

Rear Door Skin Panel - Crew Cab

Special Tool(s) / General Equipment

6.5 mm Drill Bit
Scraper for Straight Edges
Grinder
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Hot Air Gun
Knife

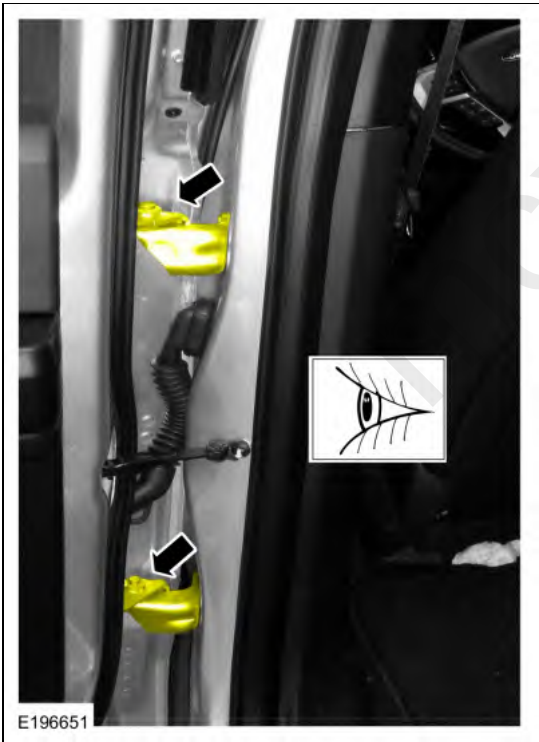
Materials

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	-

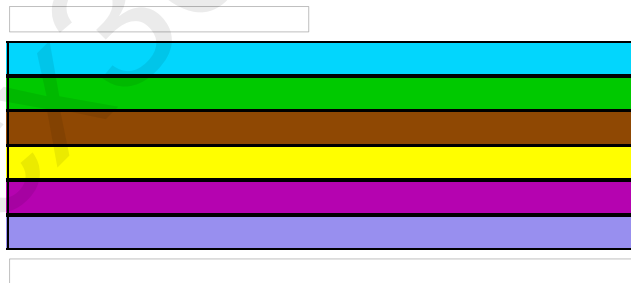
Removal

NOTE: LH side shown, RH side similar.

- 1. Inspect the door hinges for excessive wear or damage. Install new or rebuild as necessary.



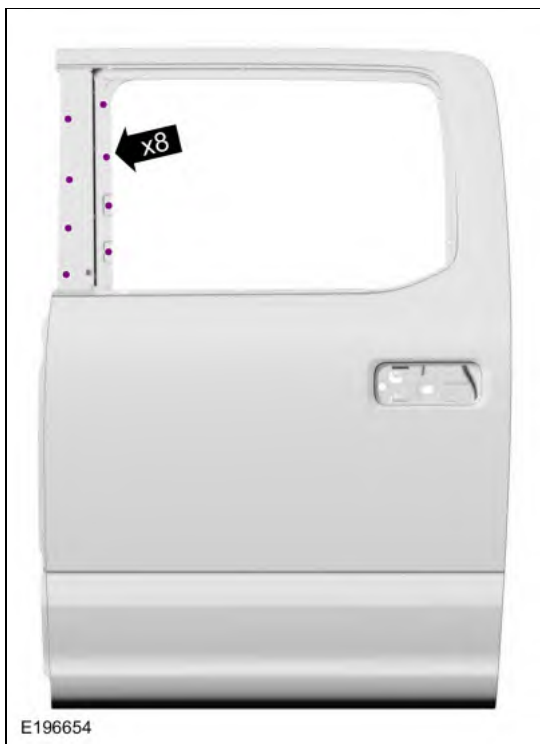
- 2. Remove the exterior door handle.
Refer to: Exterior Rear Door Handle - Crew Cab (501-14 Handles, Locks, Latches and Entry Systems, Removal and Installation).
- 3. Remove the door window glass.
Refer to: Rear Door Window Glass - Crew Cab (501-11 Glass, Frames and Mechanisms, Removal and Installation).
- 4. Remove the door.
Refer to: Rear Door - Crew Cab (501-03 Body Closures, Removal and Installation).
- 5. Remove the door trim.
Refer to: Rear Door Upper Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).
- 6. Remove all door assembly weather stripping.



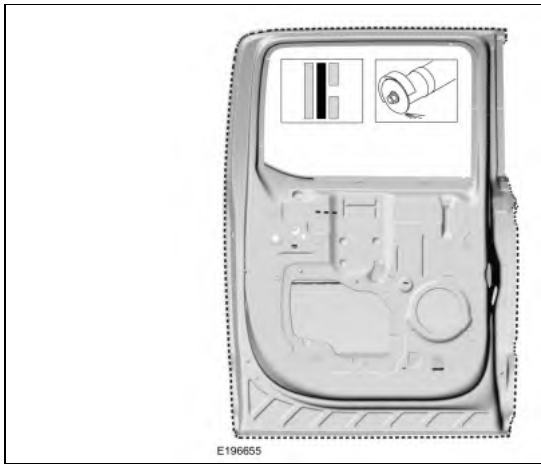
7. Remove the seam sealer from the door hem flange.
Use the General Equipment: Hot Air Gun
Use the General Equipment: Scraper for Straight Edges



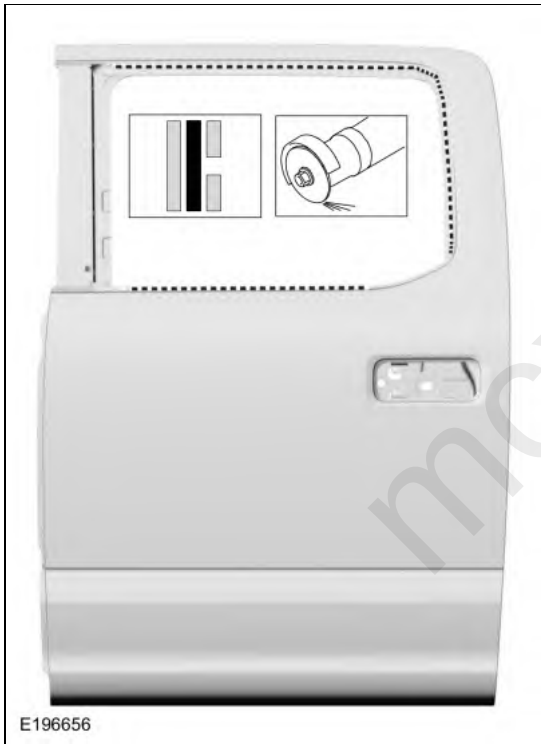
8. Remove the SPR fasteners as indicated.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



9. Carefully grind the **outer layer only** of the door skin hem flange as indicated.
Use the General Equipment: Grinder

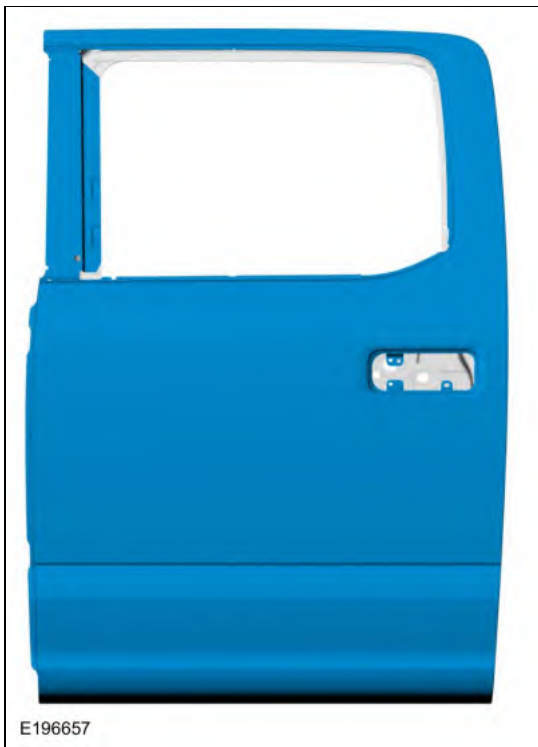


10. Carefully grind the **outer layer only** of the door skin window frame hem flange as indicated.
Use the General Equipment: Grinder



11. **NOTE:** *The use of heat may help in door skin removal.*

Remove the door skin outer panel.
Use the General Equipment: Hot Air Gun



12. Remove the remaining portion of the door outer panel hem flange.
 Use the General Equipment: Knife
 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.

NOTE: LH side shown, RH side similar.

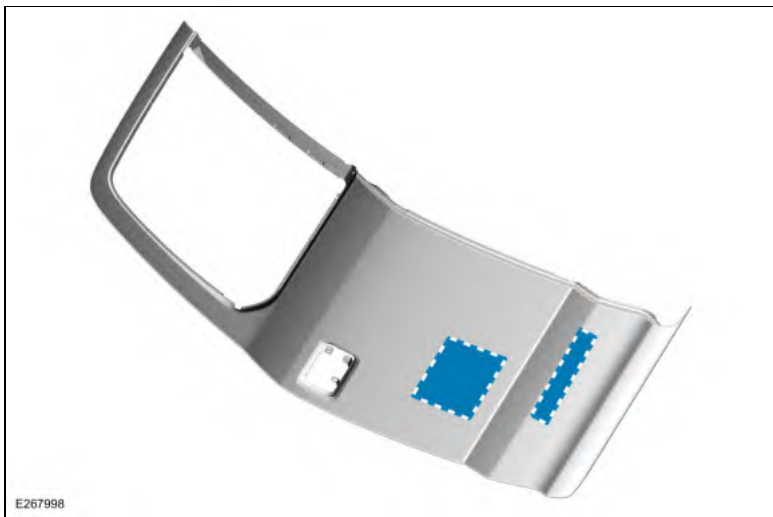
1. Using a hammer and dolly dedicated to aluminum repair, straighten any door shell distortion as necessary.
2. 80-120 grit sand paper.
 Sand to remove old adhesive from the contact area and clean.



3. 80-120 grit sand paper.
Sand to remove e-coat from the mating surface and clean.

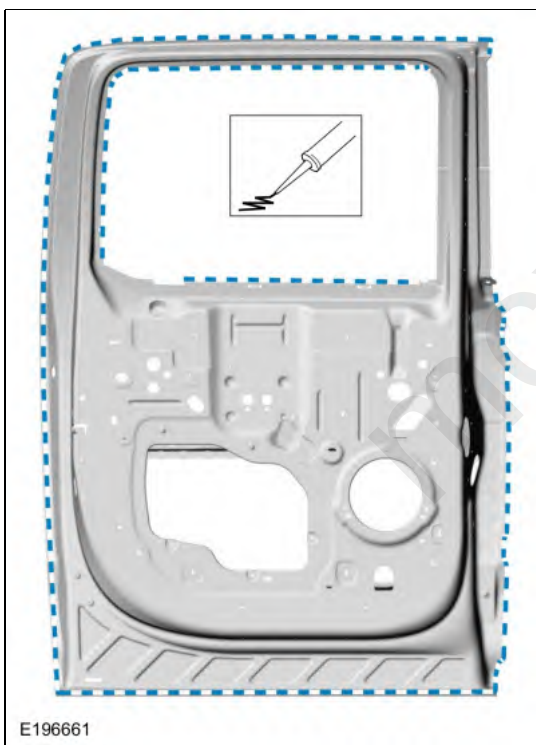


4. Apply NVH butyl patches as indicated (obtain locally).



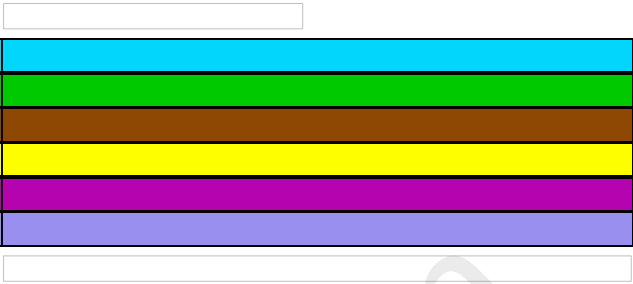
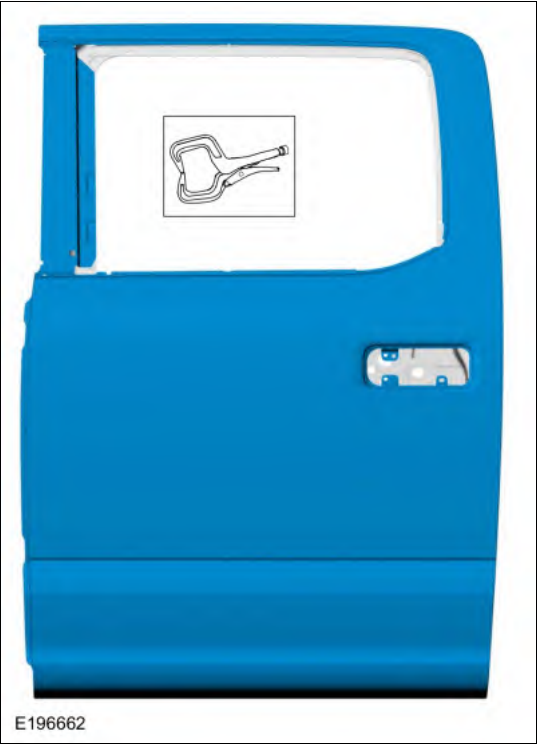
5. Apply adhesive.

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

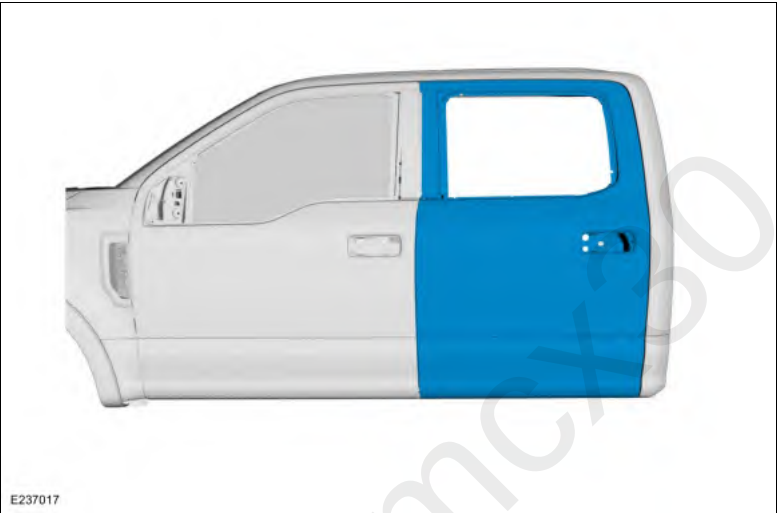


6. NOTICE: To prevent work-hardening of the metal do not use the hammer and dolly method for closing the hem flange. A hem flanging tool designed to work with aluminum is the preferred method.

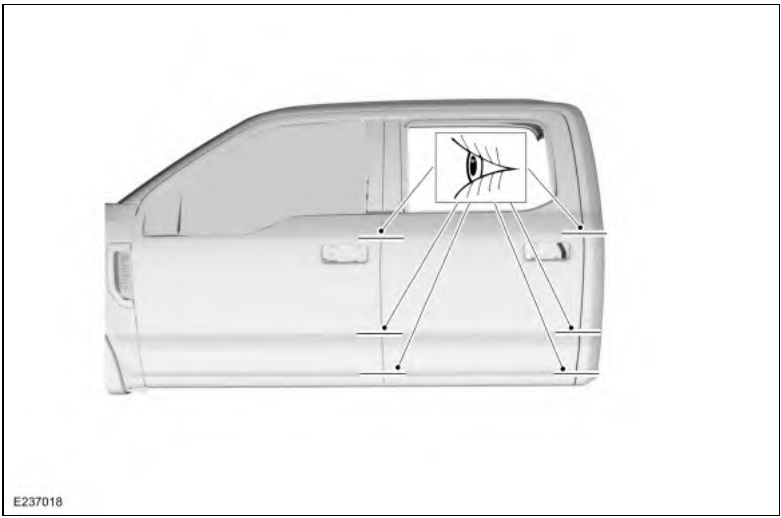
Install, clamp and partially close the flange. Remove the clamp after partially closing the flange.



7. Install the door on the vehicle.

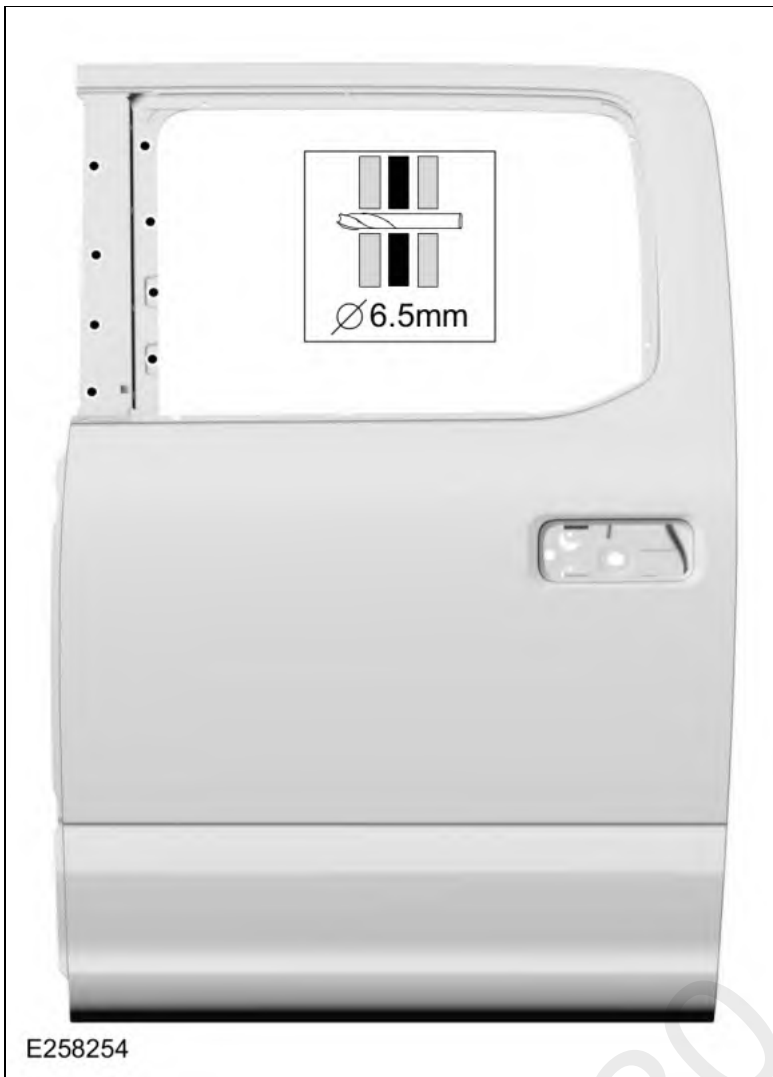


8. Check the door panel for proper fit and alignment.



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

mcx30.com



mcx30.com



10. **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	-	-	-	-	W702512-S900C	W790376-S900	-

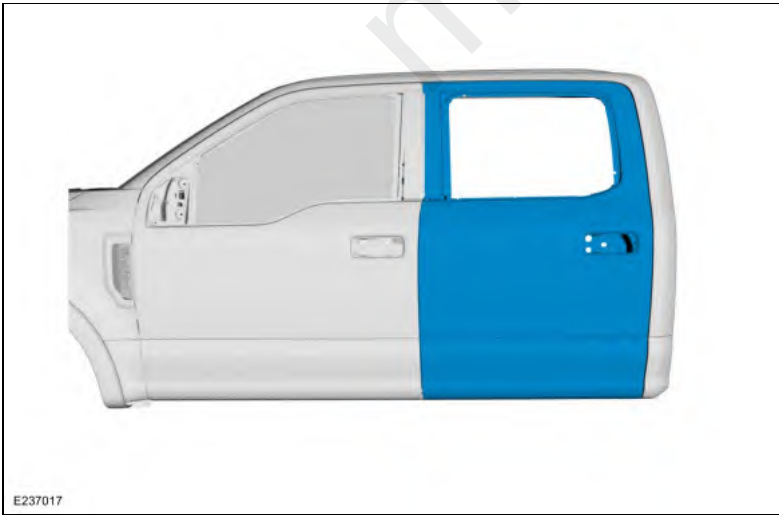
Use the General Equipment: Blind Rivet Gun



E196665



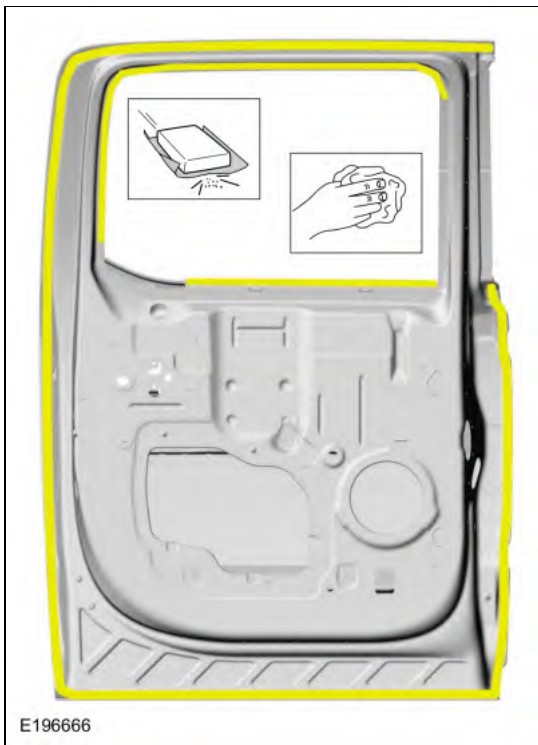
11. Remove the door from the vehicle.



E237017



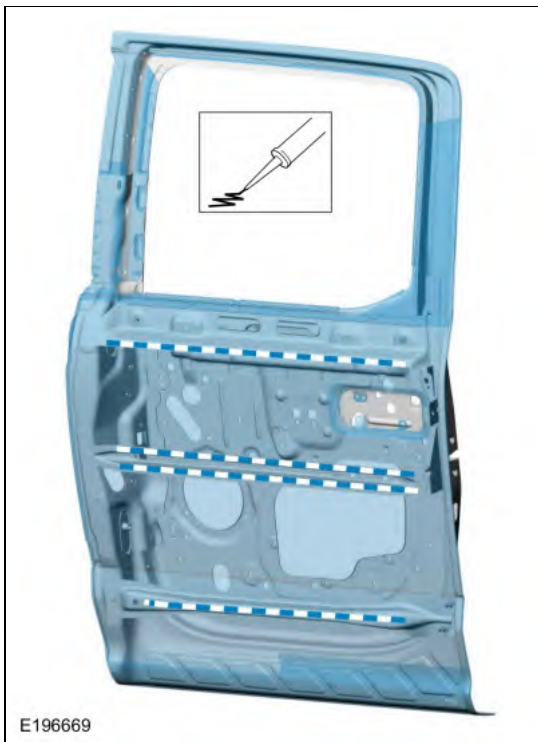
12. **NOTICE:** To prevent work-hardening of the metal do not use the hammer and dolly method for closing the hem flange. A hem flanging tool designed to work with aluminum is the preferred method.
- NOTE:** Smooth residual adhesive squeeze-out in to seam to act as a sealer.
- Complete the hemming process.
13. Sand and clean for primer application.



14. Apply a Ford approved primer to the entire flange repair area.
15. Seam Sealing:
All seams must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M, 08308, LORD Fusor® 805DTM



16. Apply NVH foam as indicated.
Material: Flexible Foam Repair / 3M, 08463, LORD Fusor® 121



17. Refinish the door shell flange using a Ford approved paint system and typical refinishing techniques.

18. Install all door weather stripping.



19. Install the door.

Refer to: Rear Door - Crew Cab (501-03 Body Closures, Removal and Installation).

20. Refinish the exterior using a Ford approved paint system and typical refinishing techniques.

21. Install the exterior door handle.

Refer to: Exterior Rear Door Handle - Crew Cab (501-14 Handles, Locks, Latches and Entry Systems, Removal and Installation).

22. Install the rear door window glass.

Refer to: Rear Door Window Glass - Crew Cab (501-11 Glass, Frames and Mechanisms, Removal and Installation).

23. Install the exterior door trim.

Refer to: Rear Door Upper Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).

24. Align the door as necessary.

Refer to: Rear Door Alignment - Crew Cab (501-03 Body Closures, General Procedures).

