

Rocker Panel Inner Reinforcement - Regular Cab

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	-
Seam Sealer TA-2-B, 3M [®] , 08308, LORD Fusor [®] 805DTM	-
Roof Ditch Sealer 3M [®] , 08307, LORD Fusor [®] 122EZ	-
Flexible Foam Repair 3M [®] , 08463, LORD Fusor [®] 121	-

Removal

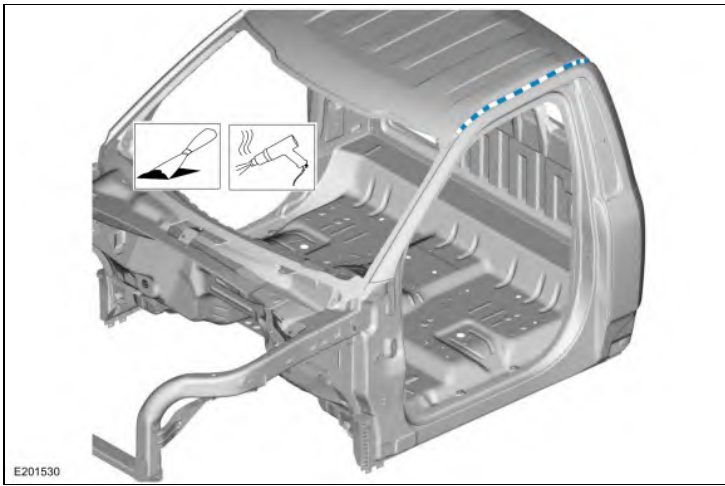
NOTICE: Body side sectioning is prohibited within 50 mm of door hinge, door striker and restraints anchoring points.

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: The rocker panel reinforcement may be sectioned at any point providing restraints, door hinge and door striker restrictions are met. Adjust sectioning point to meet repair requirements. The following procedure assumes full component replacement.

NOTE: Pay particular attention to NVH baffle and foam locations to aid in installation.

1. Depower the SRS.
Refer to: Supplemental Restraint System (SRS) Depowering (501-20B Supplemental Restraint System, General Procedures).
2. If equipped:
Remove the outer body trim.
Refer to: Bodyside Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).
Refer to: Roof Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).
3. Remove the pickup bed.
Refer to: Pickup Bed (501-04 Pickup Bed and Platform Body, Removal and Installation).
4. Remove the windshield and the rear window glass.
Refer to: Fixed Glass (501-11 Glass, Frames and Mechanisms, General Procedures).
5. Remove the A-pillar reinforcement.
Refer to: A-Pillar Outer Panel Section and Reinforcement (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
6. Remove the roof ditch sealer.
Use the General Equipment: Hot Air Gun
Use the General Equipment: Scraper for Straight Edges



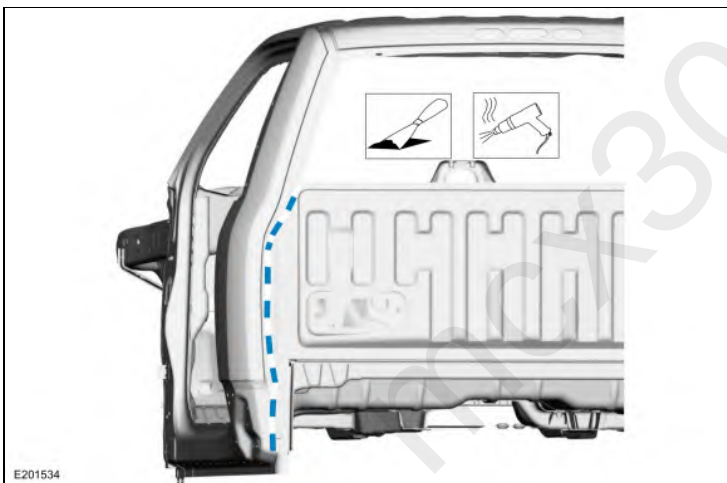
7. Carefully cut the **outer panel only**.
 Use the General Equipment: Air Body Saw
 Use the General Equipment: Spherical Cutter



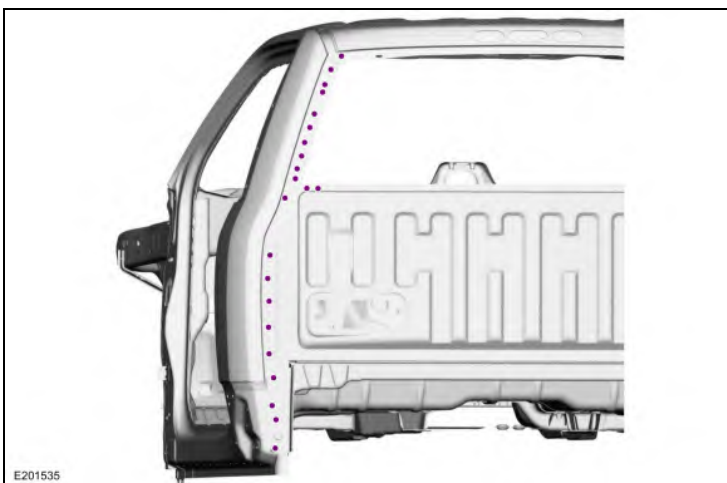
8. Remove the SPR fasteners.
 Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Belt Sander



9. Remove the cab back seam sealer.
Use the General Equipment: Scraper for Straight Edges
Use the General Equipment: Hot Air Gun

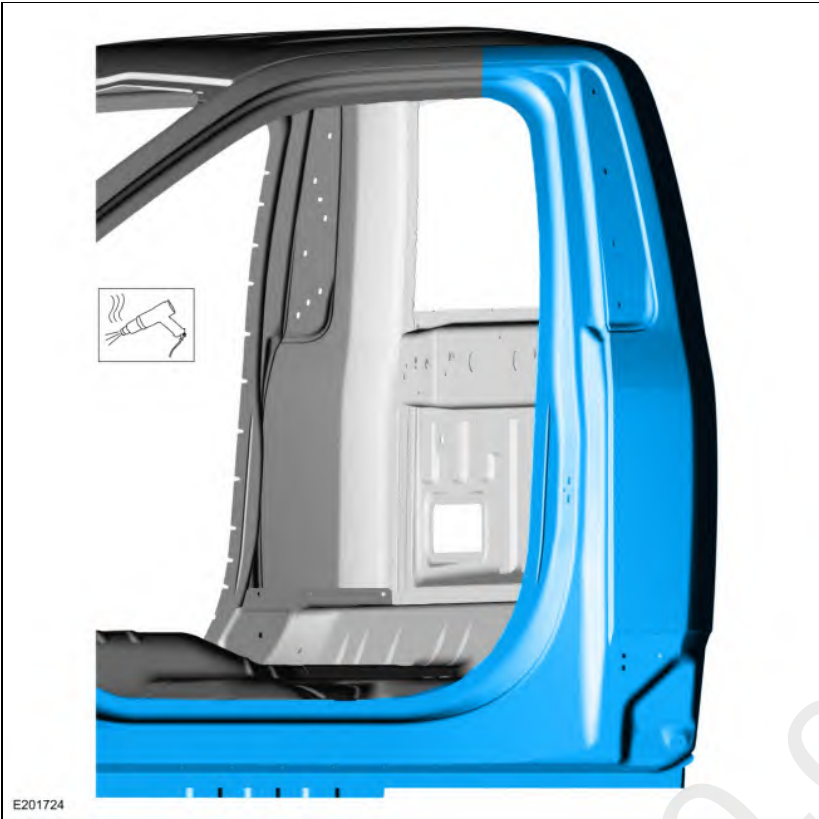


10. Remove the cab back SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



11. **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 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 body side section.
Use the General Equipment: Hot Air Gun



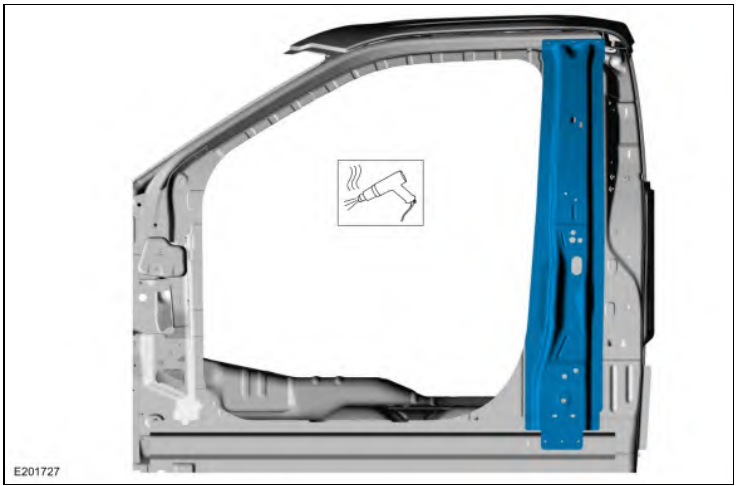
12. Remove and discard the FDS fasteners.
Use the General Equipment: Polydrive Bit Socket



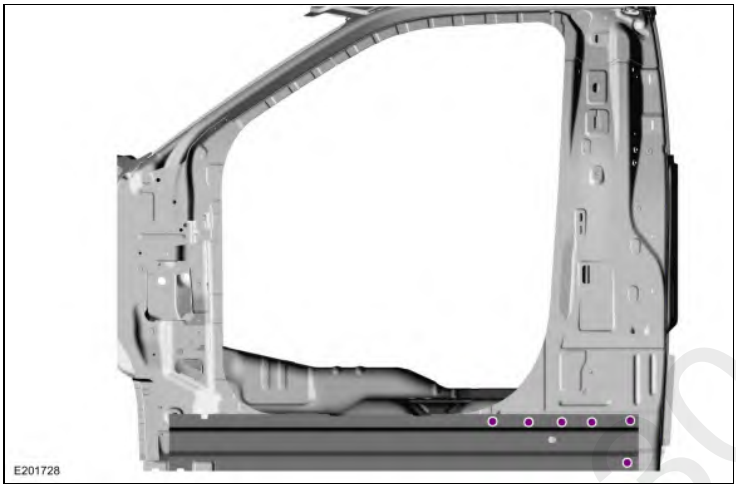
13. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



14. Break the adhesive bond and remove the C-pillar reinforcement.
Use the General Equipment: Hot Air Gun



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



16. Break the adhesive bond and remove the rocker panel reinforcement.
Use the General Equipment: Hot Air Gun



Installation

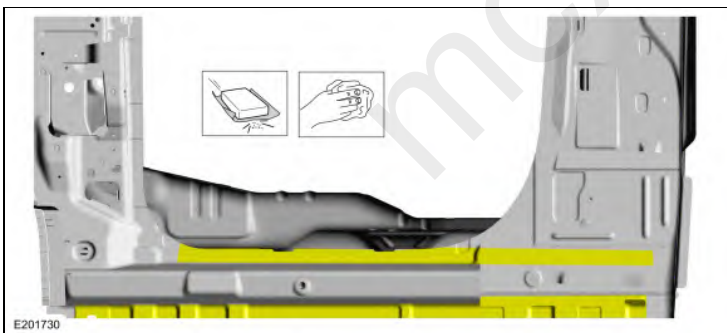
NOTICE: Body side sectioning is prohibited within 50 mm of door hinge, door striker and restraints anchoring points.

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

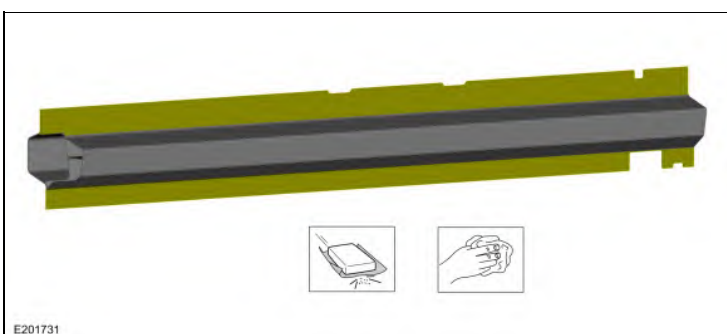
NOTE: Blind or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

NOTE: The use of a backer panel when creating butt welds will produce a stronger and more uniform repair.

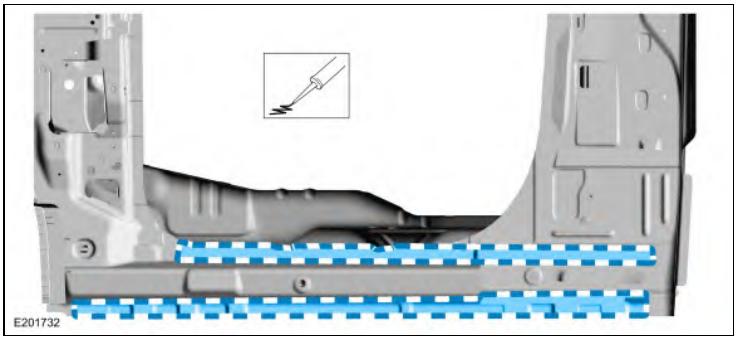
1. 80-120 grit sand paper.
Sand to remove old adhesive and clean.



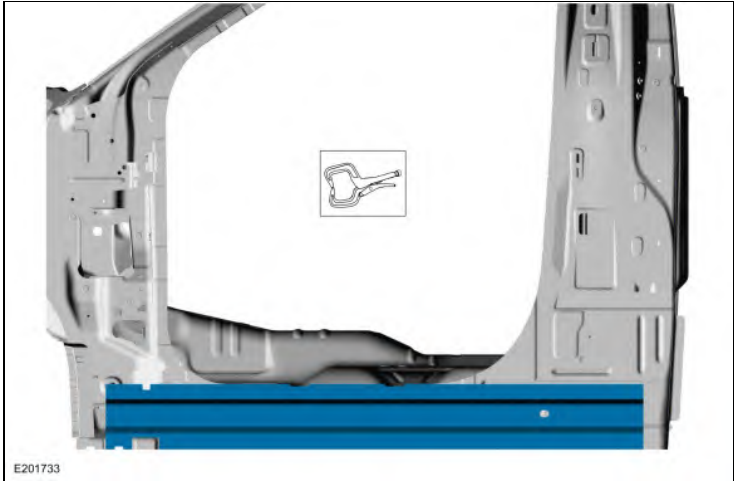
2. 80-120 grit sand paper.
Sand to remove e-coat and clean.



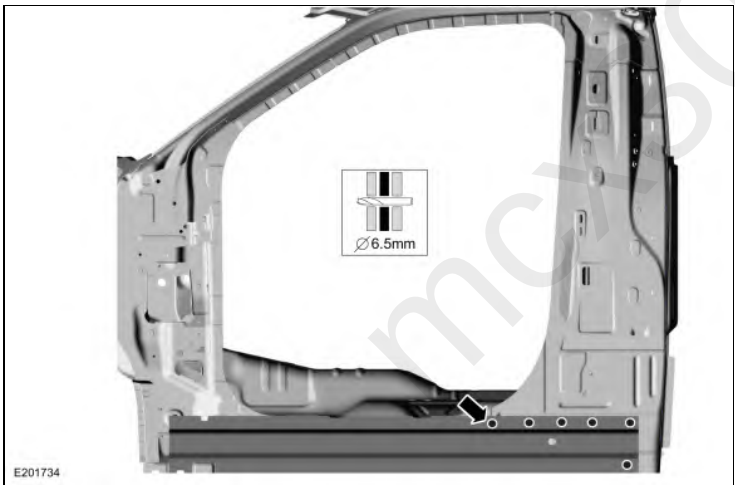
3. Apply adhesive.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M[®], 08115, LORD Fusor[®] 108B



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



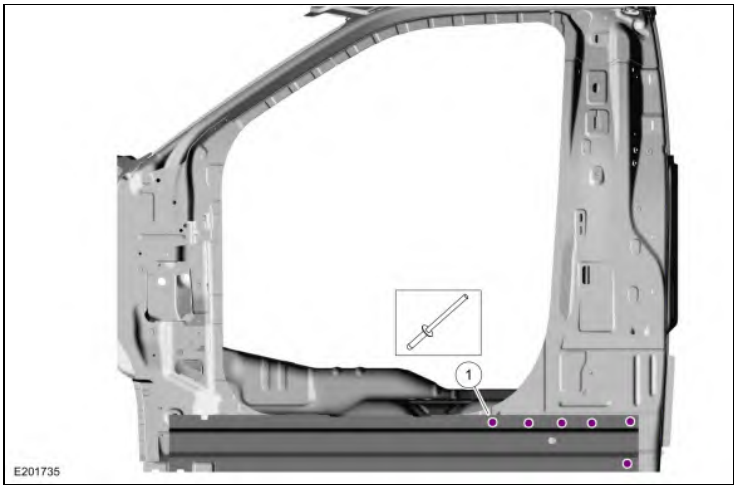
5. Drill 6.5 mm holes for blind rivet fasteners.
Use the General Equipment: 6.5 mm Drill Bit



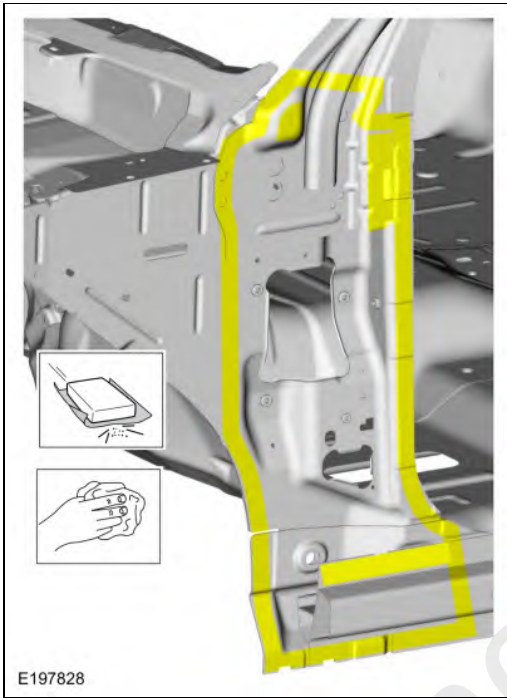
6. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.
NOTE: Blind or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.
Install fasteners.

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

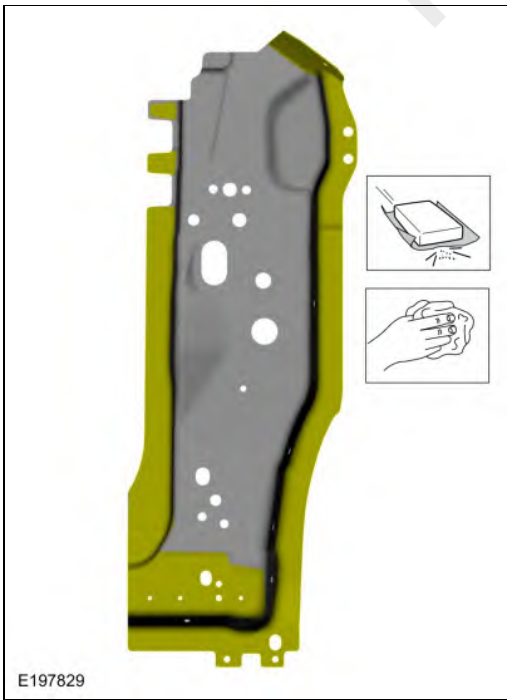
Use the General Equipment: Blind Rivet Gun



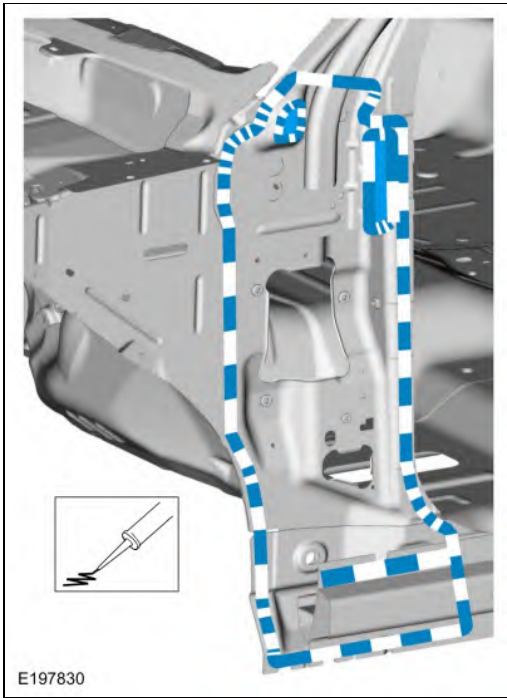
7. 80-120 grit sand paper.
Sand to remove old adhesive and e-coat and clean.



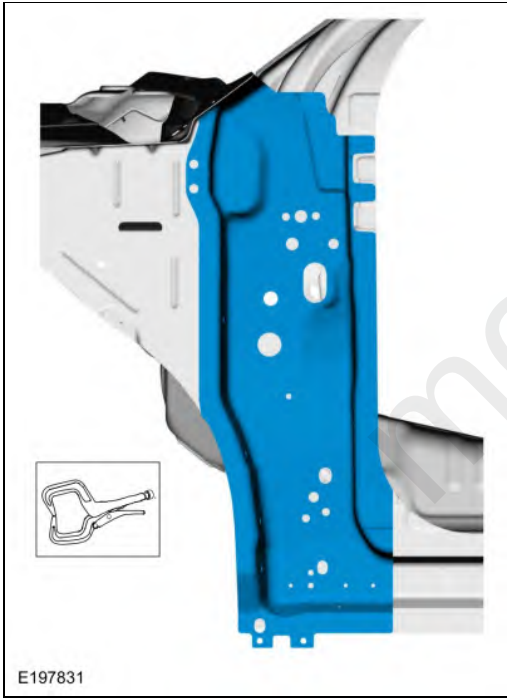
8. 80-120 grit sand paper.
Sand to remove e-coat and clean.



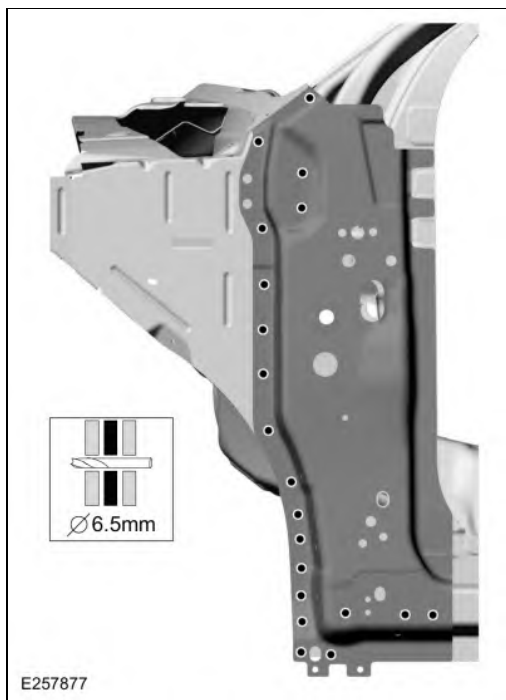
9. Apply adhesive.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3Mâ,ç 08115, LORD FusorÂ® 108B



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



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



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

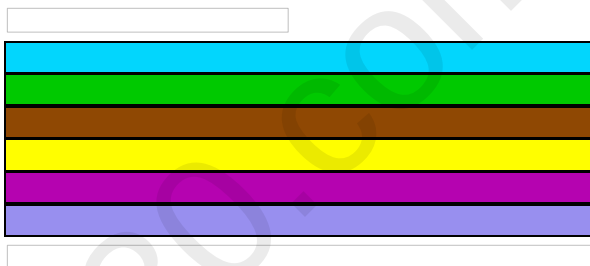
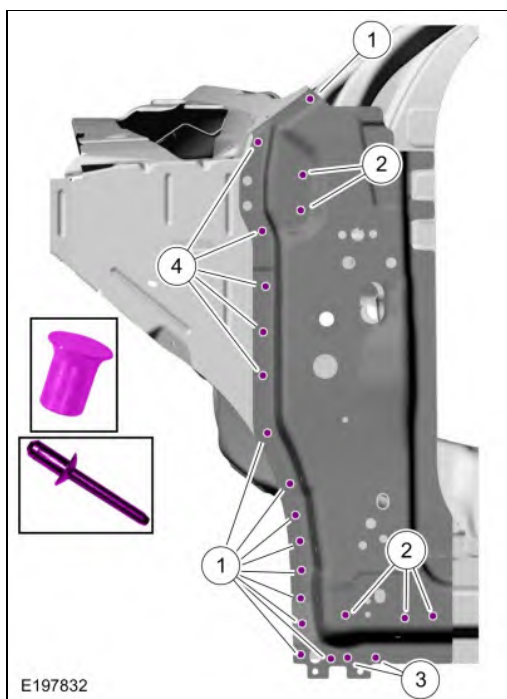
NOTE: Blind or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Install fasteners.

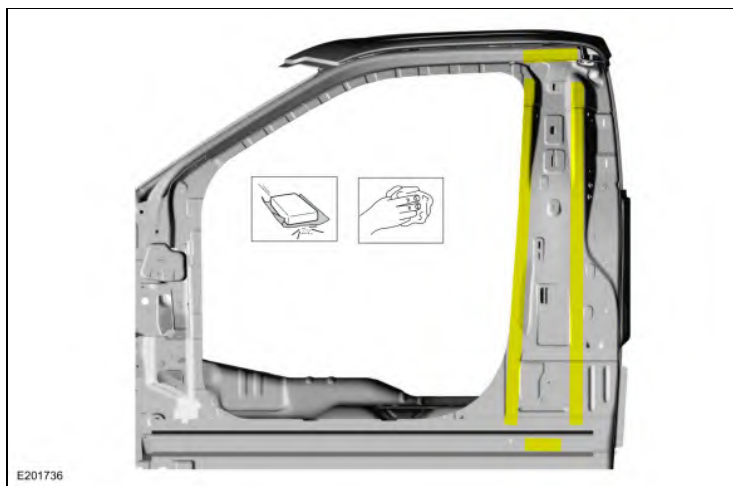
Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W717182-S900	QC	DP10-200/H	SA-0400/SA-0402	W708777-S900C	W790377-S900	-
2	-	-	-	-	W708777-S900C	-	-
3	W717186-S900	EL	DP11-200/H	SA-0400/SA-0402	W708777-S900C	W790377-S900	-
4	-	-	-	-	W702512-S900C	-	-

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

Use the General Equipment: Blind Rivet Gun

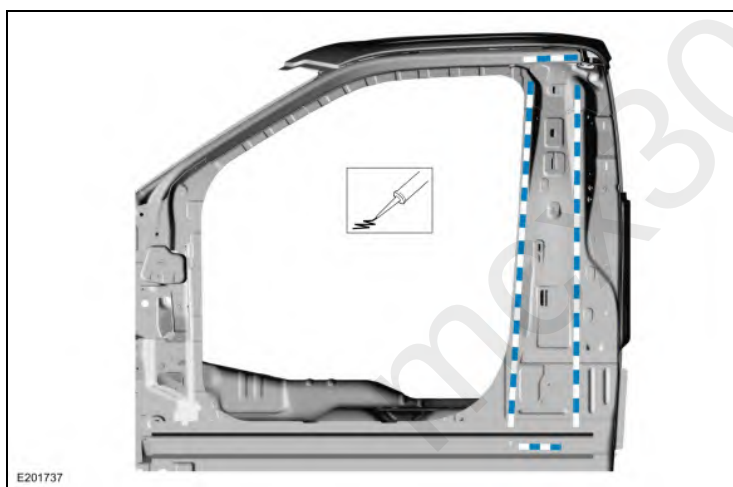


13. Install the fender apron panel.
Refer to: Fender Apron Panel Reinforcement (501-27 Front End Sheet Metal Repairs, Removal and Installation).
14. 80-120 grit sandpaper.
Sand to remove old adhesive and clean.

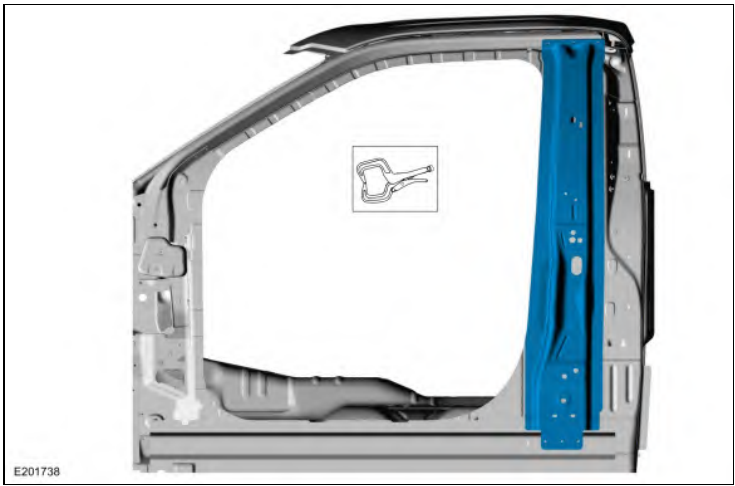


15. Apply adhesive.

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



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



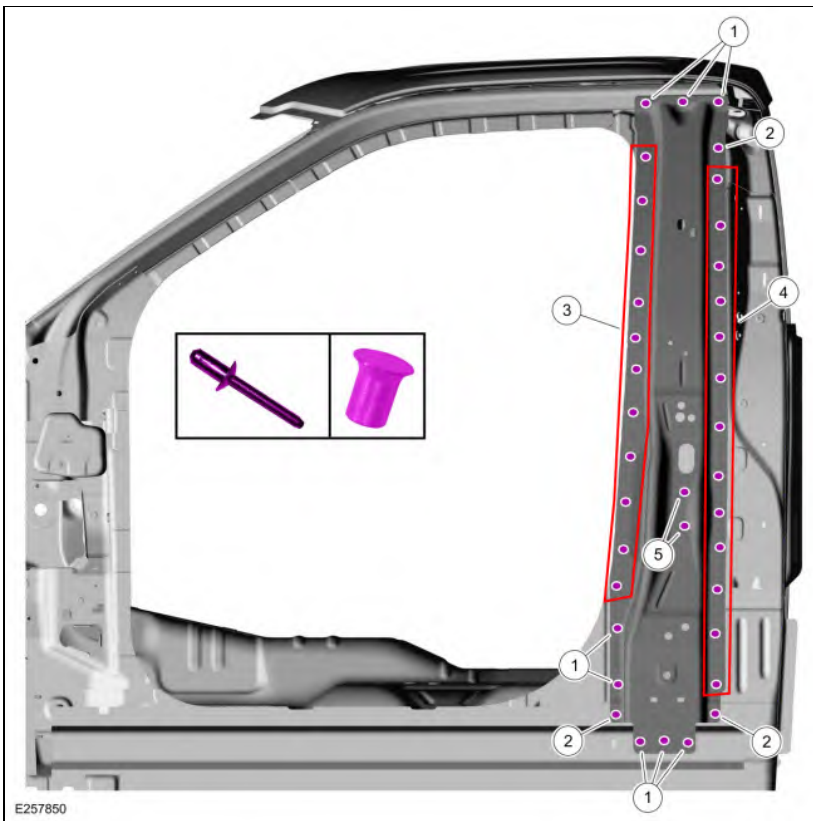
17. Drill for fasteners.
Use the General Equipment: 6.5 mm Drill Bit



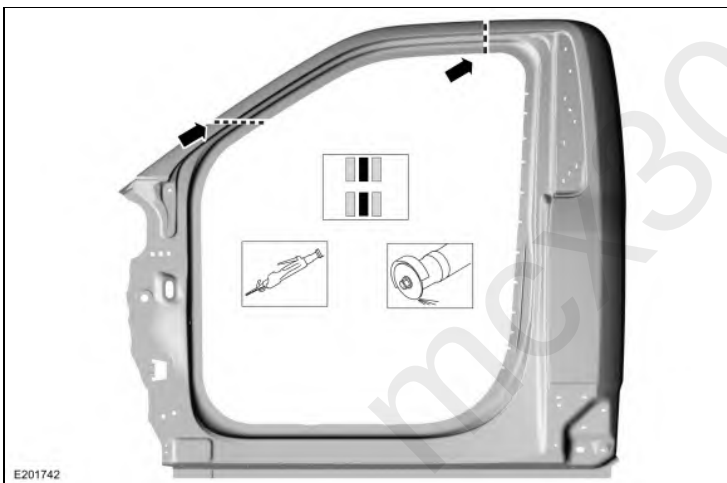
18. Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W702554-S900C	-	-
3	W717337-S900	PX	DG10-200/H	SA-0400/SA-0402	-	W790377-S900	-
4	-	-	-	-	W708777-S900C	-	-

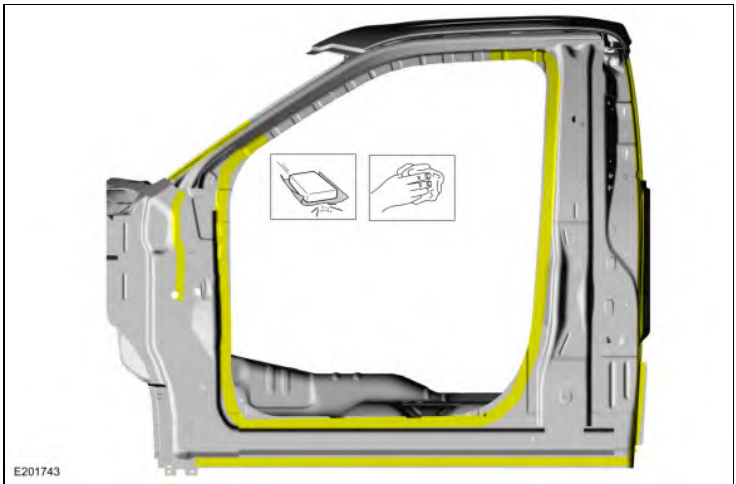
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Blind Rivet Gun



19. Cut the body side service panel to fit repair.
Use the General Equipment: Air Body Saw
Use the General Equipment: Spherical Cutter



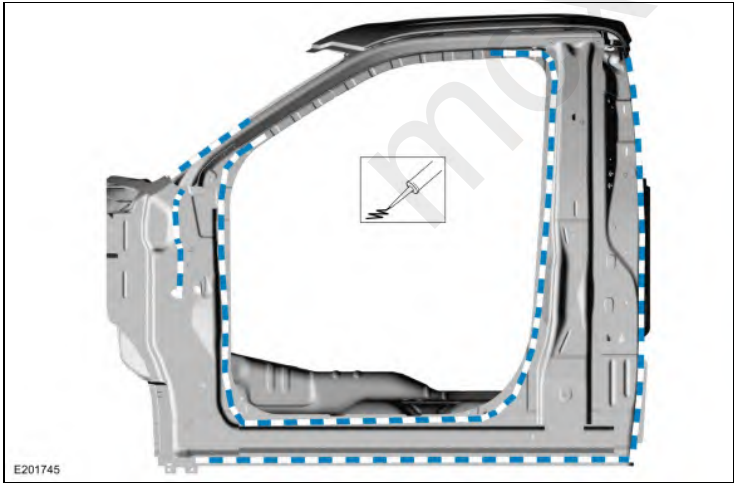
20. Create backing plates from unused portions of the service panel for each sectioning joint and attach to vehicle.
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
21. 80-120 grit sand paper.
Sand to remove old adhesive and e-coat and clean.



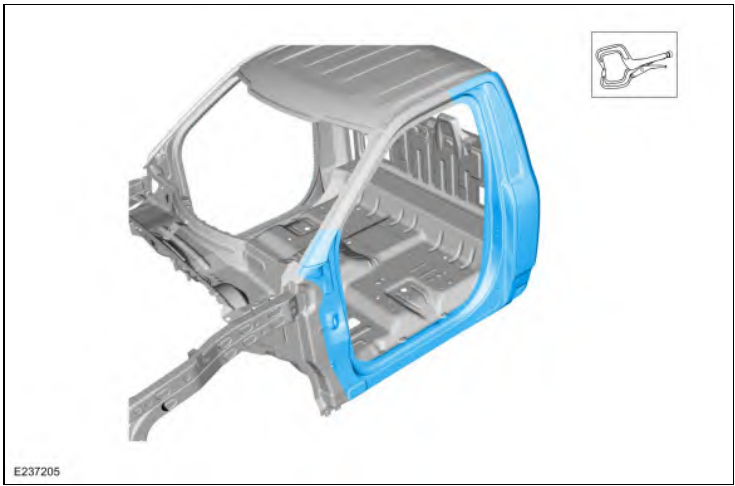
22. 80-120 grit sand paper.
Sand to remove e-coat and clean.



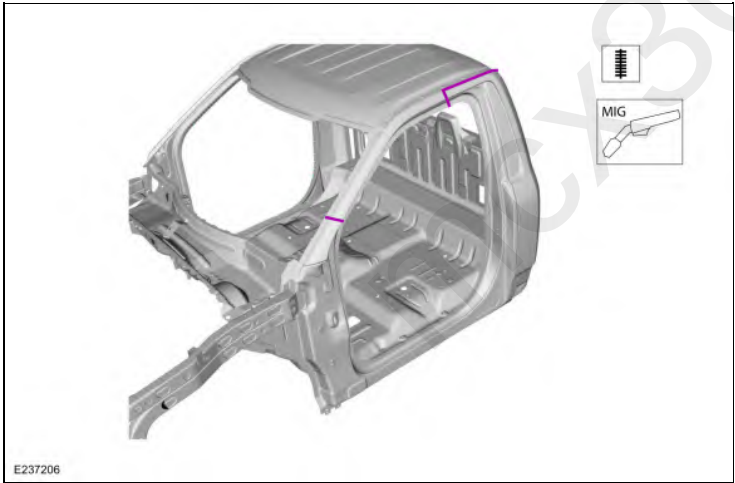
23. Install all NVH baffles noted during removal.
24. Apply adhesive.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M[®] 08115, LORD Fusor[®] 108B



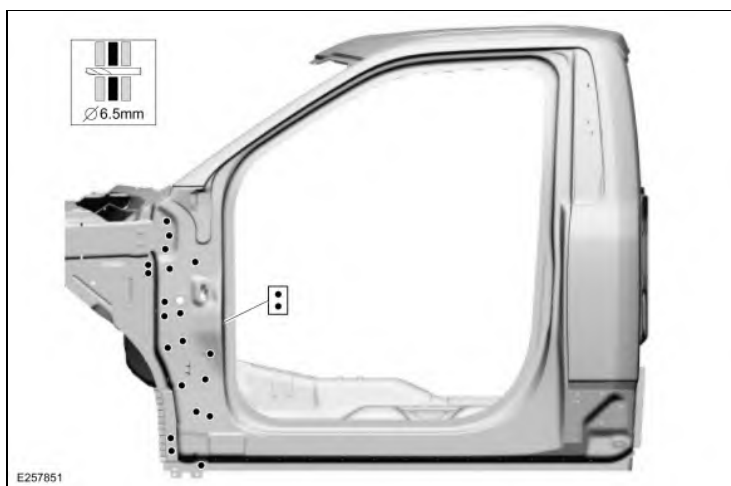
25. Install the body side service panel section and clamp in position.
Use the General Equipment: Locking Pliers



26. Complete joining of backer plates to the body side service panel.
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
Use the General Equipment: MIG/MAG Welding Equipment
27. Completely seam-weld all sectioning joints using a MIG welder set up for aluminum repair.
Use the General Equipment: MIG/MAG Welding Equipment



28. Drill for fasteners.
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.

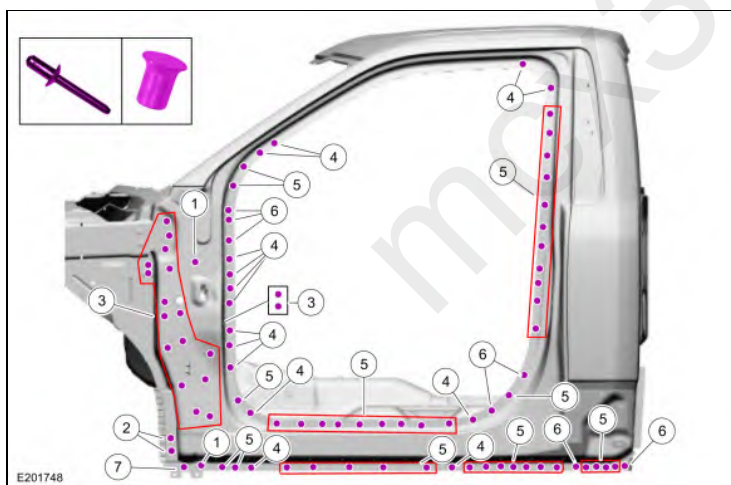
NOTE: Blind or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W702554-S900C	-	-
3	-	-	-	-	W708777-S900C	-	-
4	W708713-S900	AS	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
5	W717186-S900	EN	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
6	W708717-S900	AW	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
7	W710246-S900	BN	DP10-200/H	Sa-0400/SA-0402	-	W790377-S900	-

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

Use the General Equipment: Blind Rivet Gun



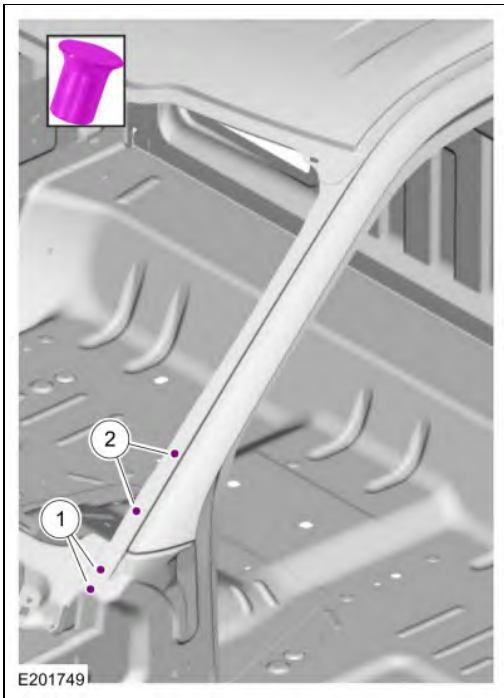
30. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

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

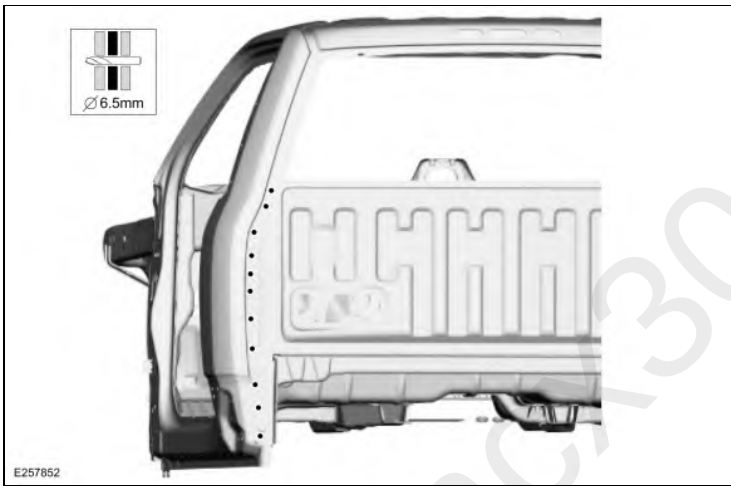
Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
2	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-

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



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



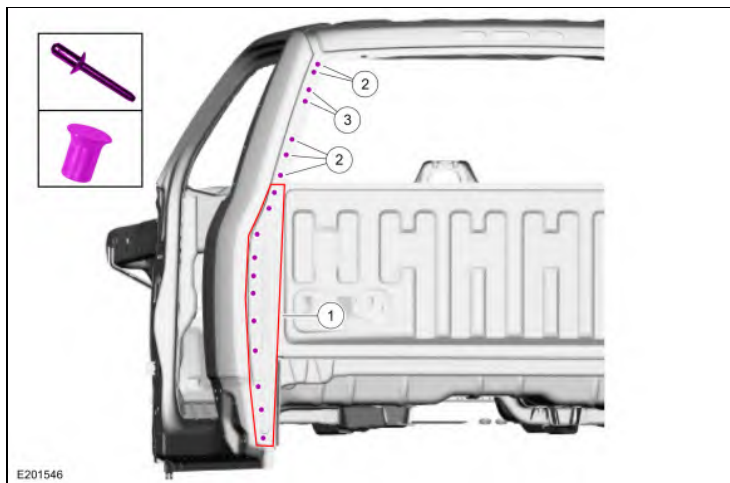
32. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

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

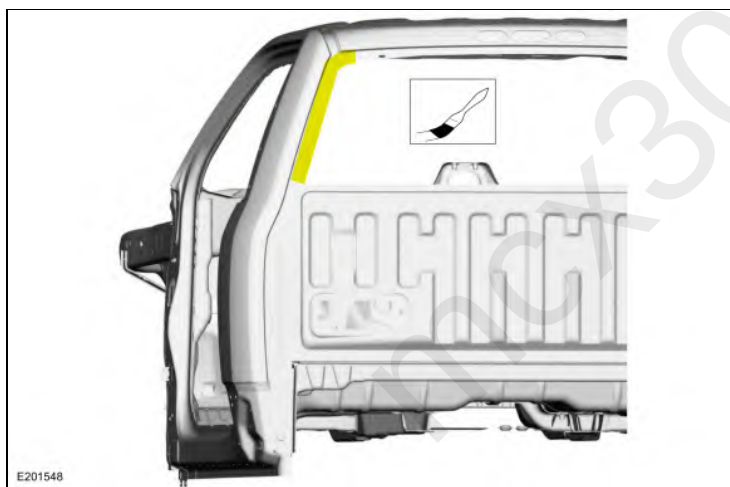
Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
	-	-	-	-	W708777-S900C	-	-
2	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-
3	W708717-S900	AW	DG10-220/H	SA-0400/SA-0402	-	W790377-S900	-

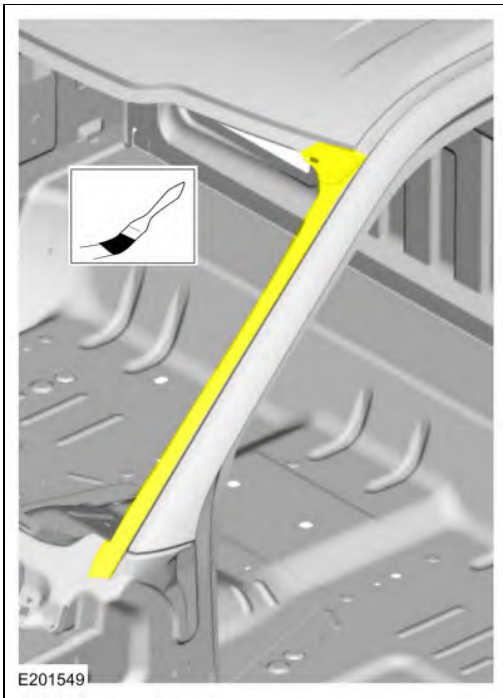
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Blind Rivet Gun



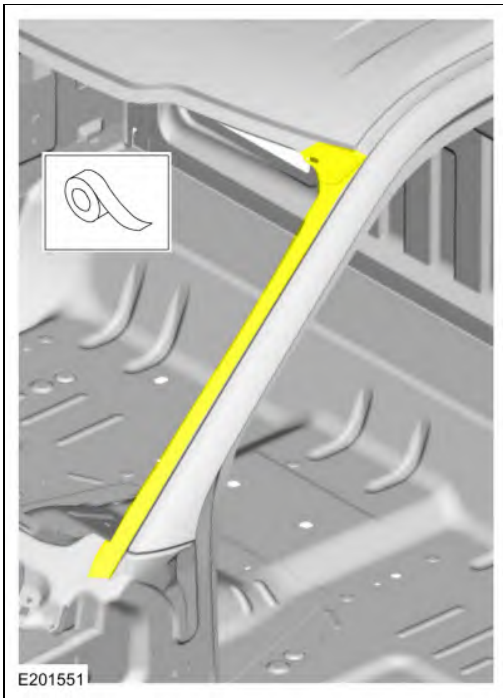
33. Metal finish all sectioning seams using typical aluminum repair techniques and a fiber-based body filler.
Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).
34. Sand and epoxy prime.
Prime the rear window glass opening channel using a Ford approved epoxy-based primer on both sides and allow to dry.



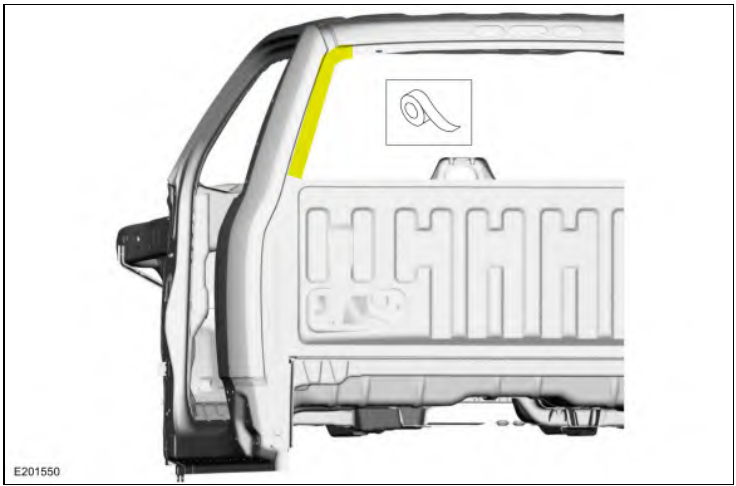
35. Sand and epoxy prime.
Prime the windshield glass opening channel using a Ford approved epoxy-based primer on both sides and allow to dry.



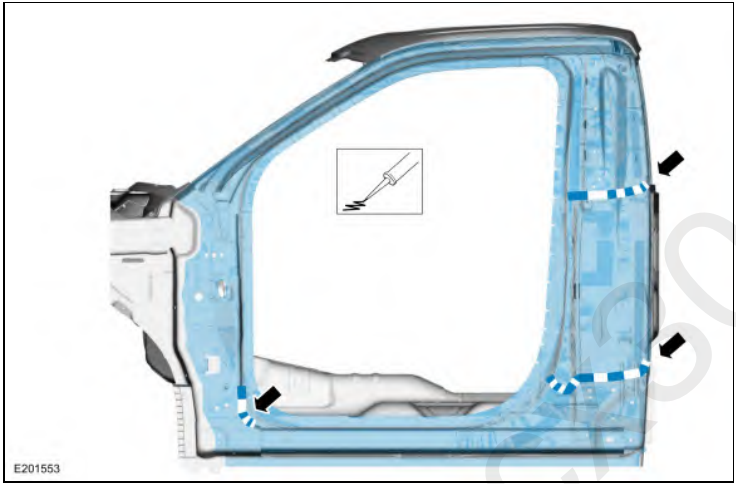
36. Mask the windshield glass opening channel on both sides.



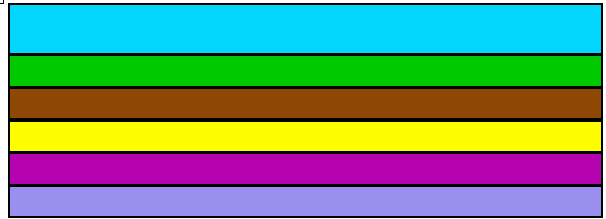
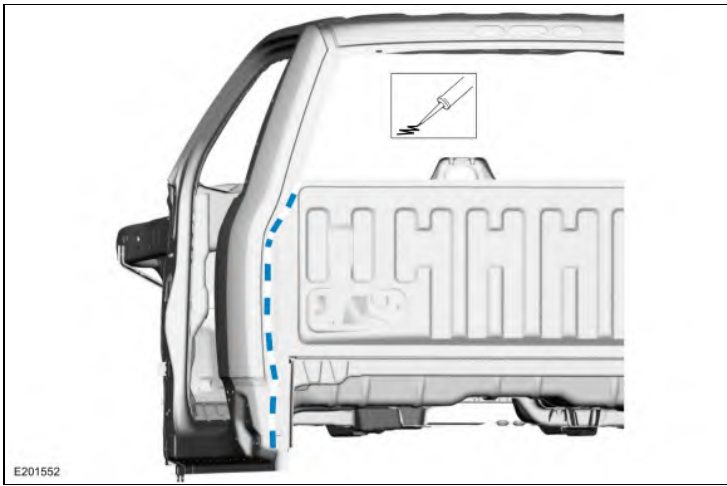
37. Mask the rear window glass opening channel on both sides.



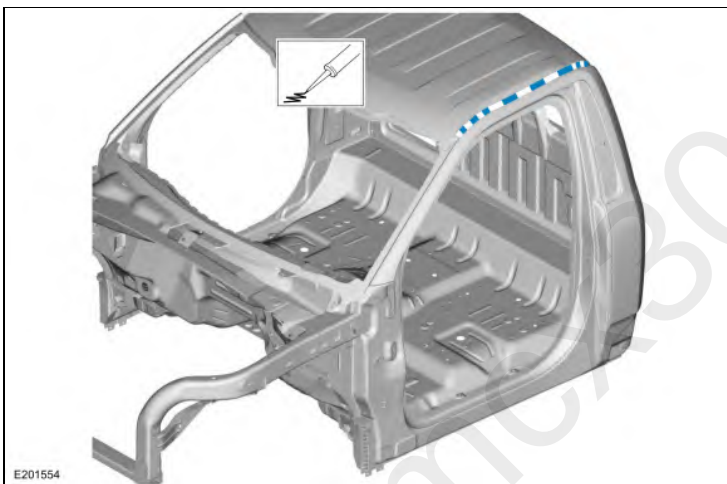
38. Apply NVH foam to all locations noted during removal to assure complete sealing.
Material: Flexible Foam Repair / 3M, 08463, LORD Fusor 121



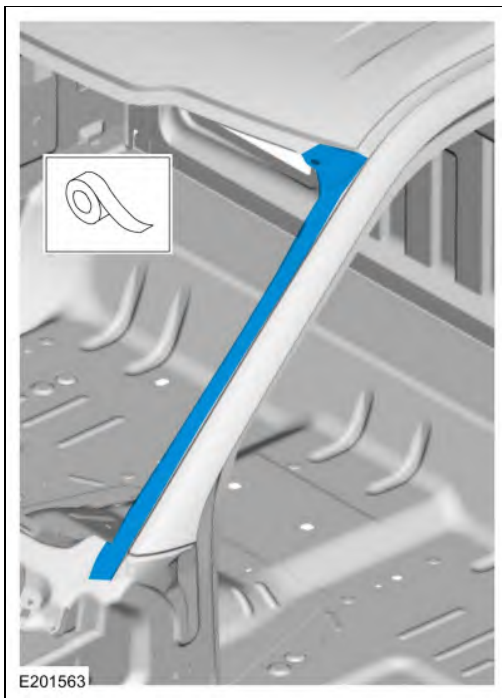
39. **Seam Sealing:**
All seams must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M, 08308, LORD Fusor 805DTM



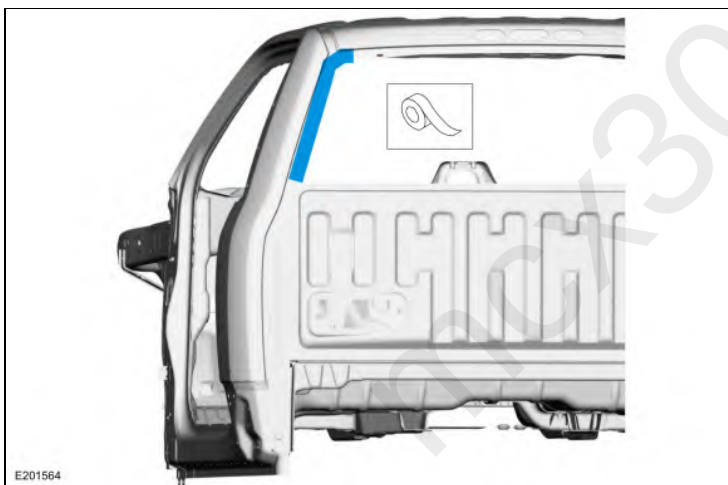
40. Apply roof ditch sealer.
 Material: Roof Ditch Sealer / 3M[®] 08307, LORD Fusor[®] 122EZ



41. Refinish the entire repair using a Ford approved paint system and typical refinishing techniques.
 42. Unmask the windshield glass opening channel.



43. Unmask the rear window glass opening channel.



44. Install the side curtain air bag.
Refer to: Side Curtain Airbag - Regular Cab (501-20B Supplemental Restraint System, Removal and Installation).
45. Install the door opening weather strips and scuff plate.
46. Install the windshield and rear window glass.
Refer to: Fixed Glass (501-11 Glass, Frames and Mechanisms, General Procedures).
47. Install the door hinges and striker.
 - Door hinges.
Torque: 21 lb.ft (28 Nm)
 - Striker.
Torque: 18 lb.ft (25 Nm)
48. Install the A and C-pillar trim.
Refer to: A-Pillar Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: C-Pillar Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
49. Install the outer body exterior trim.
Refer to: Bodyside Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).
Refer to: Roof Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).
50. If equipped:
Install the pickup bed.
Refer to: Pickup Bed (501-04 Pickup Bed and Platform Body, Removal and Installation).

51. Install the fender.
Refer to: Fender (501-02 Front End Body Panels, Removal and Installation).
Refer to: Fender Splash Shield (501-02 Front End Body Panels, Removal and Installation).
 52. Install and align the door.
Refer to: Front Door - Crew Cab/Regular Cab (501-03 Body Closures, Removal and Installation).
Refer to: Front Door Alignment - Crew Cab/Regular Cab (501-03 Body Closures, General Procedures).
 53. Repower the SRS.
Refer to: Supplemental Restraint System (SRS) Depowering (501-20B Supplemental Restraint System, General Procedures).
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mcx30.com