

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

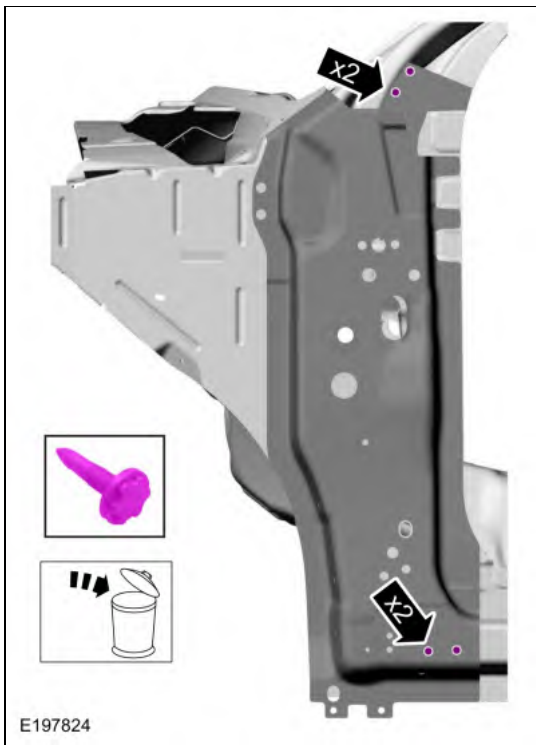
Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M [®] , 08115, LORD Fusor [®] 108B	-
Flexible Foam Repair 3M [®] , 08463, LORD Fusor [®] 121	-

Removal

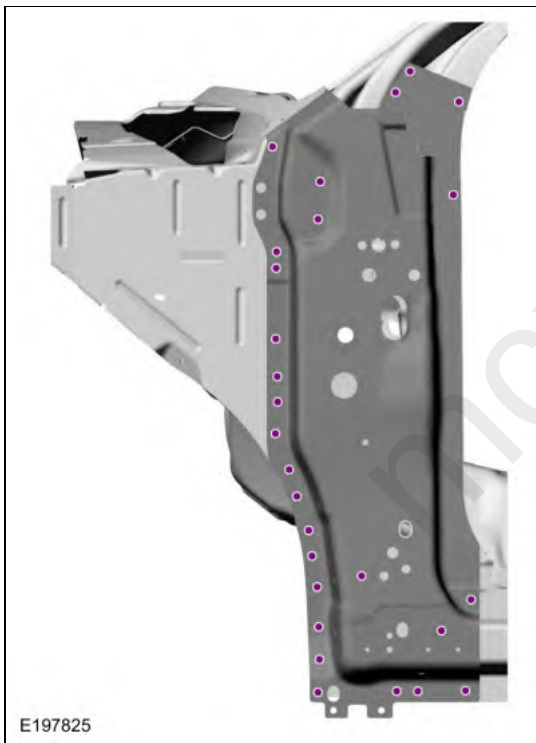
1. Depower the SRS.
Refer to: Supplemental Restraint System (SRS) Depowering (501-20B Supplemental Restraint System, General Procedures).
2. Make sure the vehicle is dimensionally correct.
Refer to: Body and Frame (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).
3. Remove A-pillar outer panel.
Refer to: A-Pillar Outer Panel (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
4. Remove the fender apron panel.
Refer to: Fender Apron Panel Reinforcement (501-27 Front End Sheet Metal Repairs, Removal and Installation).
5. Remove the reinforcement pad.



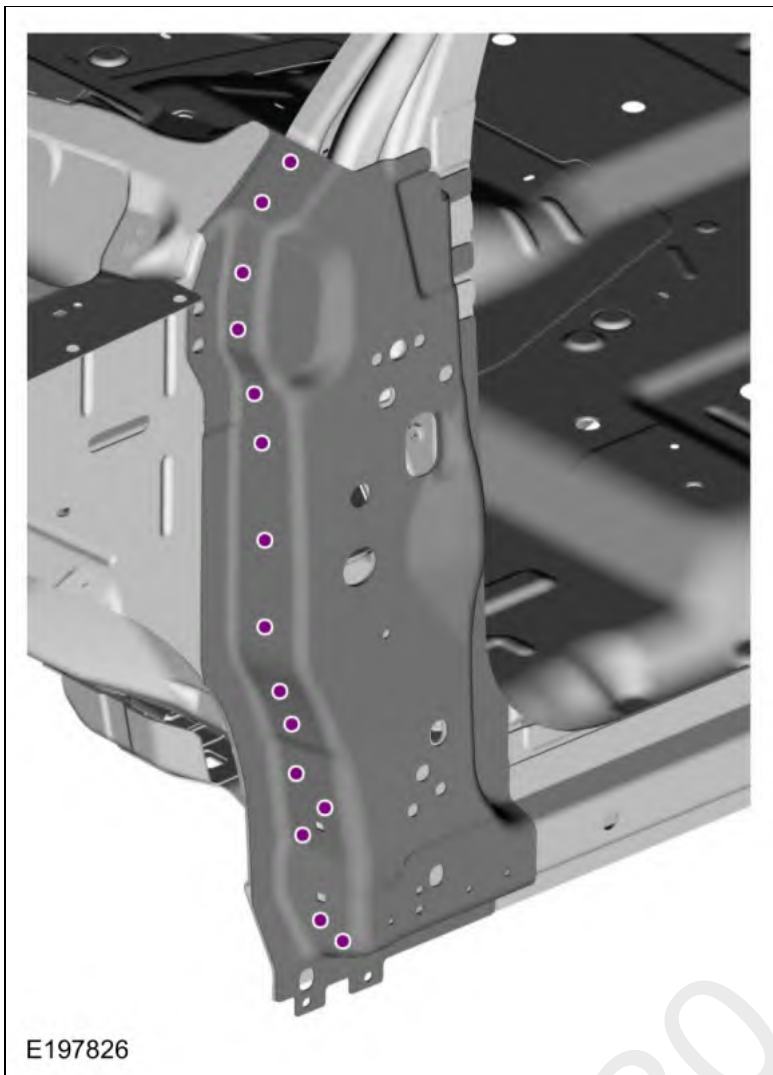
6. Remove and discard the FDS fasteners.
Use the General Equipment: Polydrive Bit Socket



7. 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



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

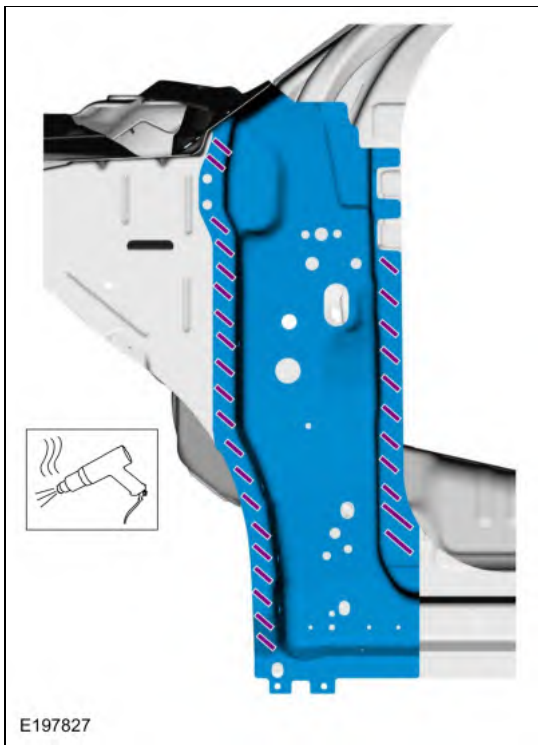


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9. **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated 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

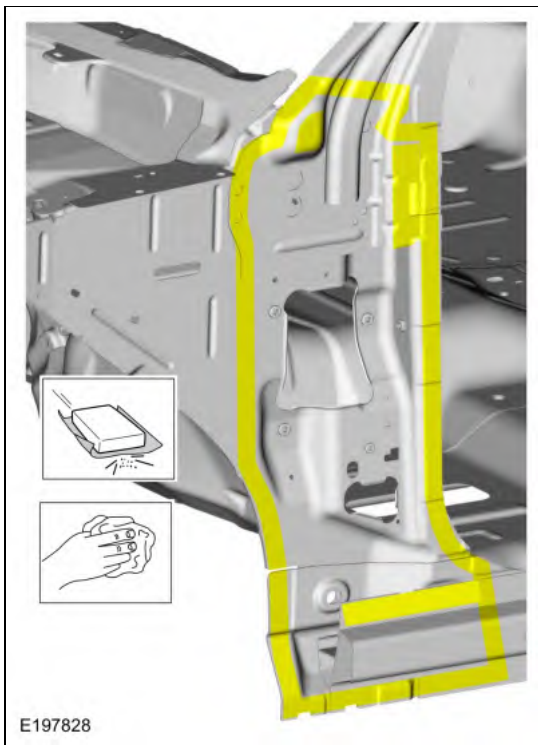


Installation

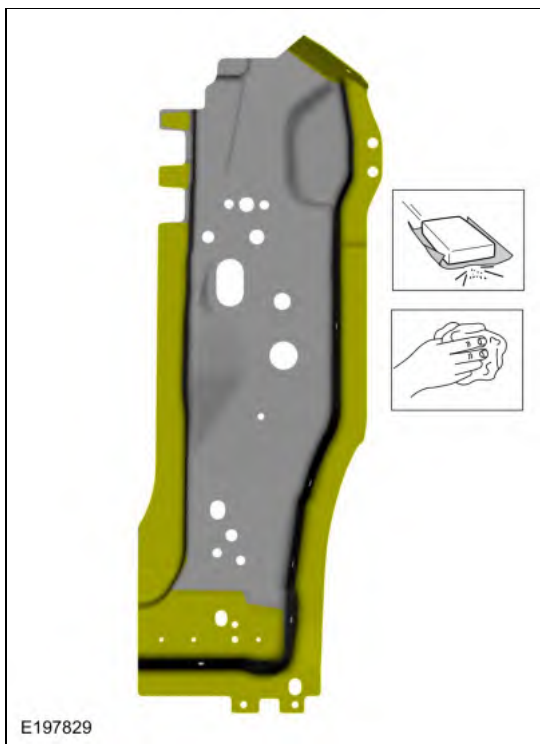
NOTE: Do not install SPR fasteners directly in old SPR fastener location. SPR fasteners must be installed adjacent to the original location matching original quantity..

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

1. 80-120 grit sand paper.
Sand to remove the old adhesive from the body side and clean.



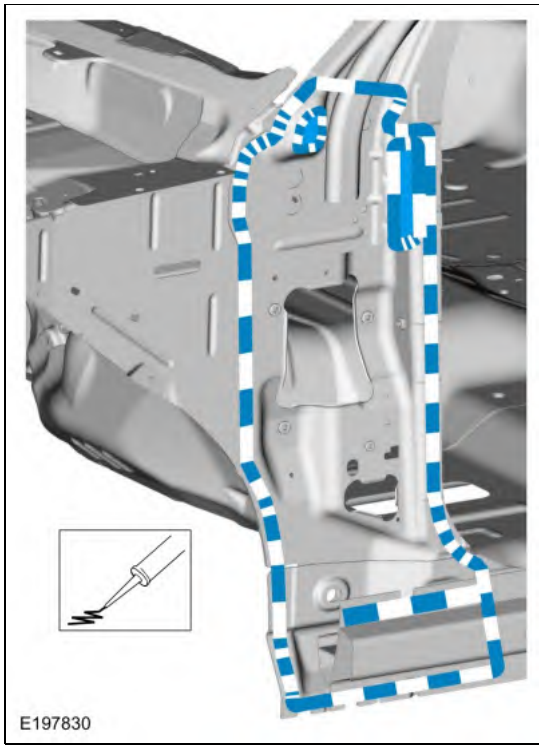
2. 80-120 grit sand paper.
Sand to remove the e-coat from the reinforcement and clean.



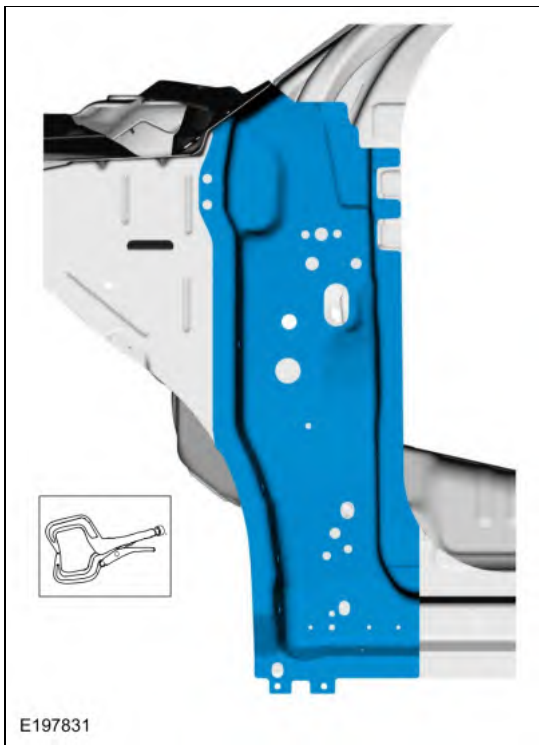
3. Apply adhesive and NVH foam in original locations.

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

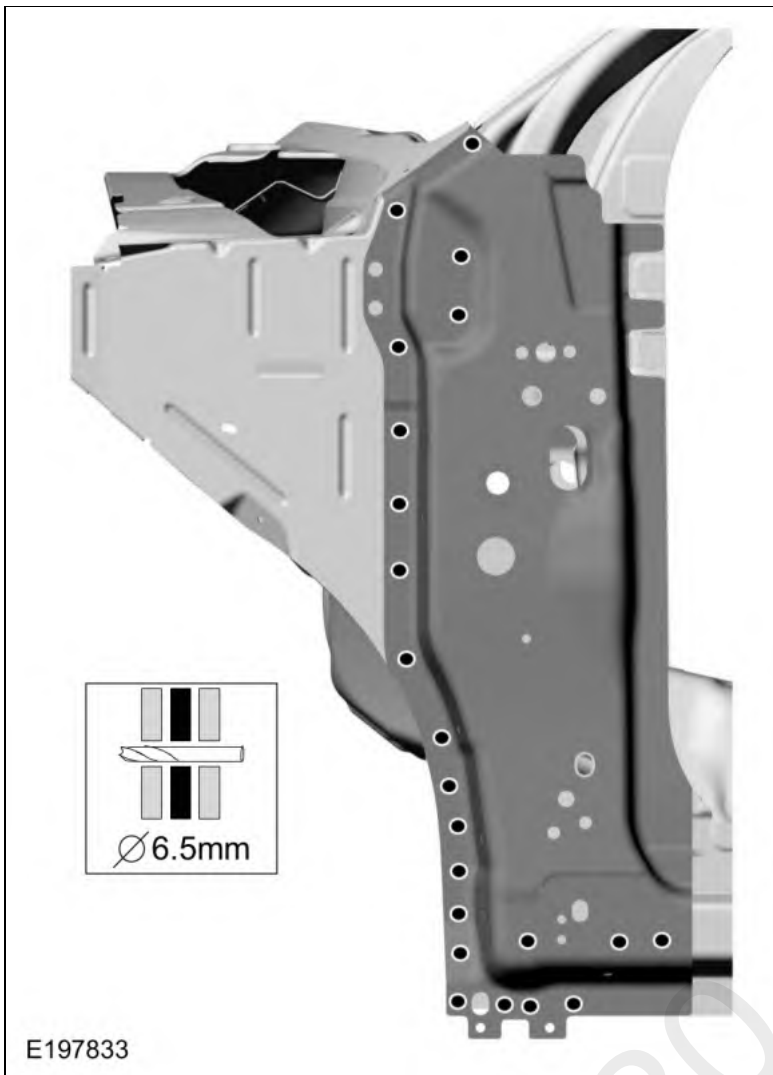
Material: Flexible Foam Repair / 3M[®], 08463, LORD Fusor[®] 121



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



5. Drill fastener holes.
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..

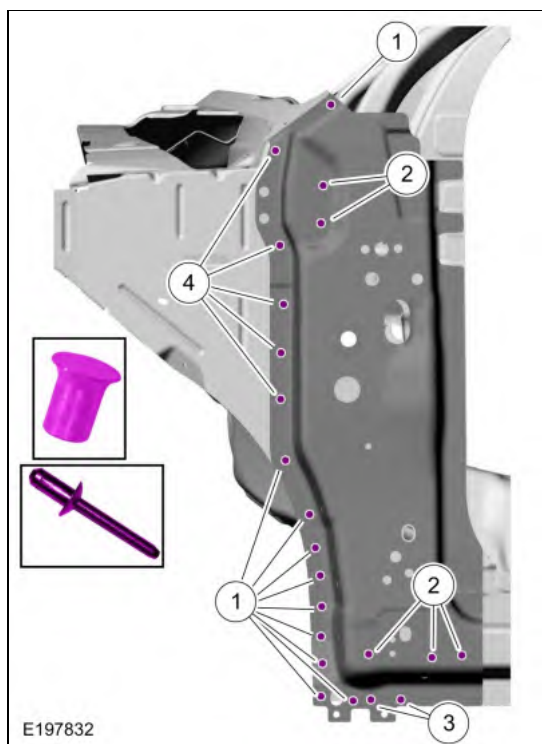
NOTE: Solid rivets or blind rivet fasteners may be used in place of SPR fasteners after enlarging existing holes to 6.5 mm.

Install fasteners.

Item	SPR Number	SPR Code	HenrobÂ® Mandrel	Pro-SpotÂ® Mandrel	Blind Rivet	Solid Rivet	RivnutÂ®
1	W717185-S900	QC	DP10-200/H	SA-0400/SA-0402	W708777-S900C	W790377-S900	-
2	-	-	-	-	W708777-S900C	-	-
3	W717185-S900	EL	DP11-200/H	SA-0400/SA-0402	W708777-S900C	W790377-S900	-
4	-	-	-	-	W702512-S900C	-	-

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

Use the General Equipment: Blind Rivet Gun



7. Install the reinforcement pad.



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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).
10. Repower the SRS.
Refer to: Supplemental Restraint System (SRS) Repowering (501-20B Supplemental Restraint System, General Procedures).

