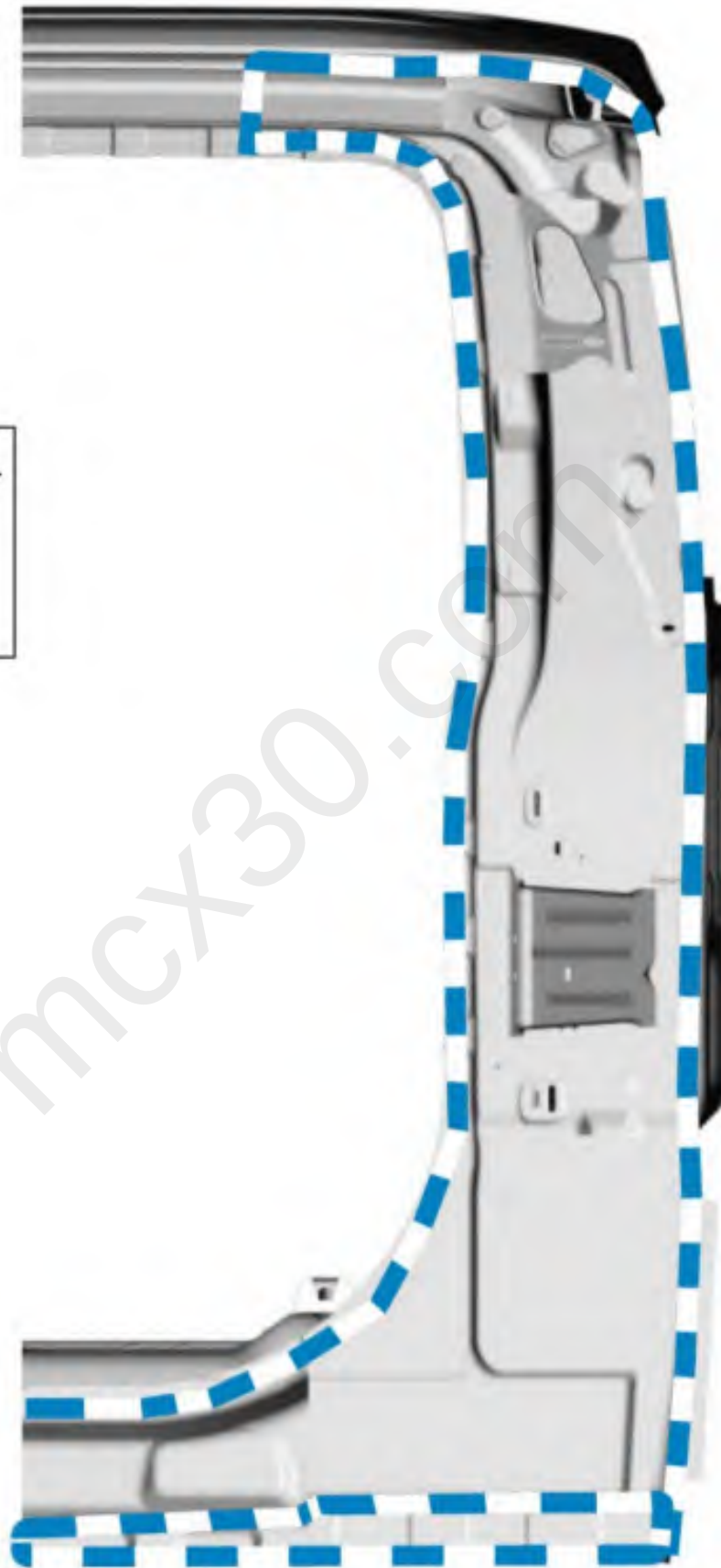
17. Sand the service panel mating surfaces using 80 grit sand paper to remove e-coat and clean.



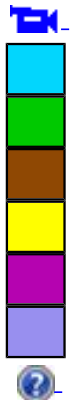
E199480



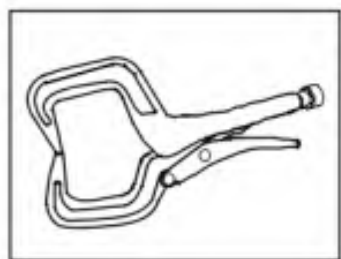
18. Apply adhesive.



E199481



19. Install service panel and clamp in position.
Use the General Equipment: Locking Pliers

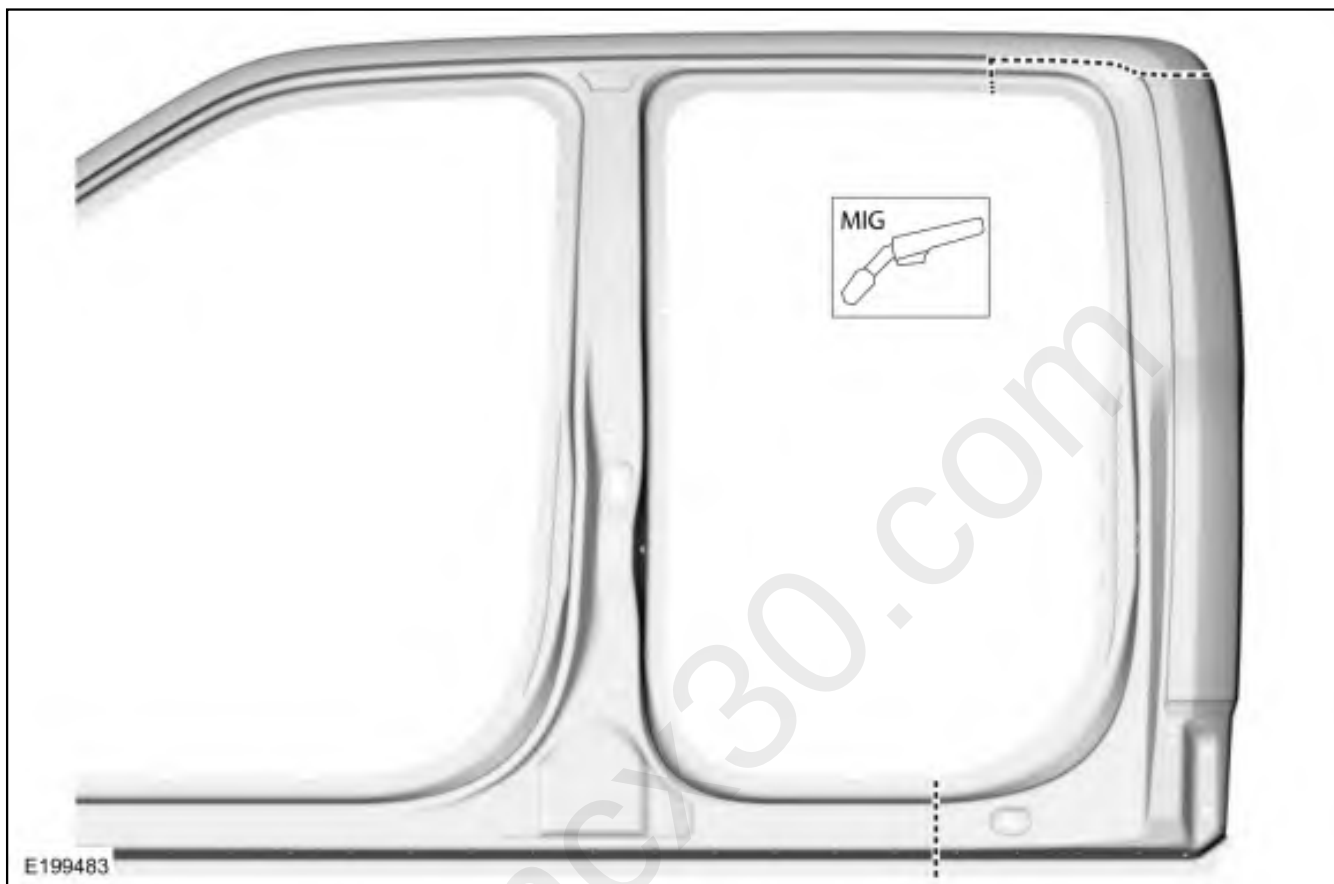


E199482





20. Complete installation of sectioning joint backer plates to service panel.
Refer to: [Joining Techniques](#) (501-25 Body Repairs - General Information, General Procedures).
21. Completely seam weld sectioning joints using a MIG welder set up for aluminum repairs.
Use the General Equipment: MIG/MAG Welding Equipment



SuperCrew

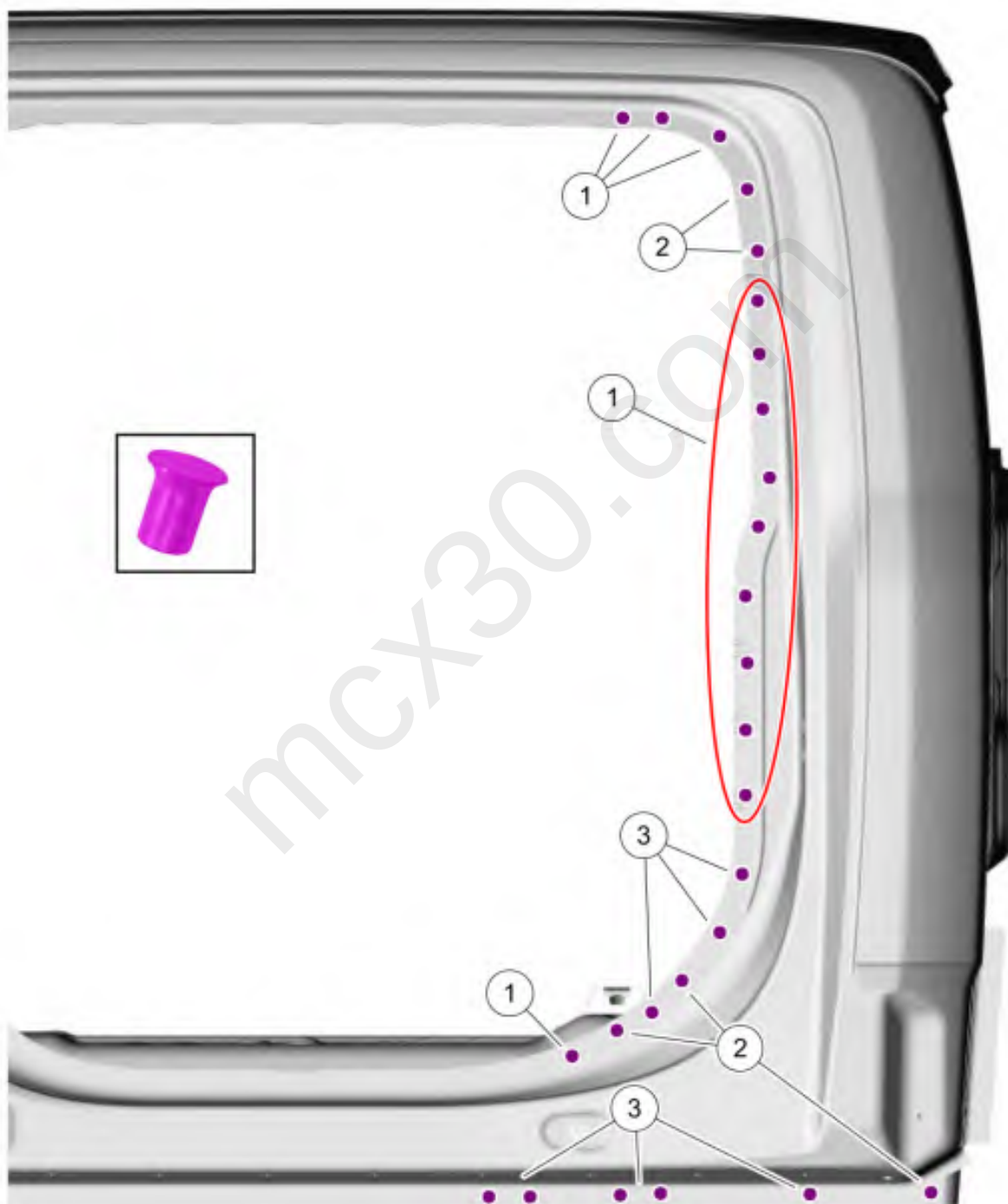
22. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

Install the fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0401	-	W790376-S900	-
2	W708717-S900	AW	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-

3	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
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Refer to: [Joining Techniques](#) (501-25 Body Repairs - General Information, General Procedures).
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer



E199484

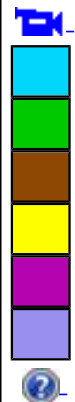
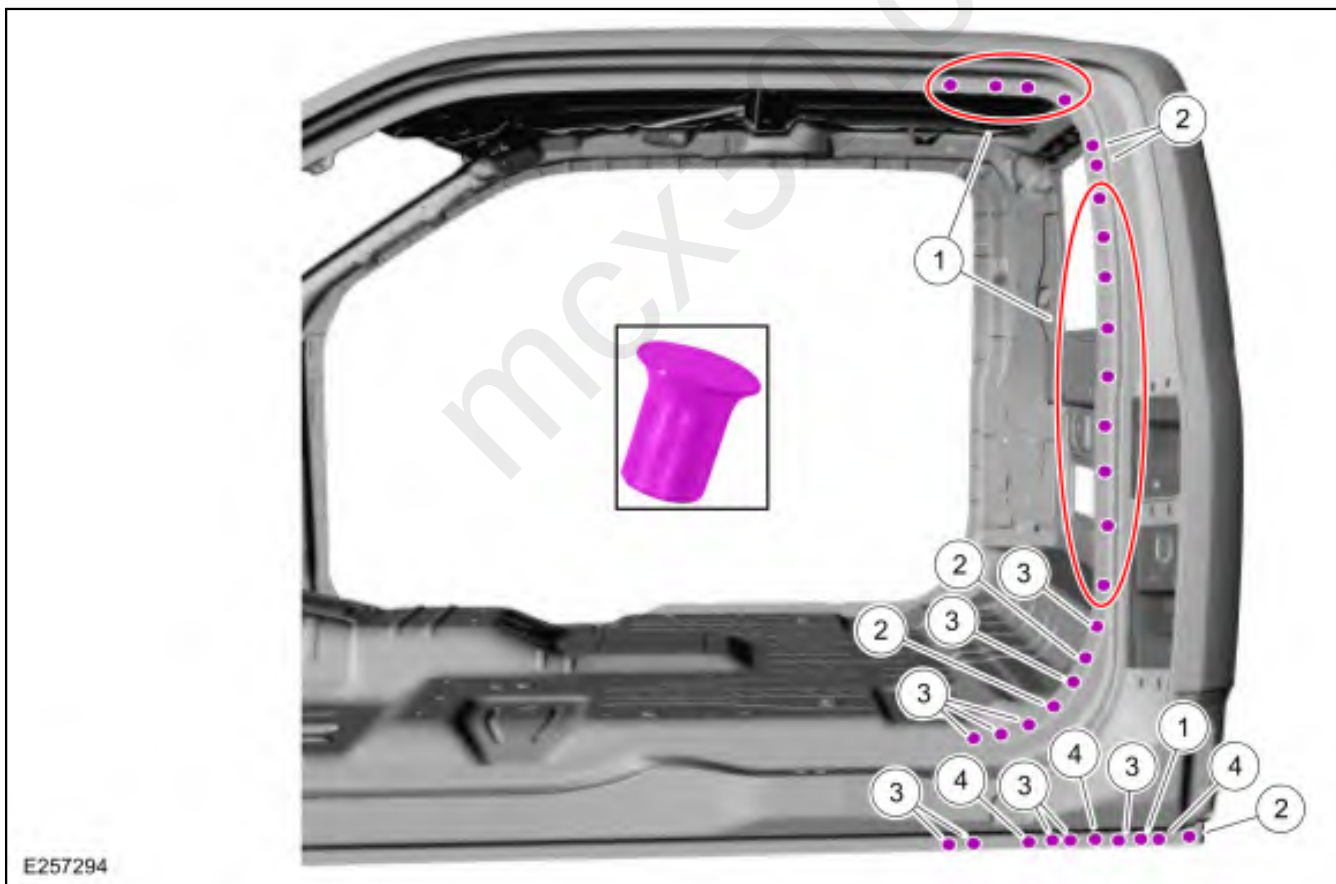


23. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0401	-	W790376-S900	-
2	W708717-S900	AW	DG10-220/H	SA-0400/SA-0402	-	W790377-S900	-
3	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
4	W710246-S900	BN	DP10-200/H	SA-0400/SA-0402	-	W790377-S900	-

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



Regular Cab

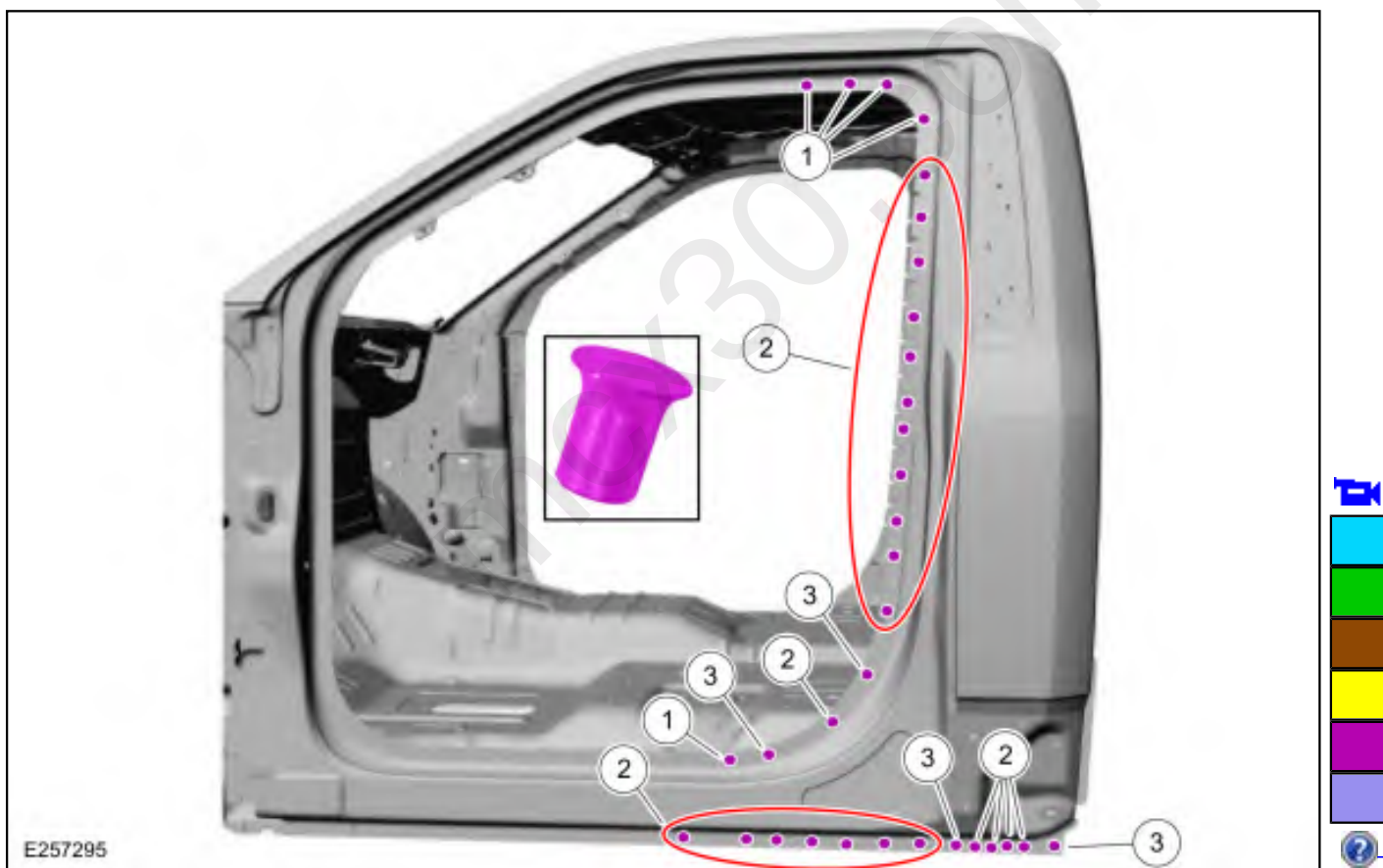
24. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

original location matching original quantity.

Install fasteners.

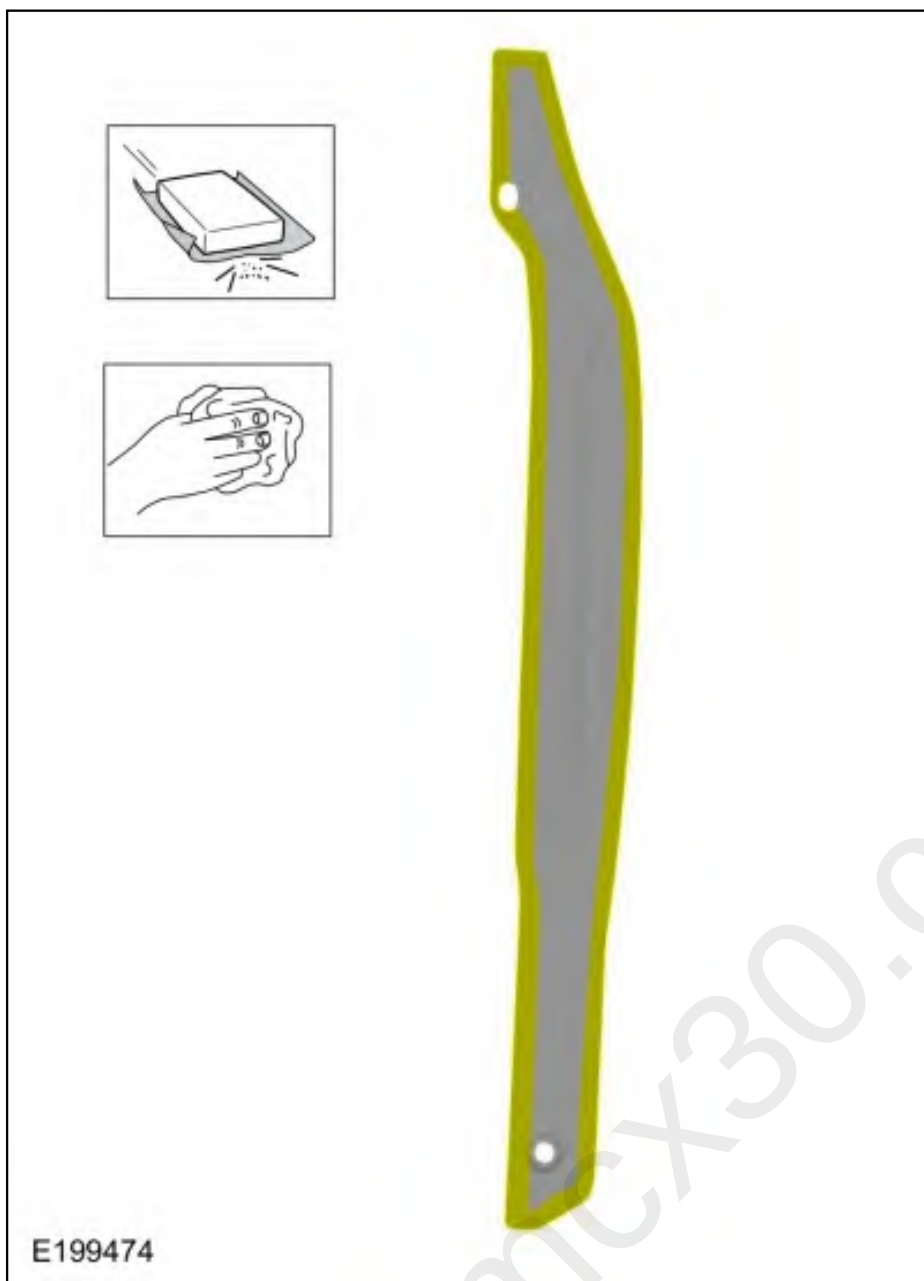
Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0401	-	W790376-S900	-
2	W717186-S900	EN	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
3	W708717-S900	AW	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-

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



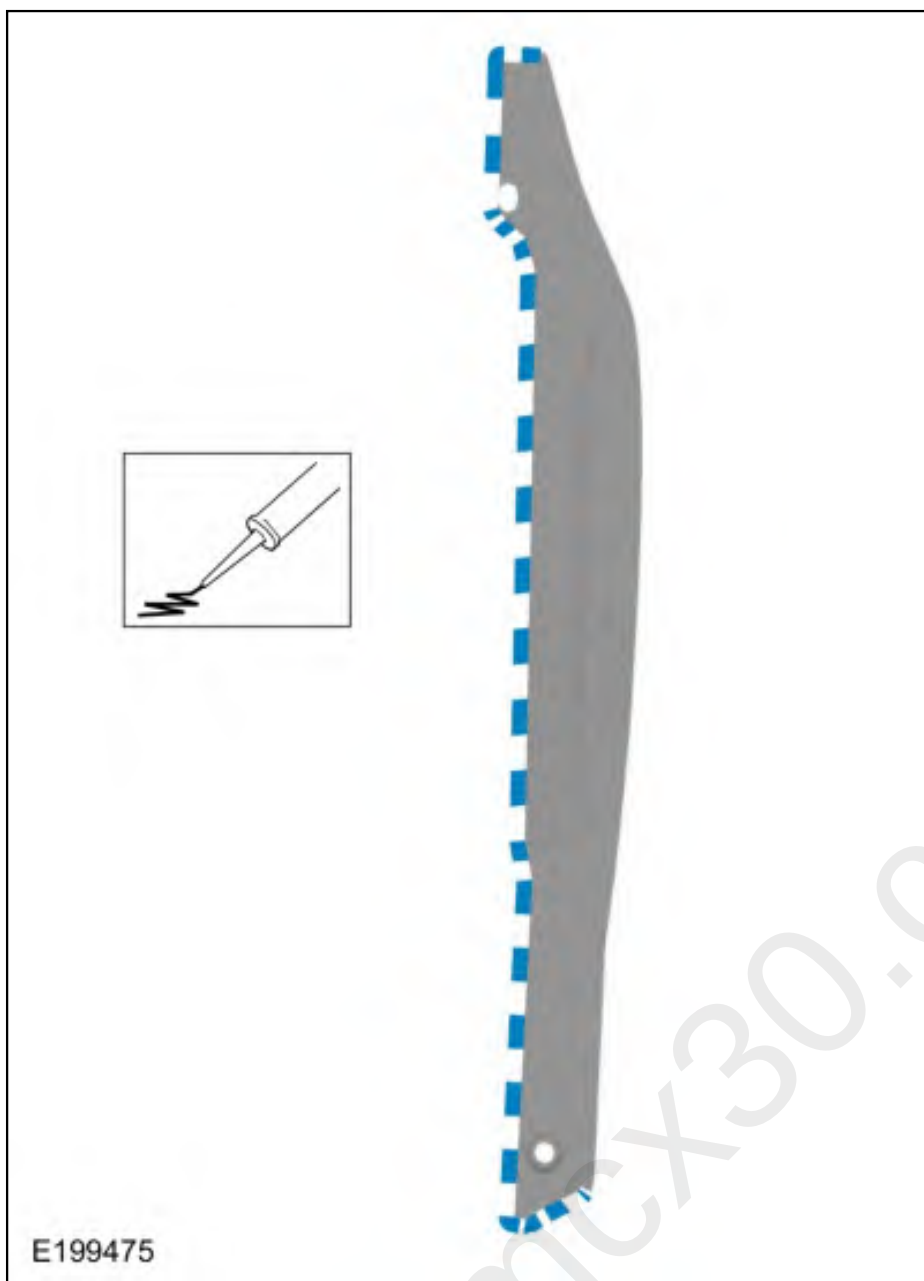
All vehicles

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

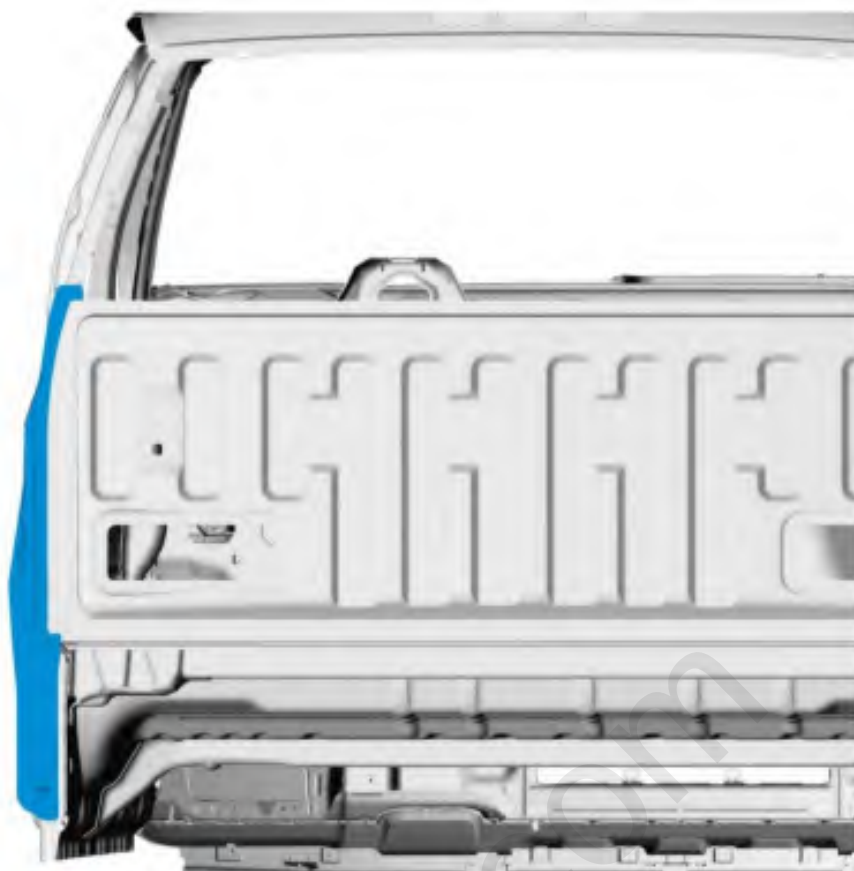
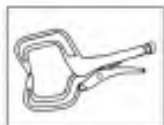


26. Apply adhesive as indicated to the cab back filler panel mating surface.

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



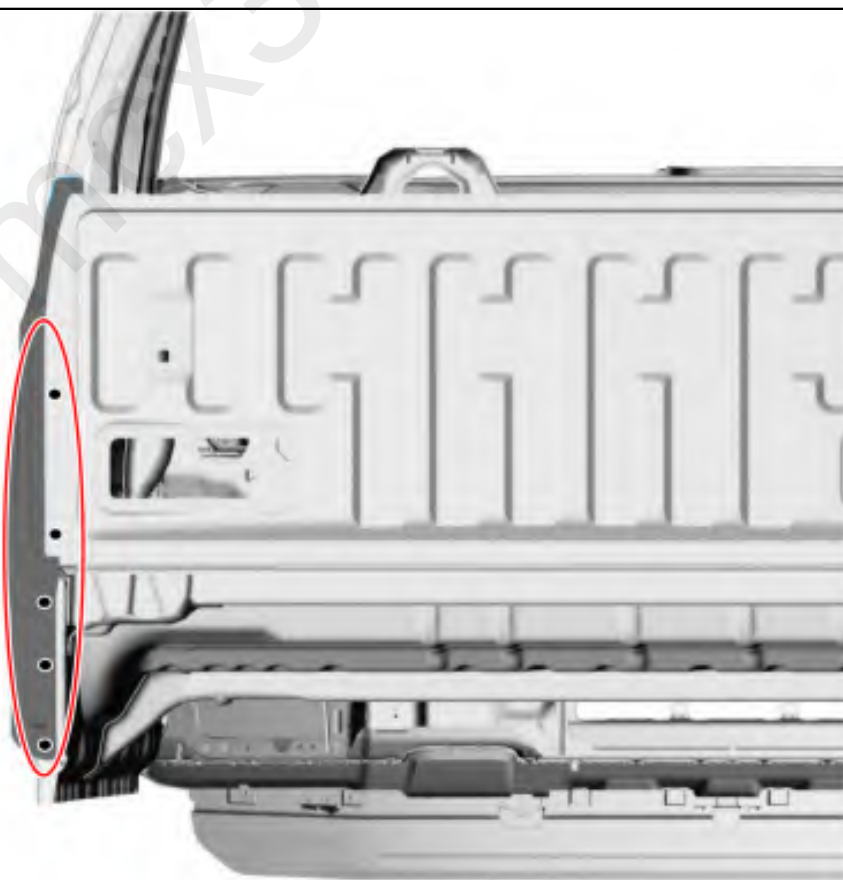
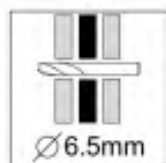
27. Install the cab back filler panel and clamp in position.
Use the General Equipment: Locking Pliers



E199476



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



E257296



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

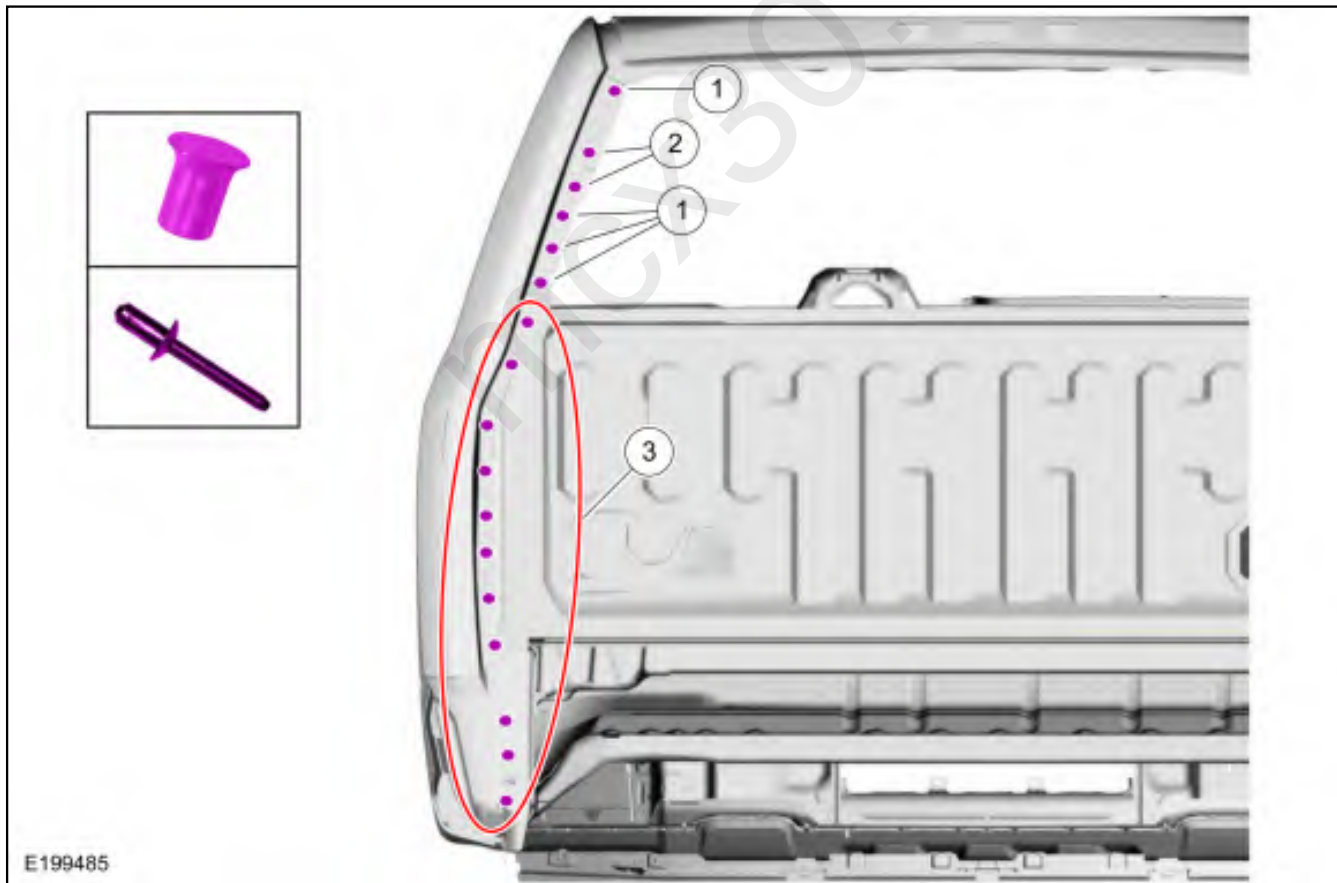
Install the fasteners.

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

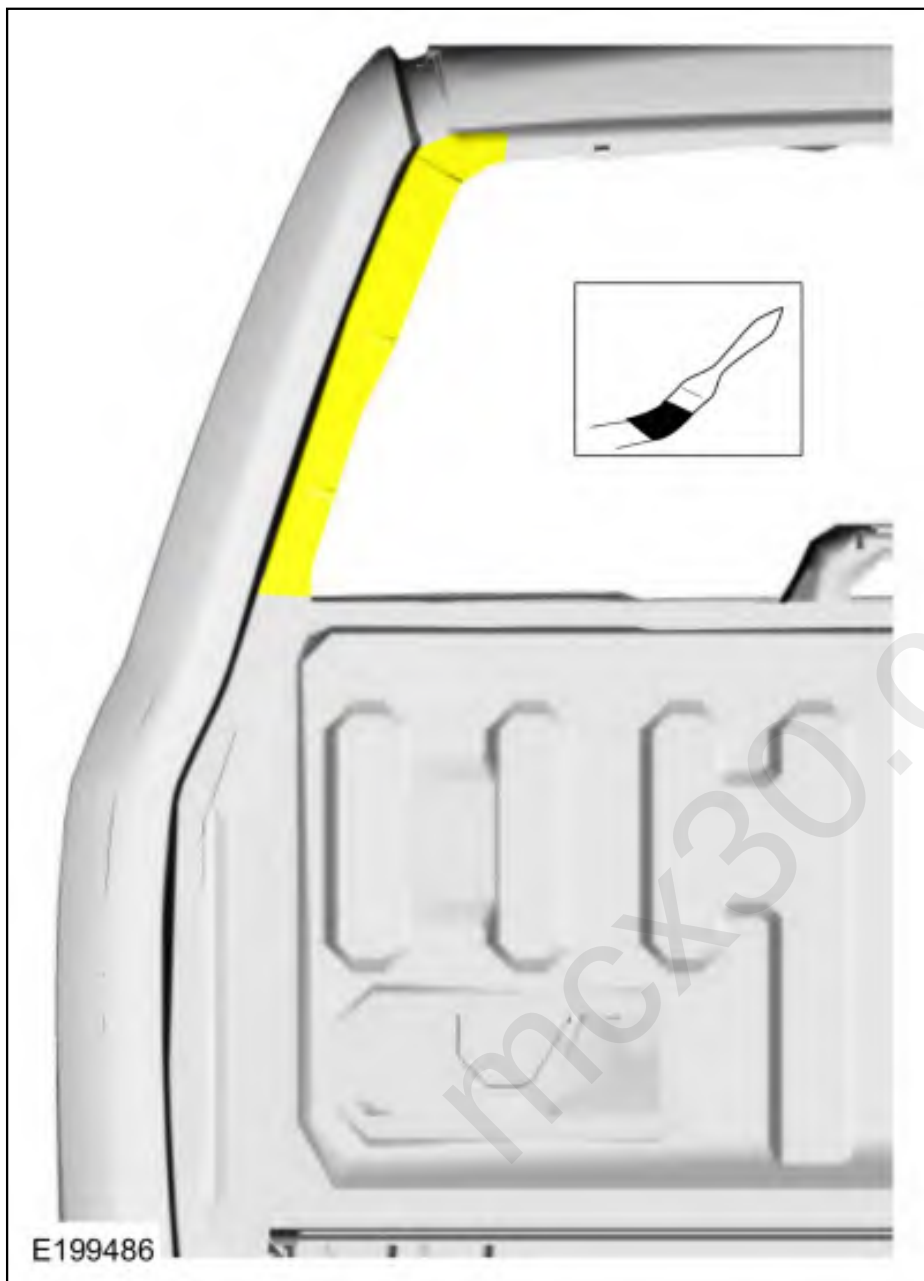


30. Metal finish all sectioning seams using typical aluminum metal finishing techniques and a fiber-based filler.
Refer to: [Special Repair Considerations for Aluminum Repairs](#) (501-25 Body Repairs - General Information,

Description and Operation).

31. **Epoxy Primer:**

Prime the rear window opening channel using a Ford approve epoxy-based primer.



32. Mask the rear window opening channel.

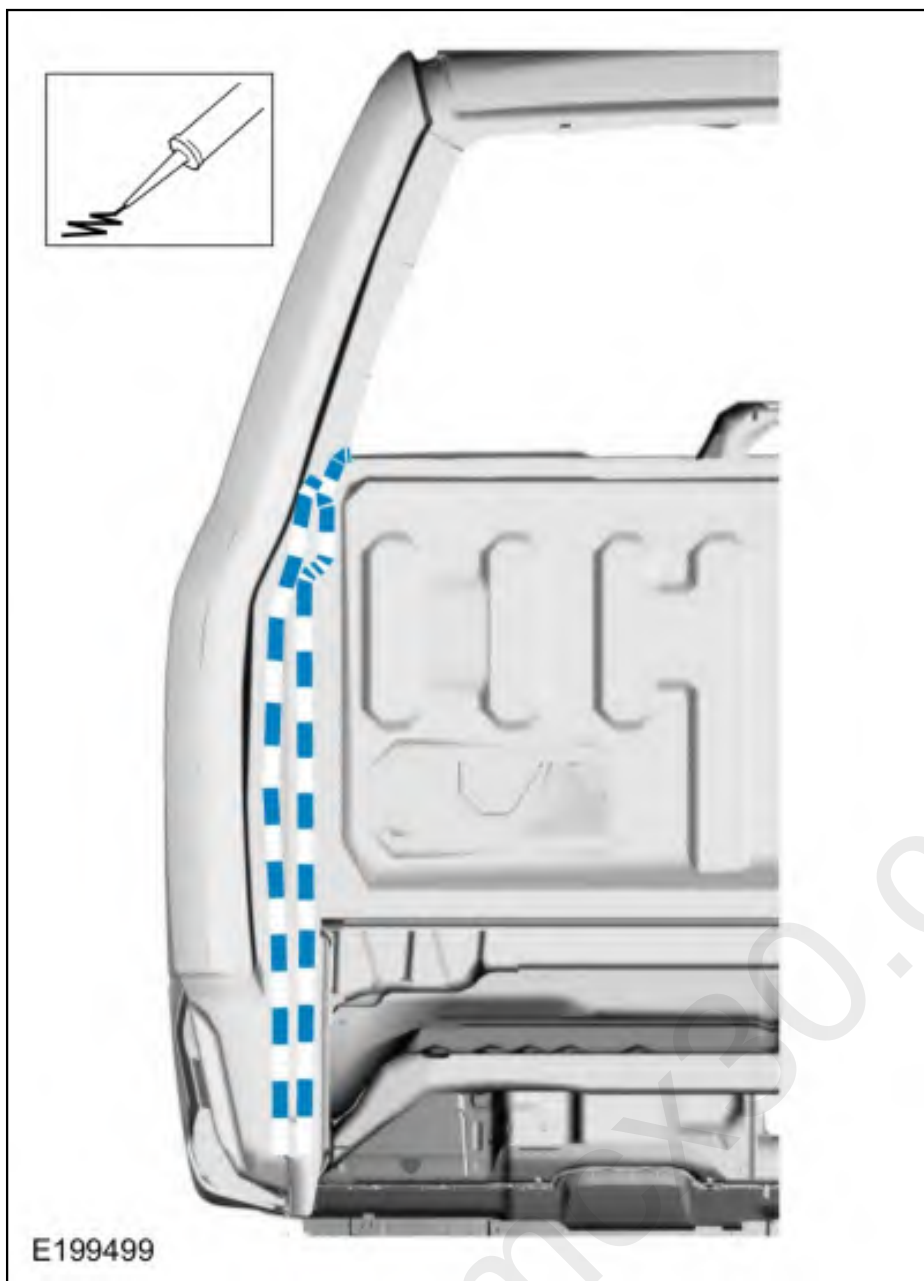


33. Prime the entire repair using a Ford approved paint system.

34. **Seam Sealing:**

All seams must be sealed to production level.

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



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

36. Unmask the rear window opening channel.



37. Install the side curtain air bag.

Refer to: [Side Curtain Airbag - Regular Cab](#) (501-20B Supplemental Restraint System, Removal and Installation).

Refer to: [Side Curtain Airbag - SuperCab](#) (501-20B Supplemental Restraint System, Removal and Installation).

Refer to: [Side Curtain Airbag - SuperCrew](#) (501-20B Supplemental Restraint System, Removal and Installation).

38. Install the rear window.

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

39. Reposition the wiring harness and carpeting.

40. Install the door opening weather strip.

41. Install the door opening scuff plate.

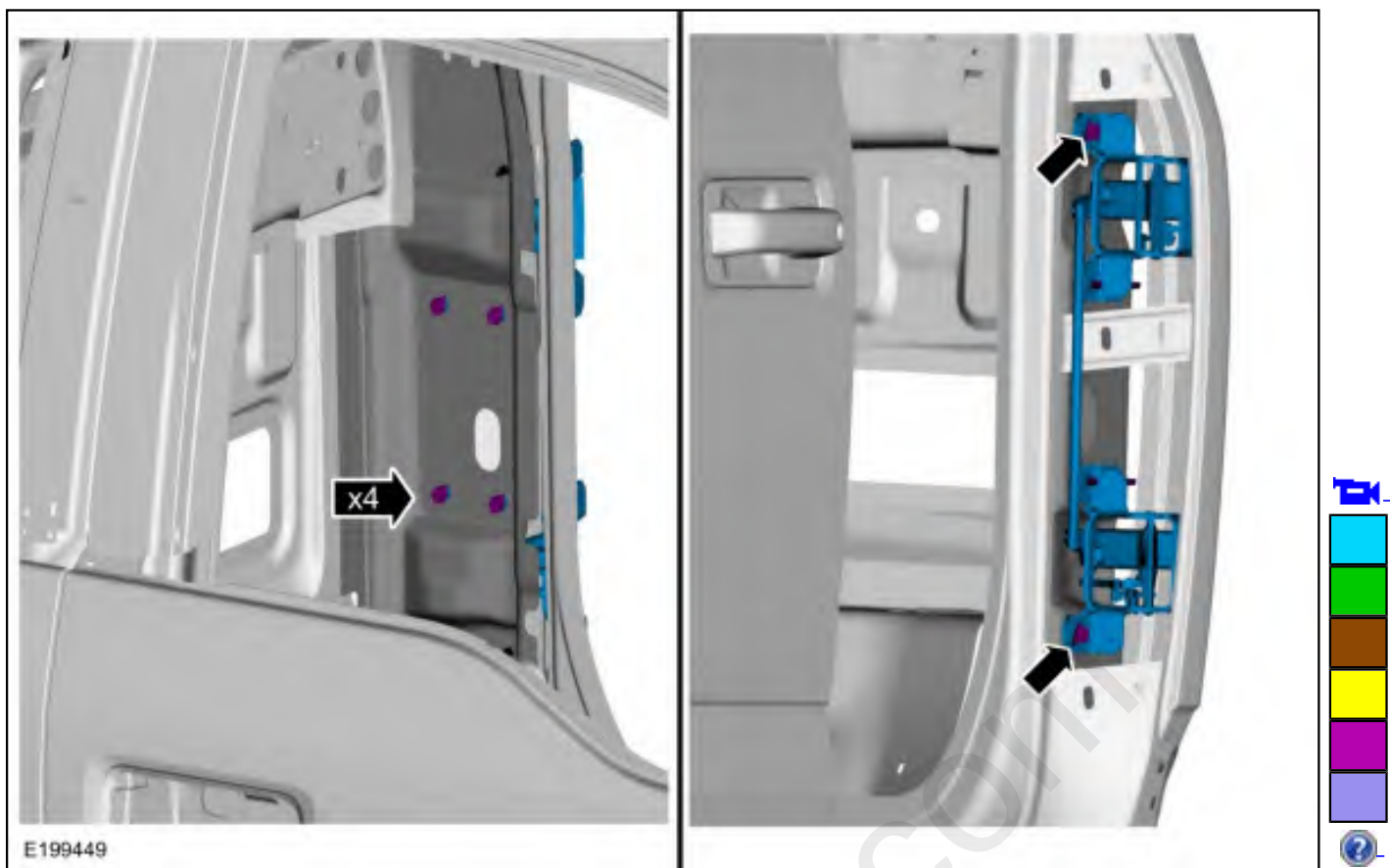
Regular Cab and SuperCrew Cab

42. Install the door striker (front door on regular cab, rear door on SuperCrew cab).
Torque: 18 lb.ft (25 Nm)



SuperCab

43. Install the rear door hinge.
Torque: 21 lb.ft (28 Nm)



SuperCab and SuperCrew Cab

44. Install the rear seat.

Refer to: [Rear Seat LH - SuperCab](#) (501-10B Rear Seats, Removal and Installation).

Refer to: [Rear Seat LH - SuperCrew](#) (501-10B Rear Seats, Removal and Installation).

Regular Cab

45. Install the front seat.

Refer to: [Front Seat](#) (501-10A Front Seats, Removal and Installation).

All vehicles

46. Install the safety belt.

Refer to: [Front Seatbelt Retractor and Pretensioner - Regular Cab](#) (501-20A Seatbelt Systems, Removal and Installation).

Refer to: [Seatbelt Shoulder Height Adjuster - Regular Cab](#) (501-20A Seatbelt Systems, Removal and Installation).

Refer to: [Rear Outer Seatbelt Lower Retractor - Vehicles With: Inflatable Seatbelts](#) (501-20A Seatbelt Systems, Removal and Installation).

Refer to: [Rear Outer Seatbelt Upper Retractor - Vehicles With: Inflatable Seatbelts](#) (501-20A Seatbelt Systems, Removal and Installation).

47. Install the loadspace trim panel.

Refer to: [Loadspace Trim Panel - Regular Cab](#) (501-05 Interior Trim and Ornamentation, Removal and

Installation).

Refer to: [Loadspace Trim Panel - SuperCab/SuperCrew](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).

48. Install the exterior trim.

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

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

49. Install the pickup bed.

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

50. Repower the SRS.

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