

Pickup Box Outer Side Panel - Raptor

Special Tool(s) / General Equipment

6.5 mm Drill Bit
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	-
Flexible Foam Repair 3M™ 08463, LORD Fusor® 121	-

Removal

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: LH side shown, RH side does not include fuel fill.

1. Remove the tailgate.
2. Remove the pickup bed.
Refer to: [Pickup Bed](#) (501-04 Pickup Bed and Platform Body, Description and Operation).
3. Remove the tail lamp assembly.
Refer to: [Rear Lamp Assembly](#) (417-01 Exterior Lighting) .
4. LH side only:
Remove the fuel fill door and fuel fill cup.
Refer to: [Fuel Filler Door Assembly](#) (501-03 Body Closures, Removal and Installation).
5. If Equipped; Remove the top rail cover, wheel house opening and lower side trim.
6. Remove the screw.



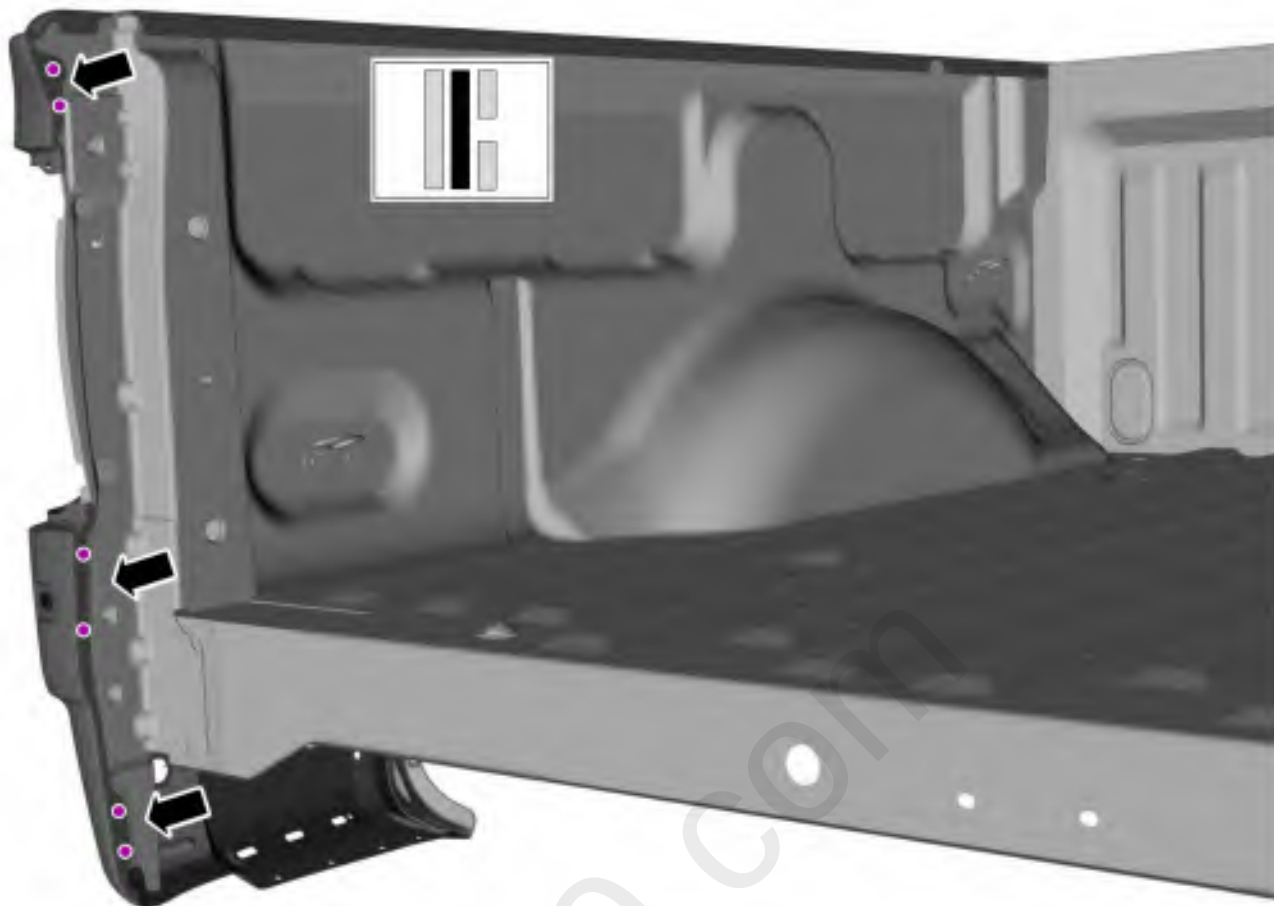
7. Remove the fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



8. Remove the SPR fasteners.

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

Use the General Equipment: Belt Sander

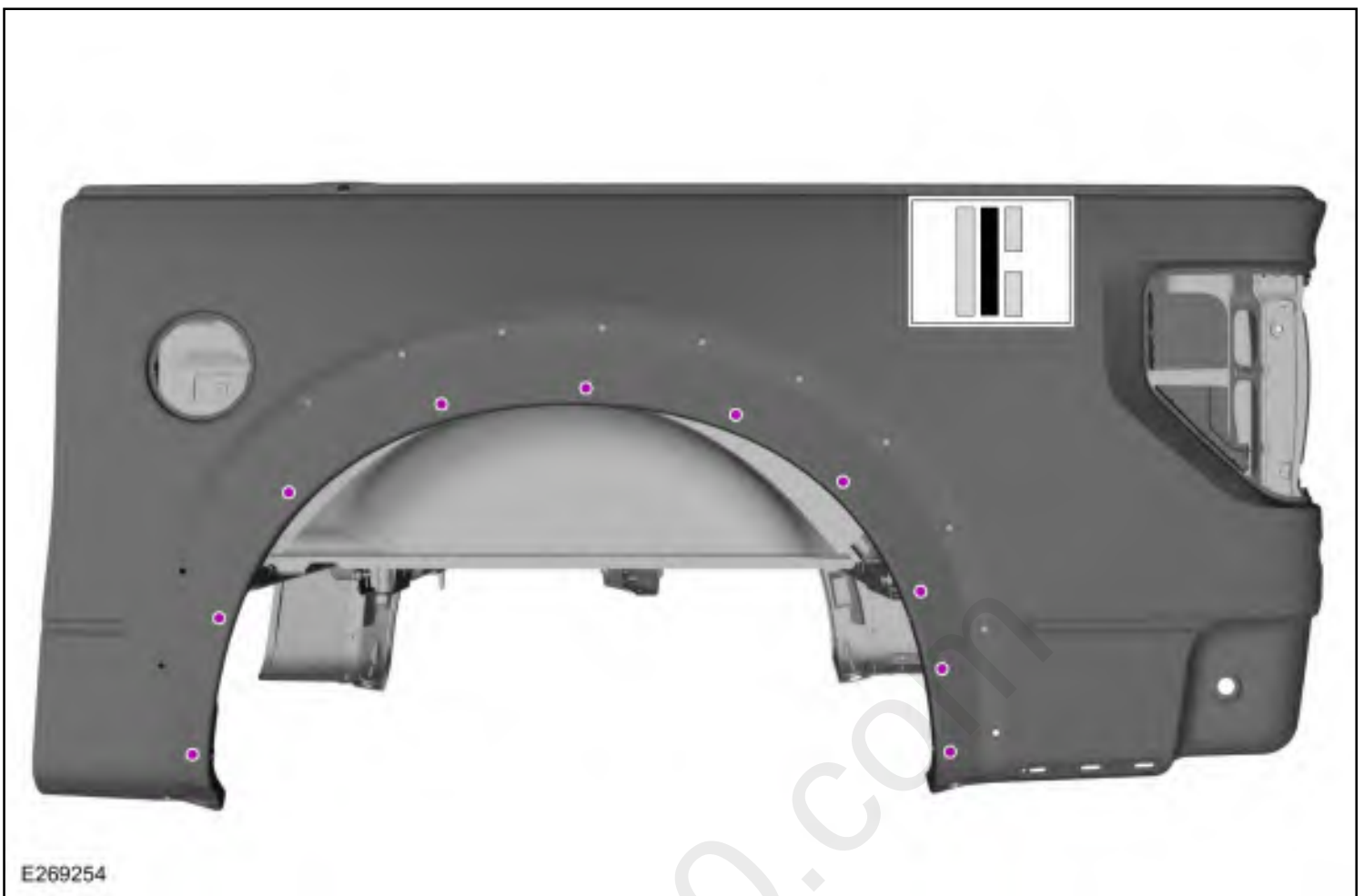


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9. Remove the SPR fasteners.

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

Use the General Equipment: Belt Sander



10. Remove the SPR fasteners.

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

Use the General Equipment: Belt Sander



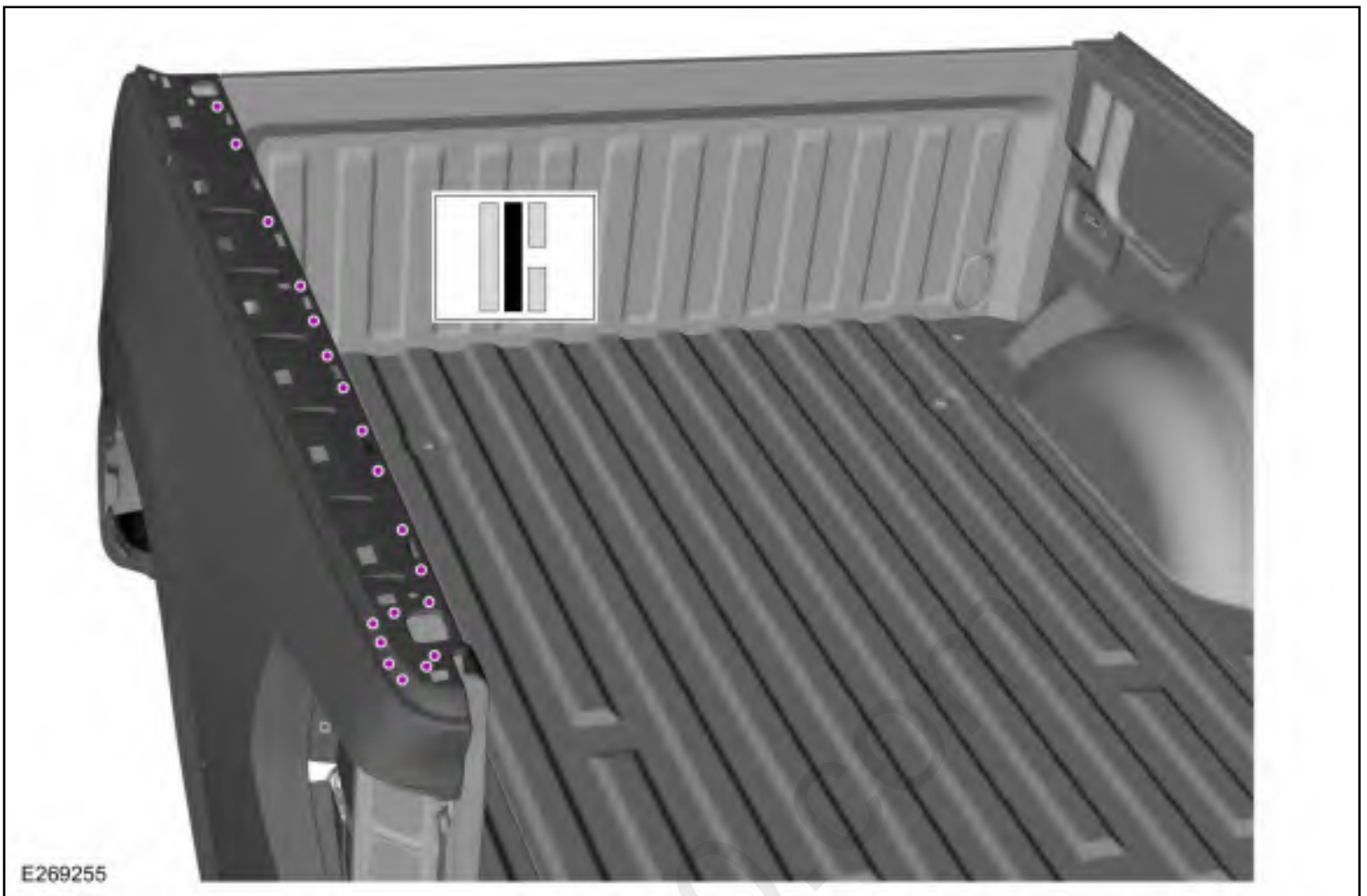
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11. Remove the SPR fasteners.

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

Use the General Equipment: Belt Sander



12. **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: Note the location of adhesives and NVH sealers to aid in installation.

Break the adhesive bond and remove the pickup box outer side panel.
Use the General Equipment: Hot Air Gun



Installation

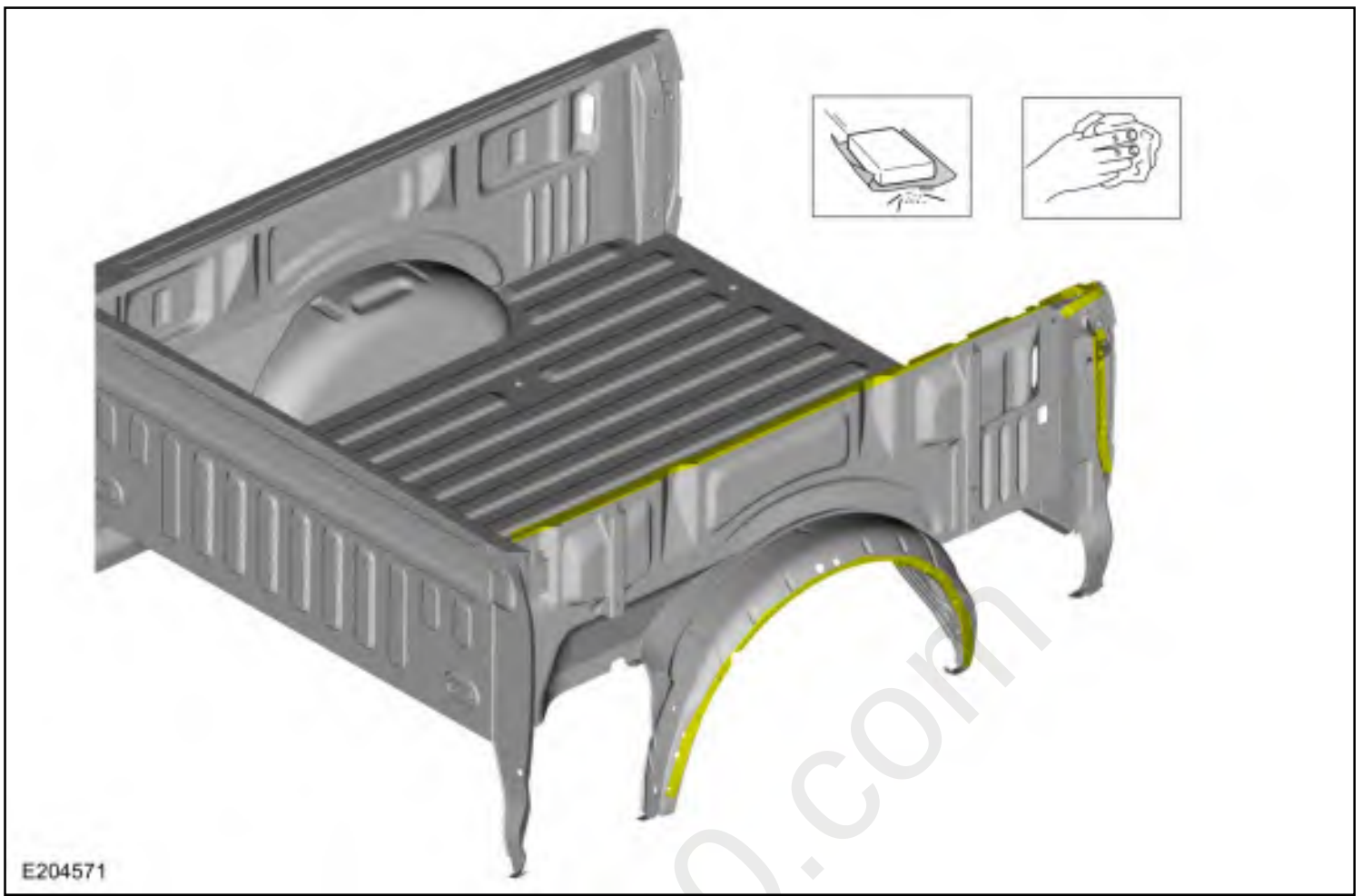
NOTE: *LH side shown, RH side does not include fuel fill.*

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

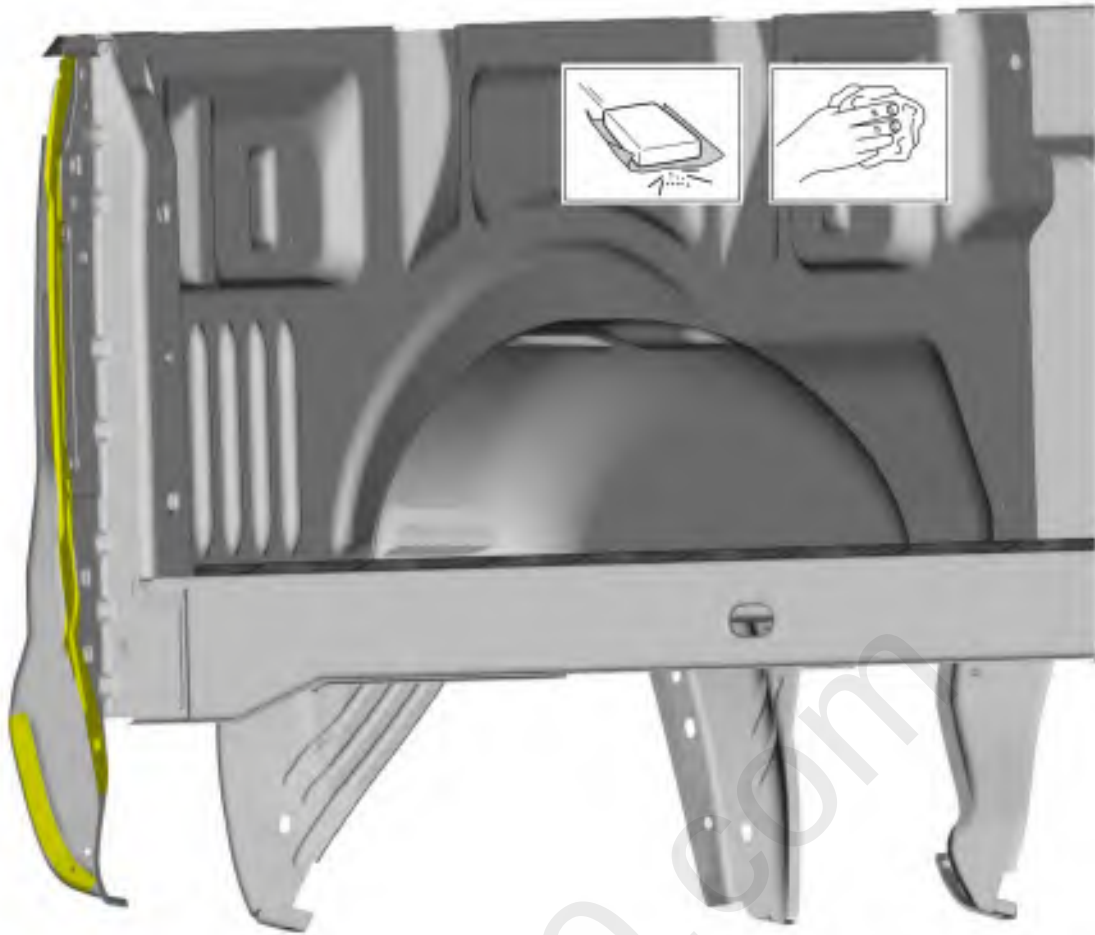
NOTE: *Blind rivets, solid rivet fasteners or aluminum MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.*

Rivet-Bonding

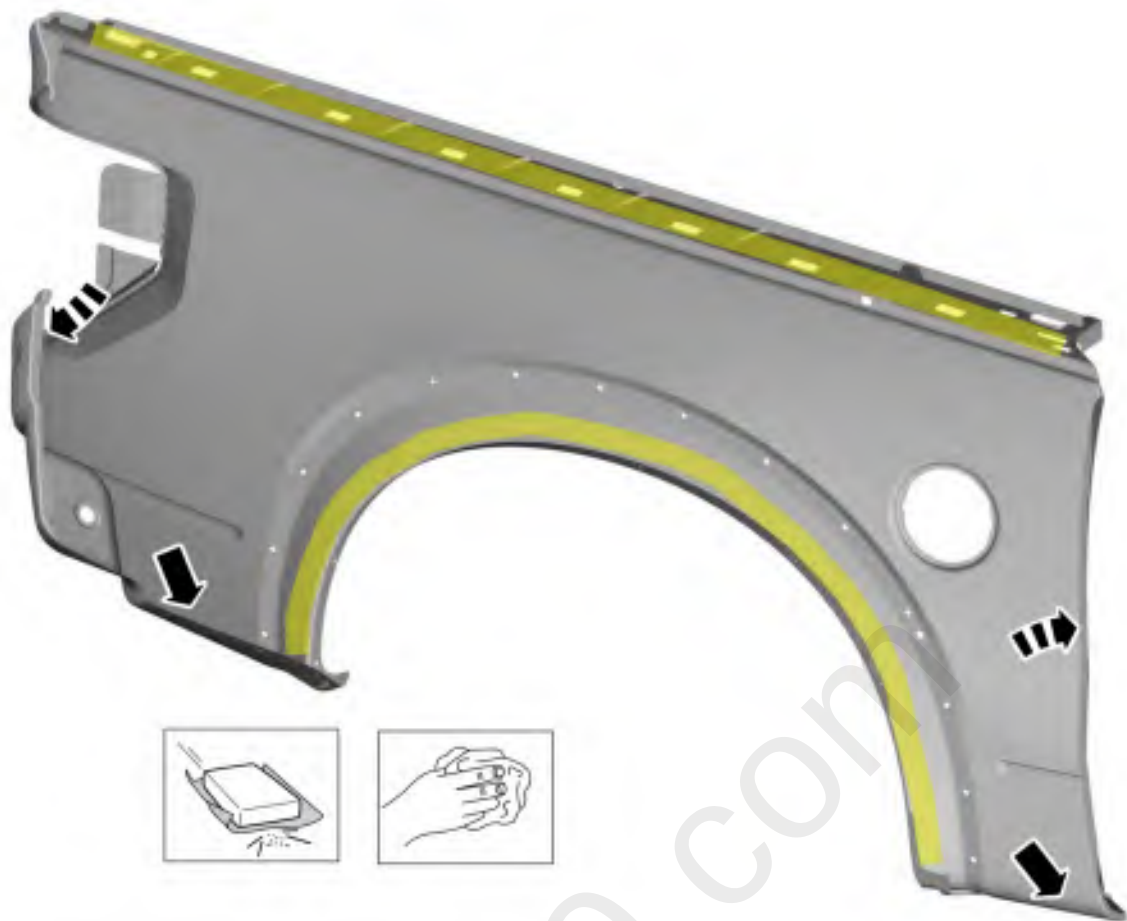
1. 80-120 grit sand paper.
Sand to remove old adhesive and NVH sealer and clean.



2. 80-120 grit sand paper.
Sand to remove old adhesive and clean.

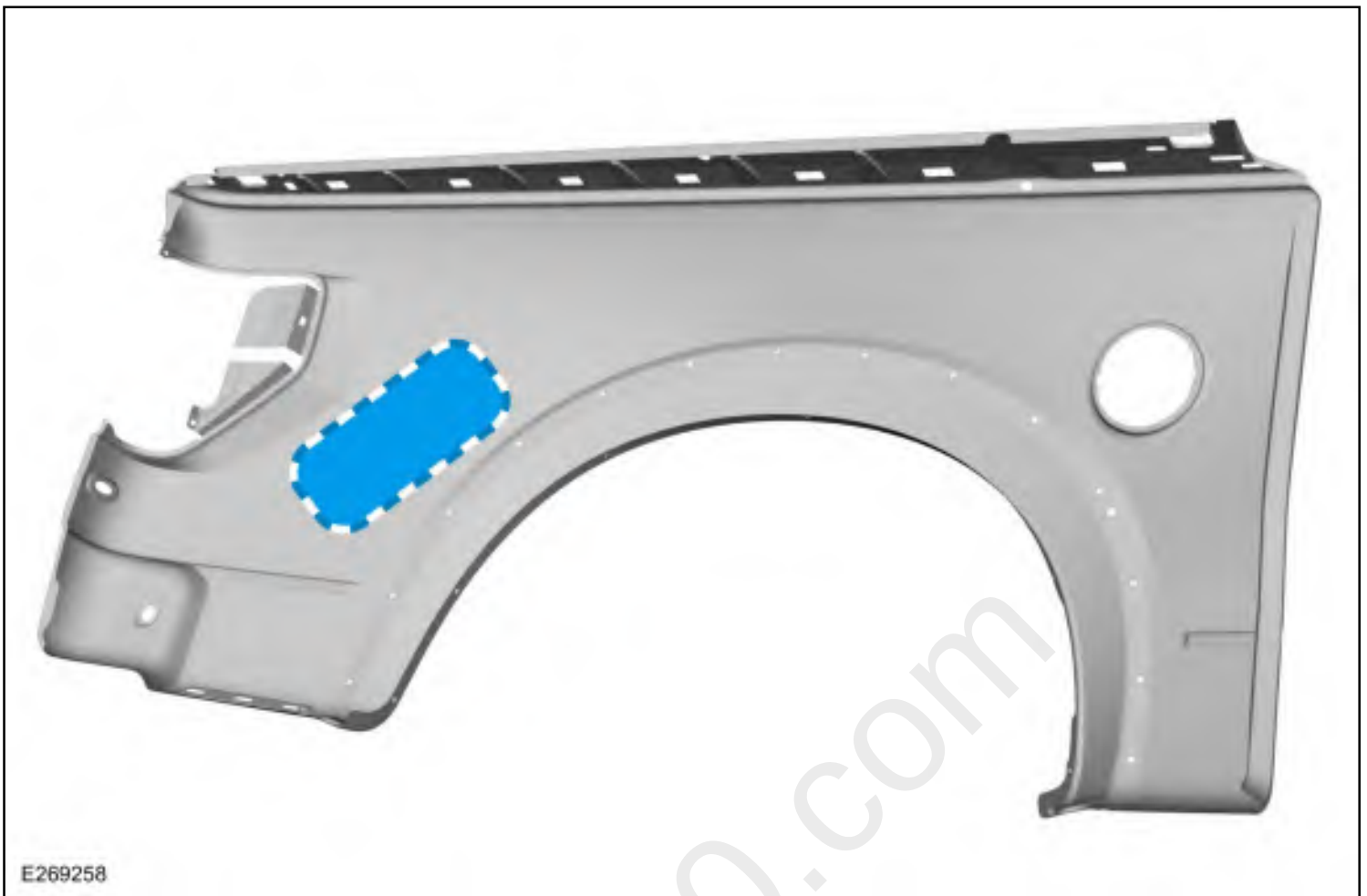


3. 80-120 grit sand paper.
Sand to remove e-coat and clean.



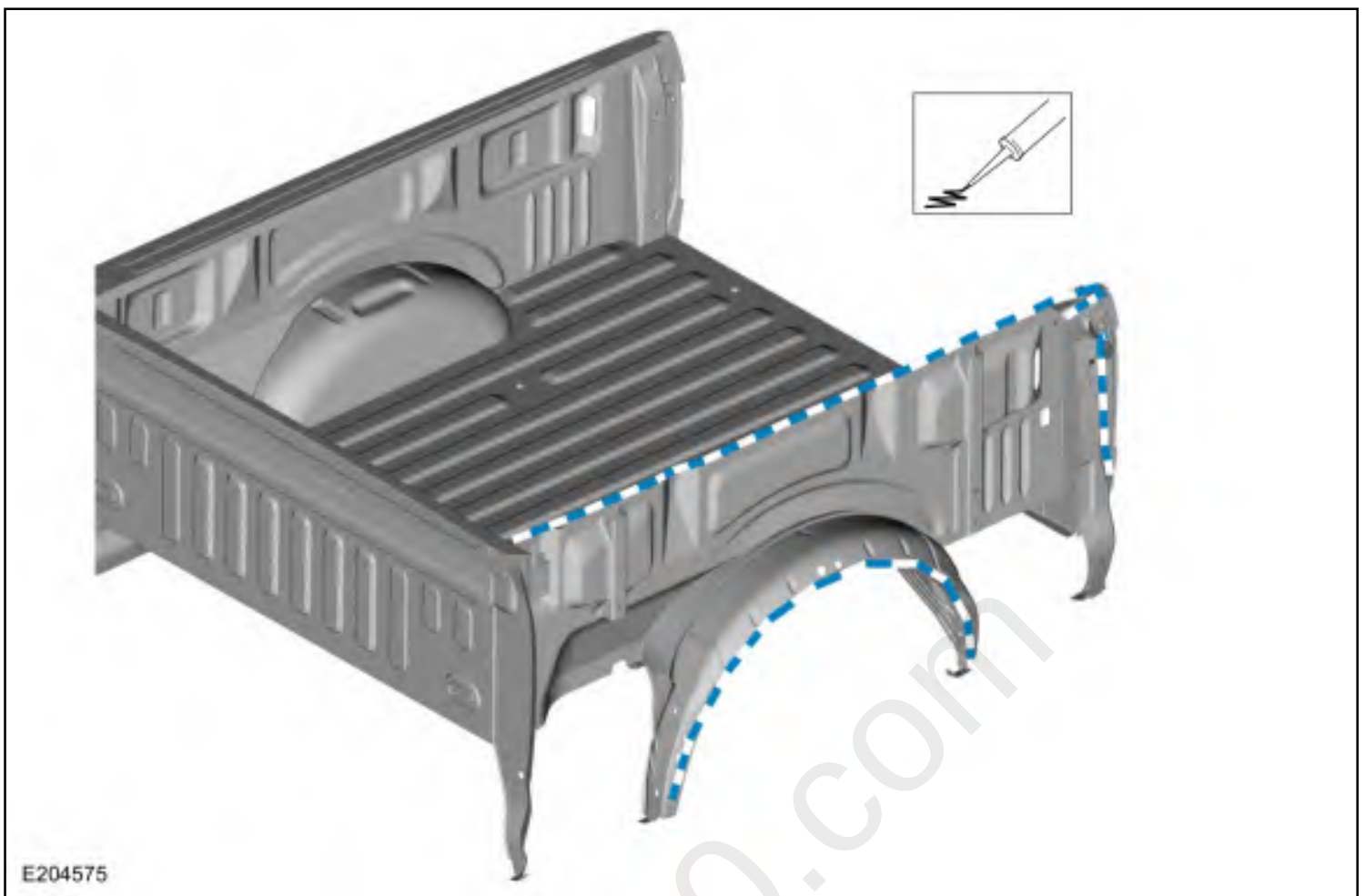
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4. Install a locally obtained NVH pad.



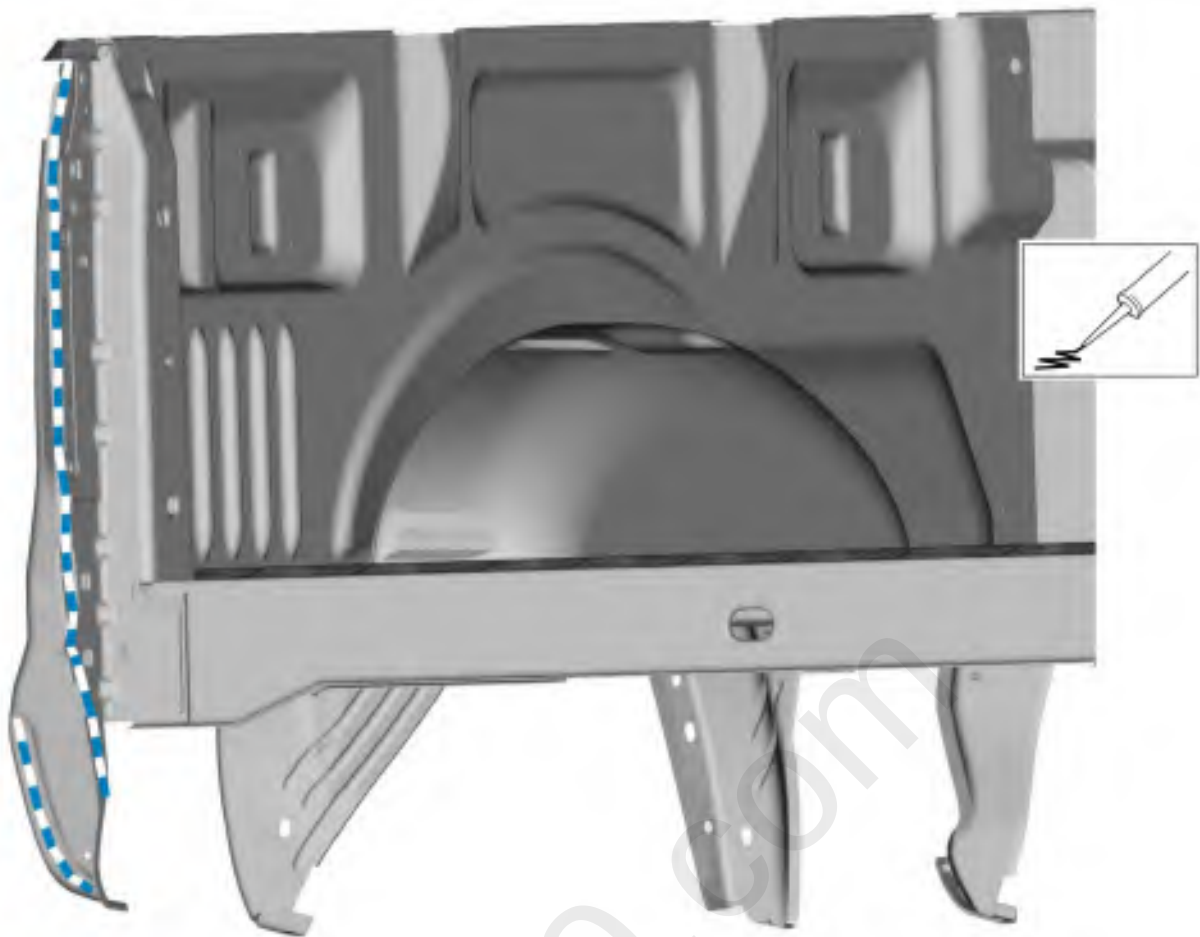
5. Apply adhesive.

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



6. Apply adhesive.

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



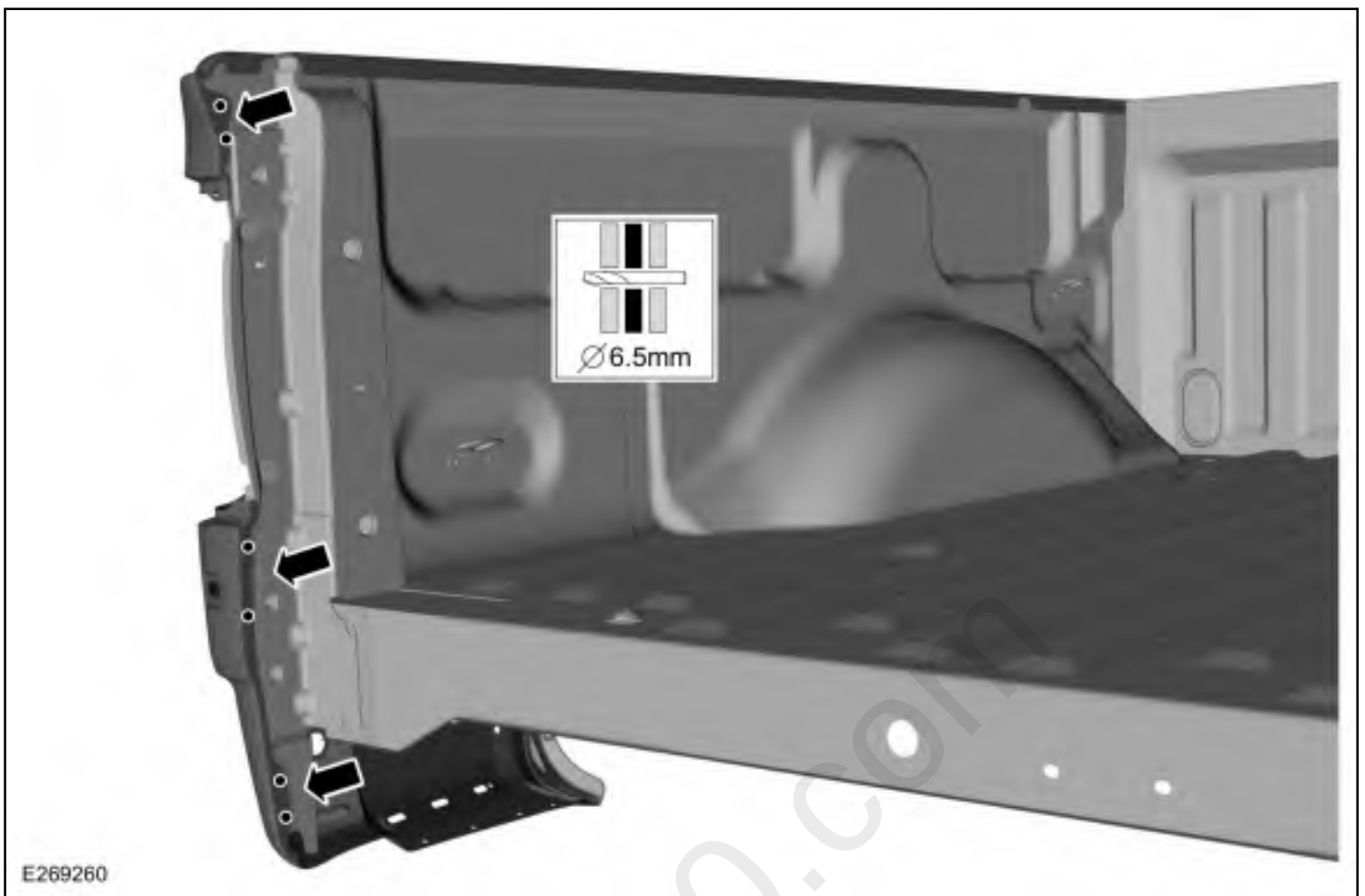
7. Install the replacement pickup box outer side panel and clamp in position.
Use the General Equipment: Locking Pliers



8. **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 rivet fastener installation.

Use the General Equipment: 6.5 mm Drill Bit



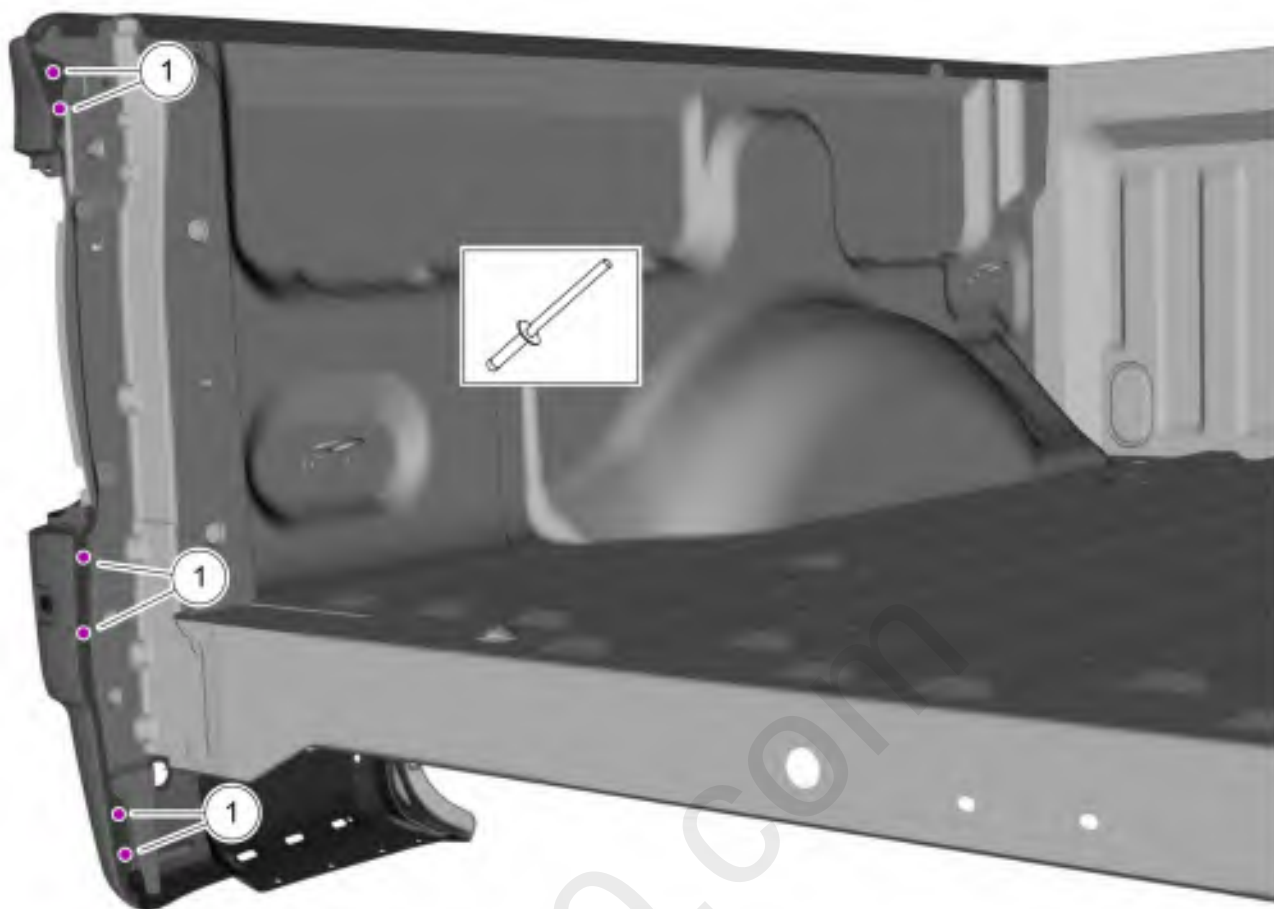
9. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

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.

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



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



11. **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.*

Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707637-S900C	-	-

Use the General Equipment: Blind Rivet Gun



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



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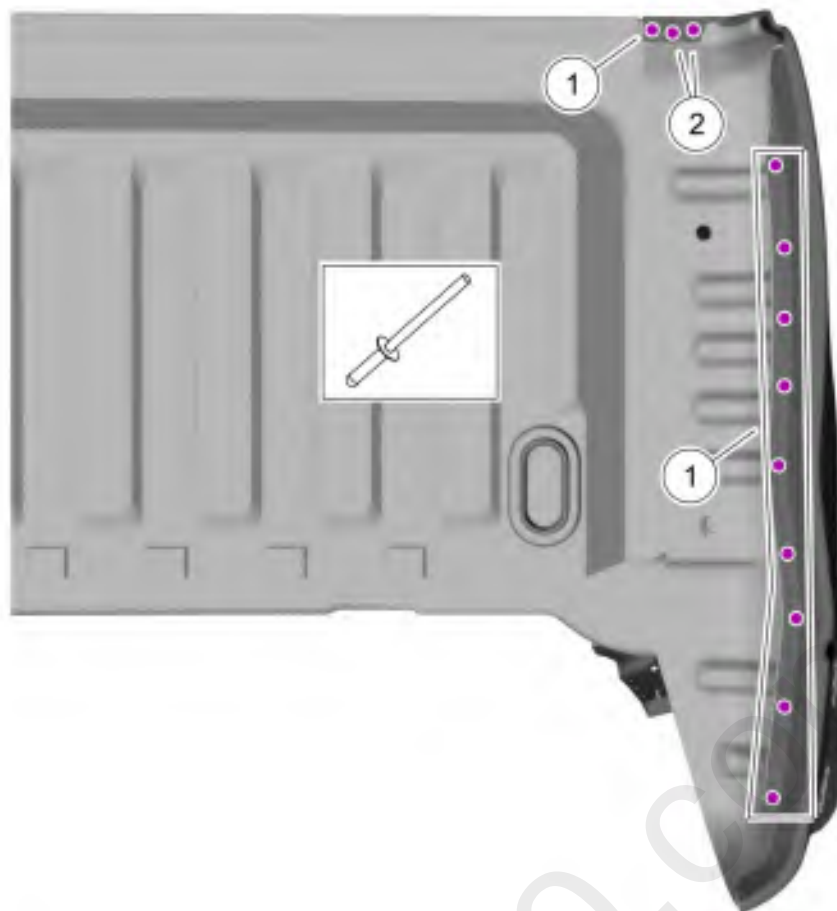
13. **NOTE:** *SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.*

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.*

Install fasteners.

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

Use the General Equipment: Blind Rivet Gun



E269265

14. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



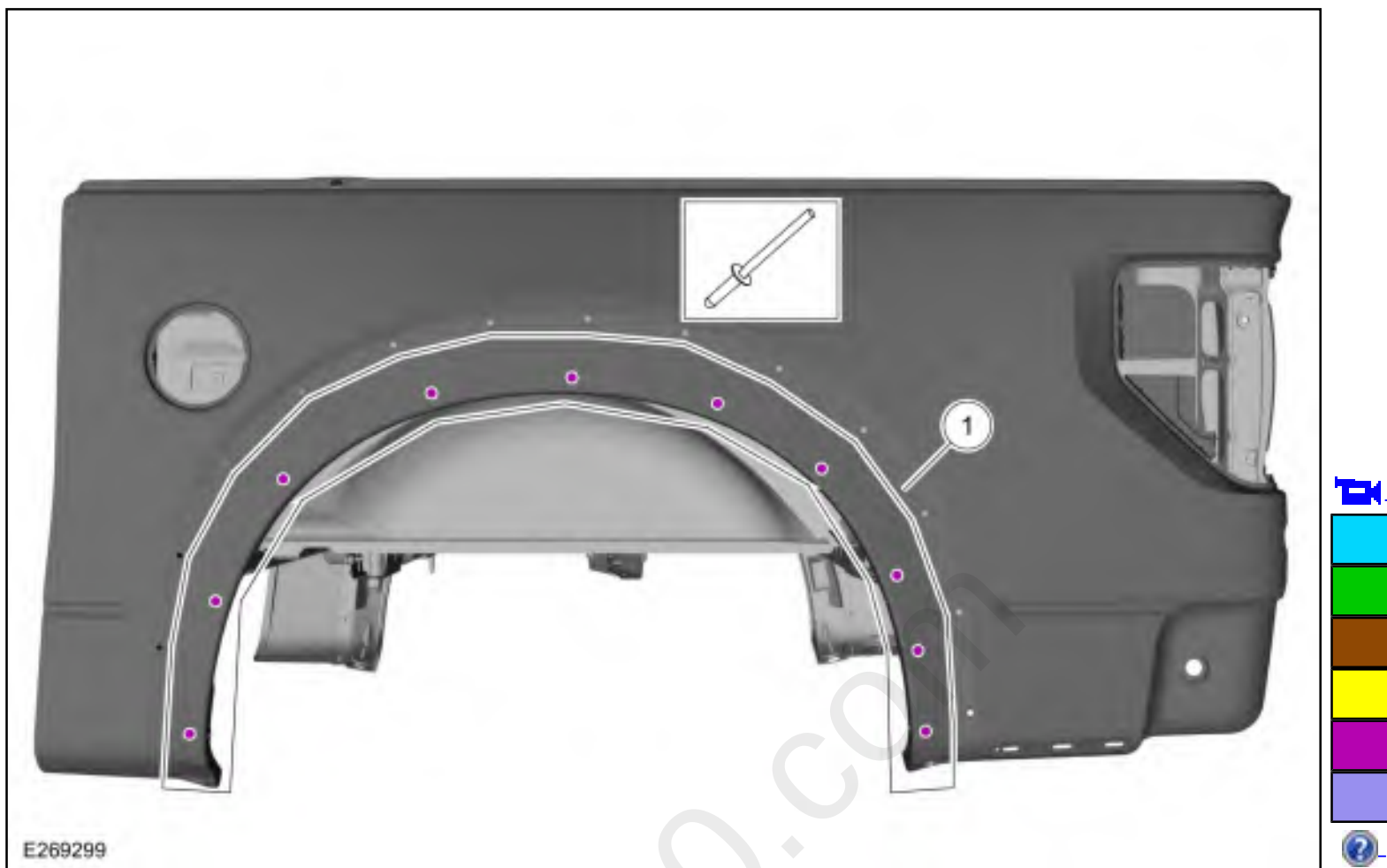
15. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

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

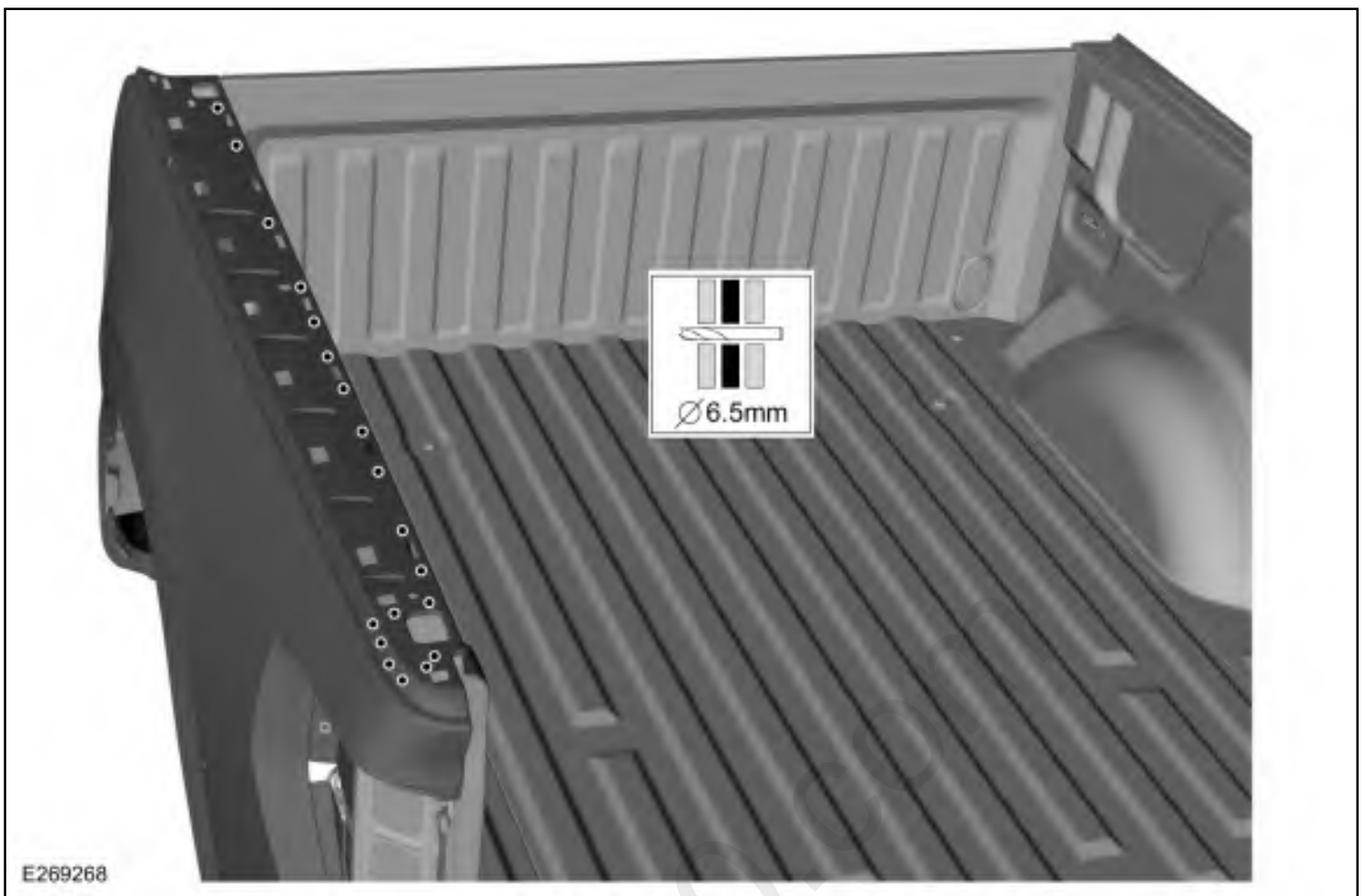
Install fasteners.

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



16. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



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

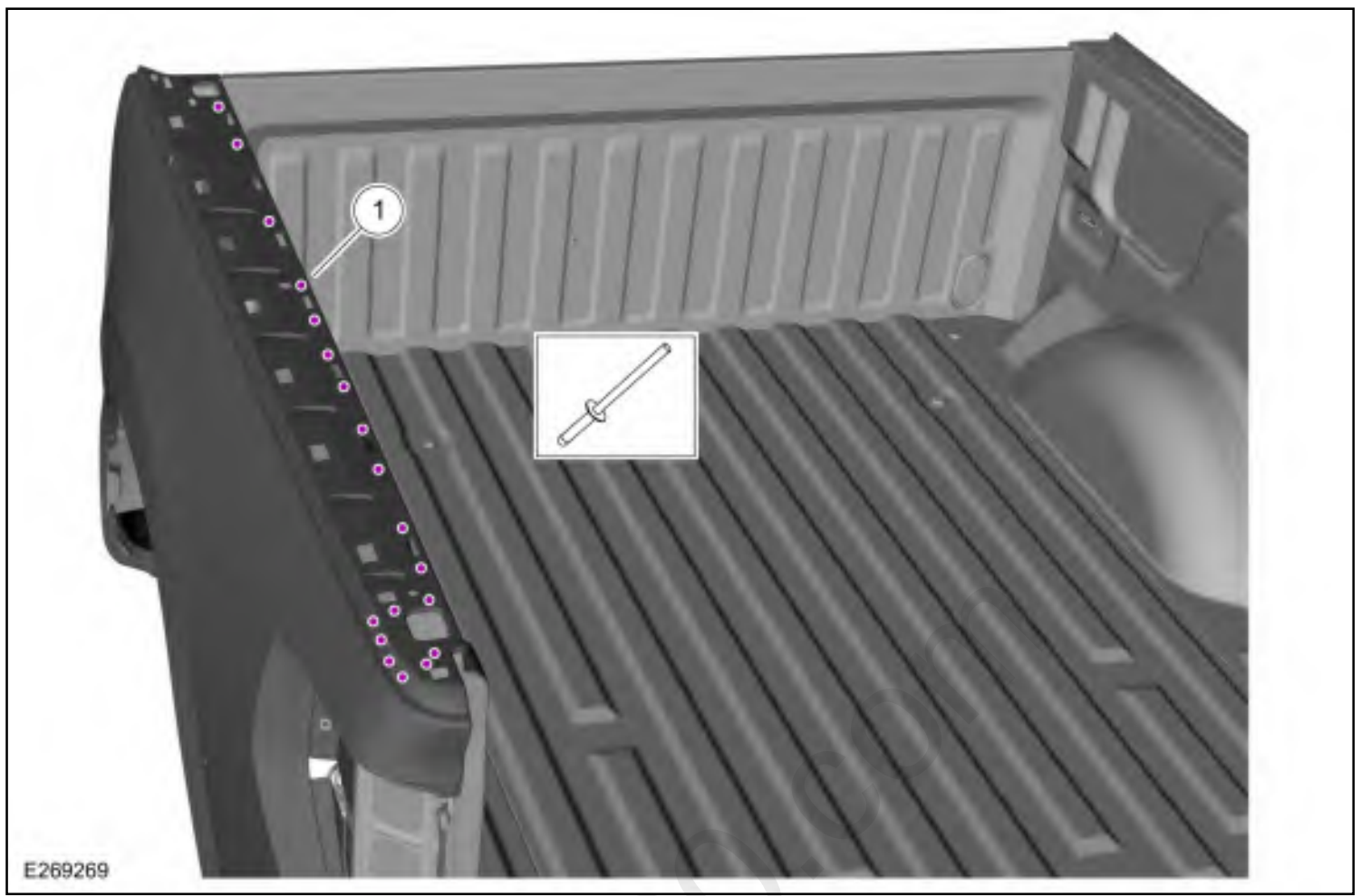
NOTE: Blind rivets, solid rivet fasteners or aluminum MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Install fasteners.

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

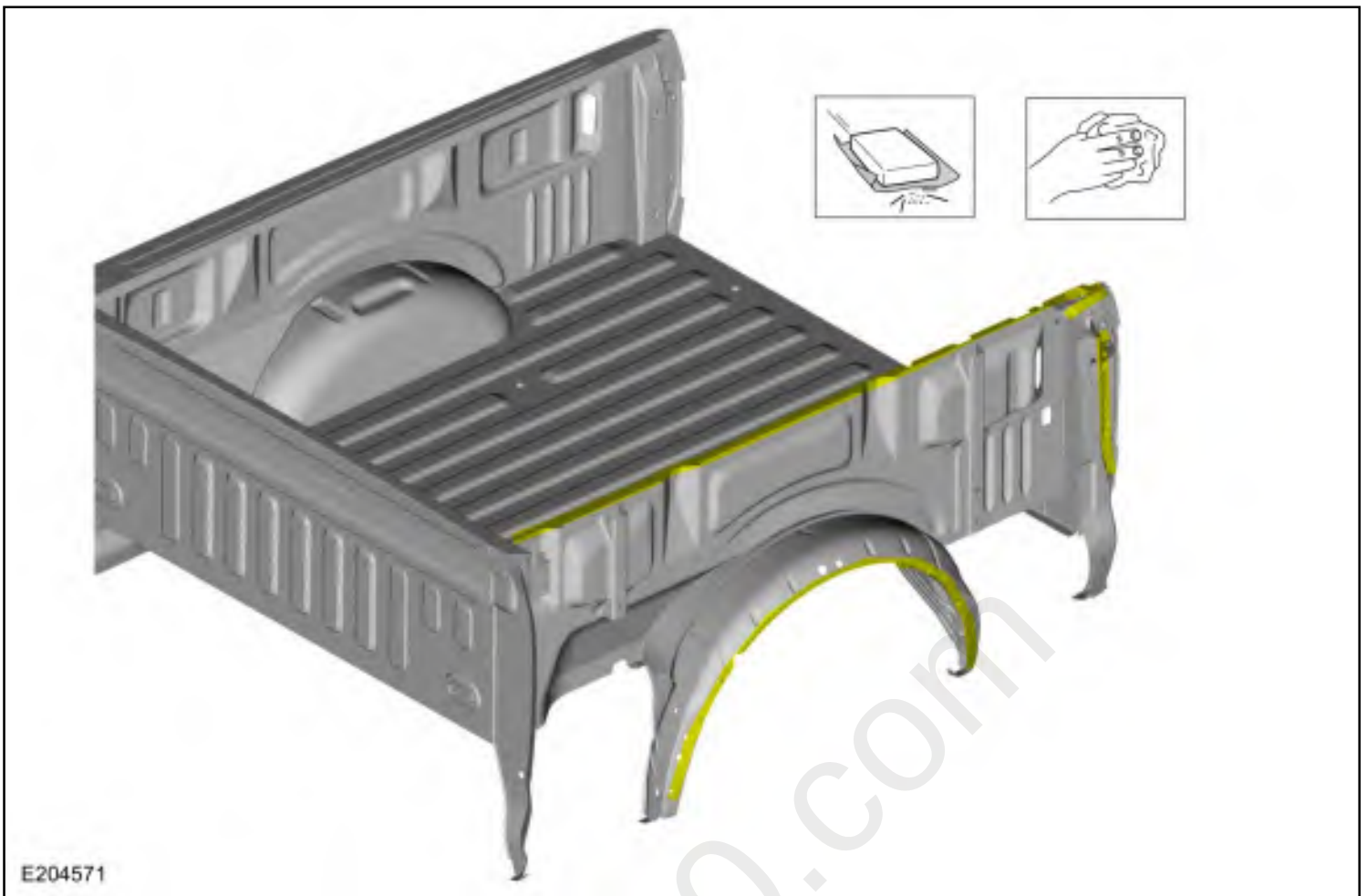
Use the General Equipment: Blind Rivet Gun

18.

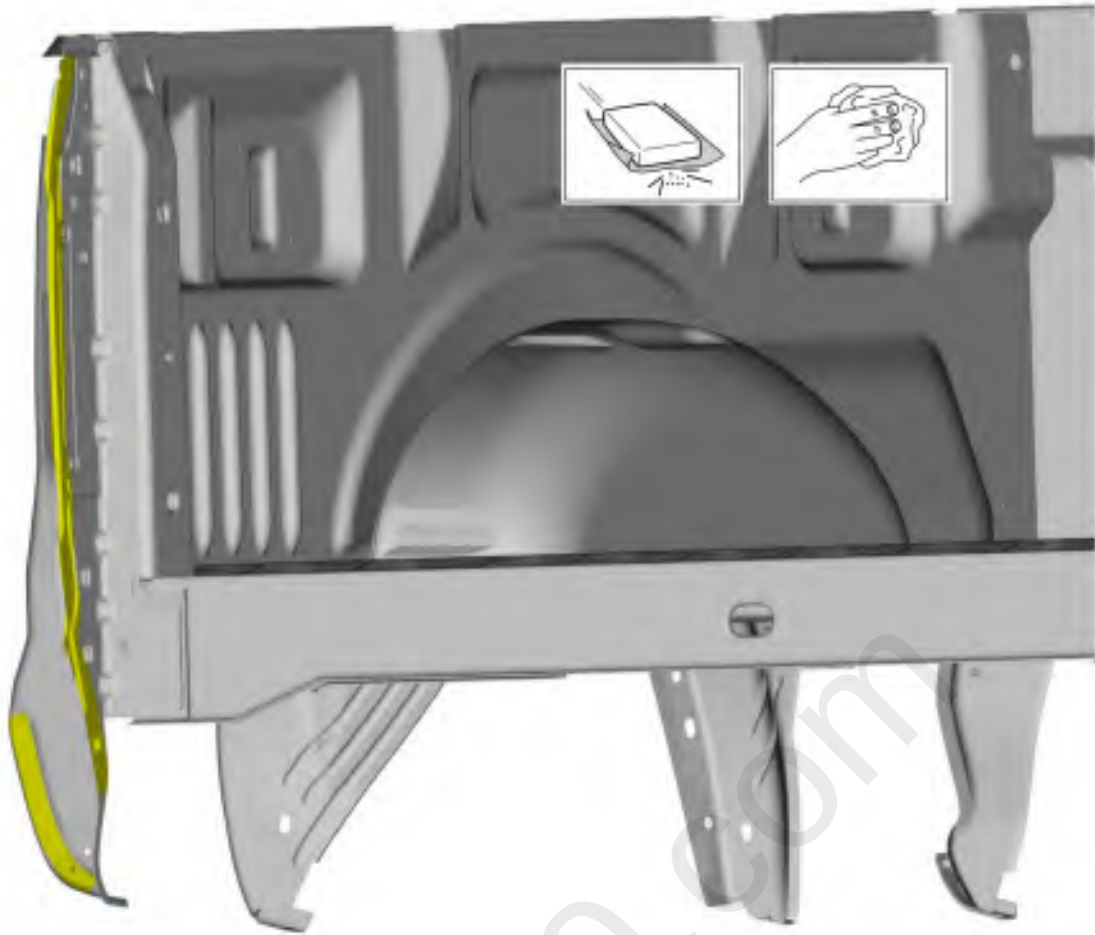


Plug-Welds

19. Sand to remove old adhesive and NVH sealer and clean.

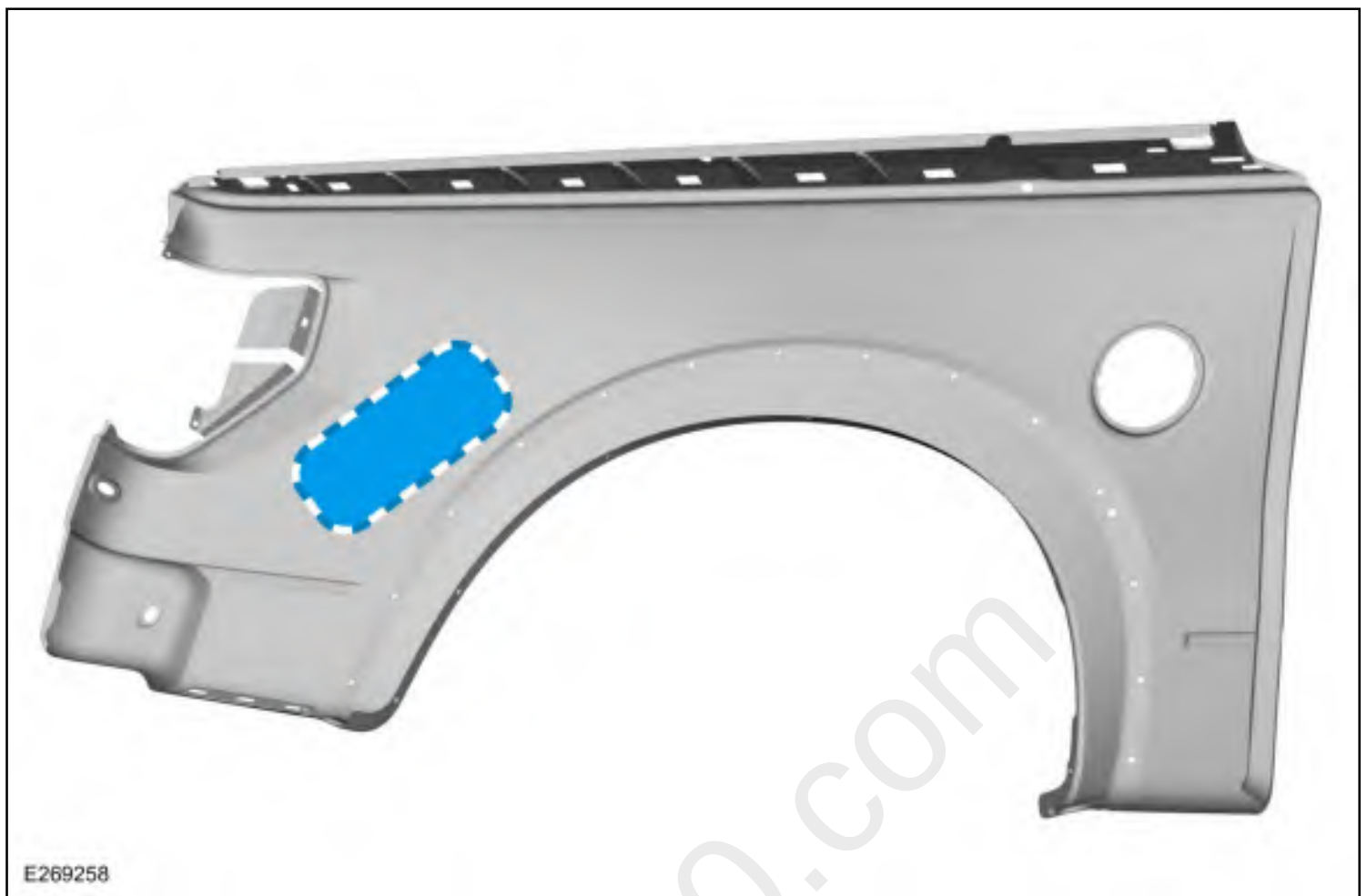


20. Sand to remove old adhesive and clean.



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21. Install a locally obtained NVH pad as noted during removal.



22. Drill for plug welds.

Use the General Equipment: 6.5 mm Drill Bit



23. Drill for plug welds.

Use the General Equipment: 6.5 mm Drill Bit

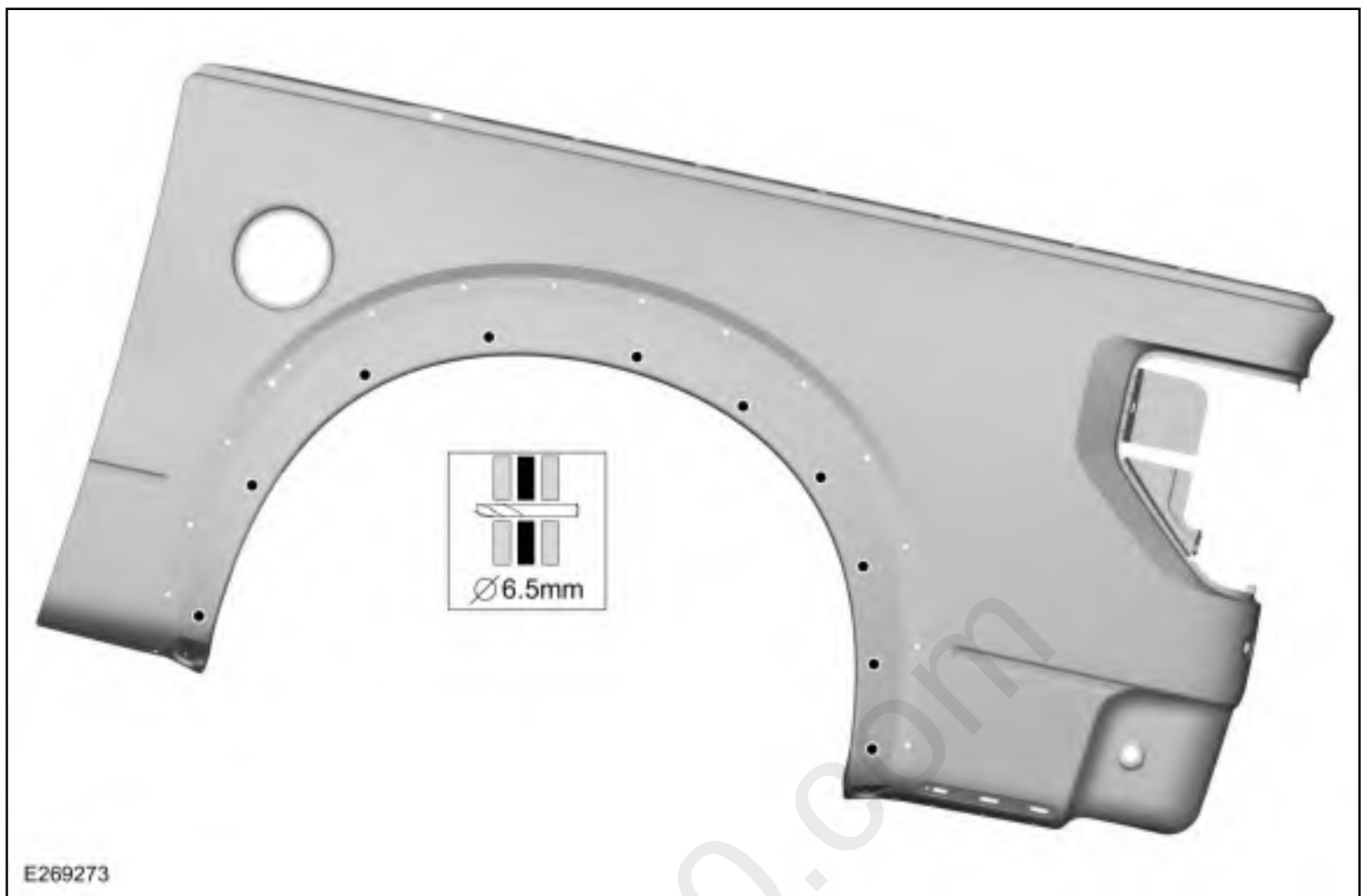


24. Drill for plug welds.

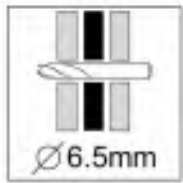
Use the General Equipment: 6.5 mm Drill Bit



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



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



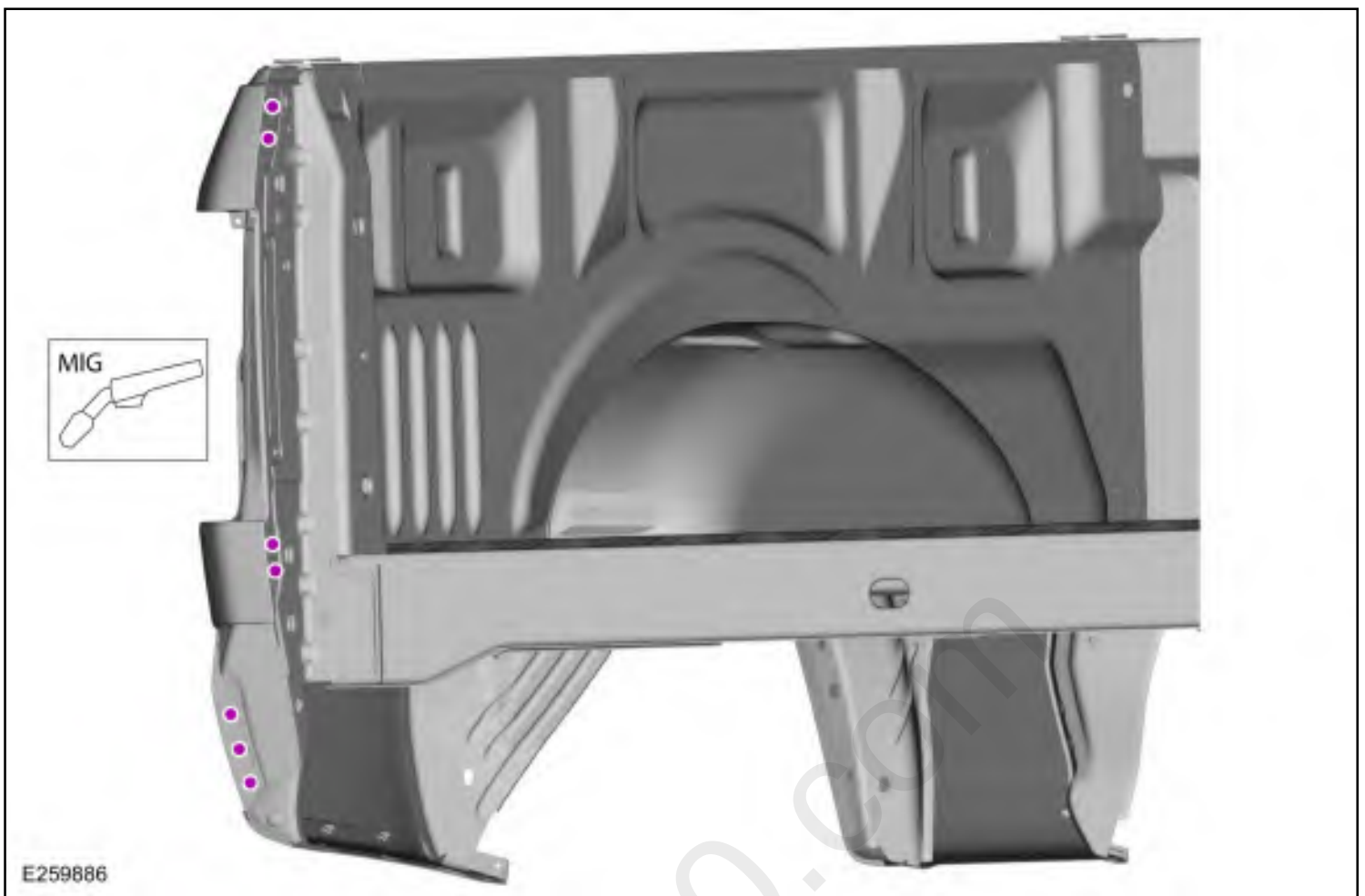
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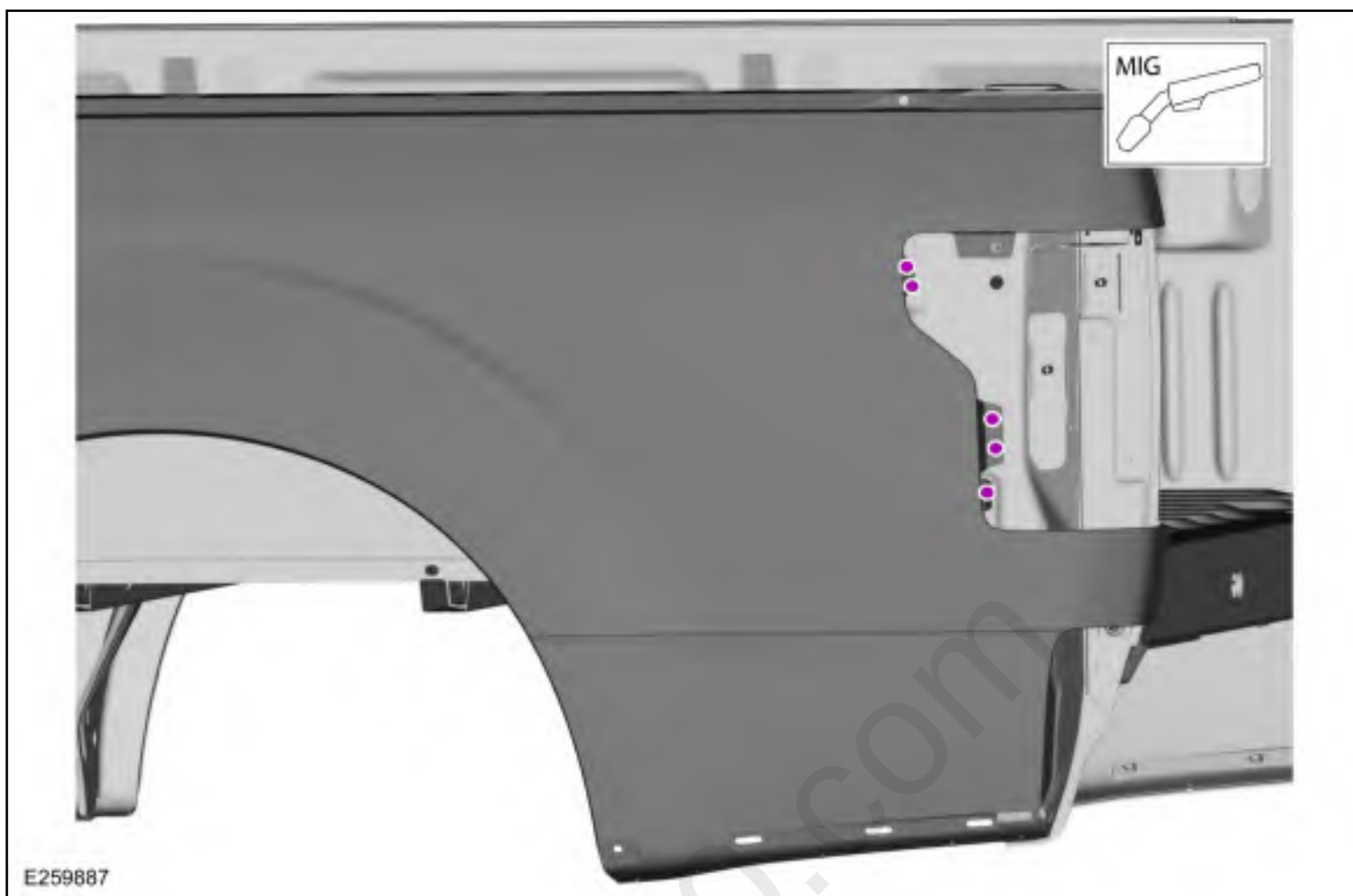
27. Install the replacement pickup box outer panel and clamp in position.
Use the General Equipment: Locking Pliers



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



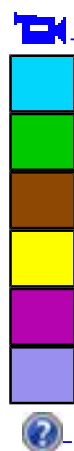
29. Install aluminum MIG plug welds.
Use the General Equipment: MIG/MAG Welding Equipment



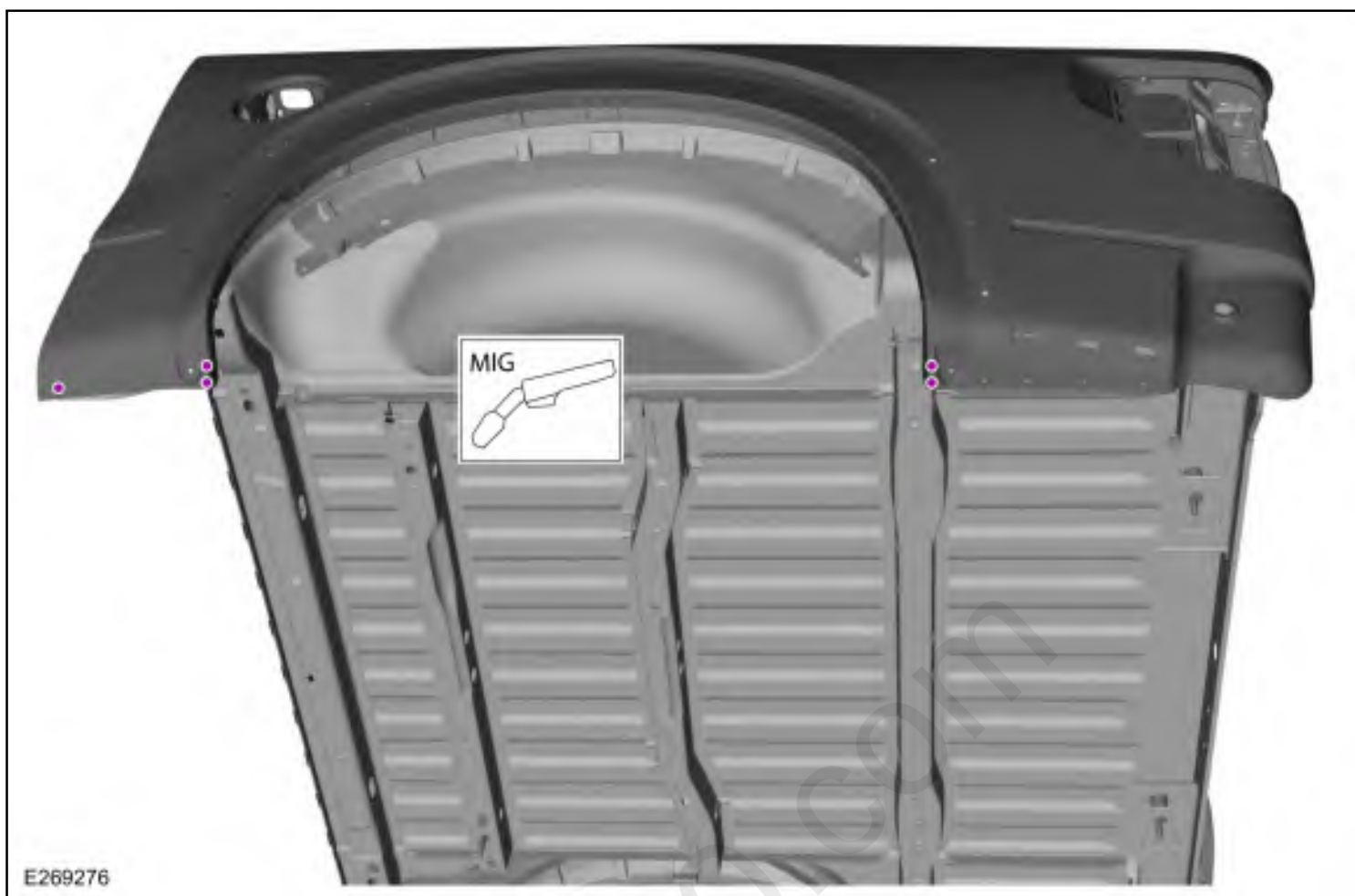
30. Install aluminum MIG plug welds.
Use the General Equipment: MIG/MAG Welding Equipment



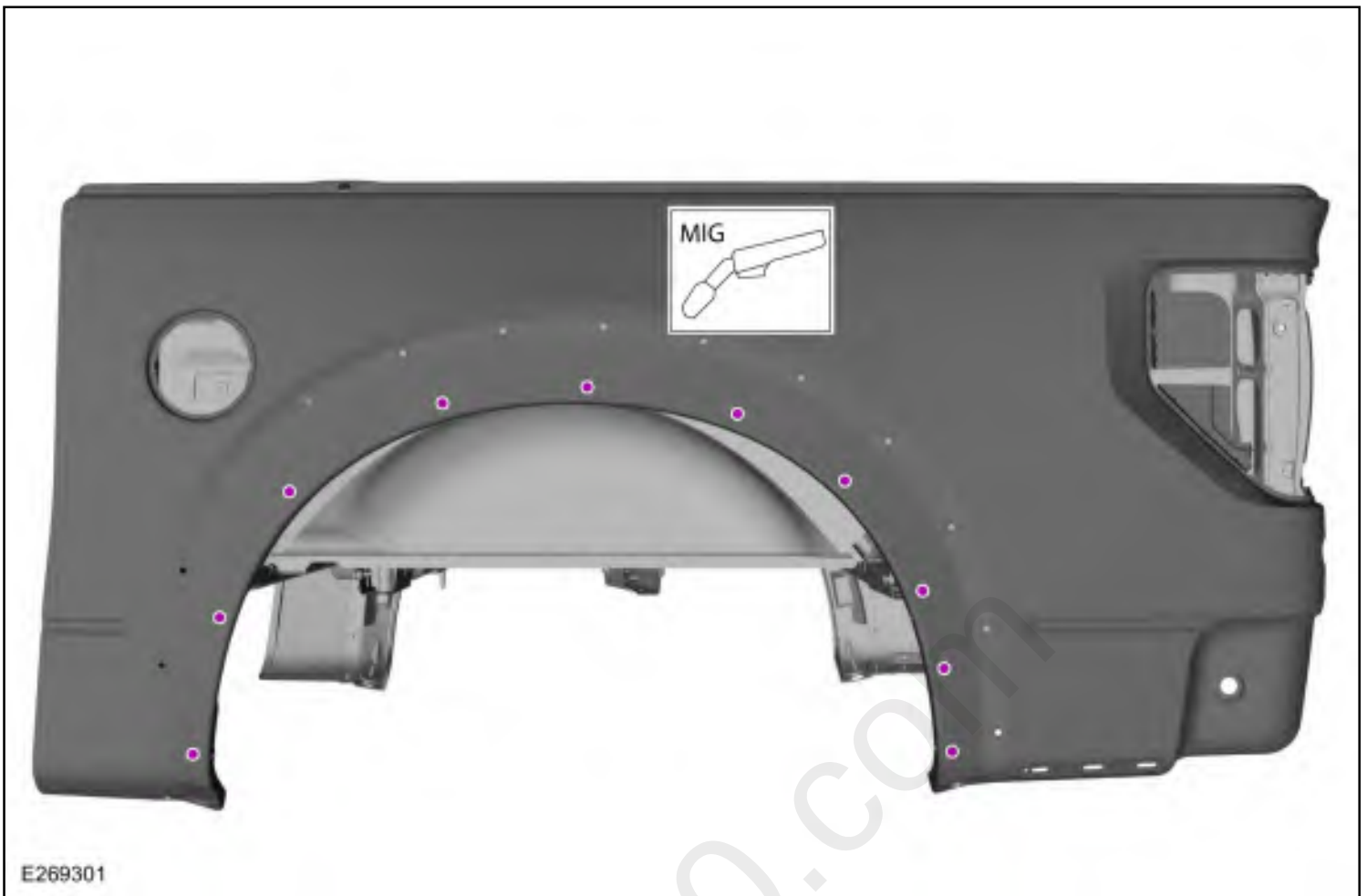
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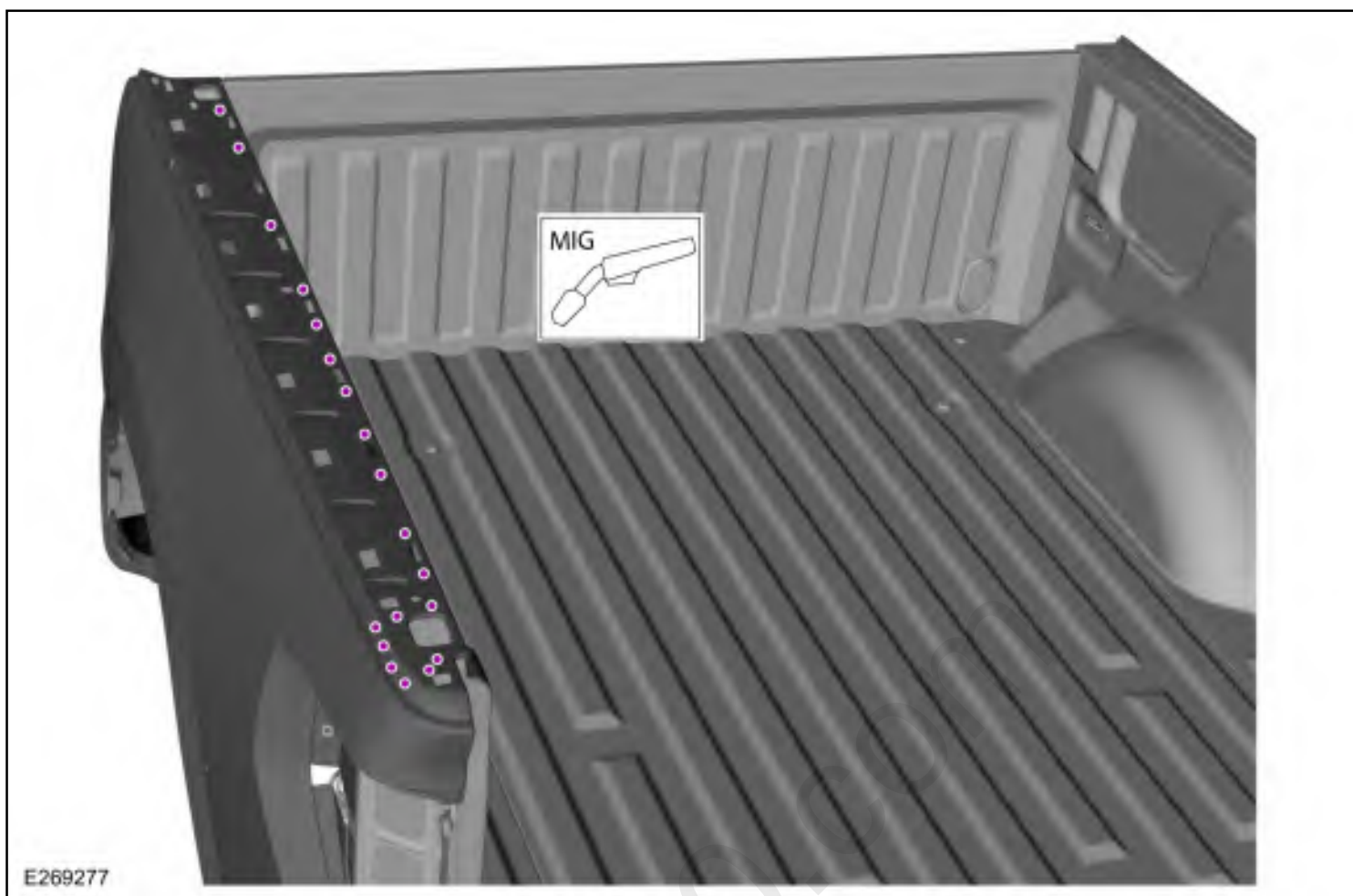
31. Install aluminum MIG plug welds.
Use the General Equipment: MIG/MAG Welding Equipment



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



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



34. Metal Finishing:

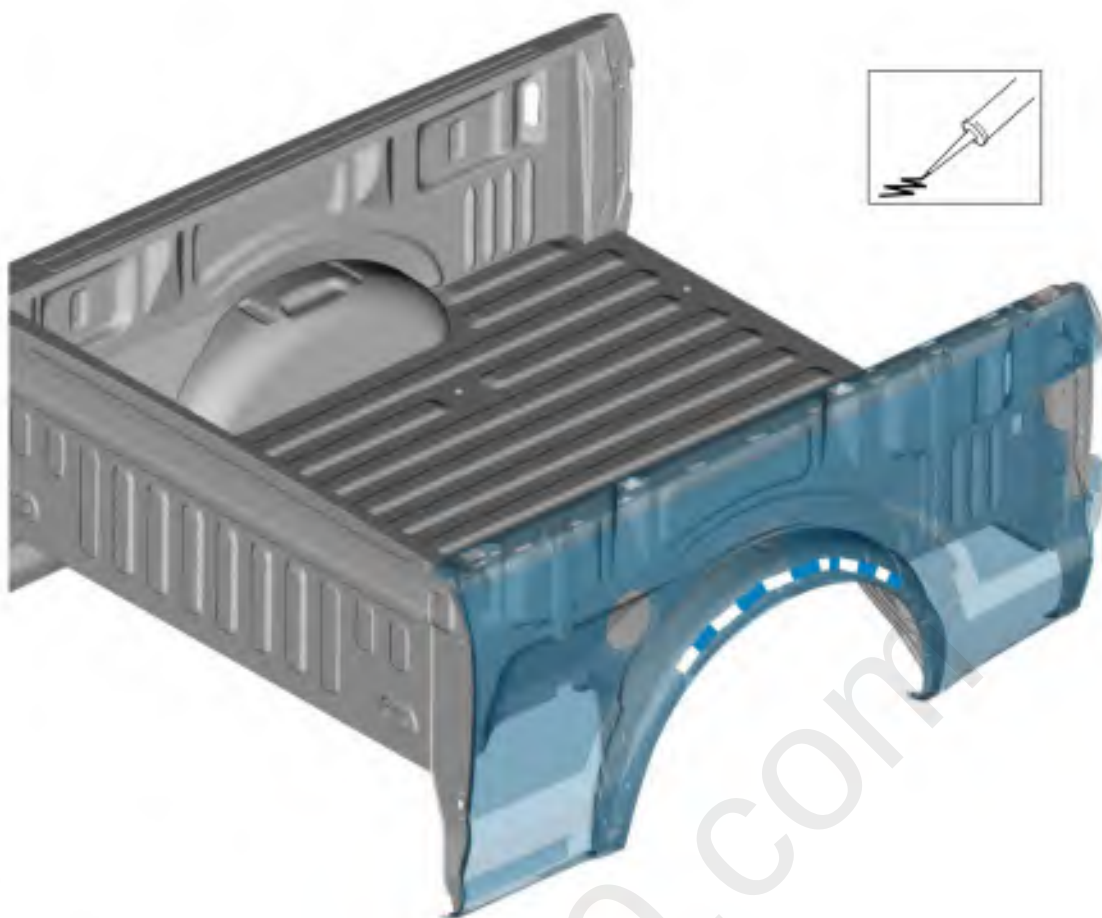
Metal finish as necessary using typical techniques and materials.

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

All vehicles

35. Apply NVH foam in locations noted during removal.

Material: Flexible Foam Repair / 3M™ 08463, LORD Fusor® 121



E204585

36. Install the screw
Torque: 177 lb.in (20 Nm)





37. Seam Sealing: All seams must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M™ 08308, LORD Fusor® 805DTM
38. Refinish the entire repair using a Ford approved paint system and typical refinishing techniques.
39. Install the pickup bed.
Refer to: [Pickup Bed](#) (501-04 Pickup Bed and Platform Body, Removal and Installation).
40. LH side only:
Install the fuel fill door and fuel fill cup.
Refer to: [Fuel Filler Door Assembly](#) (501-03 Body Closures, Removal and Installation).
41. Install the tail lamp assembly.
Refer to: Rear Lamp Assembly (417-01 Exterior Lighting) .
42. **If Equipped:** Install the top rail cover, wheel house opening and lower side trim.
43. Install the tailgate.

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