

Side Panel - Crew Cab

Special Tool(s) / General Equipment

6.5 mm Drill Bit
Scraper for Straight Edges
Spherical Cutter
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Hot Air Gun
Air Body Saw
MIG/MAG Welding Equipment
Locking Pliers

Materials

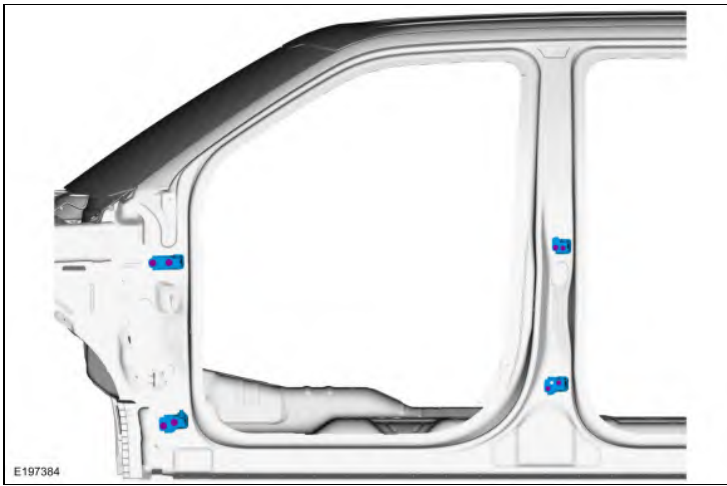
Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M [®] , 08115, LORD Fusor [®] 108B	-
Seam Sealer TA-2-B, 3M [®] , 08308, LORD Fusor [®] 805DTM	-
Roof Ditch Sealer 3M [®] , 08307, LORD Fusor [®] 122EZ	-
Flexible Foam Repair 3M [®] , 08463, LORD Fusor [®] 121	-

Removal

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

NOTE: Partial outer panel replacement is possible and reasonable depending on damage. The following procedure assumes full outer panel replacement. Removal and installation steps may be adjusted according to damage as necessary.

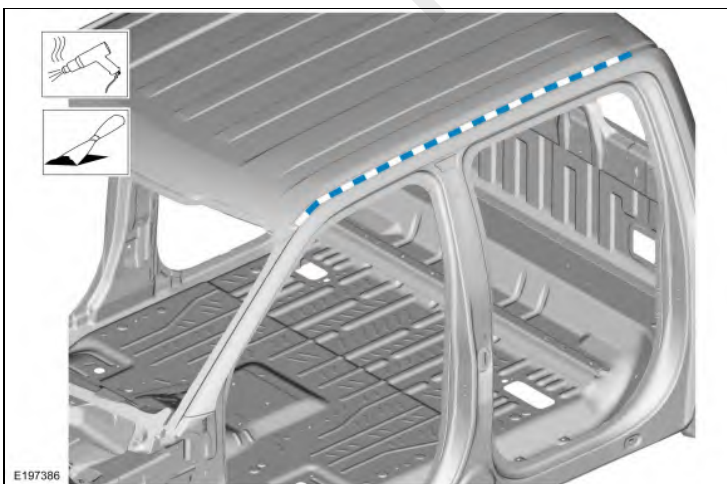
1. Possible sectioning points.
Refer to: Complete Panel Replacement/Partial Replacement (501-25 Body Repairs - General Information, Description and Operation).
Refer to: Body Panel Sectioning (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, General Procedures).
2. Depower the SRS.
Refer to: Supplemental Restraint System (SRS) Depowering (501-20B Supplemental Restraint System, General Procedures).
3. Remove the front fender.
Refer to: Fender (501-02 Front End Body Panels, Removal and Installation).
4. Remove the front and rear doors.
Refer to: Front Door - Crew Cab/Regular Cab (501-03 Body Closures, Removal and Installation).
Refer to: Rear Door - Crew Cab (501-03 Body Closures, Removal and Installation).
5. If equipped:
Remove the pickup bed.
Refer to: Pickup Bed (501-04 Pickup Bed and Platform Body, Removal and Installation).
6. Remove the front and rear door scuff plates.
7. Remove the door opening weather-strips.
8. Remove the A-pillar, B-pillar and C-pillar trim panels.
Refer to: A-Pillar Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: B-Pillar Trim Panel - Crew Cab (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: C-Pillar Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
9. Remove the front and rear door hinges at the body.



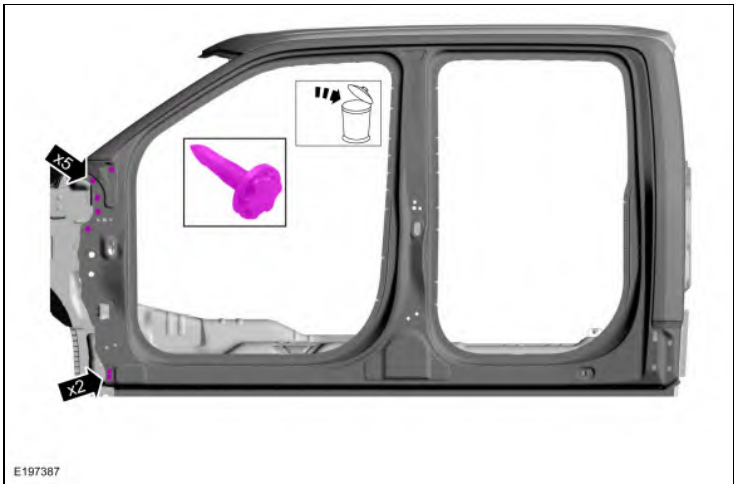
10. Remove the front and rear door strikers.



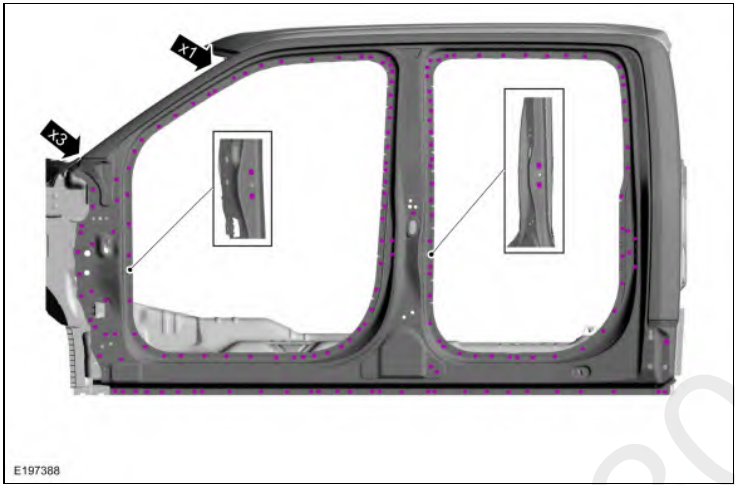
11. Remove the cab corner moulding and roof trim moulding.
Refer to: Bodyside Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).
Refer to: Roof Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).
12. Remove the windshield and rear window.
Refer to: Fixed Glass (501-11 Glass, Frames and Mechanisms, General Procedures).
13. Remove the side curtain air bag.
Refer to: Side Curtain Airbag - Crew Cab (501-20B Supplemental Restraint System, Removal and Installation).
14. Remove the roof ditch sealer.
Use the General Equipment: Hot Air Gun
Use the General Equipment: Scraper for Straight Edges



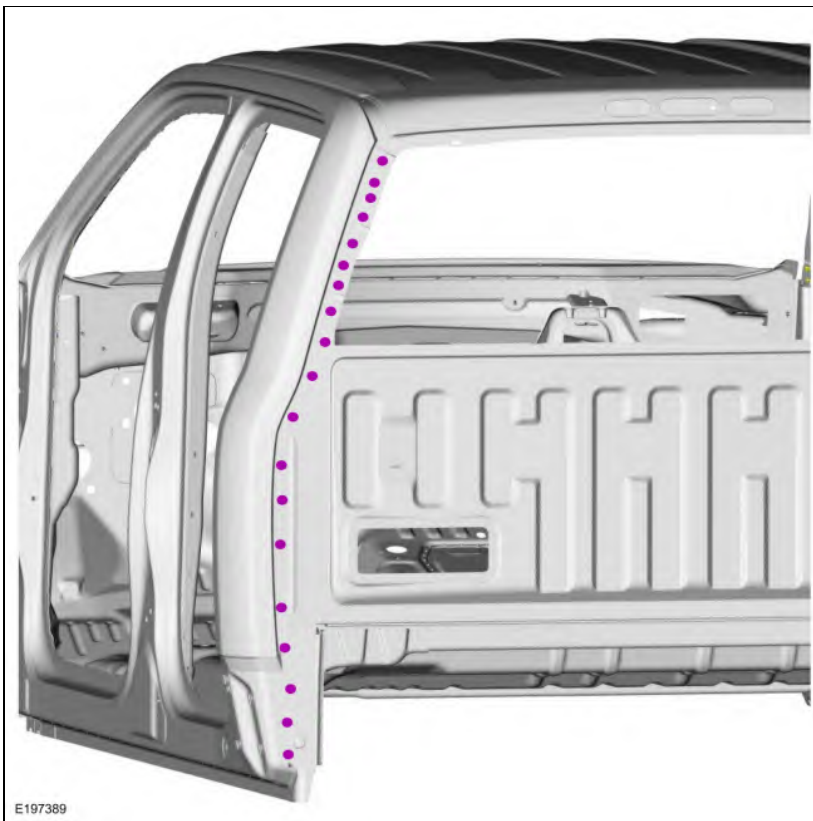
15. Remove and discard the FDS fasteners.



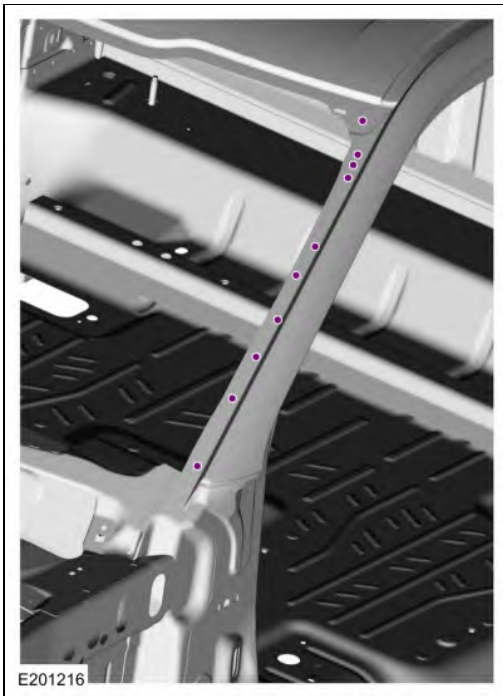
16. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



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



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



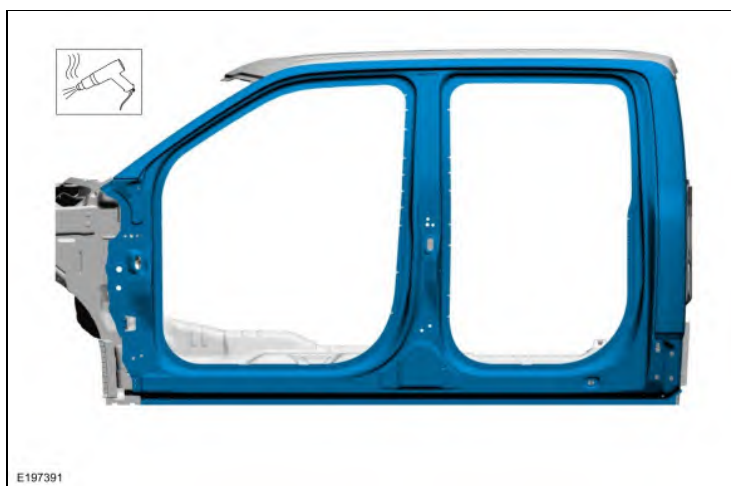
19. Carefully cut the **outer panel only** in the roof ditch as indicated.
 Use the General Equipment: Air Body Saw
 Use the General Equipment: Spherical Cutter



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 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: Pay particular attention to location of NVH foam and sealers used to aid in installation.

Break the adhesive bond and remove the body side panel.
 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:** The use of a backer plate when creating butt welds will produce a stronger and more uniform repair.

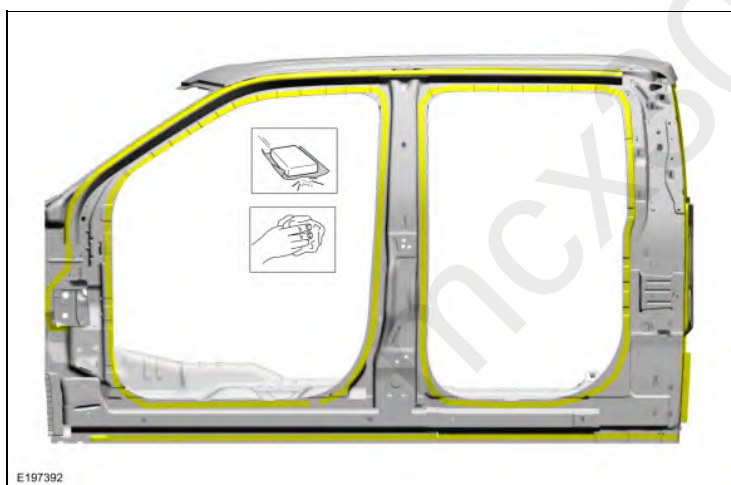
Partial panel replacement:

- Determine repair and trim service panel accordingly.
- In butt weld area(s) create a backer plate from unused portion(s) of service panel.
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
- Install backer plate to existing vehicle body panel.

- NOTE:** Pay particular attention to areas where NVH foam was applied in assembly.

80-120 grit sand paper.

Sand to remove old adhesive from all mating surfaces and clean.



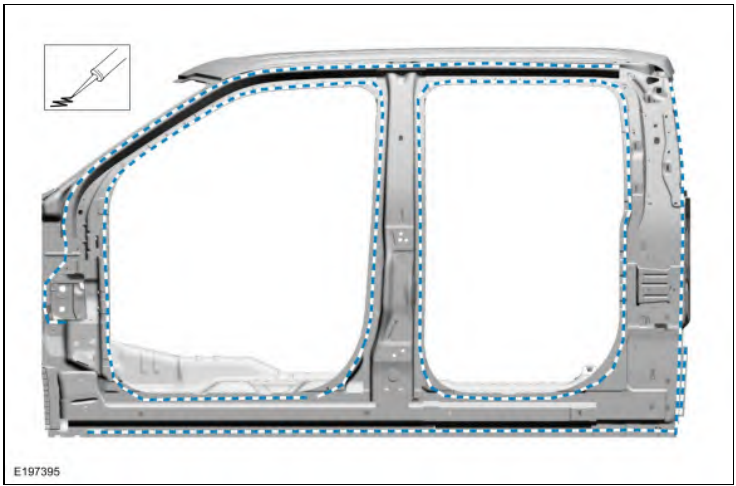
- 80-120 grit sand paper.
Sand to remove old adhesive from all mating surfaces and clean.



4. 80-120 grit sand paper.
Sand to remove e-coat from all mating surfaces and clean.



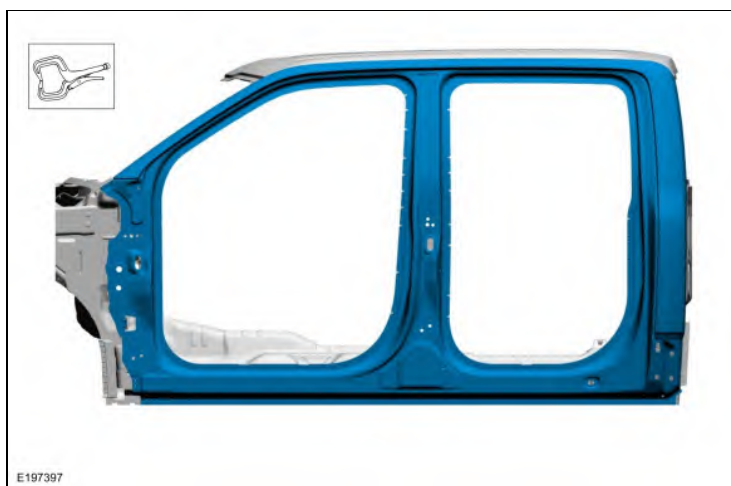
5. Apply structural adhesive as indicated.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M[®] 08115, LORD Fusor[®] 108B



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



7. Immediately install, align and clamp service panel.
Use the General Equipment: Locking Pliers



8. Partial panel replacement:

Complete joining of service panel to backer plate and weld the sectioning seam using a MIG welder set up for aluminum.

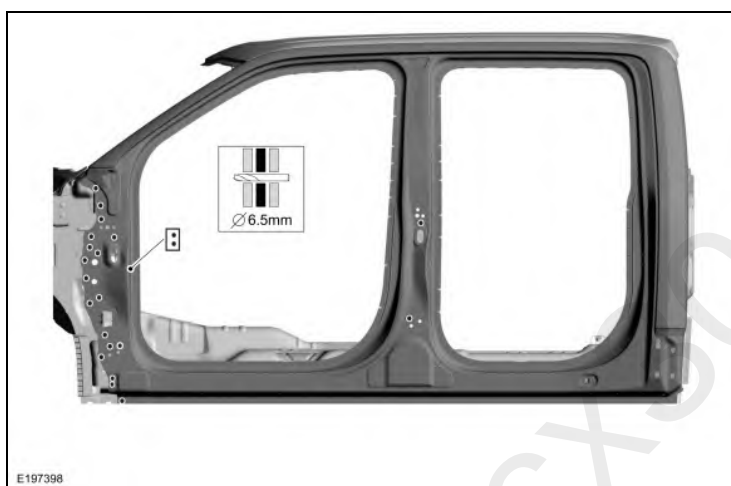
Refer to: Complete Panel Replacement/Partial Replacement (501-25 Body Repairs - General Information, Description and Operation).

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

Use the General Equipment: MIG/MAG Welding Equipment

9. Drill for fasteners.

Use the General Equipment: 6.5 mm Drill Bit



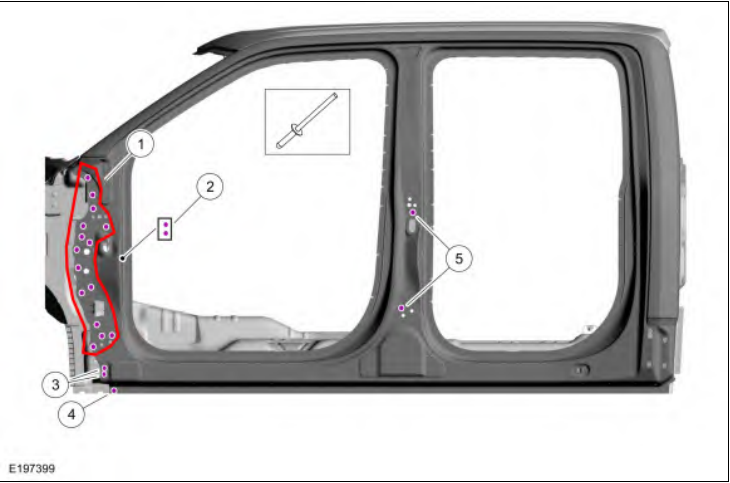
10. **NOTE:** Do not install SPR fasteners directly in old SPR fastener location. SPR fasteners must be installed adjacent to the original location matching original quantity.

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	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W707638-S900C	-	-
3	-	-	-	-	W702554-S900C	-	-
4	W710246-S900C	BN	DP10-200H	SA-0400/SA-0402	-	W790377-S900	-
5	-	-	-	-	W702512-S900C	-	-

Use the General Equipment: Blind Rivet Gun

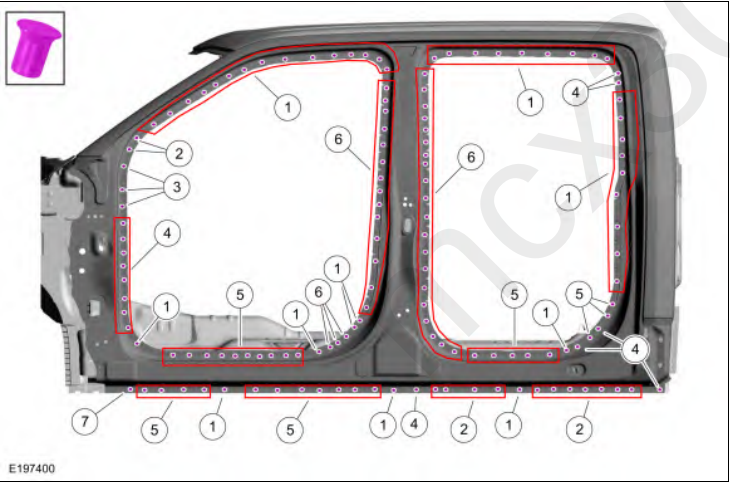


11. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

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	DP11-220/H	SA-0400/SA-0401	-	W790376-S900	-
3	W717185-S900	EL	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
4	W708717-S900-	AW-	DP11-200/H-	SA-0400/SA-0402-	-	W790377-S900-	-
5	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
6	W717184-S900	QA	DP10-200/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

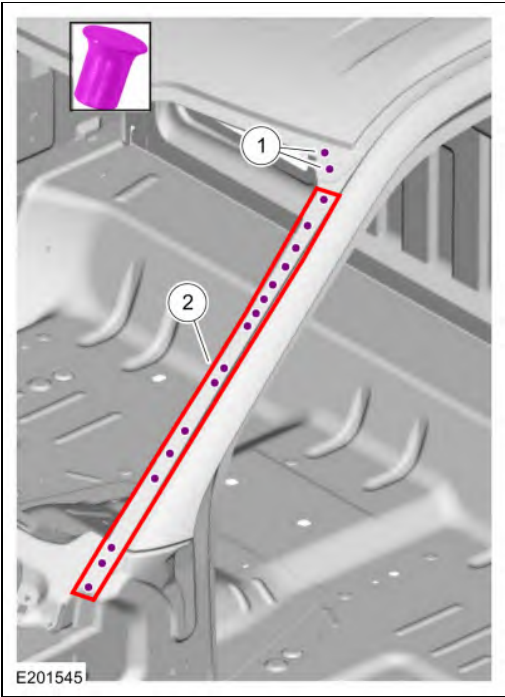


12. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

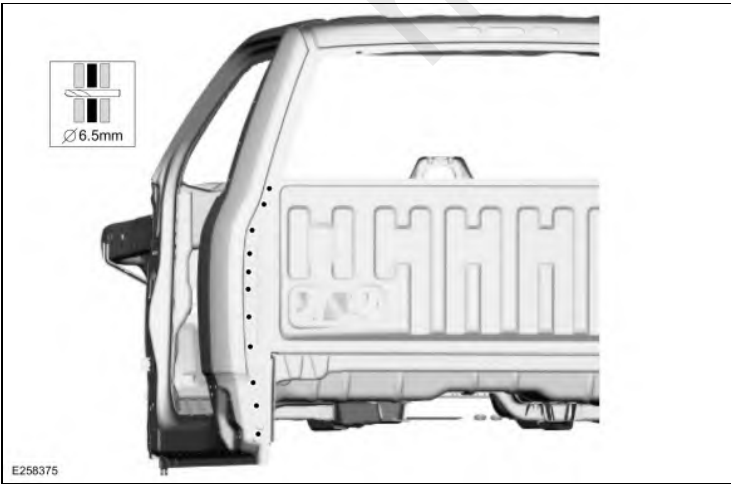
Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W708713-S900	AS	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



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



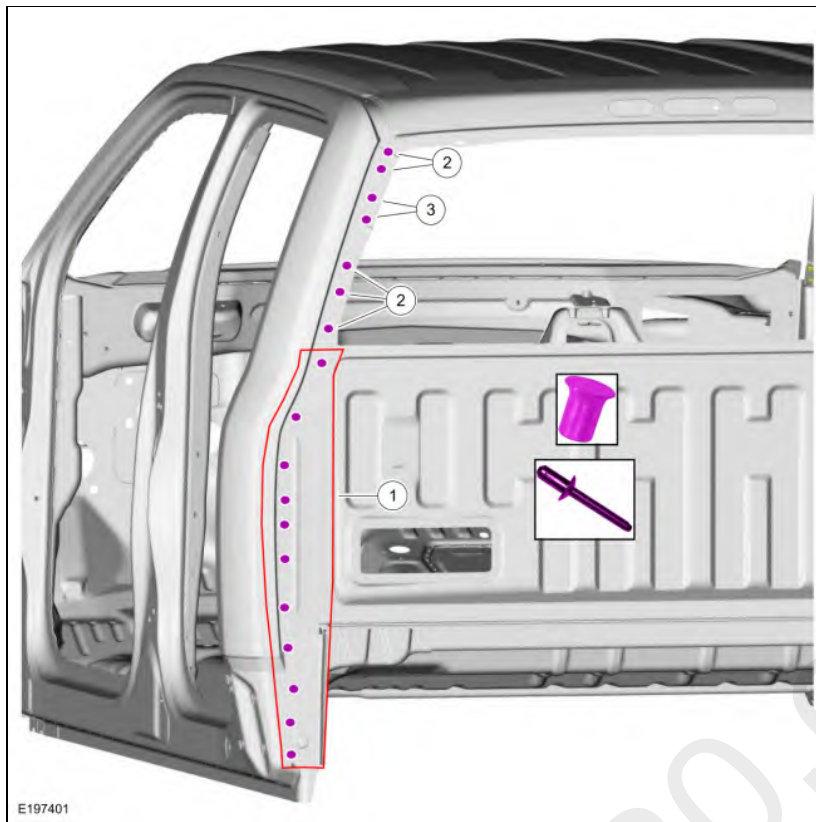
14. **NOTE:** Do not install SPR fasteners directly in old SPR fastener location. SPR fasteners must be installed adjacent to the original location matching original quantity.
- NOTE:** Solid rivets or blind rivet fasteners may be used in place of SPR fasteners after enlarging existing holes to 6.5 mm.

Install fasteners.

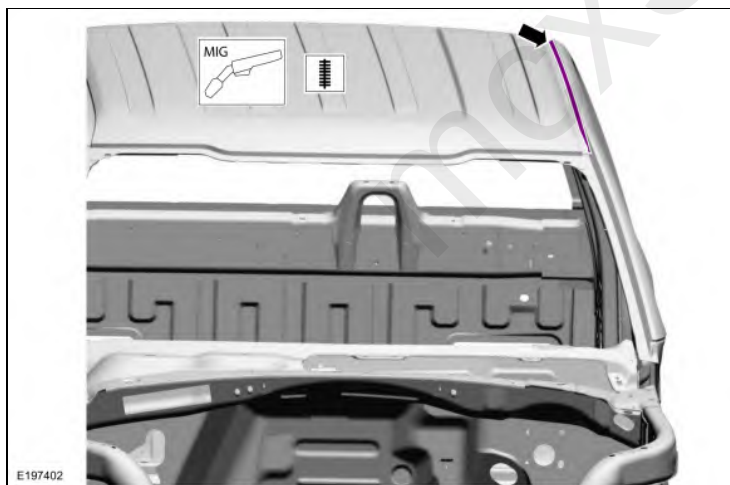
Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
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1	-	-	-	-	W708777-S900C	-	-
2	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-
3	W708717-S900	AW	DZ09-220/H	SA-0400/SA-0402	-	W790377-S900	-

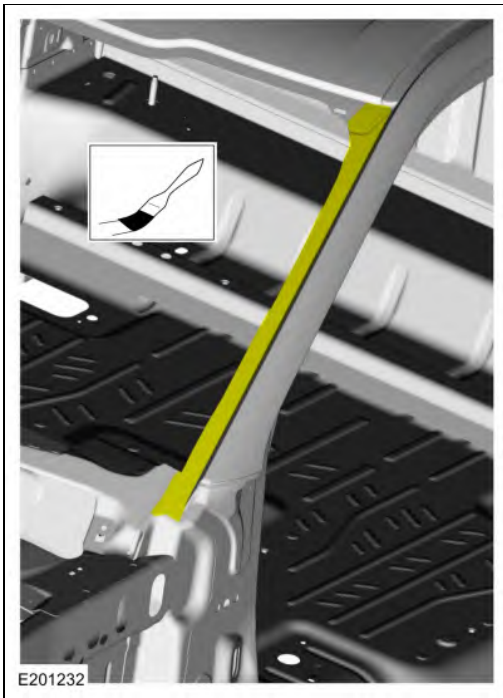
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Blind Rivet Gun



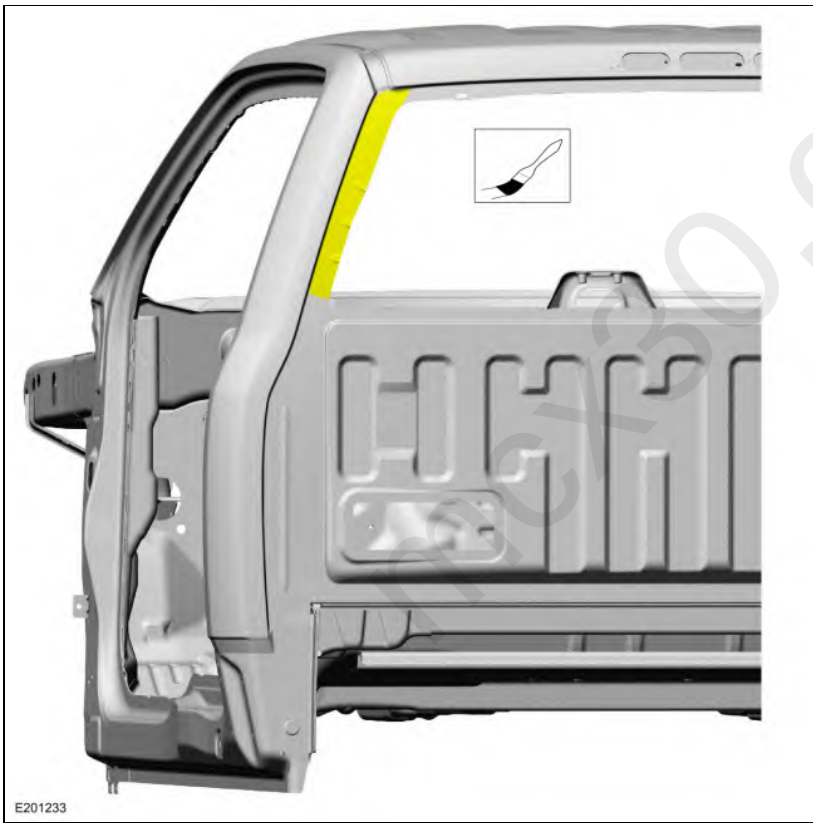
15. Using a MIG welder set up for aluminum, weld the roof seam.
 Use the General Equipment: MIG/MAG Welding Equipment



16. Metal finishing:
 Metal finish all seams using typical aluminum metal finishing techniques.
 Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).
17. Sand and prime the windshield opening channel using an Ford approved epoxy-based primer and allow to dry.



18. Sand and prime the rear window glass opening channel using an Ford approved epoxy-based primer and allow to dry.



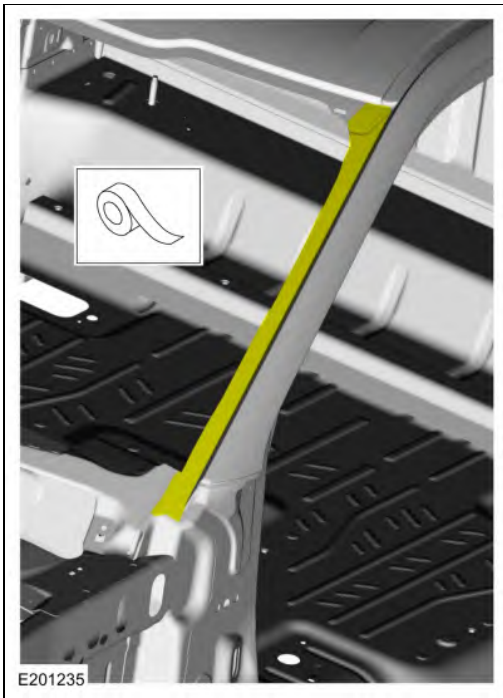
19. Mask the rear window opening channel.



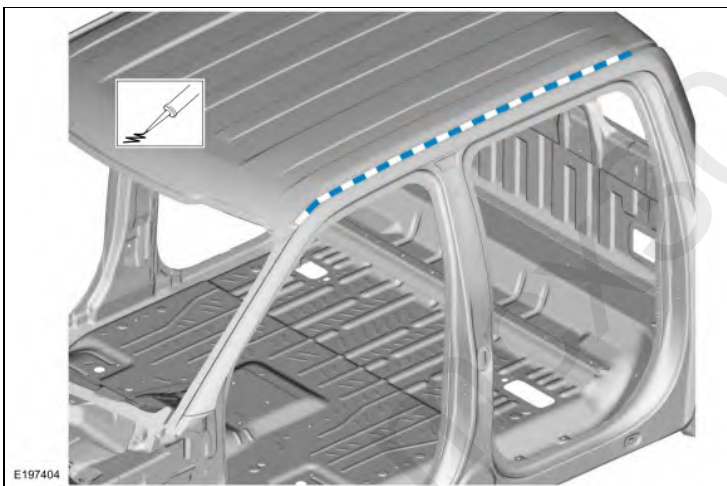
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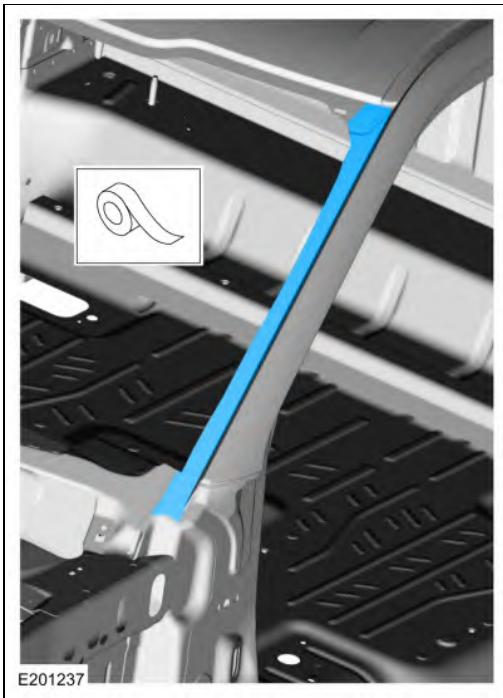
20. Mask the windshield opening channel.



21. Sand and prime the entire repair using a Ford approved paint system.
22. Apply NVH foam in all areas noted during removal.
Material: Flexible Foam Repair / 3M[®], 08463, LORD Fusor[®] 121
23. Apply roof ditch sealer.
Material: Roof Ditch Sealer / 3M[®], 08307, LORD Fusor[®] 122EZ



24. **Seam Sealing:** All seams must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M[®], 08308, LORD Fusor[®] 805DTM
25. Refinish the entire repair area using a Ford approved paint system and typical refinishing techniques.
26. Unmask the windshield opening channel.



27. Unmask the rear window glass opening channel.

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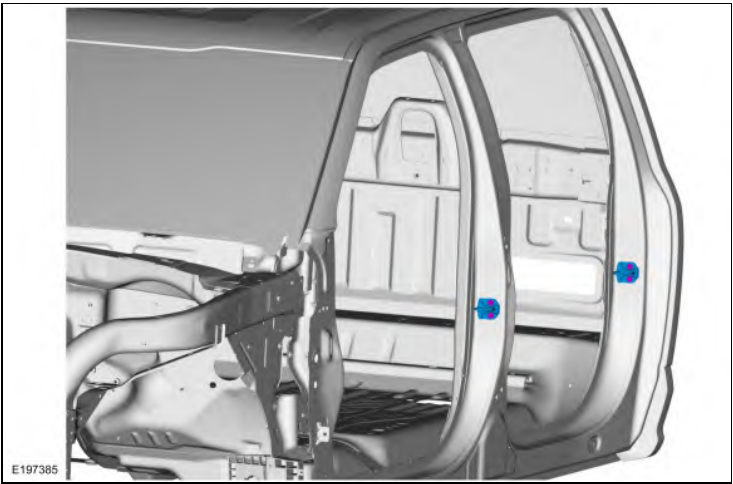


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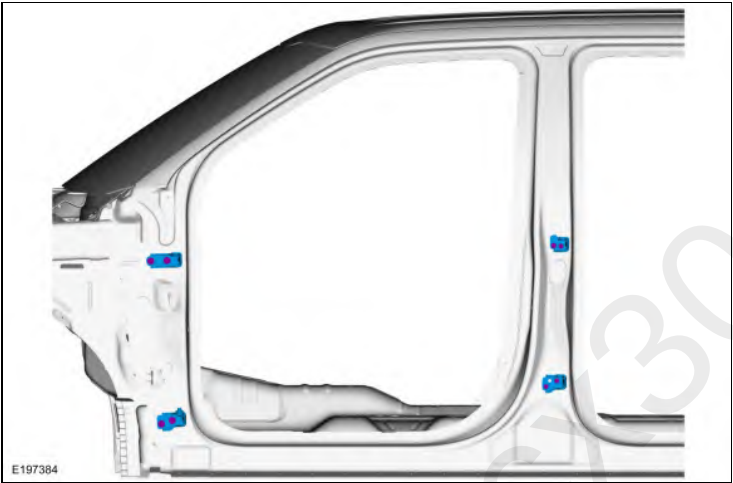


28. Install the side curtain air bag.
Refer to: Side Curtain Airbag - Crew Cab (501-20B Supplemental Restraint System, Removal and Installation).
29. Install the windshield and rear window.
Refer to: Fixed Glass (501-11 Glass, Frames and Mechanisms, General Procedures).
30. Install the roof moulding and cab corner 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).
31. Install the door opening weather-strips.
32. Install the A-pillar, B-pillar and C-pillar trim panels.
Refer to: A-Pillar Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: B-Pillar Trim Panel - Crew Cab (501-05 Interior Trim and Ornamentation, Removal and Installation).
Refer to: C-Pillar Trim Panel (501-05 Interior Trim and Ornamentation, Removal and Installation).
33. Install the front and rear door scuff plates.

34. Install the front and rear door strikers.
Torque: 18 lb.ft (25 Nm)



35. Install the front and rear door hinges to the body.
- Front door.
Torque: 20 lb.ft (27 Nm)
 - Rear door.
Torque: 22 lb.ft (30 Nm)



36. Install the front fender.
Refer to: Fender (501-02 Front End Body Panels, Removal and Installation).
37. Align the doors.
Refer to: Front Door Alignment - Crew Cab/Regular Cab (501-03 Body Closures, General Procedures).
Refer to: Rear Door Alignment - Crew Cab (501-03 Body Closures, General Procedures).
38. If equipped:
Install the pickup bed.
Refer to: Pickup Bed (501-04 Pickup Bed and Platform Body, Removal and Installation).
39. Repower the SRS.
Refer to: Supplemental Restraint System (SRS) Repowering (501-20B Supplemental Restraint System, General Procedures).

