

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	-

Removal

NOTICE: Body side sectioning is prohibited within 50 mm 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 - Super Cab (501-20B Supplemental Restraint System, Removal and Installation).
Refer to: Side Curtain Airbag - Crew Cab (501-20B Supplemental Restraint System, Removal and Installation).

Regular Cab and Crew Cab

3. Front door on regular cab, rear door on Crew Cab.
Remove the door striker.



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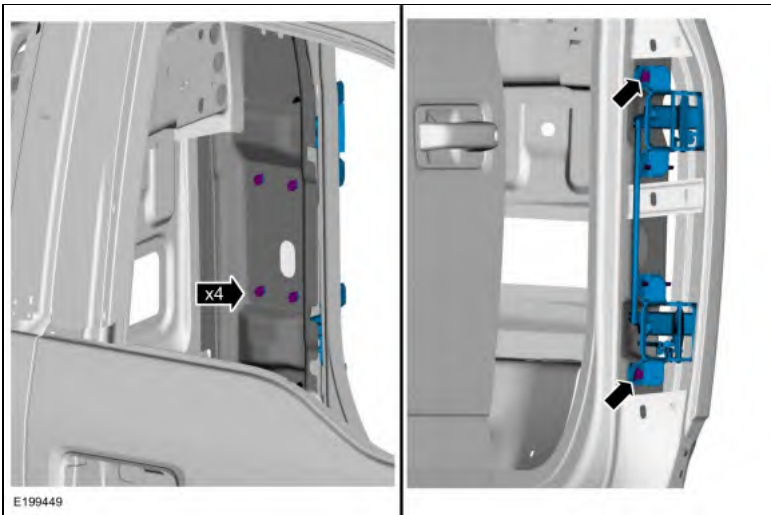


Regular Cab

4. Remove the front seat.
Refer to: Front Seat (501-10A Front Seats, Removal and Installation).

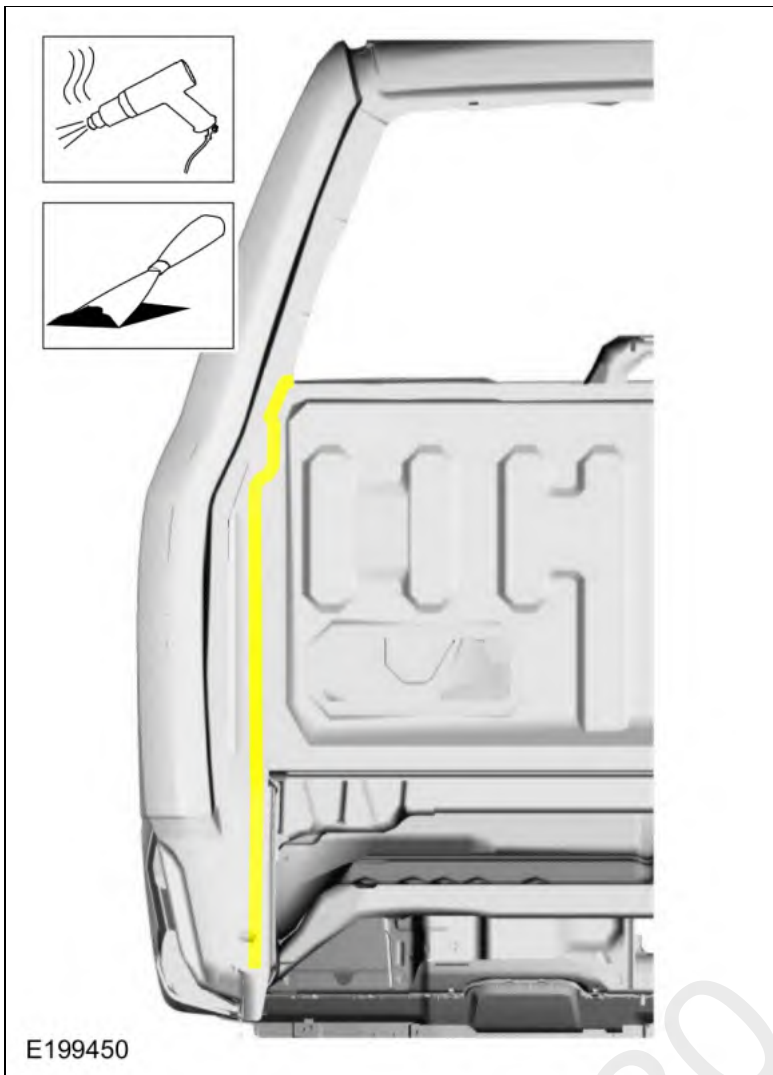
SuperCab

5. Remove the rear door.
Refer to: Rear Door - SuperCab (501-03 Body Closures, Removal and Installation).
6. Remove the rear door hinge.

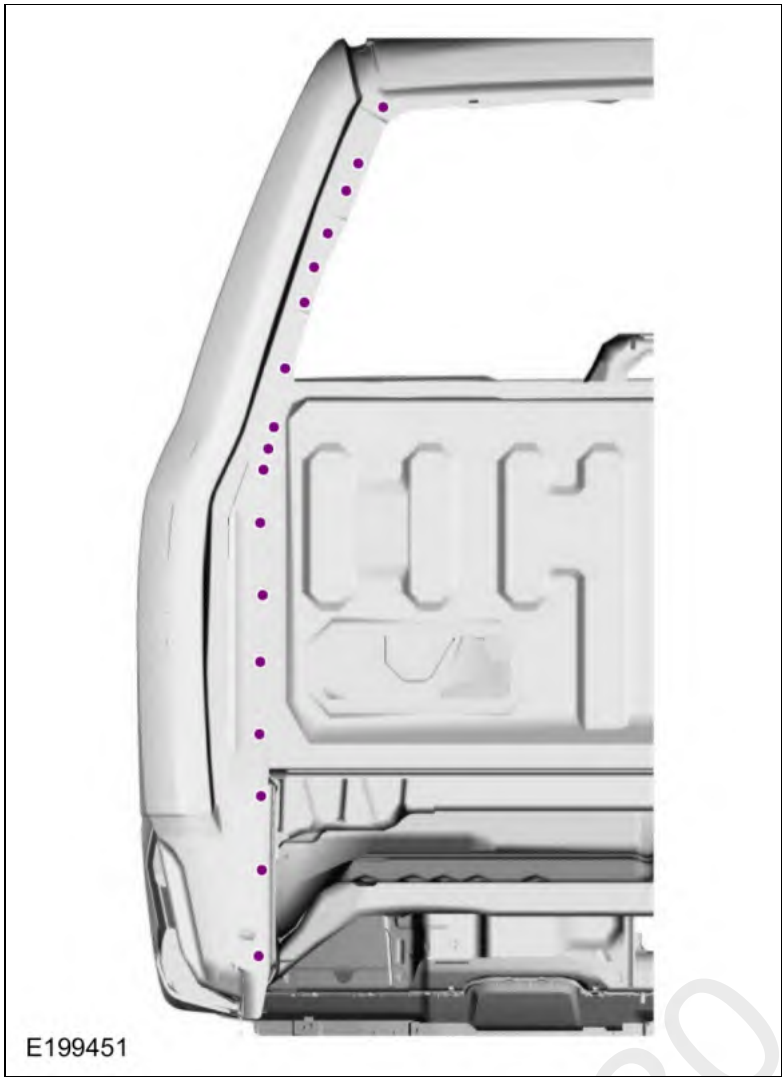


All vehicles

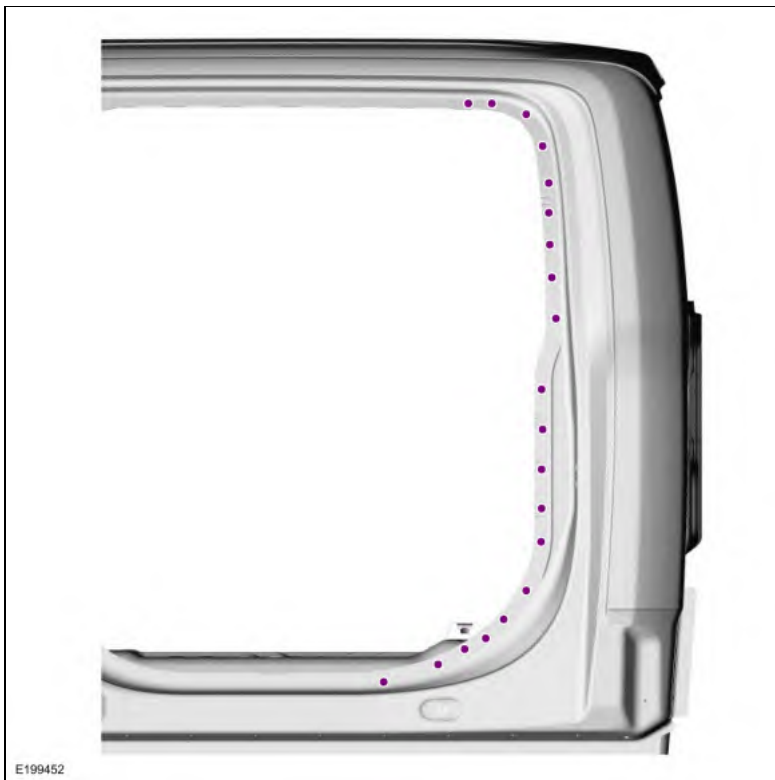
7. If equipped.
Remove the pickup bed.
Refer to: Pickup Bed (501-04 Pickup Bed and Platform Body, Removal and Installation).
8. Remove the exterior trim.
Refer to: Roof Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).
Refer to: Bodyside Moulding (501-08 Exterior Trim and Ornamentation, 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).
10. Remove the door opening scuff plate and position the carpeting and wire 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 - Crew Cab/Super Cab (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



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



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



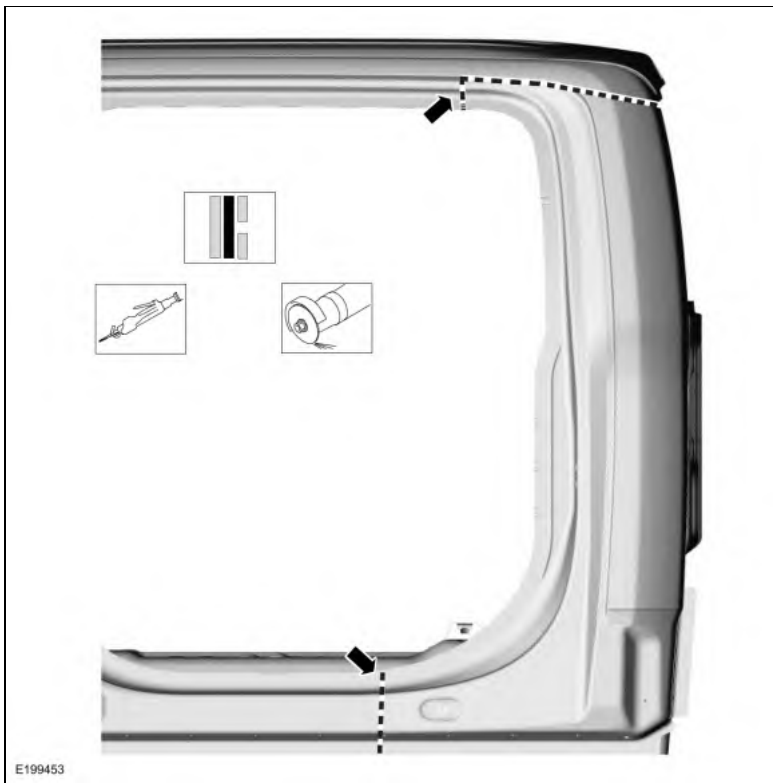
17. **NOTICE:** Body side sectioning is prohibited within 50 mm of door hinge, door striker and restraints anchoring points.

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

Carefully cut the **outer panel only**.

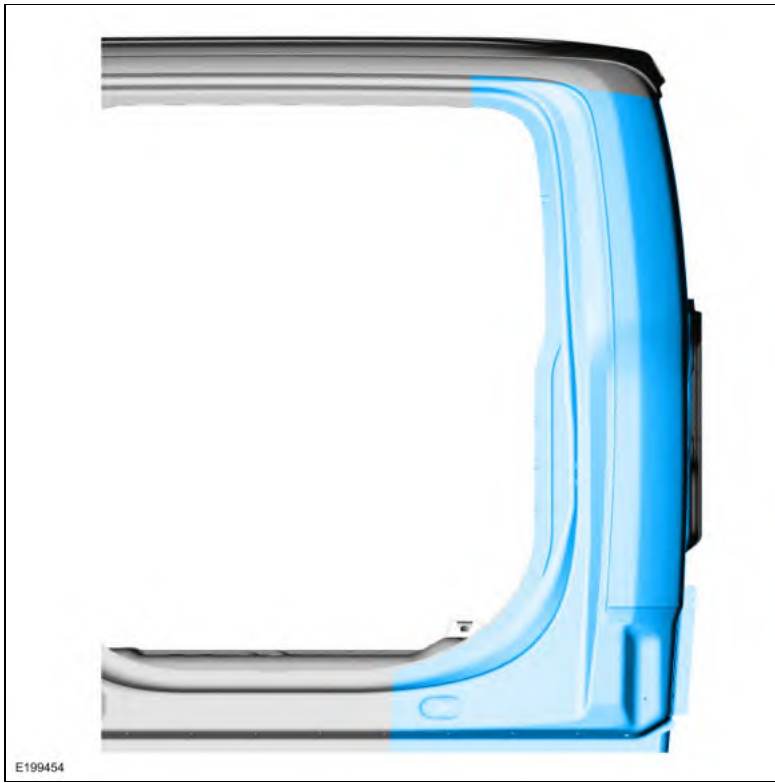
Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter



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 repair areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceed 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.



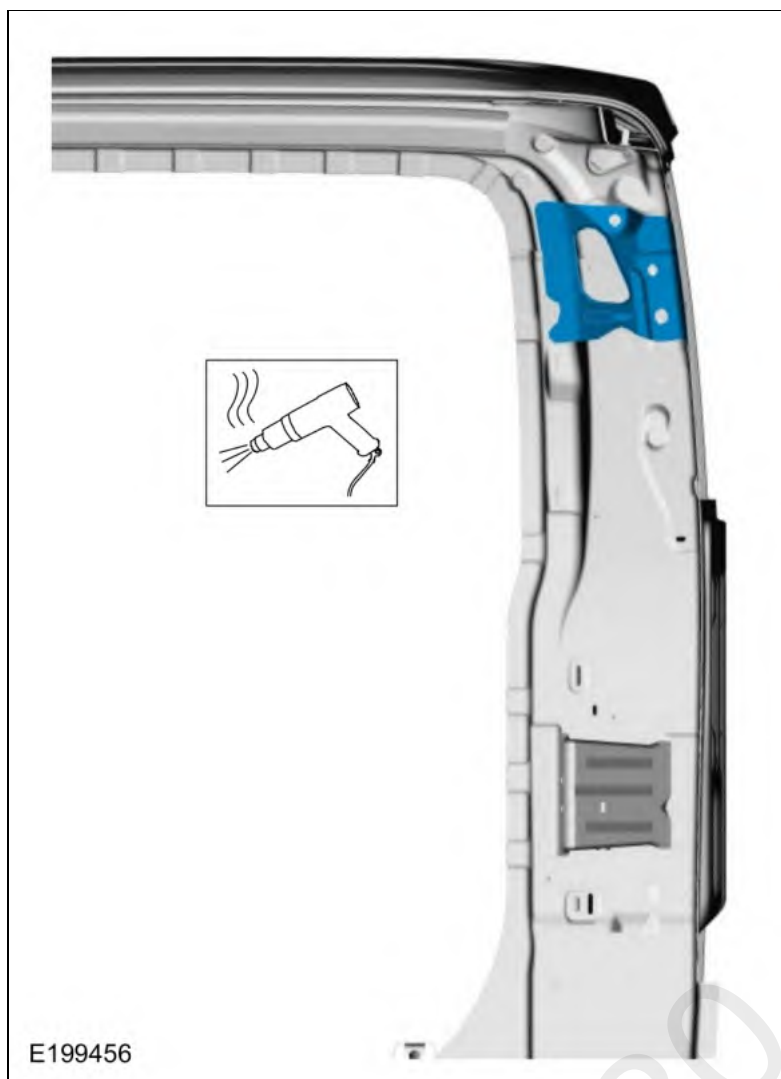
Crew Cab

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



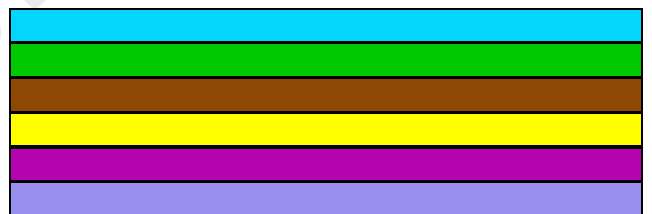
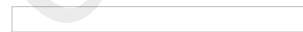
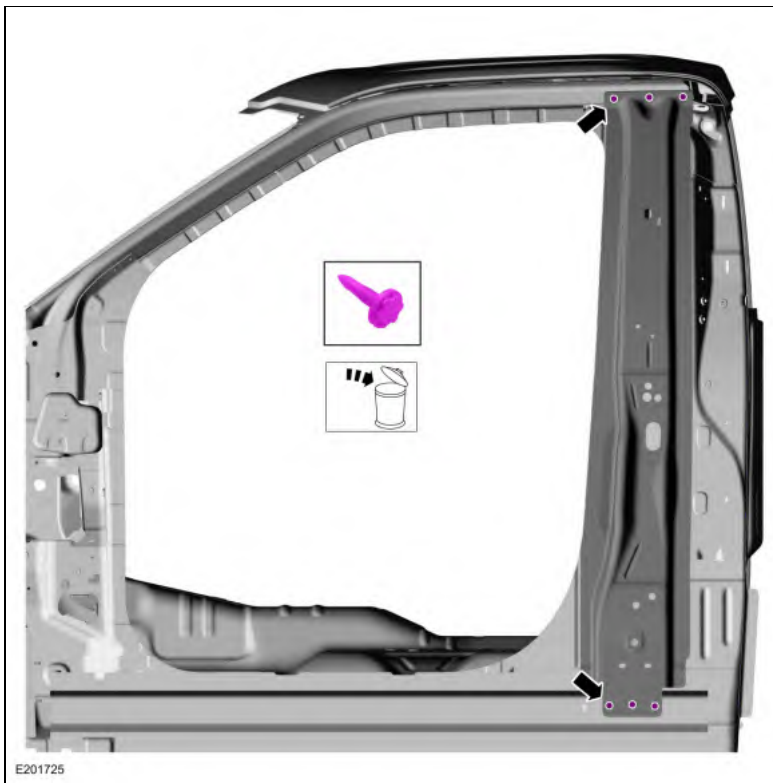
20. **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repair areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceed 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

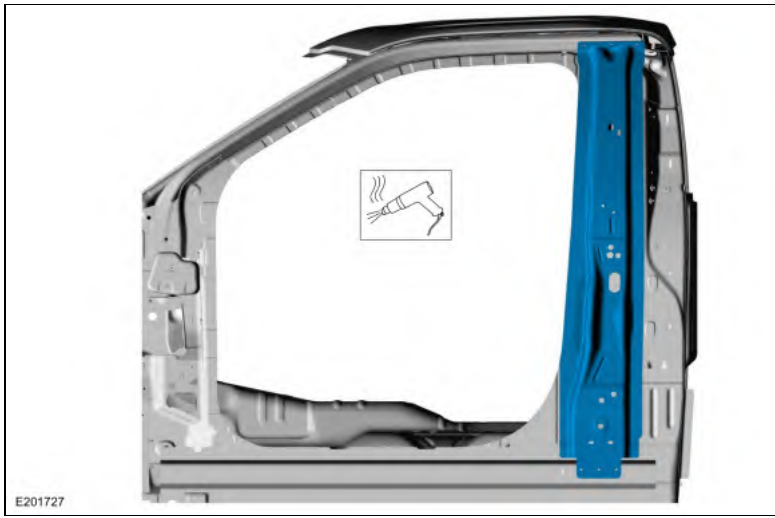


22. Remove the SPR fasteners.
 Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Belt Sander

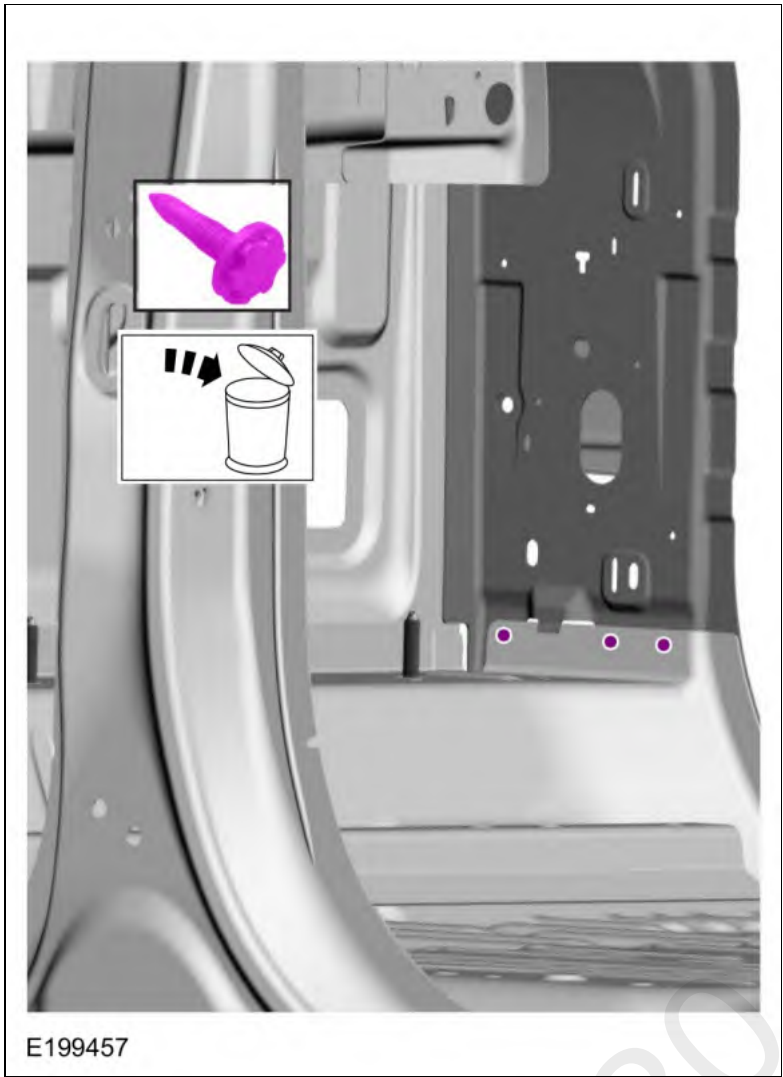


23. **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repair areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceed 425°F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

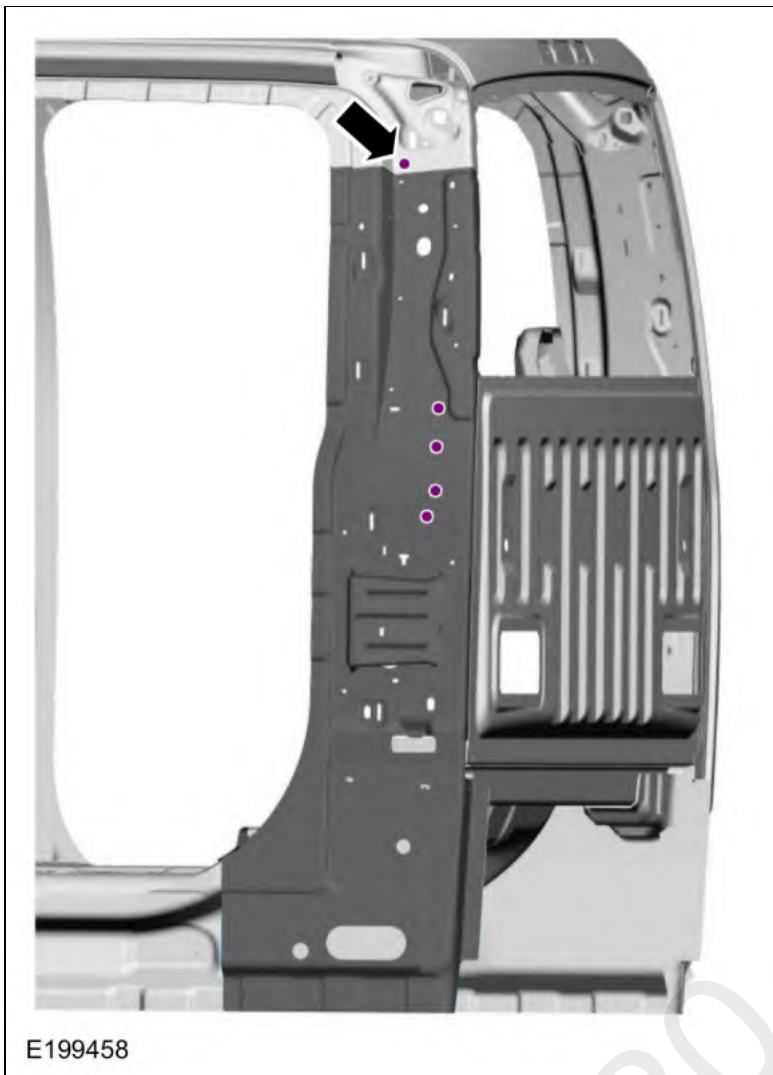
Break the adhesive bond and remove the inner reinforcement.
Use the General Equipment: Hot Air Gun



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



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

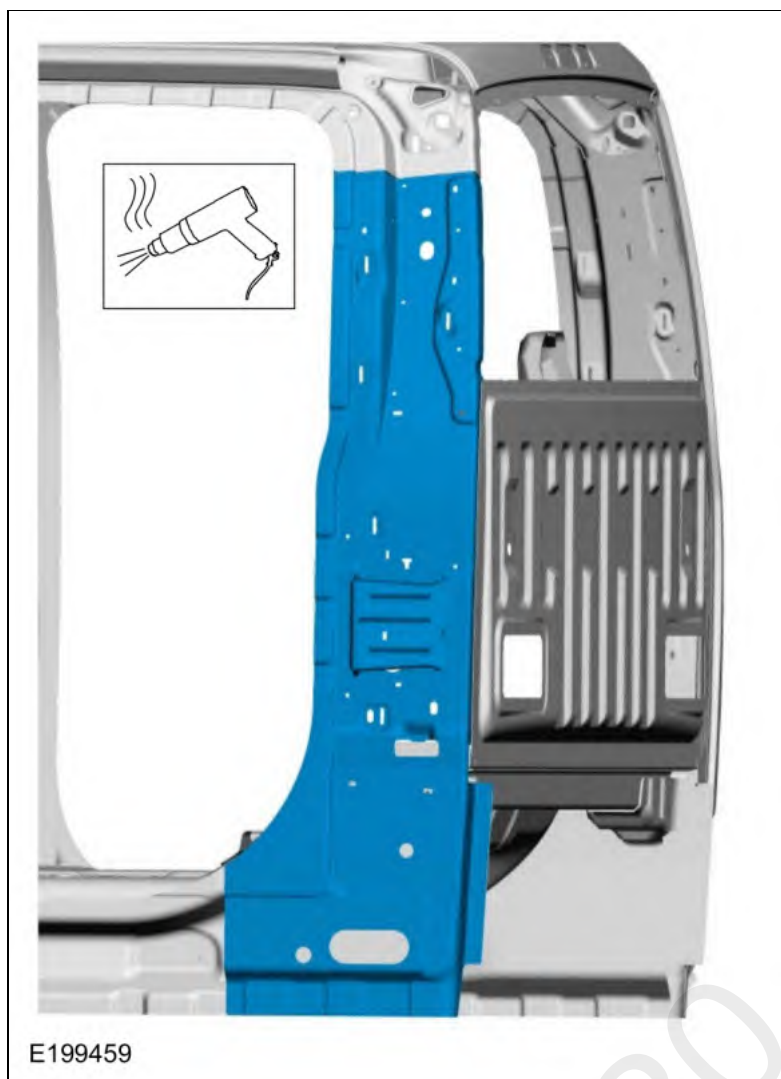


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26. **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repair areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceed 425Å° 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 inner.



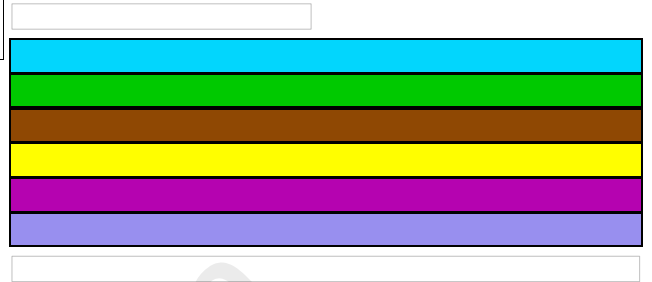
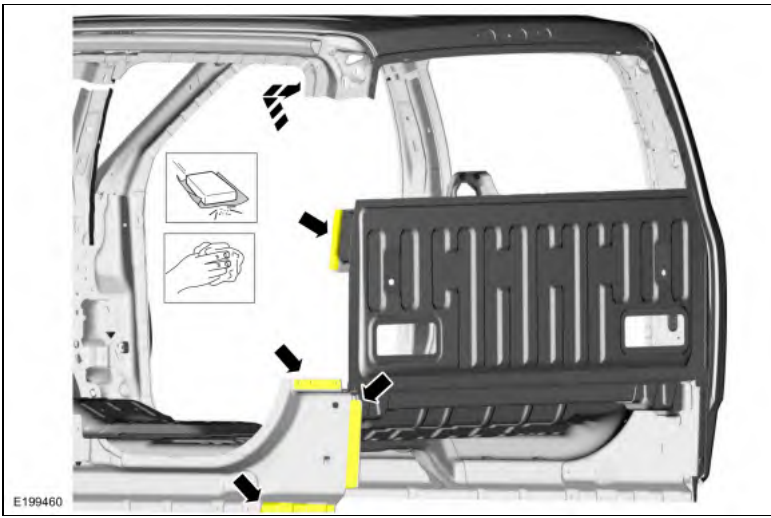
Installation

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

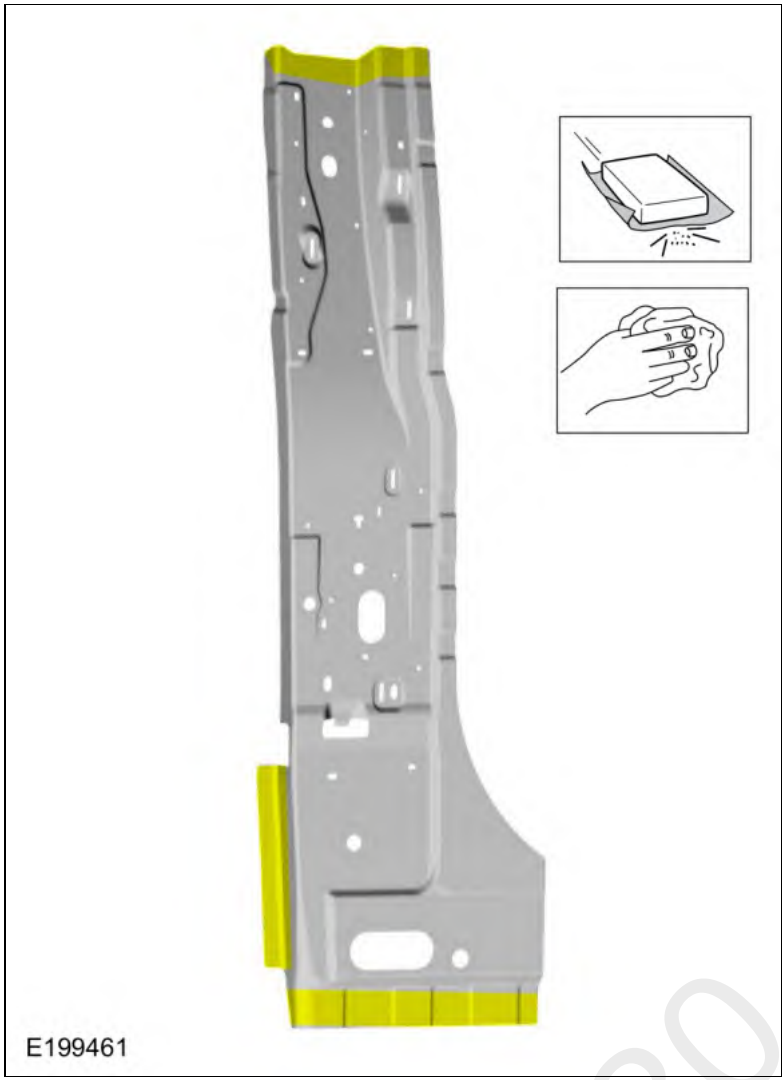
NOTE: SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

All vehicles

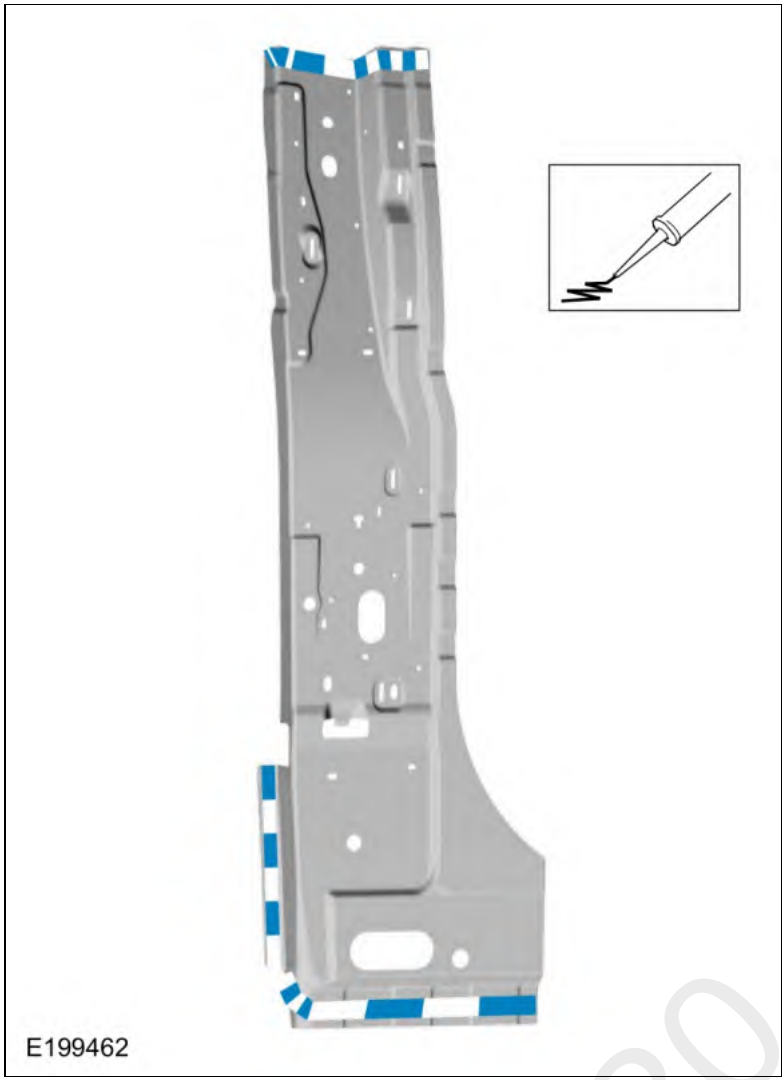
1. 80-12 grit sand paper.
Sand to remove old adhesive and e-coat and clean.



2. 80-12 grit sand paper.
Sand to remove old adhesive and e-coat and clean.



3. Apply adhesive to the service panel mating surface.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M[®], 08115, LORD Fusor[®] 108B



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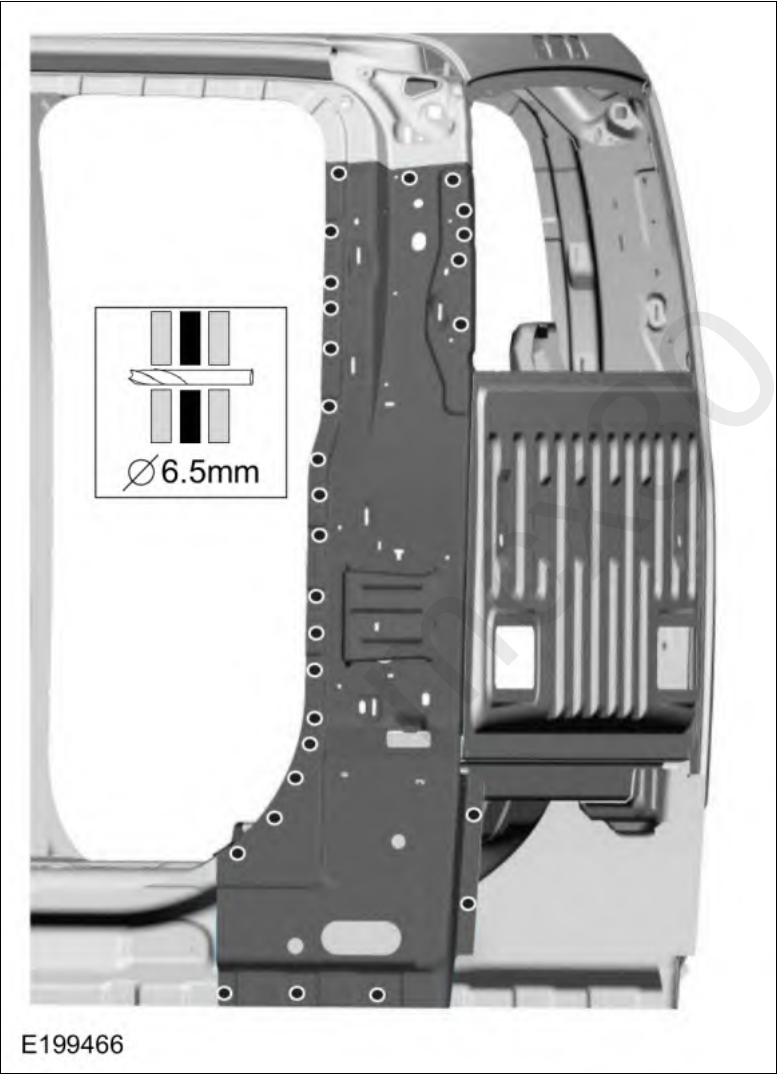


4. Install the C-pillar inner and clamp in position.
Use the General Equipment: Belt Sander



Regular Cab and Crew Cab

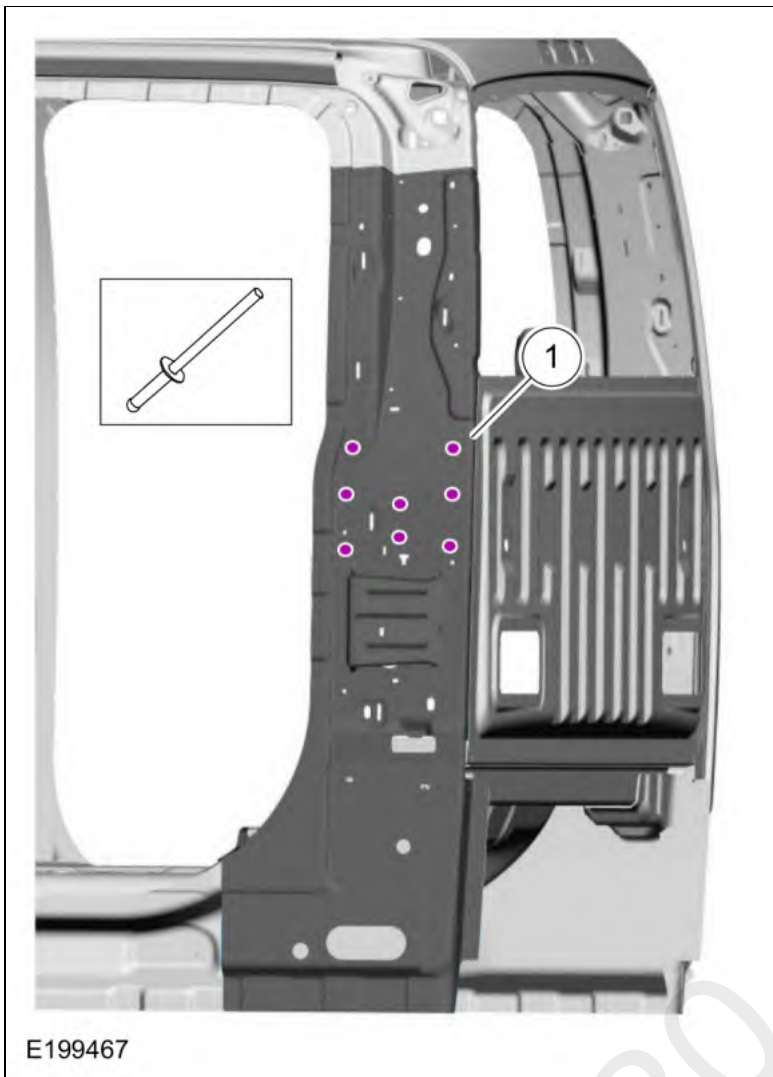
- 5. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



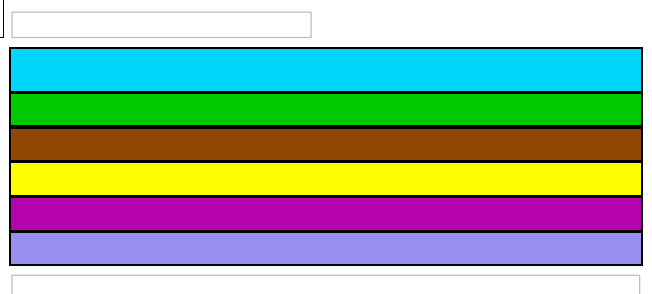
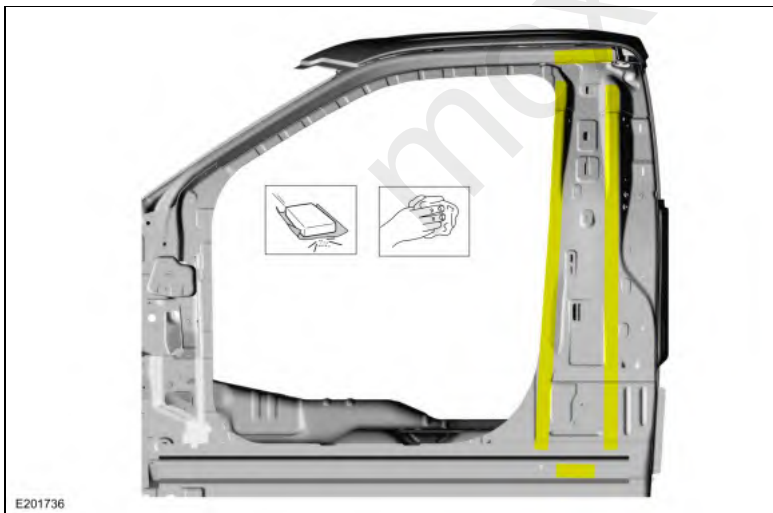
- 6. Install fasteners.

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

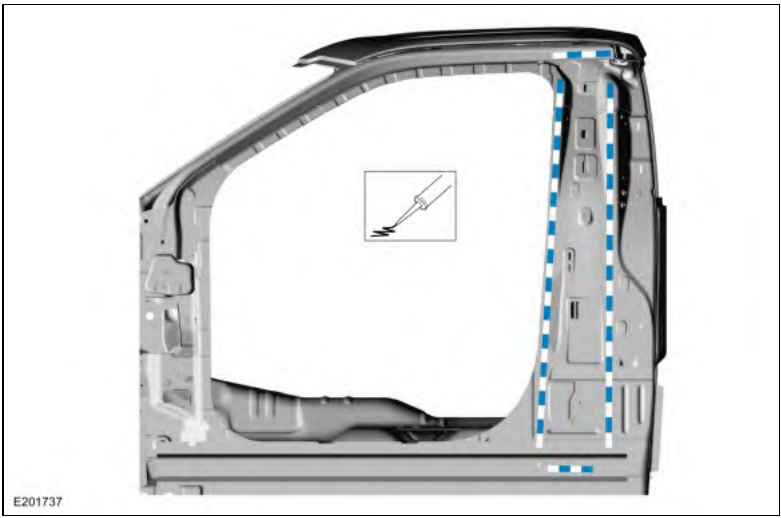
Use the General Equipment: Blind Rivet Gun



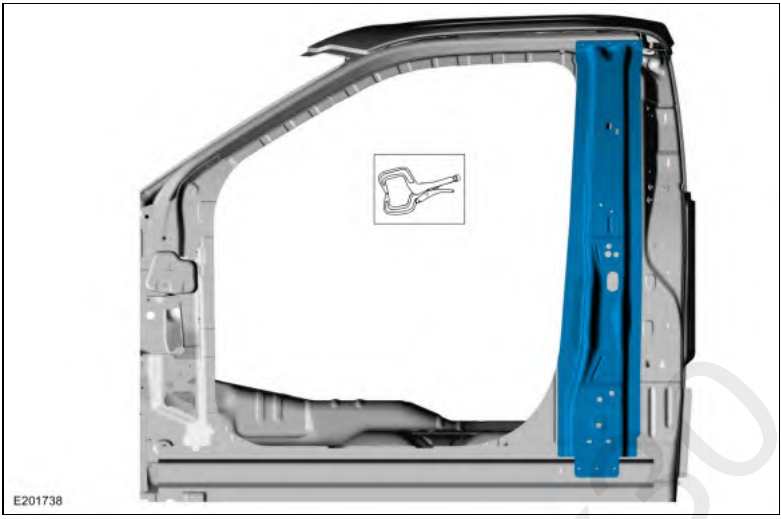
7. 80-120 grit sand paper.
Sand to remove E-coat and clean.



8. Apply adhesive.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3Mâ„¢ 08115, LORD FusorÂ® 108B



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



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



11. 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



SuperCab

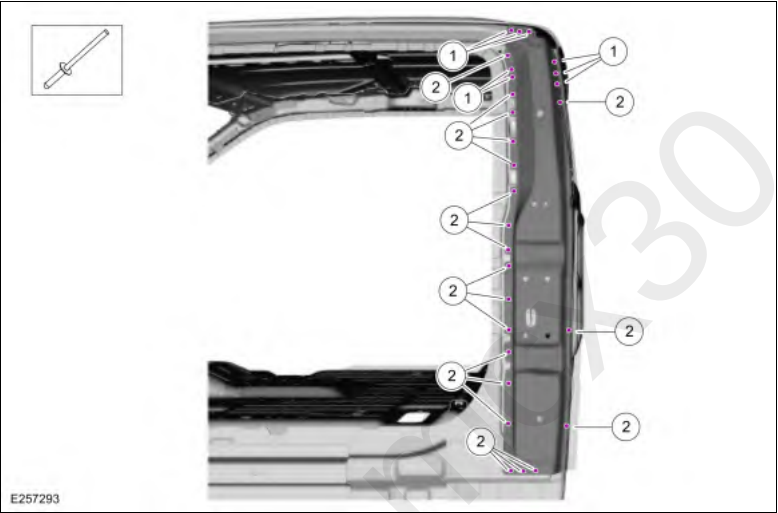
12. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



13. Install fasteners.

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

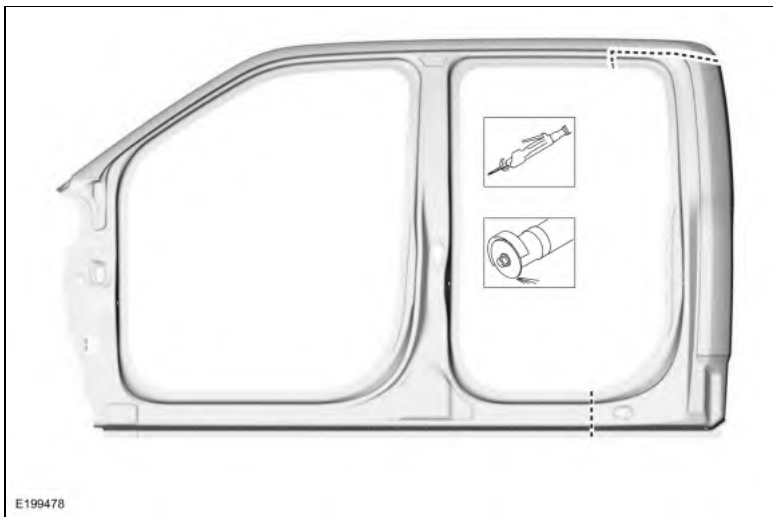
Use the General Equipment: Blind Rivet Gun



All vehicles

14. **NOTE:** Crew Cab shown, regular and SuperCab similar.

- Cut the service panel to fit repair are.
- Use the General Equipment: Air Body Saw
- Use the General Equipment: Spherical Cutter



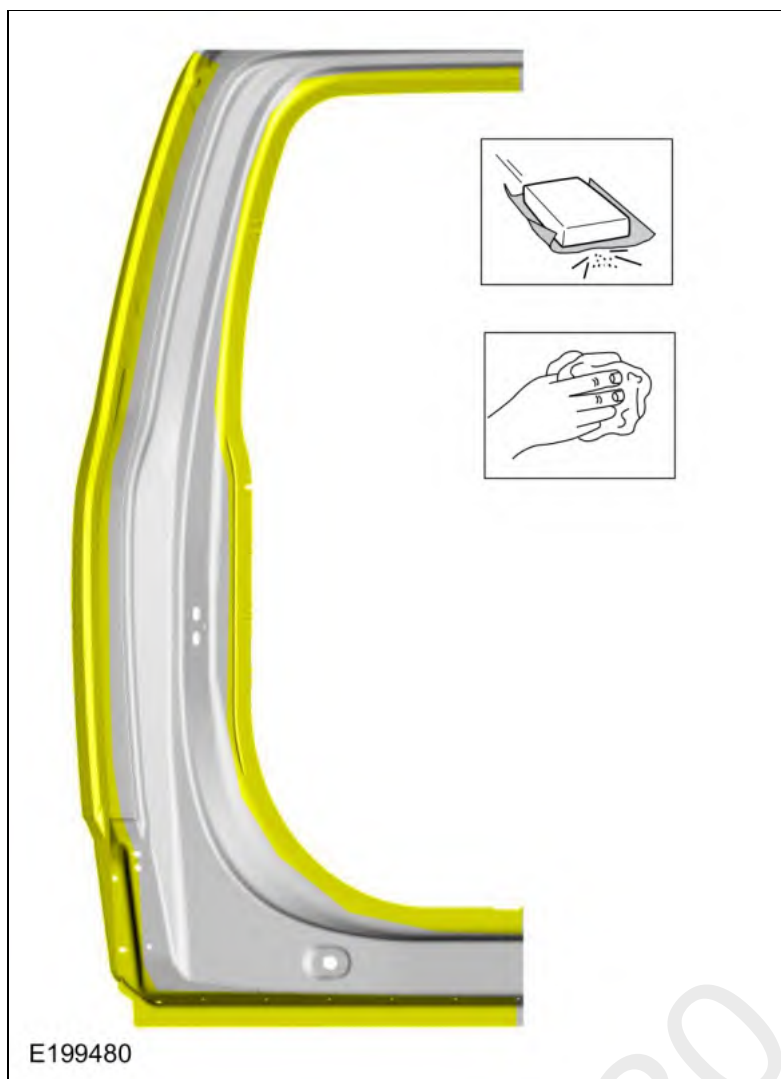
15. **NOTE:** The use of a backer plate when creating butt-weld joints will produce a stronger and more uniform repair.

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

16. 80-120 grit sand paper.
Sand to remove old adhesive and e-coat and clean.

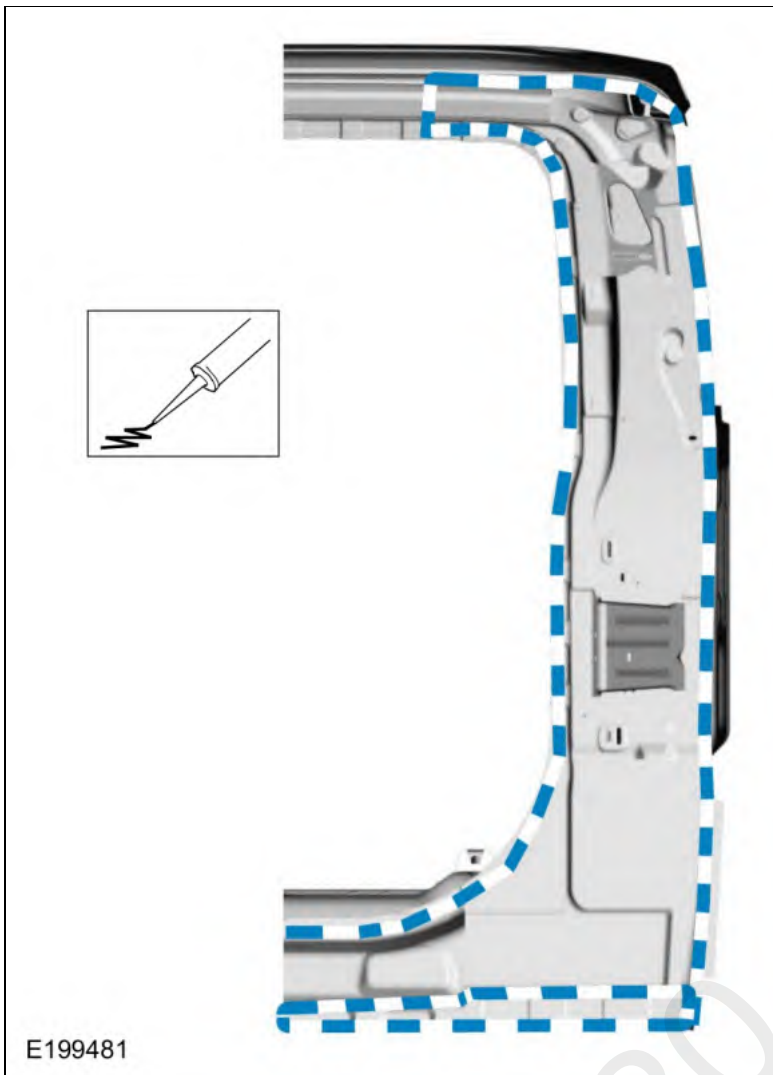


17. 80-120 grit sand paper.
Sand the service panel mating surfaces to remove e-coat and clean.

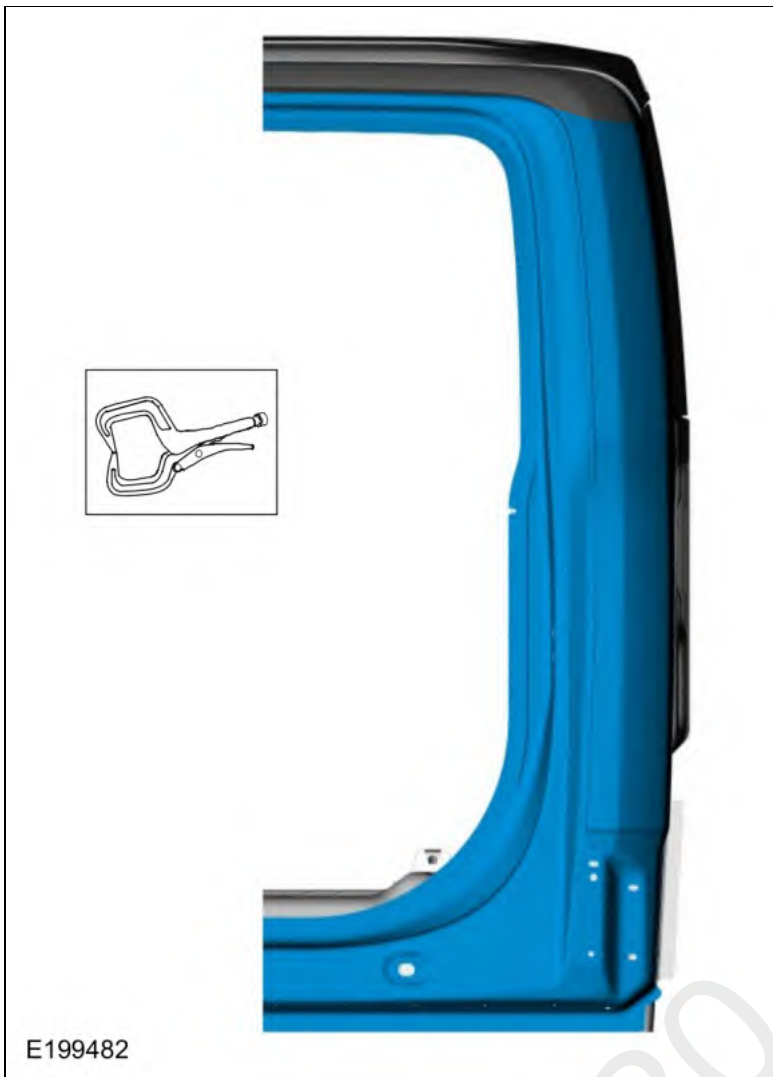


18. Apply adhesive.

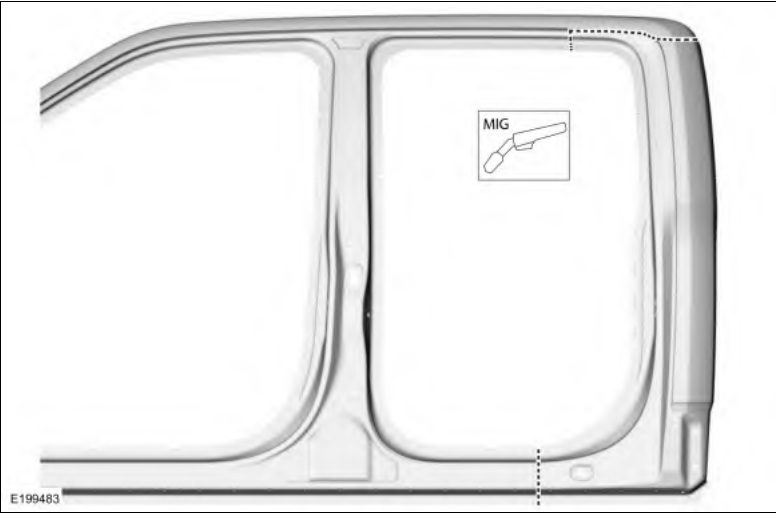
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M, 08115, LORD Fusor® 108B



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



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 welding.
Use the General Equipment: MIG/MAG Welding Equipment

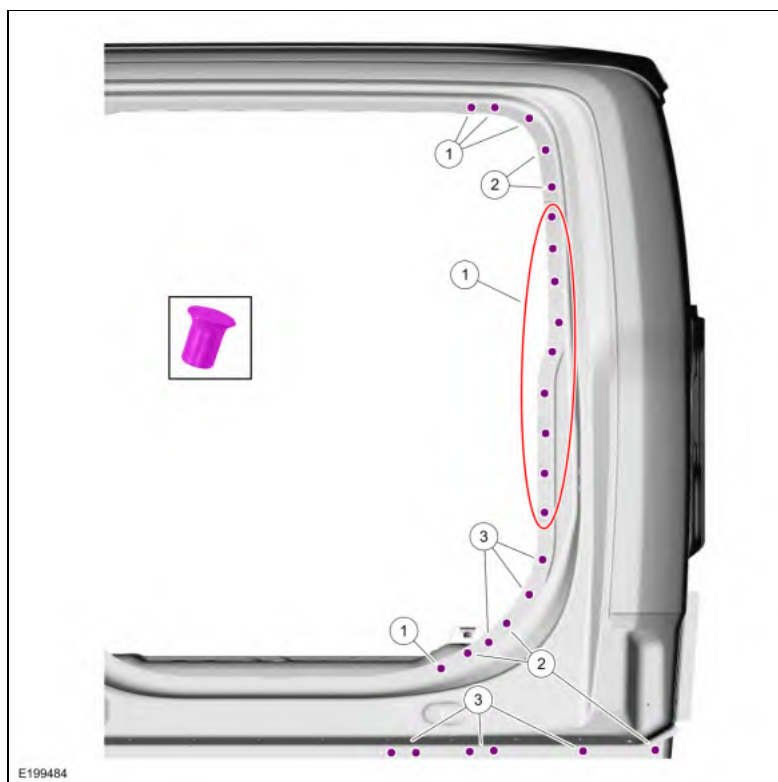


Crew Cab

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 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	-

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



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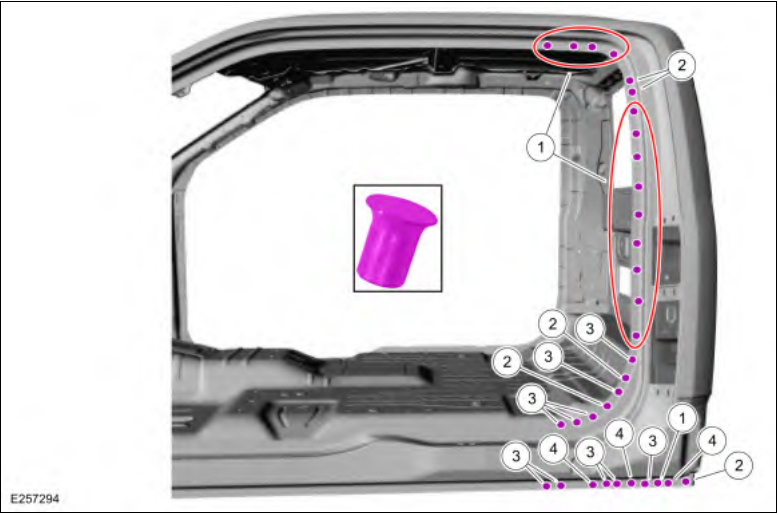
SuperCab

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	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
3	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
4	W717246-S900	BN	DP10-200/H	SA0400/SA-0402	-	W790377-S900	-

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



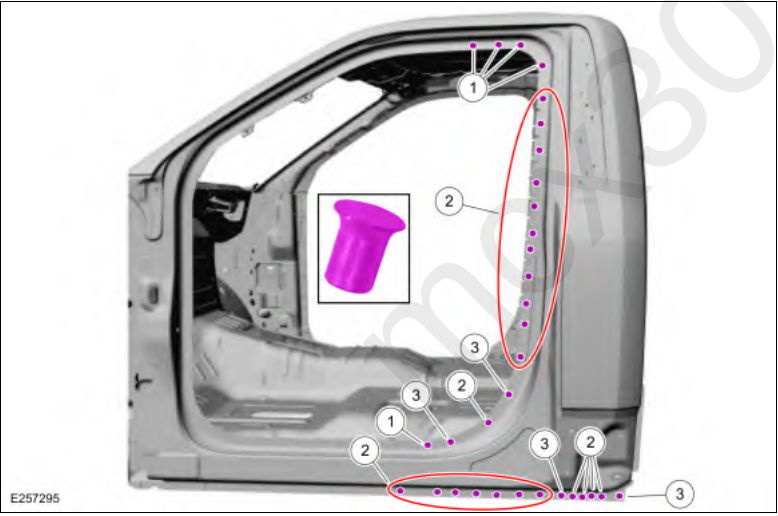
Regular Cab

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

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	W780717-S900	AW	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-

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



All vehicles

25. 80-120 grit sand paper.
Sand to remove e-coat and clean.



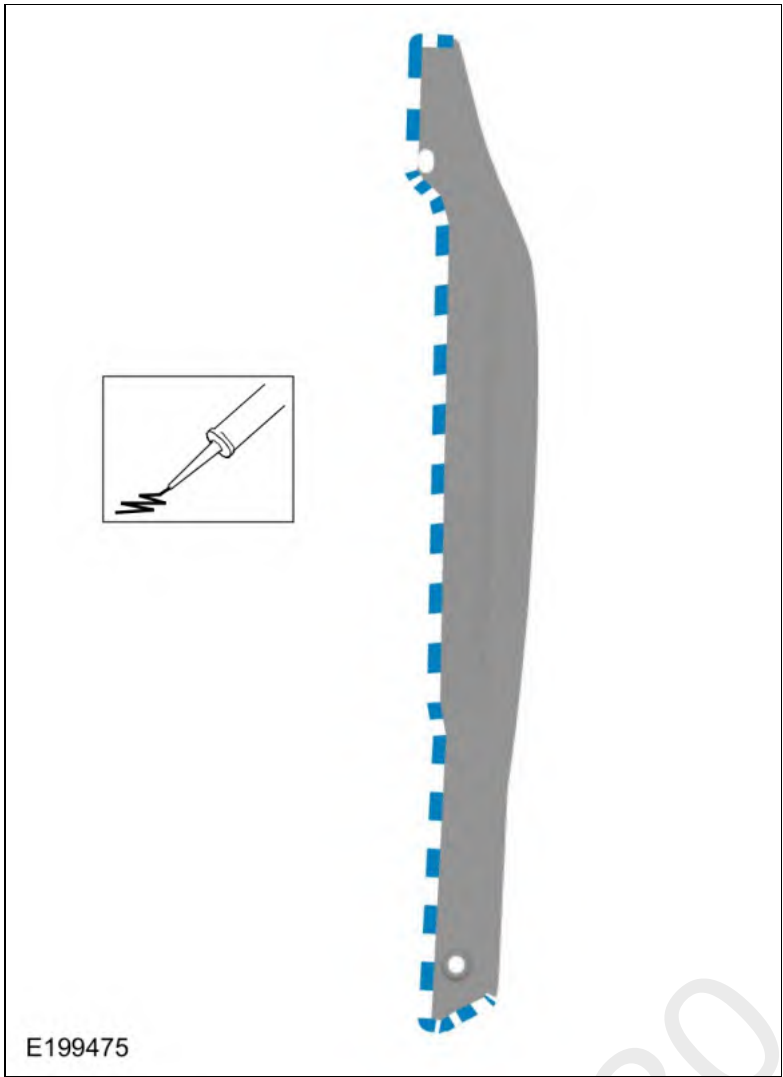
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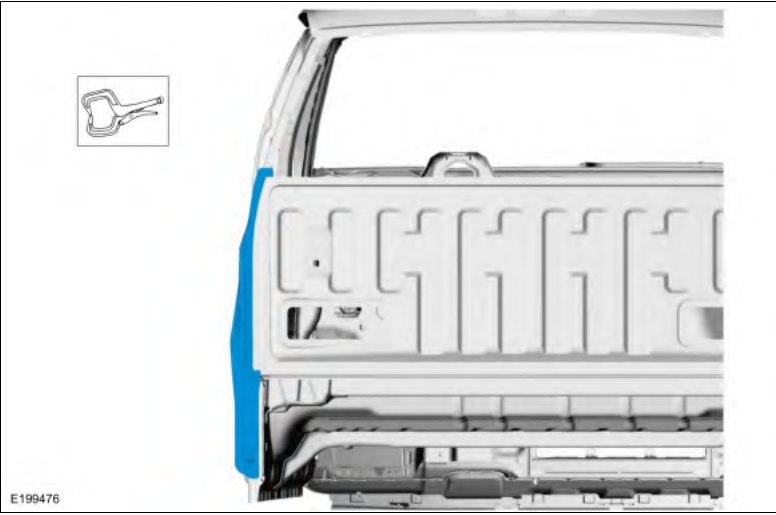


26. Apply adhesive.

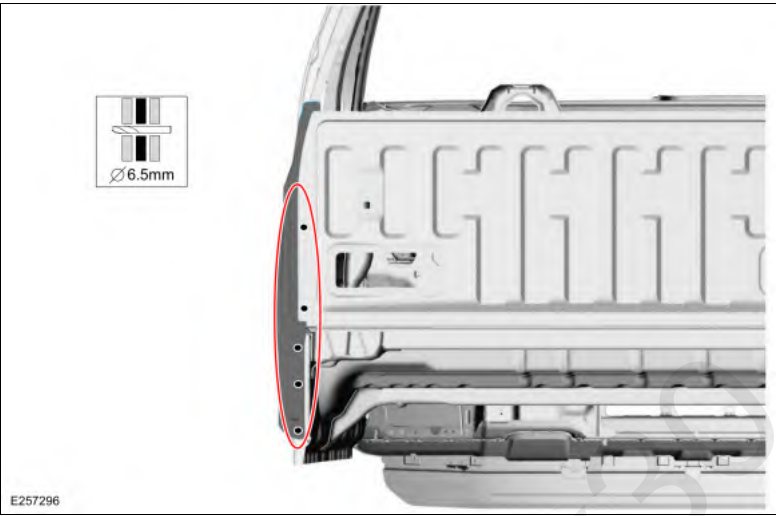
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M, 08115, LORD Fusor® 108B



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



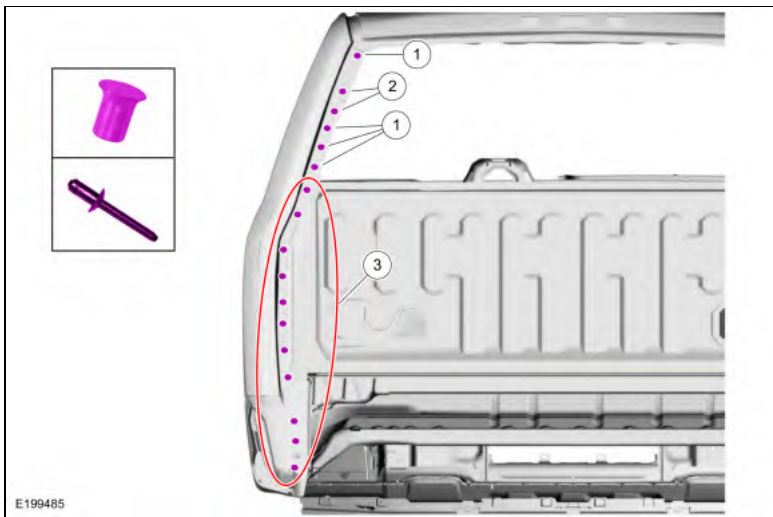
28. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



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 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	-	W709377-S900	-
2	W708717-S900	AW	DG10-220/H	SA-0400/SA-0402	-	W790377-S900	-
3	-	-	-	-	W708777-S900C	-	-

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



30. Metal finishing:

Metal finish all 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 approved epoxy-based primer and allow to dry.

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32. Mask the rear window opening channel.



33. Refinish the entire repair using a Ford approved paint system and typical refinishing techniques.
34. Unmask the rear window opening channel



35. 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 - Super Cab (501-20B Supplemental Restraint System, Removal and Installation).
 Refer to: Side Curtain Airbag - Crew Cab (501-20B Supplemental Restraint System, Removal and Installation).
36. Install the rear window glass.
 Refer to: Fixed Glass (501-11 Glass, Frames and Mechanisms, General Procedures).
37. Reposition the wiring harness and carpet.
38. Install the door opening weather strip.
39. Install the door opening scuff plate.

Crew Cab/Regular Cab

40. Front door on regular cab, rear door on Crew Cab.
 Install the door striker.
Torque: 18 lb.ft (25 Nm)

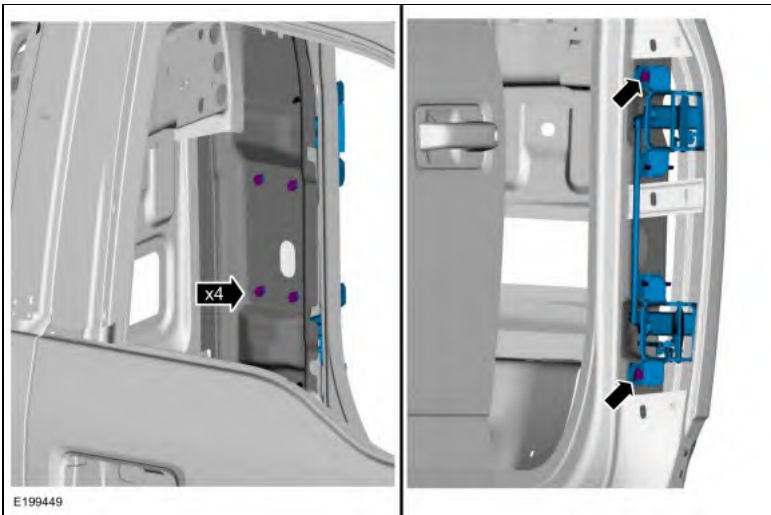


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SuperCab

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



42. Install and align the rear door.
Refer to: Rear Door - SuperCab (501-03 Body Closures, Removal and Installation).
Refer to: Rear Door Alignment - SuperCab (501-03 Body Closures, General Procedures).

Crew Cab/SuperCab

43. Install the rear seat.

Regular Cab

44. Install the front seat.
Refer to: Front Seat (501-10A Front Seats, Removal and Installation).

All vehicles

45. 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).
46. 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 - Crew Cab/Super Cab (501-05 Interior Trim and Ornamentation, Removal and Installation).
47. 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).
48. If equipped:
Install the pickup bed.
Refer to: Pickup Bed (501-04 Pickup Bed and Platform Body, Removal and Installation).
49. Repower the SRS.
Refer to: Supplemental Restraint System (SRS) Repowering (501-20B Supplemental Restraint System, General Procedures).

