

Pickup Box Inner Side Panel

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
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

NOTE: 6.5 foot pickup box shown, 8 foot and 5.5 foot pickup boxes similar.

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.

1. Remove the pickup box outer side panel.

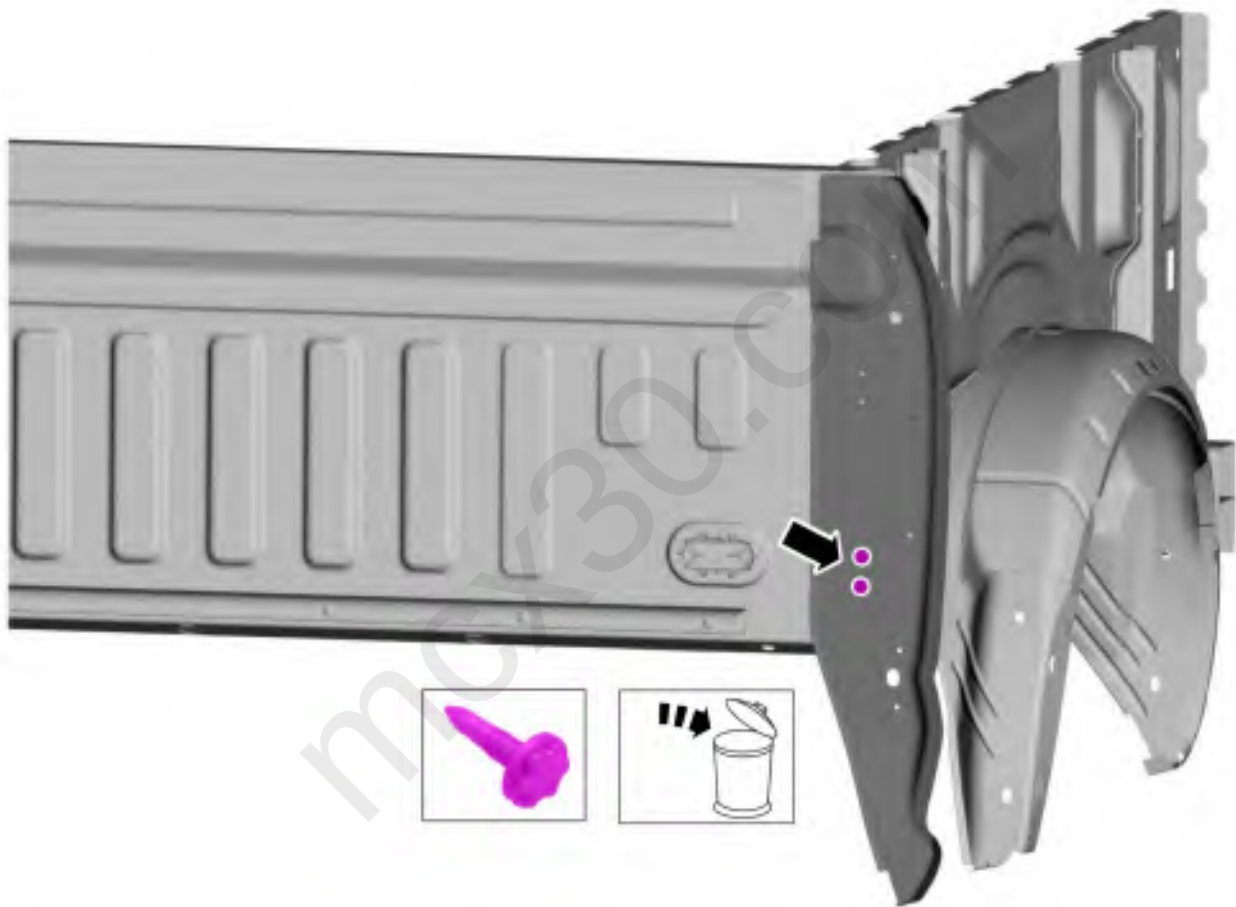
Refer to: [Pickup Box Outer Side Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

2. Remove the pickup box corner reinforcement.

Refer to: [Pickup Box Corner Reinforcement](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

3. Remove and discard the FDS fasteners.

Use the General Equipment: Polydrive Bit Socket



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4. Remove the SPR fasteners.

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

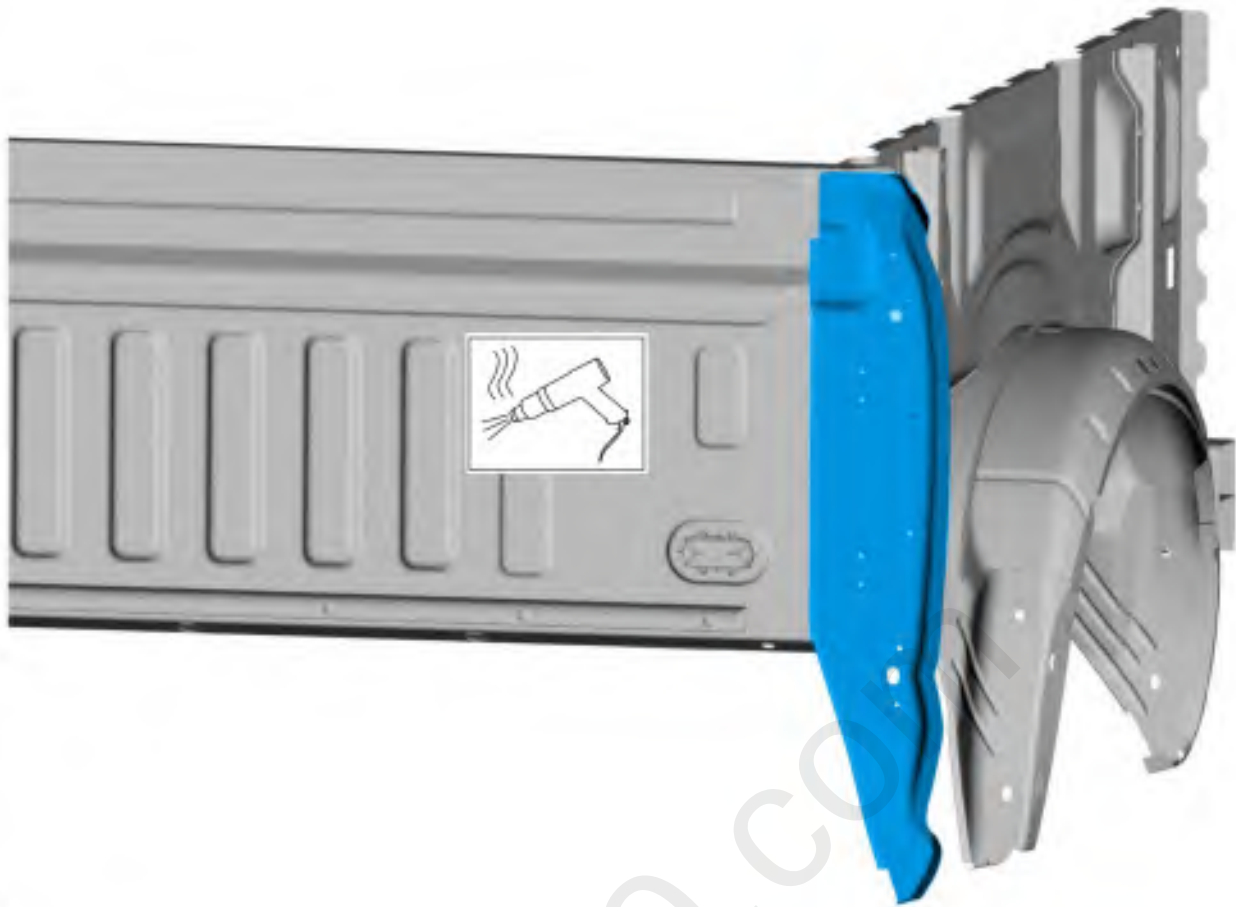
Use the General Equipment: Belt Sander



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5. **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 pickup box body extension.
Use the General Equipment: Hot Air Gun



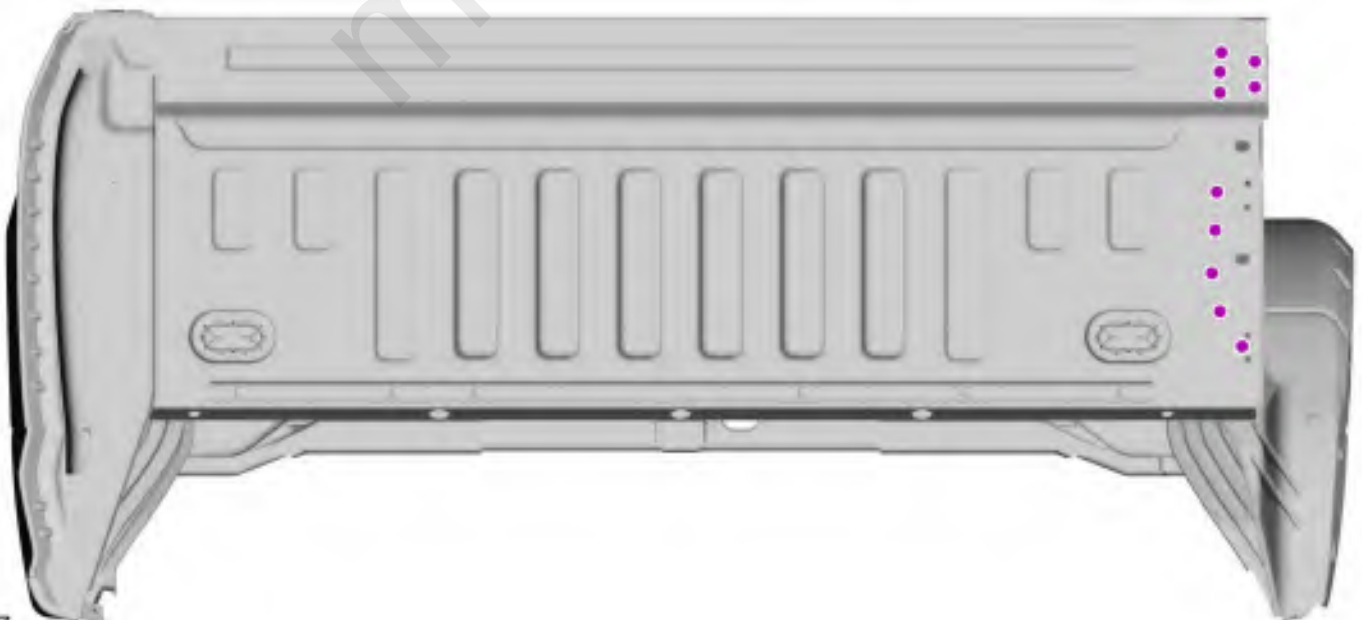
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6. Remove the SPR fasteners.

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

Use the General Equipment: Belt Sander



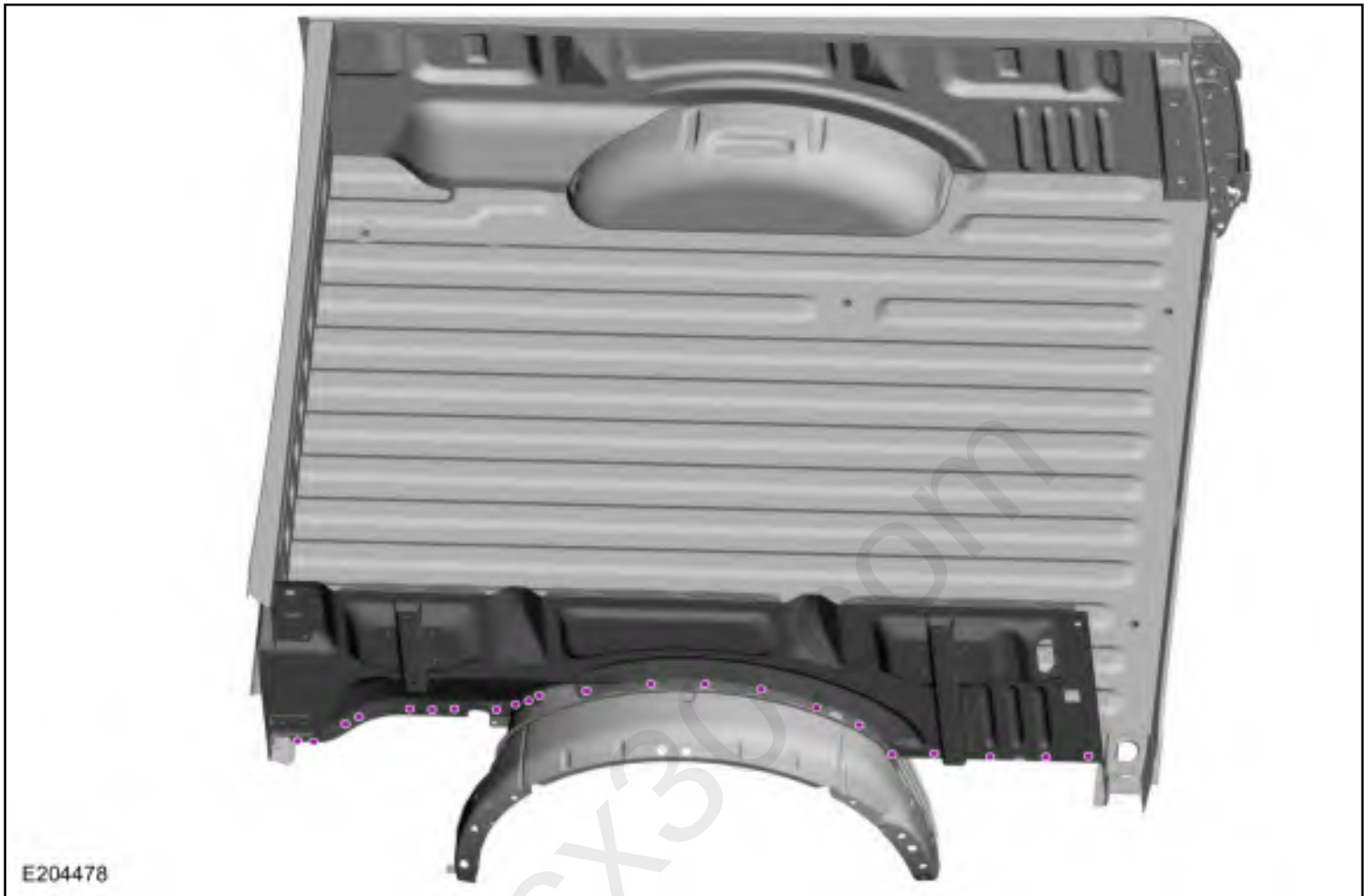
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7. Remove the SPR fasteners.

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

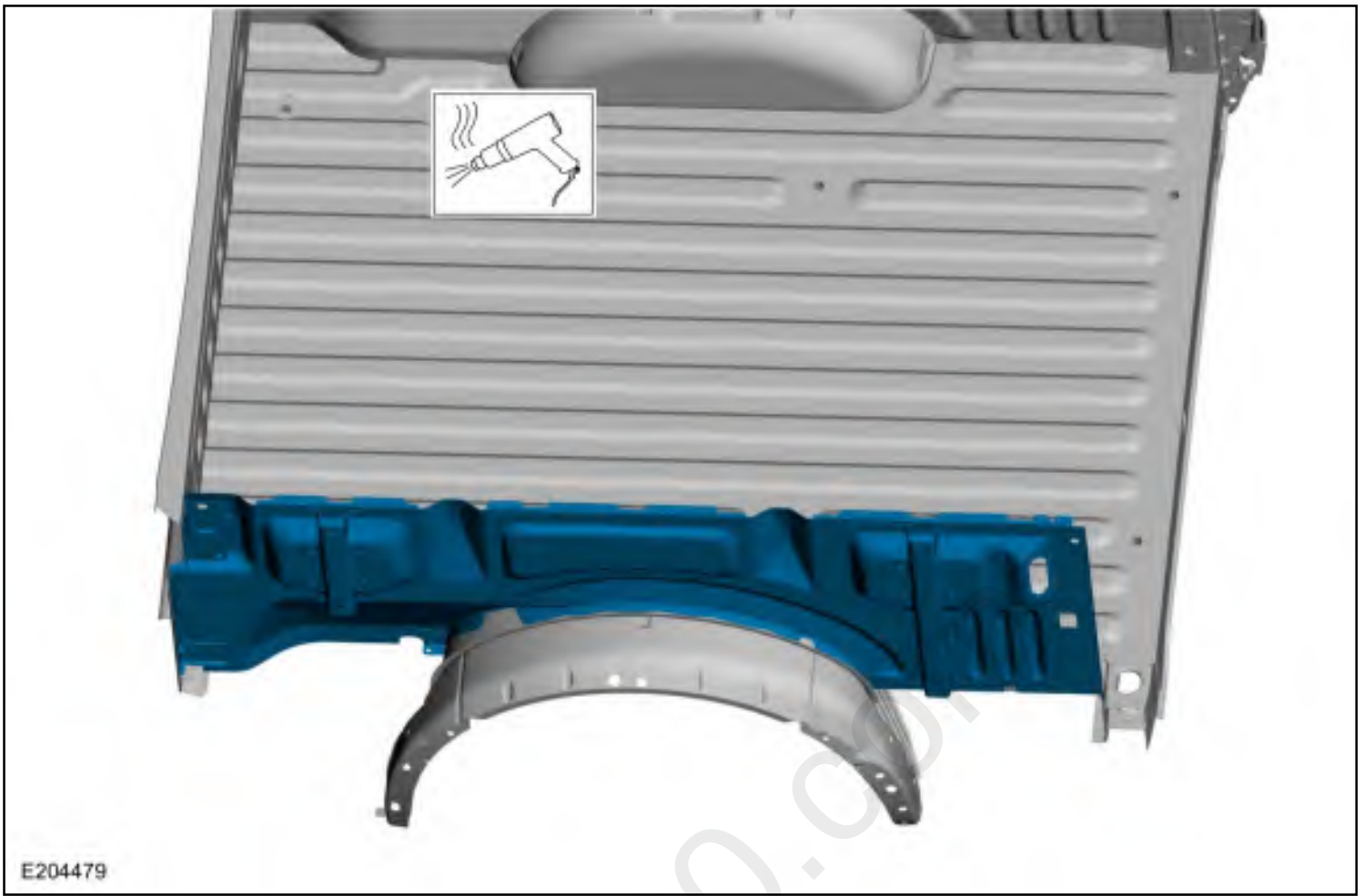
Use the General Equipment: Belt Sander



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 pickup box inner side panel.

Use the General Equipment: Hot Air Gun



Installation

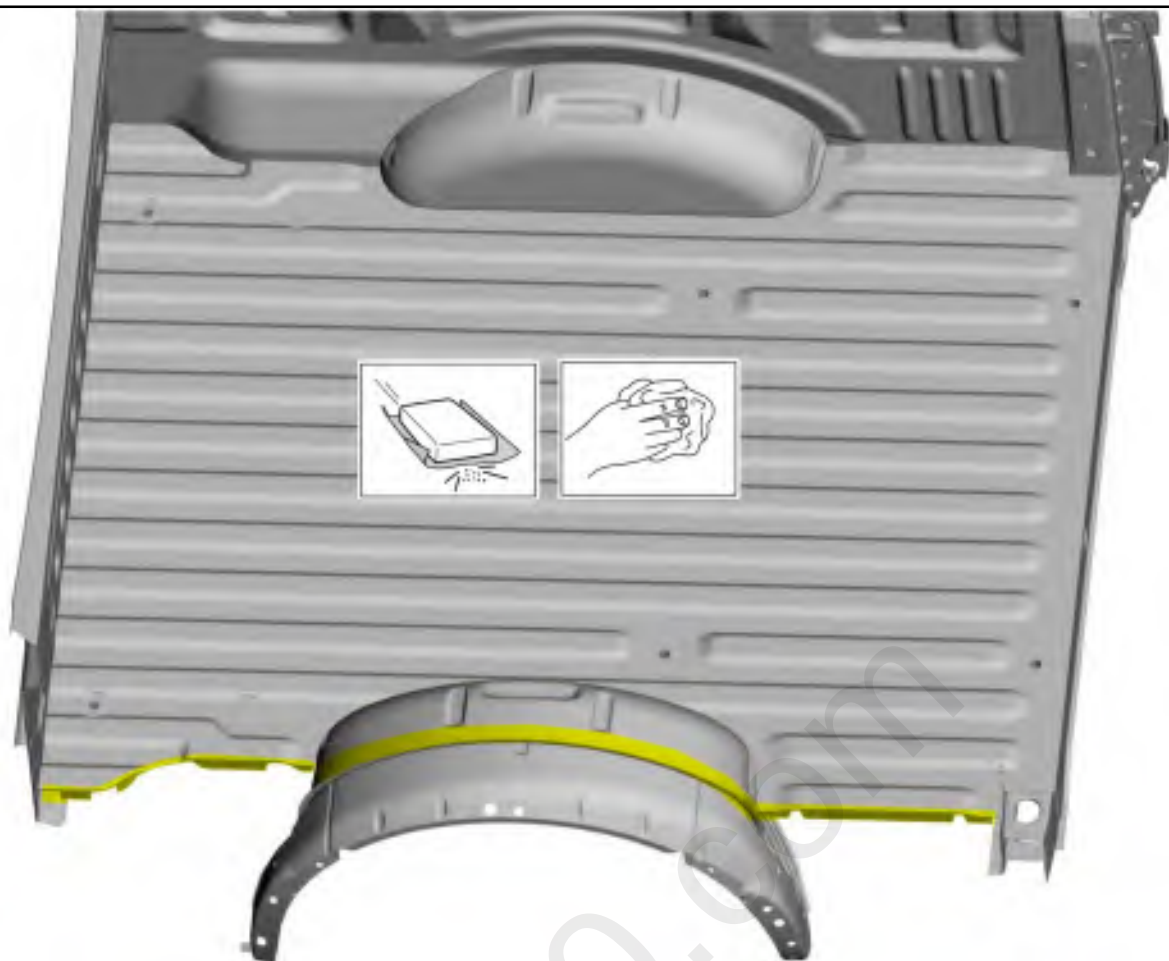
NOTE: 6.5 foot pickup box shown, 8 foot and 5.5 foot pickup boxes similar.

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 rivets, solid rivet fasteners or aluminum MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Rivet-Bonding

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



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

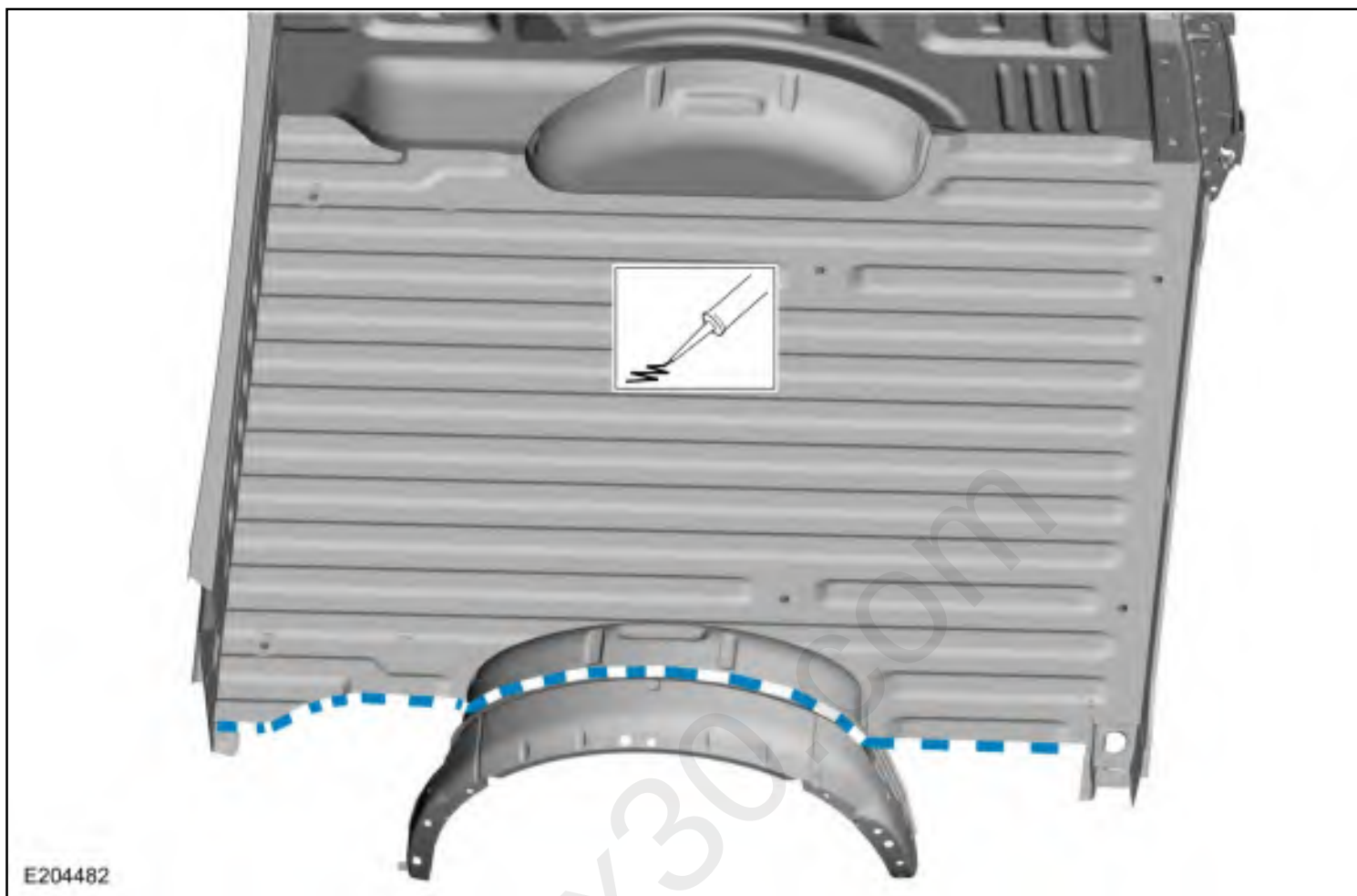


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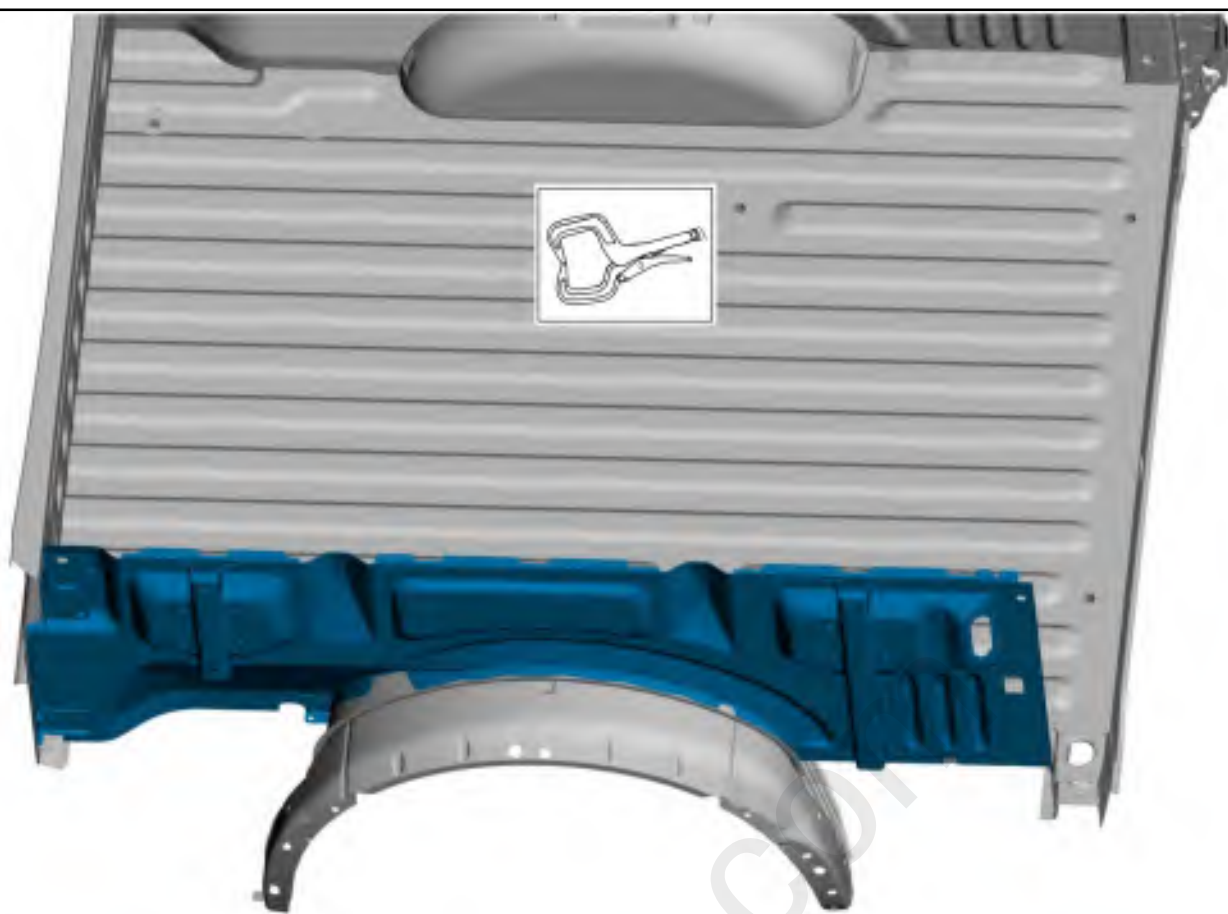


3. Apply adhesive.

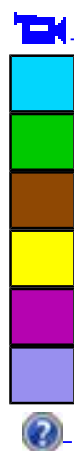
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B



4. Install the pickup box inner side panel and clamp in position.
Use the General Equipment: Locking Pliers

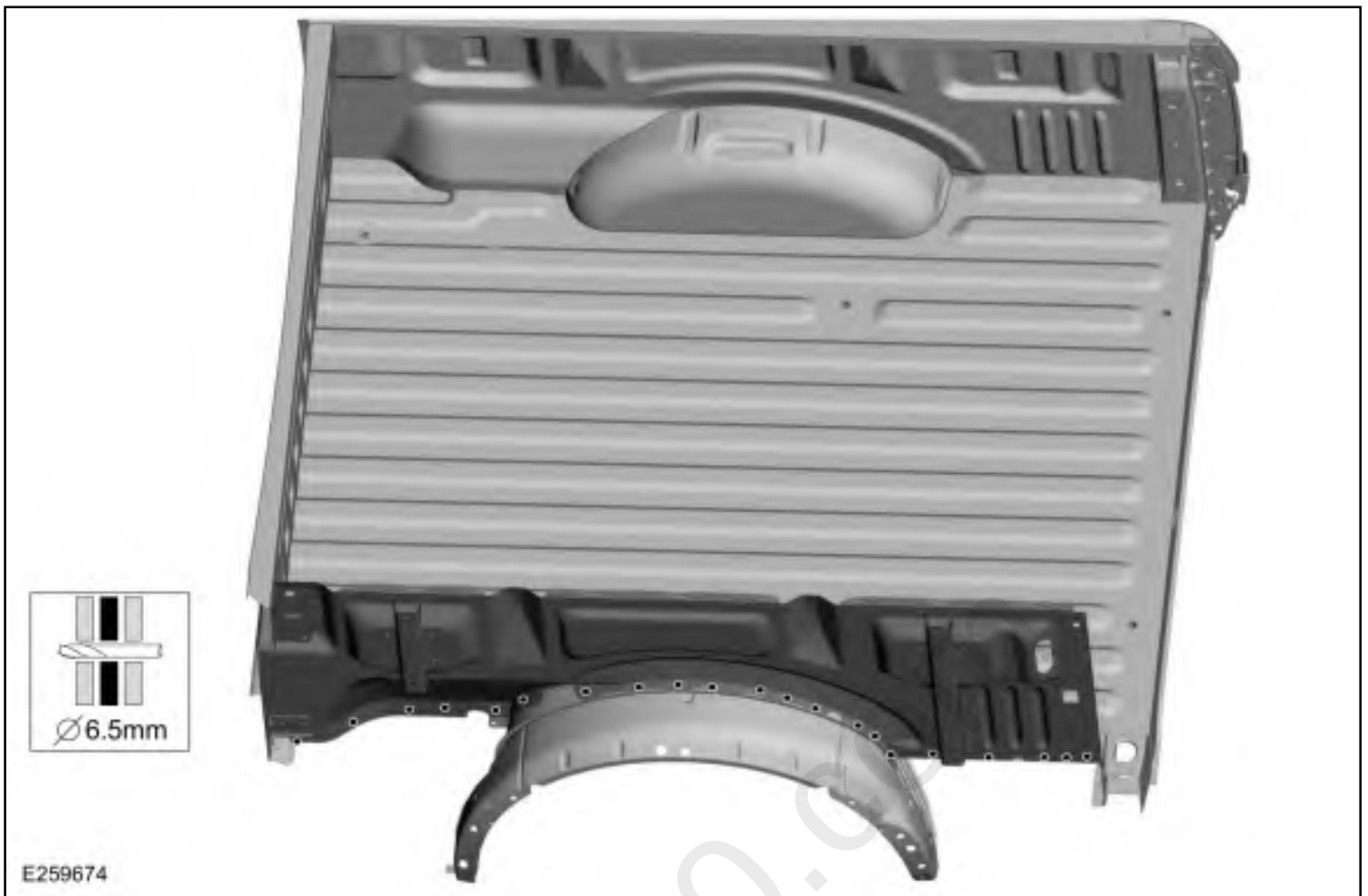


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5. Drill for fasteners.

Use the General Equipment: 6.5 mm Drill Bit

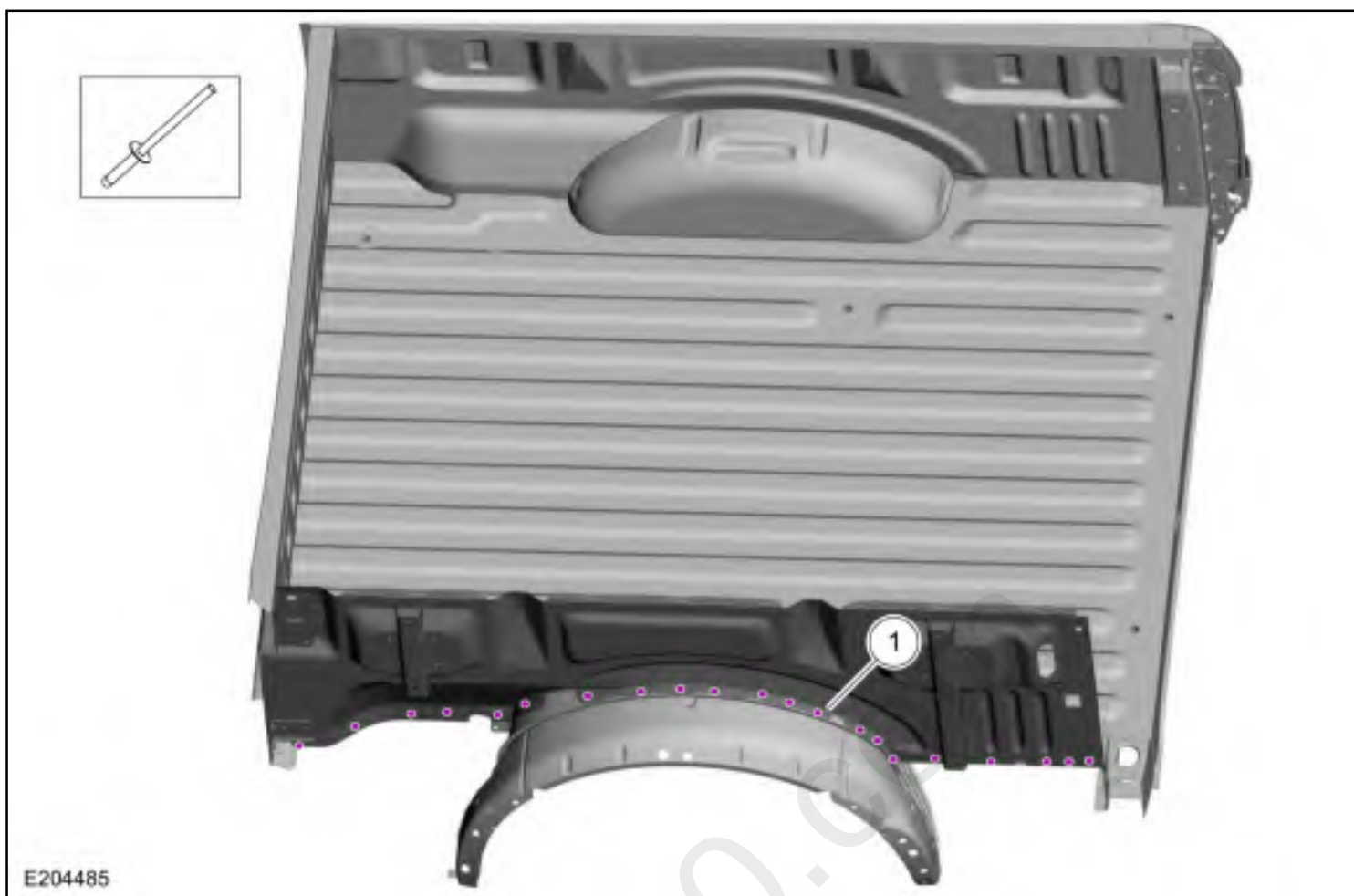


6. **NOTE:** *Blind rivets, solid rivet fasteners or aluminum MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.*

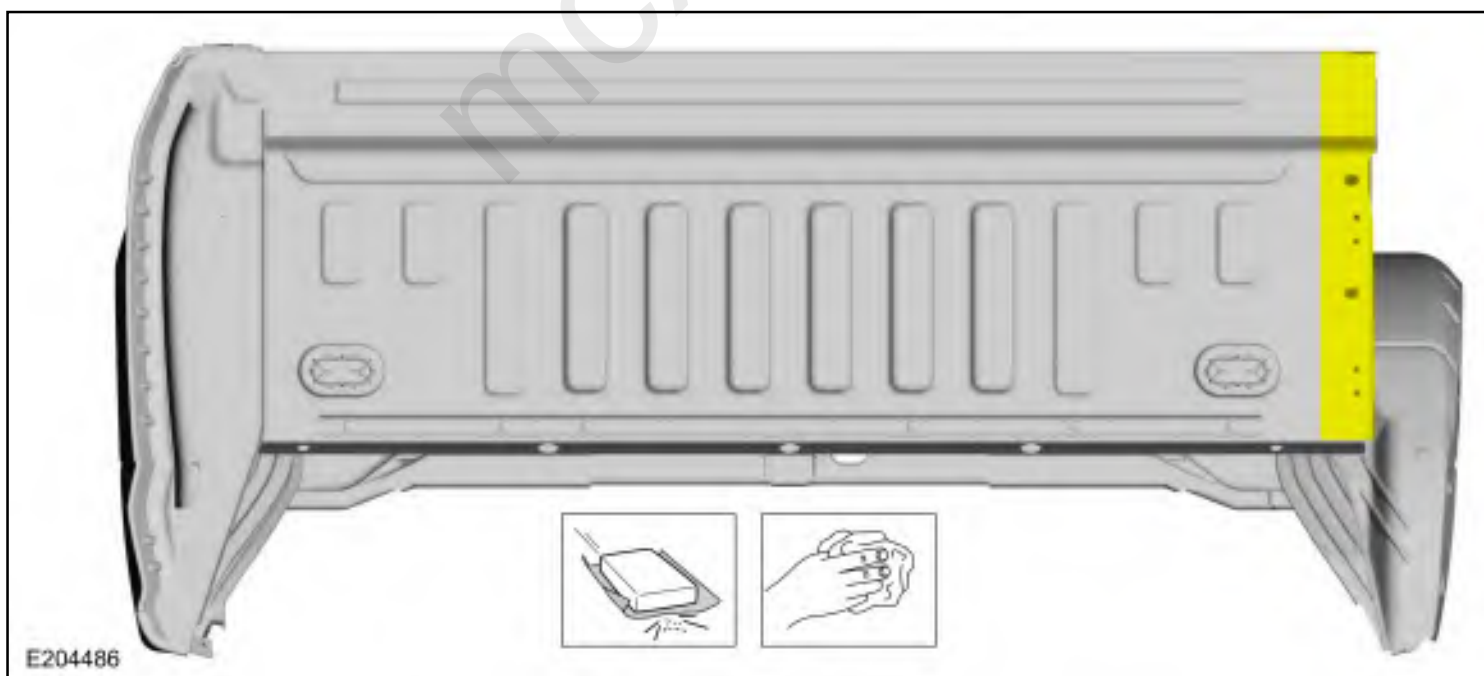
Install fasteners.

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

Use the General Equipment: Blind Rivet Gun

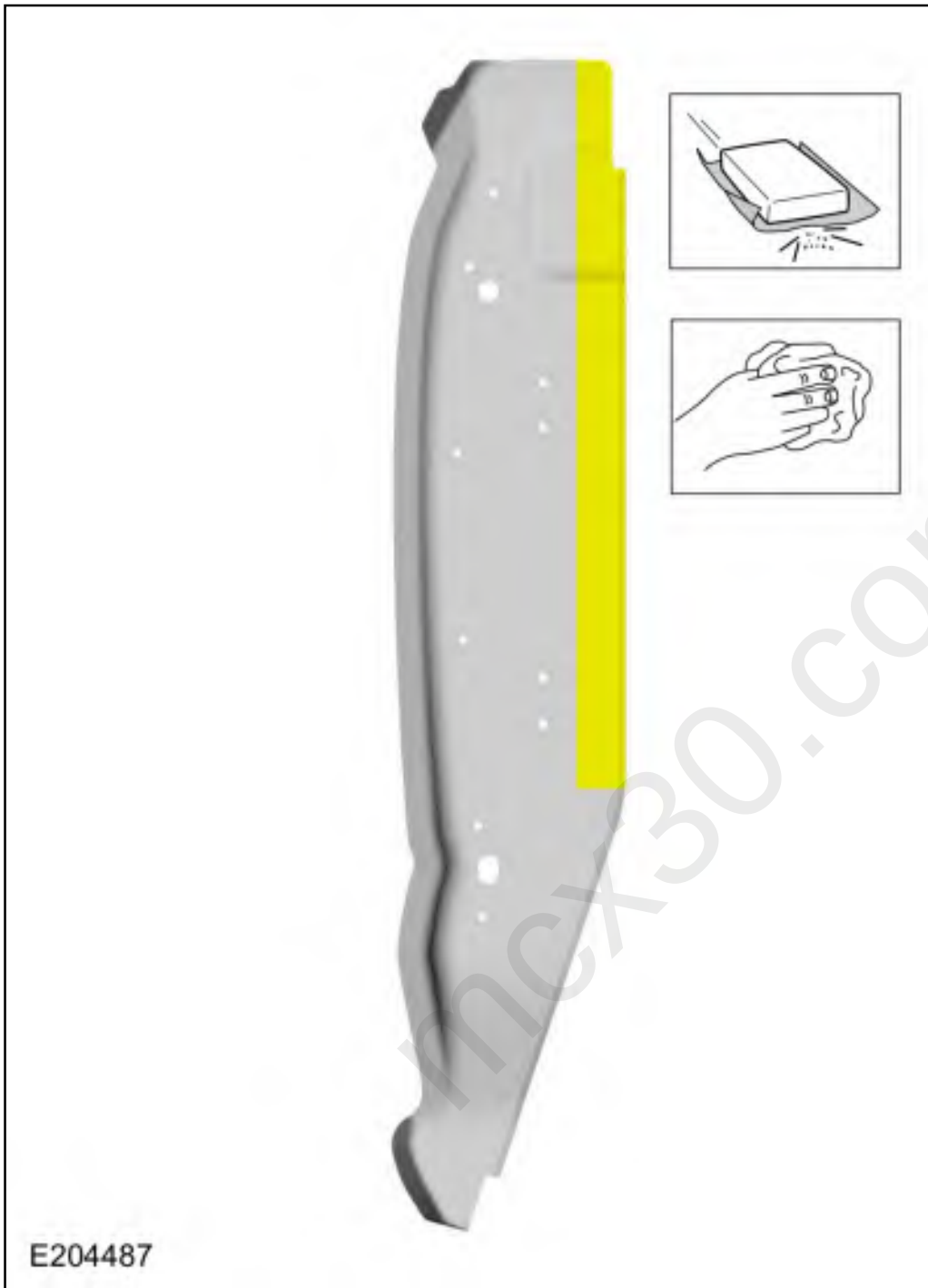


7. 80-120 grit sand paper.
Sand to remove e-coat and adhesive and clean.



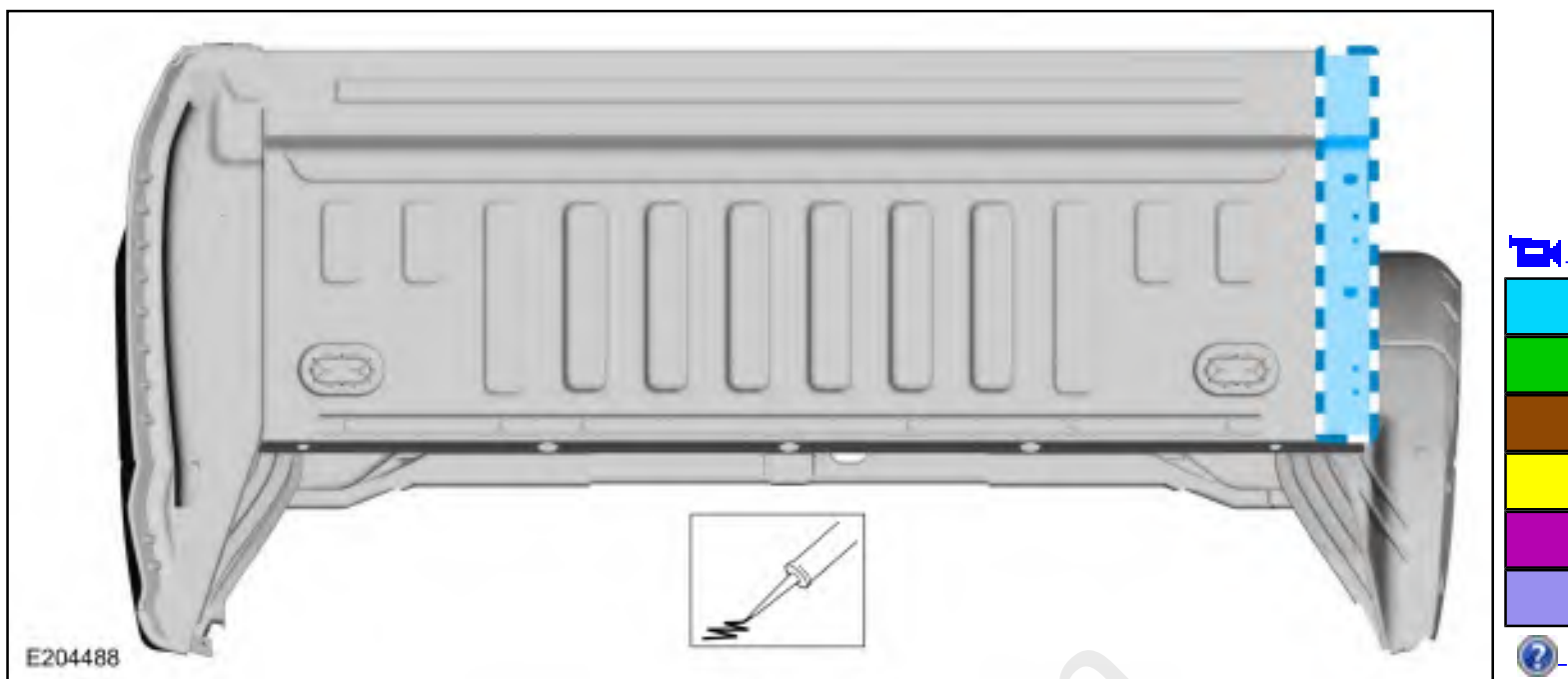
8. 80-120 grit sand paper.

Sand to remove e-coat and adhesive and clean.

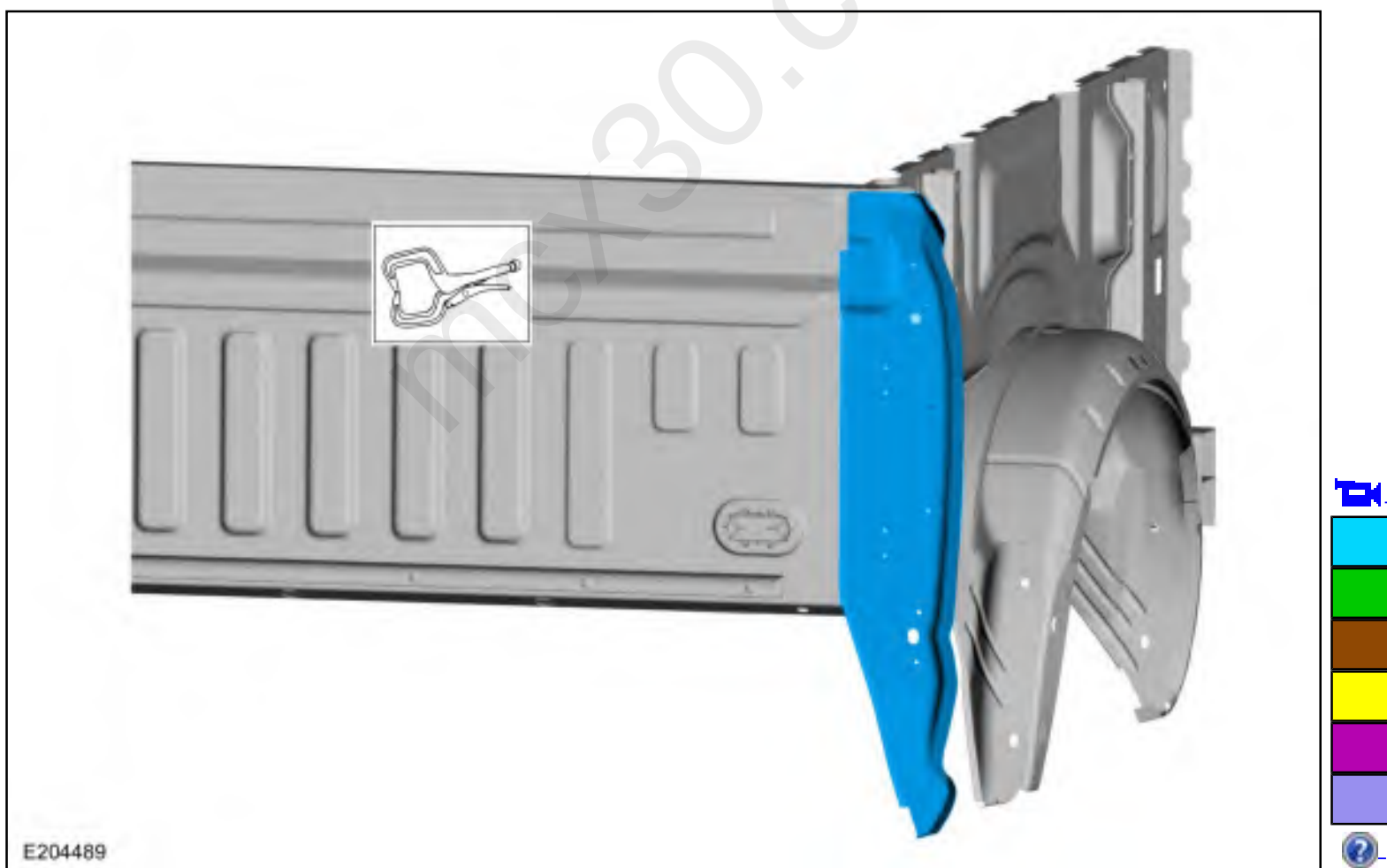


9. Apply adhesive.

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



10. Install the pickup box body extension and clamp in position.
Use the General Equipment: Locking Pliers



11. **NOTE:** Blind rivets, solid rivet fasteners or aluminum MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Drill for fastener installation.

Use the General Equipment: 6.5 mm Drill Bit

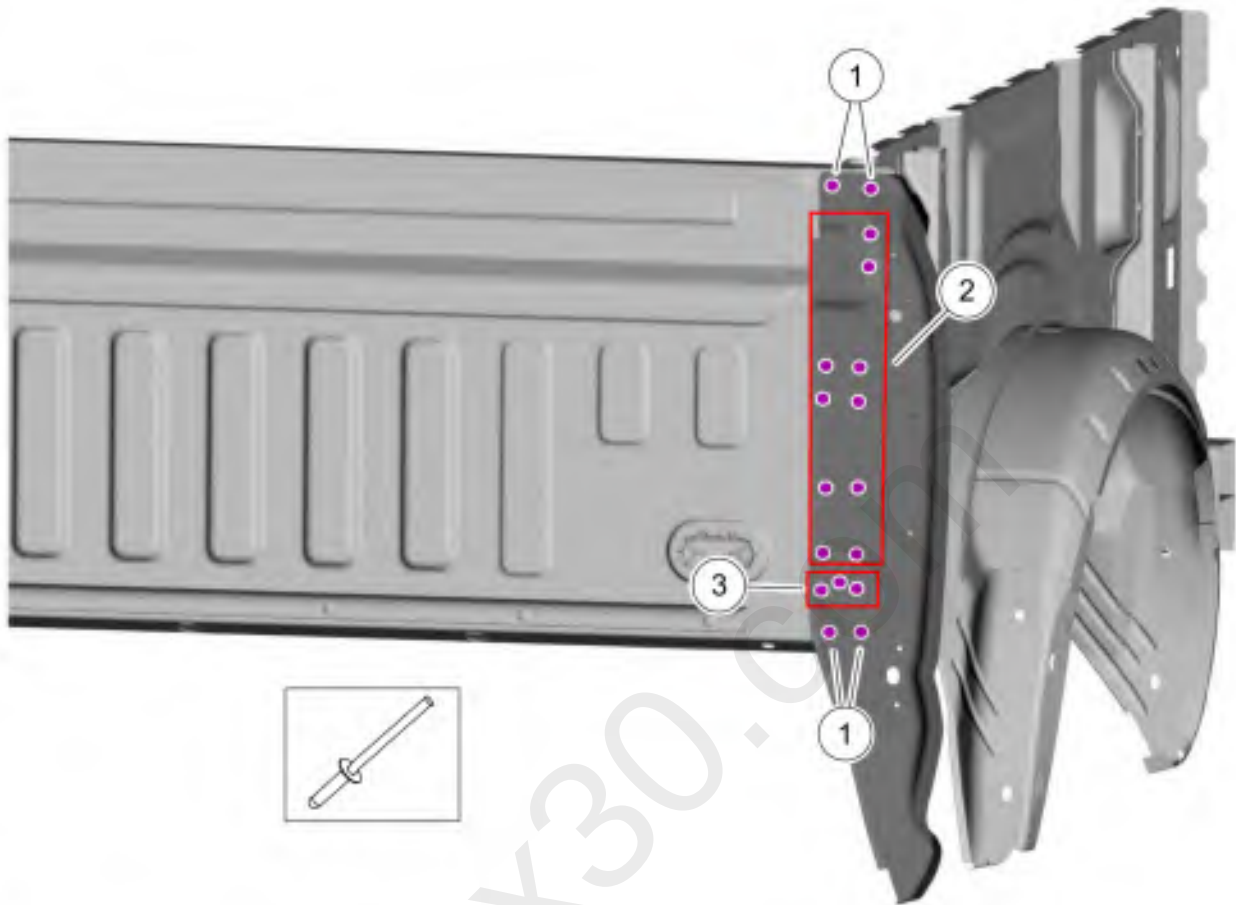


12. **NOTE:** Blind rivets, solid rivet fasteners or aluminum MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Install fasteners from the inside of the pickup box.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W702512-S900C	-	-
2	-	-	-	-	W707638-S900C	-	-

3	-	-	-	-	W708777-S900C	-	-
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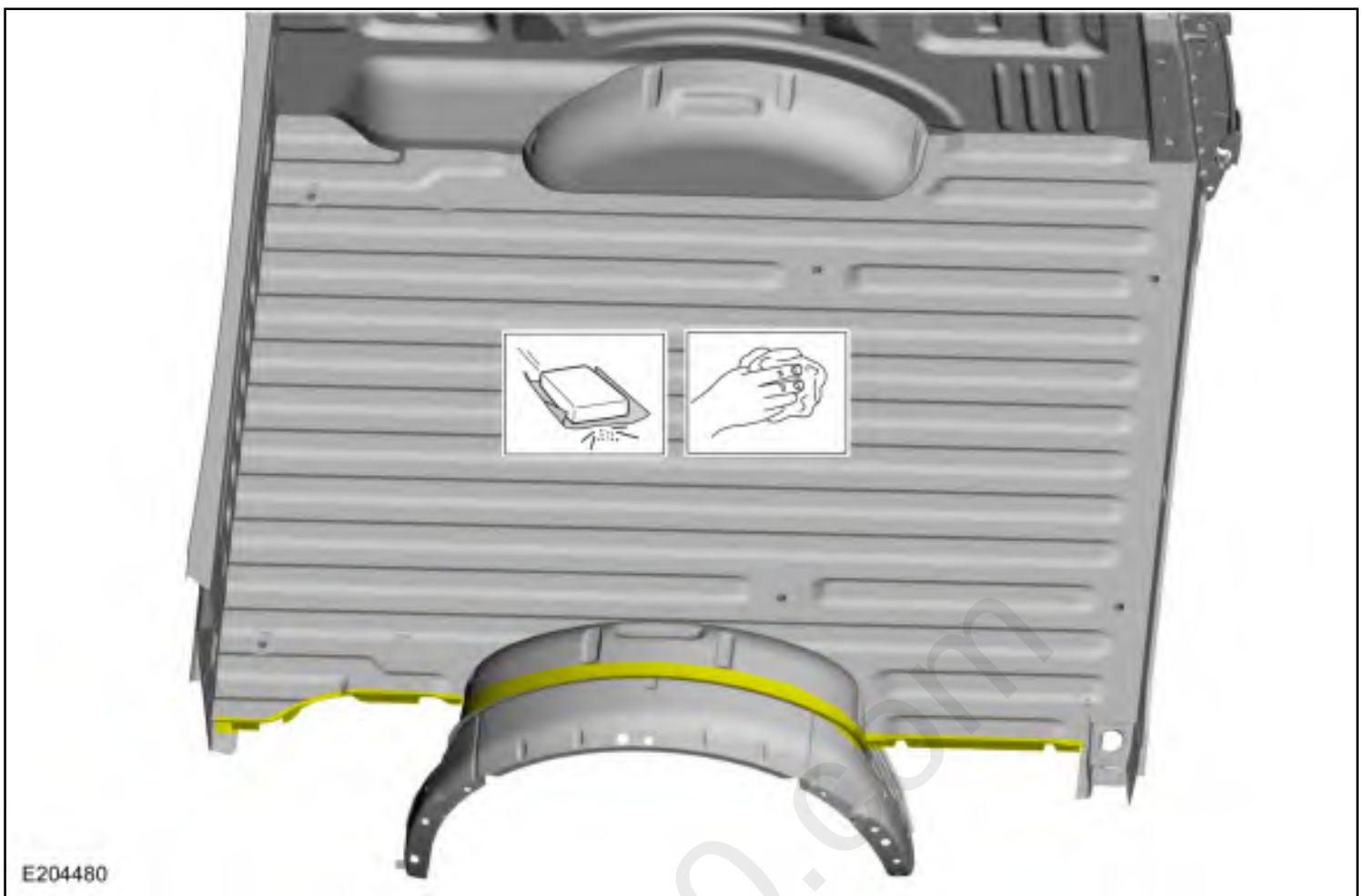


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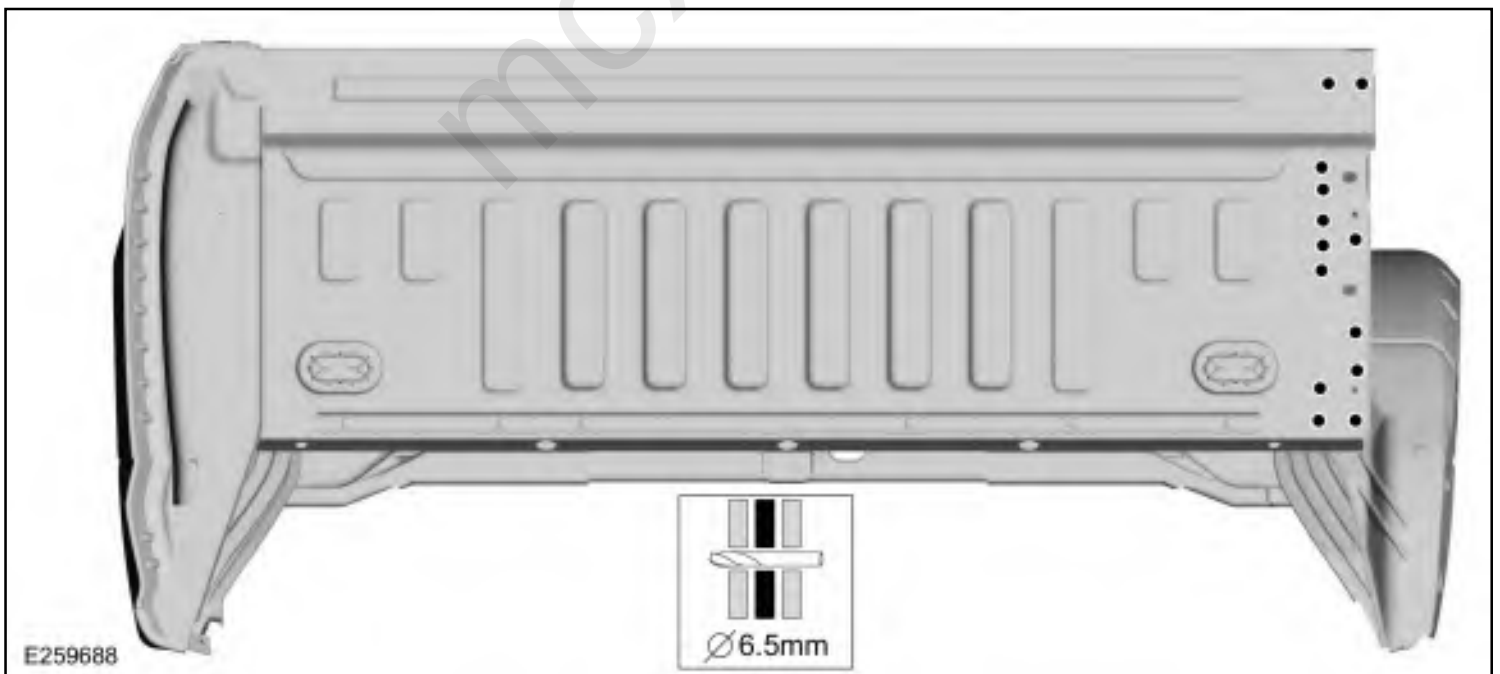


Plug-Welding

13. Sand to remove old adhesive and clean.



14. Drill for plug welds.
Use the General Equipment: 6.5 mm Drill Bit



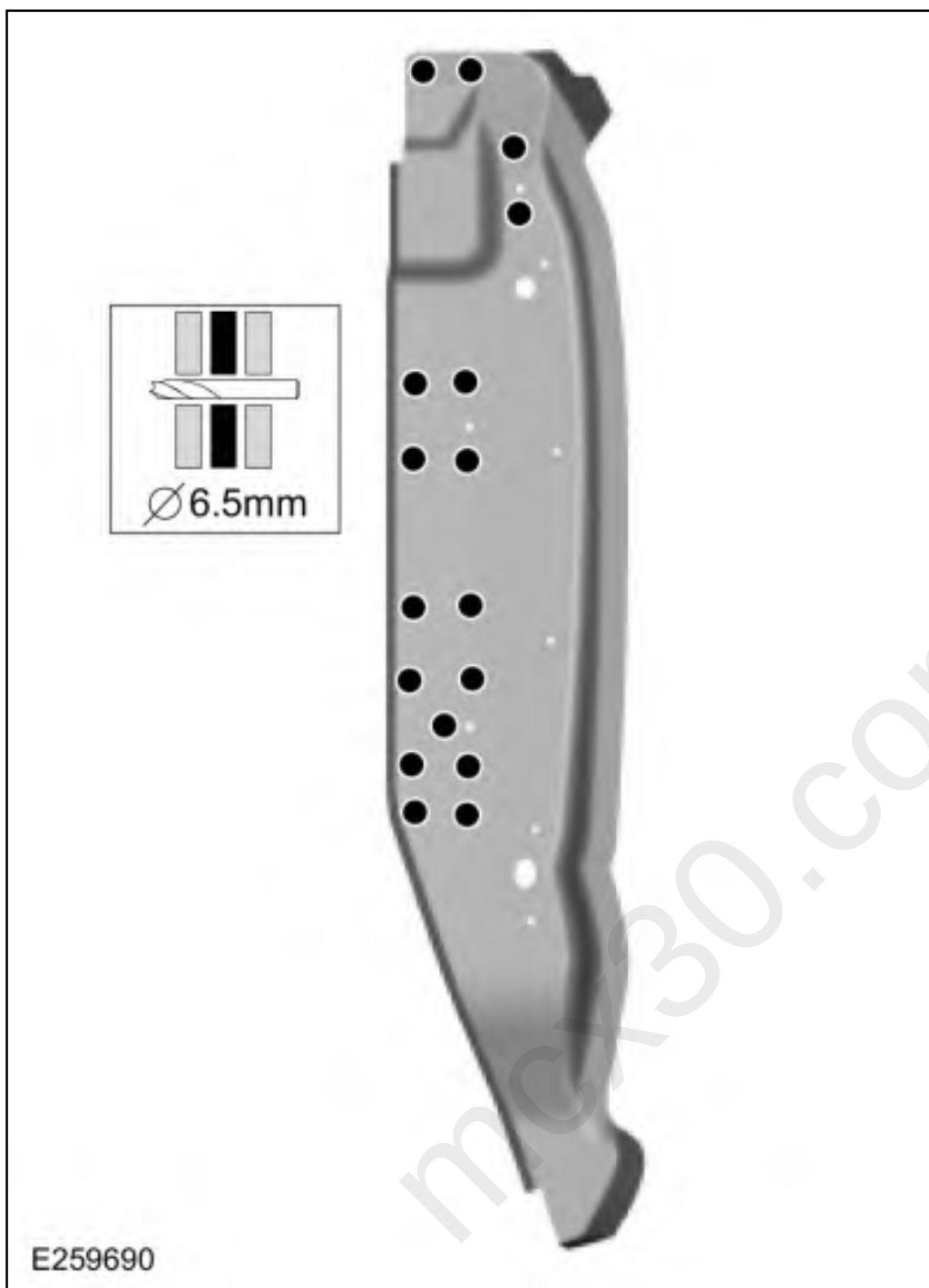
15. Drill for plug welds.

Use the General Equipment: 6.5 mm Drill Bit

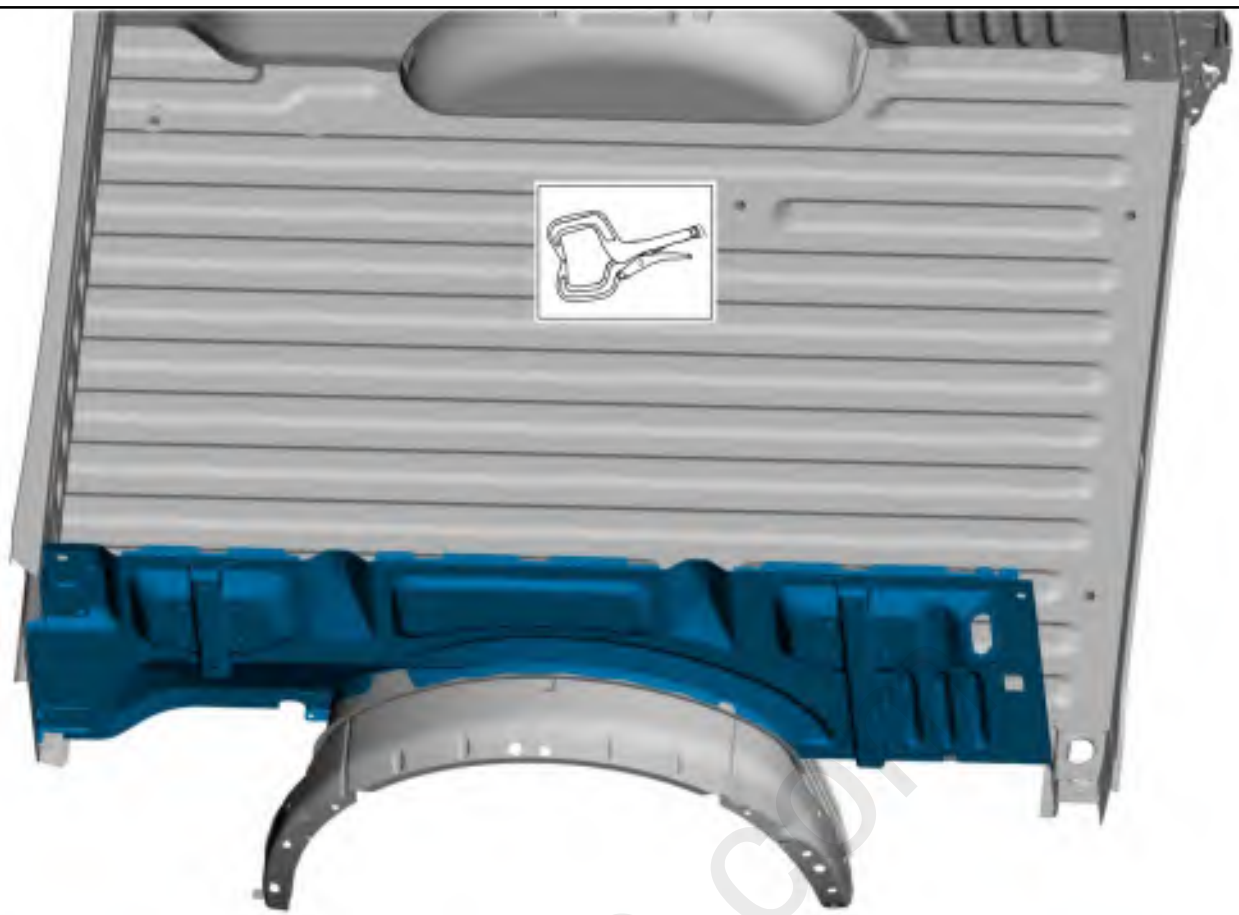


16. Drill for plug welds.

Use the General Equipment: 6.5 mm Drill Bit

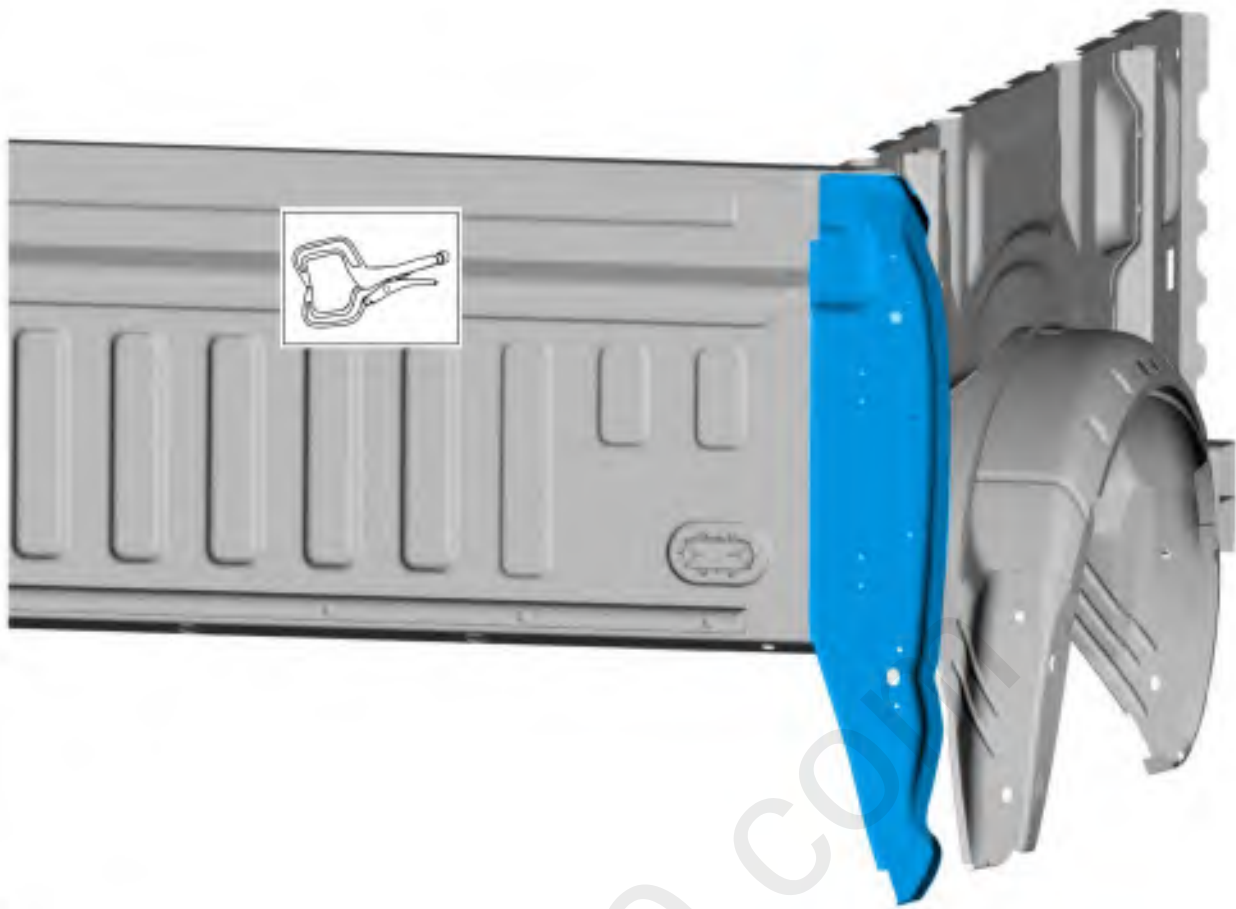


17. Install and clamp in position.
Use the General Equipment: Locking Pliers



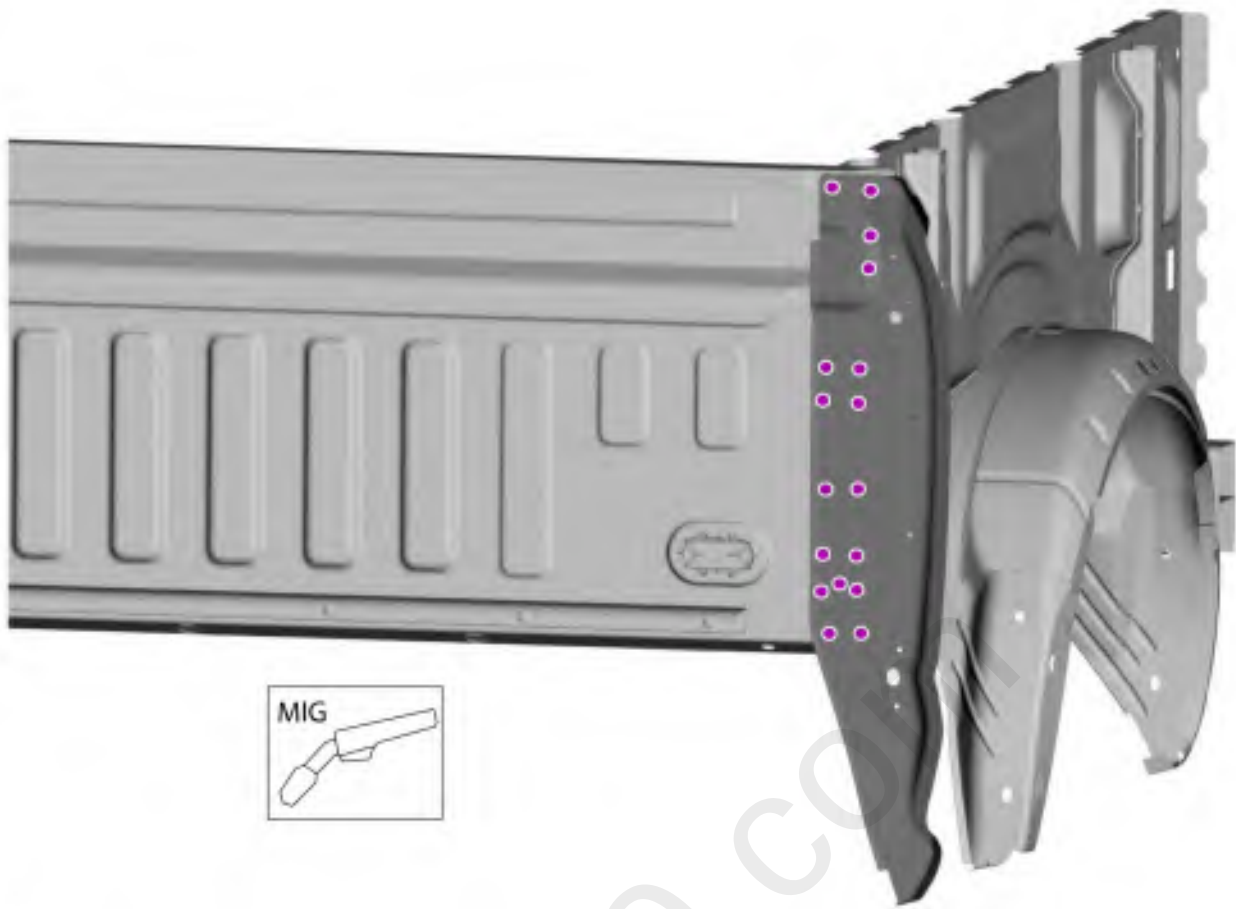
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18. Install and clamp in position.
Use the General Equipment: Locking Pliers



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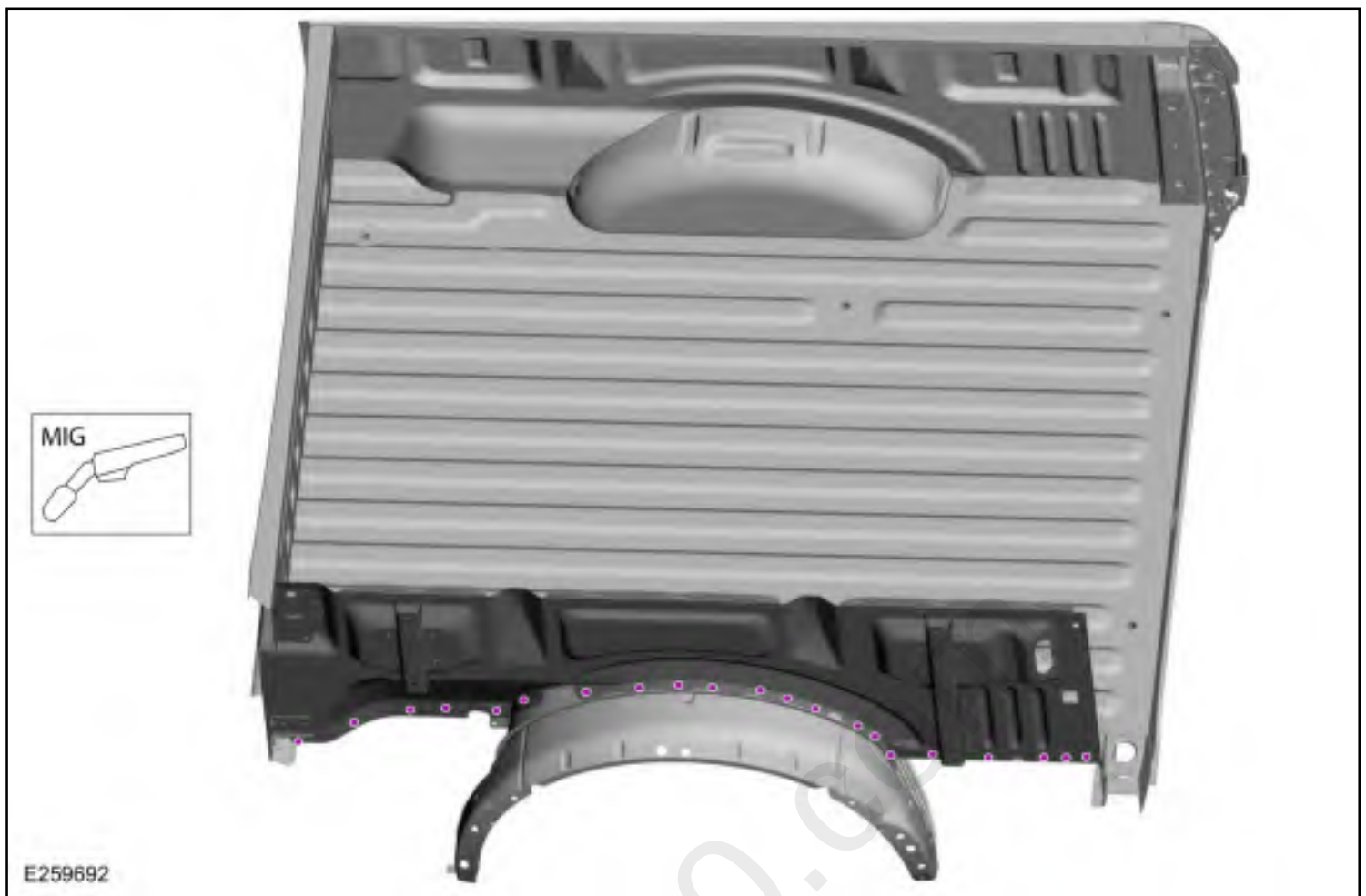
19. Install aluminum MIG plug welds.
Use the General Equipment: MIG/MAG Welding Equipment



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20. Install aluminum MIG plug welds.

Use the General Equipment: MIG/MAG Welding Equipment



21. Metal Finishing:

Metal finish the repair area as necessary using typical techniques and materials.

Refer to: [Special Repair Considerations for Aluminum Repairs](#) (501-25 Body Repairs - General Information, Description and Operation).

All vehicles

22. Install the pickup box corner reinforcement.

Refer to: [Pickup Box Corner Reinforcement](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

23. Install the pickup box outer side panel.

Refer to: [Pickup Box Outer Side Panel](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

24. Seam Sealing:

All seams must be sealed to production level.

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

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