

B-Pillar and Reinforcement - Crew Cab

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	-

Removal

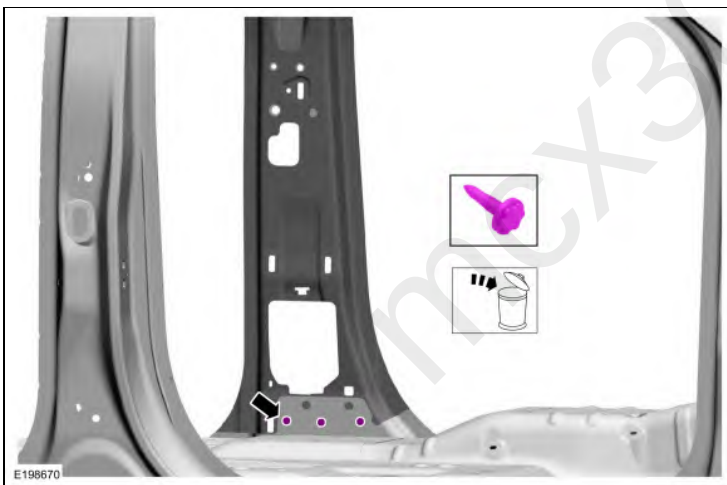
NOTICE: Body side sectioning is prohibited within 50 mm of door hinge, door striker and restraints anchoring points.

NOTE: LH side shown, RH side similar.

1. Remove the side curtain air bag.
Refer to: Side Curtain Airbag - Crew Cab (501-20B Supplemental Restraint System, Removal and Installation).
2. Remove the front safety belt and safety belt height adjuster.
Refer to: Front Seatbelt Retractor and Pretensioner - Crew Cab (501-20A Seatbelt Systems, Removal and Installation).
Refer to: Seatbelt Shoulder Height Adjuster - Crew Cab (501-20A Seatbelt Systems, Removal and Installation).
3. 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).
4. Remove the rocker panel reinforcement.
Refer to: Rocker Panel Inner Reinforcement - Crew Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
5. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



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



7. **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 B-pillar.
Use the General Equipment: Hot Air Gun



Installation

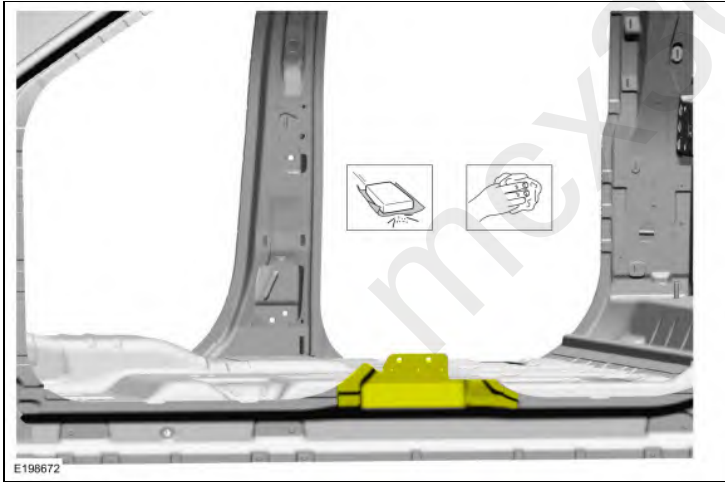
NOTICE: Body side sectioning is prohibited within 50 mm of door hinge, door striker and restraints anchoring points.

NOTE: 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.

NOTE: LH side shown, RH side similar.

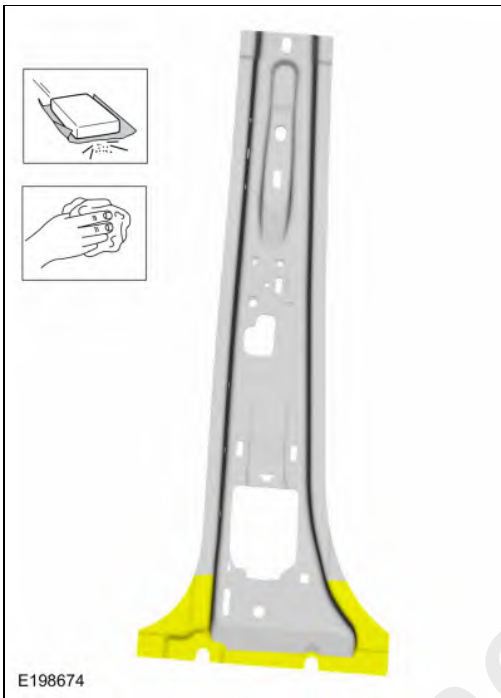
- 80-120 grit sand paper.
Sand to remove old adhesive and clean the B-pillar reinforcement lower mating surface.



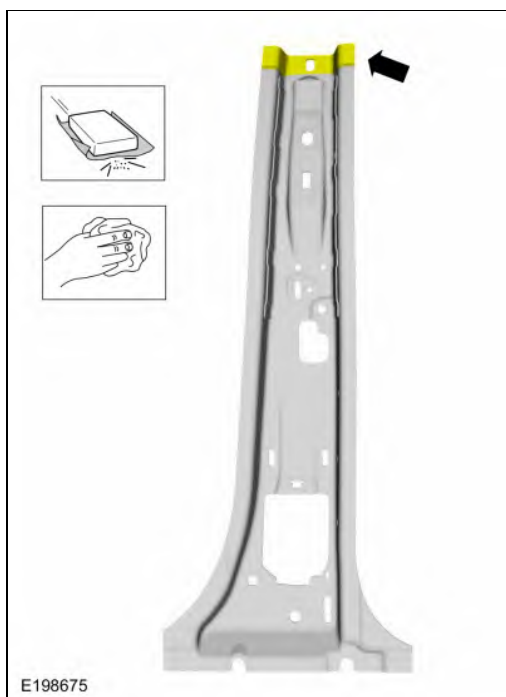
- 80-120 grit sand paper.
Sand to remove old adhesive and clean the B-pillar reinforcement upper mating surface.



3. 80-120 grit sand paper.
Sand to remove e-coat and clean the B-pillar service panel lower mating surface.



4. 80-120 grit sand paper.
Sand to remove e-coat and clean the B-pillar service panel upper mating surface.



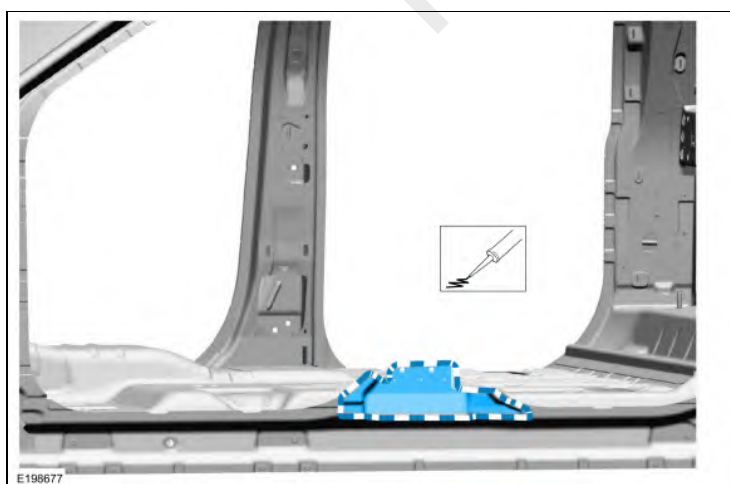
5. Apply adhesive.

Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3Mâ,ç 08115, LORD FusorÂ® 108B



6. Apply adhesive.

Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3Mâ,ç 08115, LORD FusorÂ® 108B



7. Install the B-pillar and clamp in position.

Use the General Equipment: Locking Pliers



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



9. **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..

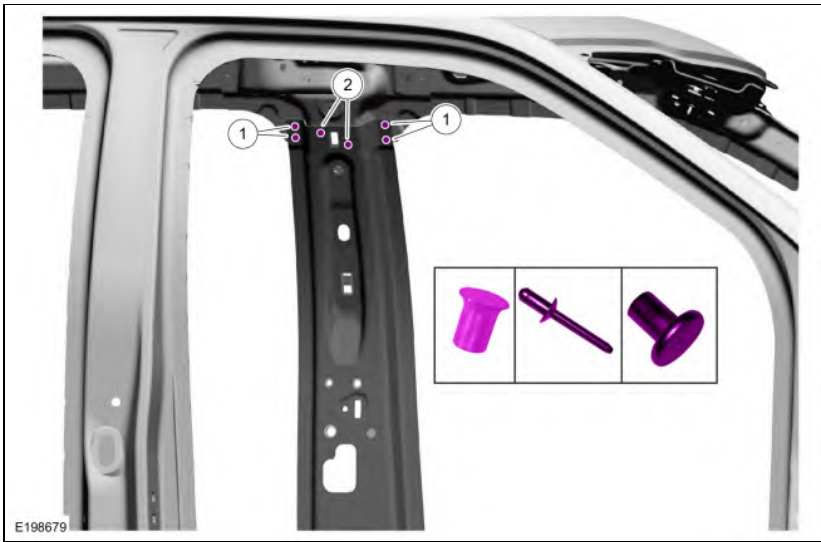
NOTE: Solid rivets or blind rivet fasteners may be used in place of SPR fasteners after enlarging existing holes to 6.5 mm.

Install fasteners.

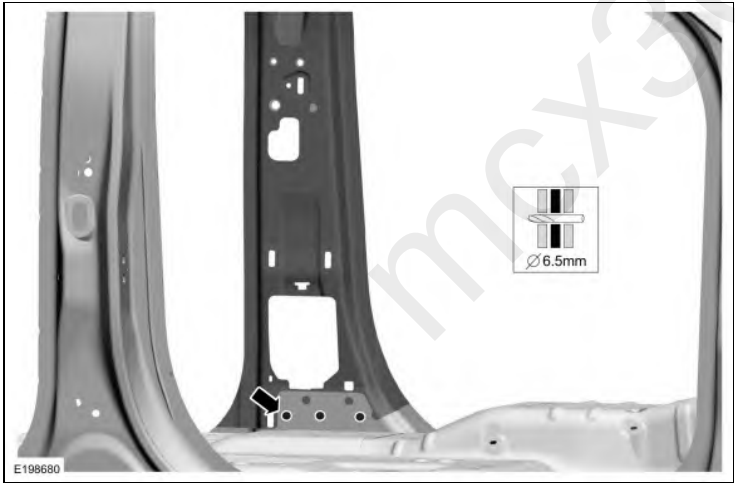
Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W717186-S900	EN	DG11-200/H	SA-0400/SA-0401	-	W790376-S900	-
2	-	-	-	-	W708777-S900C	-	--

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

Use the General Equipment: Blind Rivet Gun



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



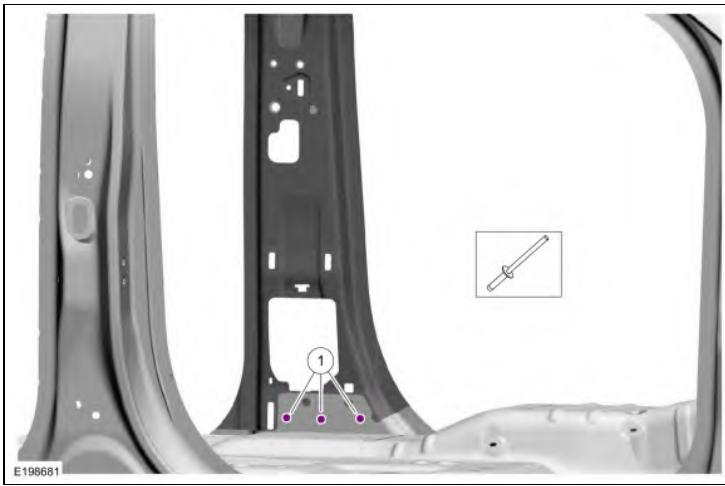
11. **NOTE:** Do not install SPR fasteners directly in old SPR fastener location. SPR fasteners must be installed adjacent to the original location matching original quantity..

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	-	-	-	-	W708777-S900C	-	-

Use the General Equipment: Blind Rivet Gun



12. Install the rocker panel reinforcement.
Refer to: Rocker Panel Inner Reinforcement - Crew Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
13. Refinish using a Ford approved paint system and typical refinishing techniques.
14. Install the side curtain air bag.
Refer to: Side Curtain Airbag - Crew Cab (501-20B Supplemental Restraint System, Removal and Installation).
15. Install the front safety belt and safety belt height adjuster.
Refer to: Front Seatbelt Retractor and Pretensioner - Crew Cab (501-20A Seatbelt Systems, Removal and Installation).
Refer to: Seatbelt Shoulder Height Adjuster - Crew Cab (501-20A Seatbelt Systems, Removal and Installation).