

Floor Panel

Special Tool(s) / General Equipment

6.5 mm Drill Bit
11 mm Drill Bit
Scraper for Straight Edges
Polydrive Bit Socket
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Hot Air Gun
Locking Pliers

Materials

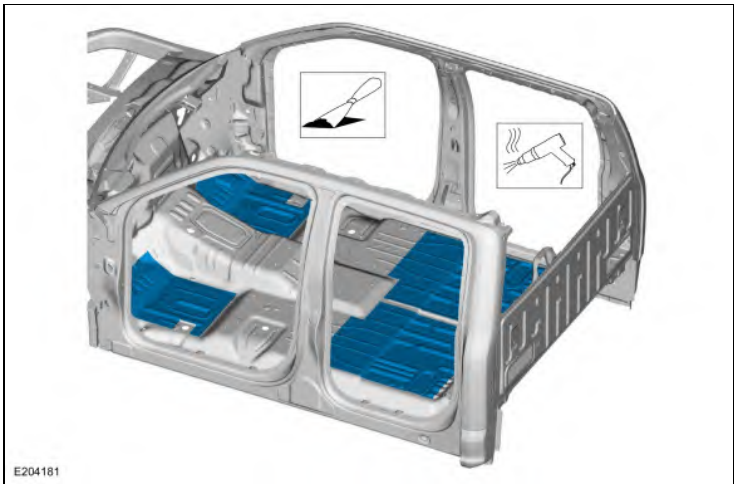
Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M [®] , 08115, LORD Fusor [®] 108B	-
Seam Sealer TA-2-B, 3M [®] , 08308, LORD Fusor [®] 805DTM	-

Removal

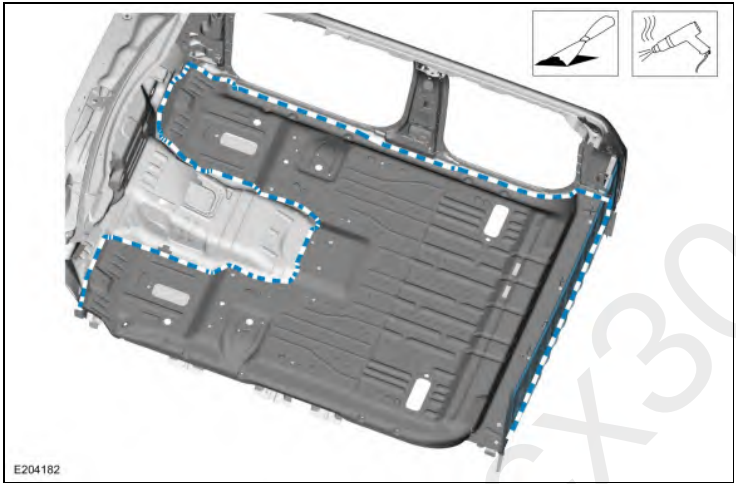
NOTE: Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs 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: Crew Cab shown, Regular cab and SuperCab similar.

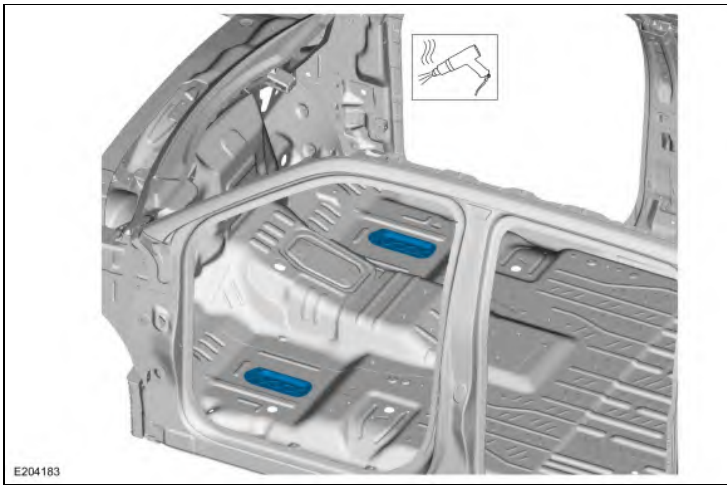
1. Depower the SRS.
Refer to: Supplemental Restraint System (SRS) Depowering (501-20B Supplemental Restraint System, General Procedures).
2. Remove the seats.
Refer to: Front Seat Track (501-10A Front Seats, Removal and Installation).
3. Remove the console (if equipped).
Refer to: Floor Console (501-12 Instrument Panel and Console, Removal and Installation).
4. Remove the carpeting and position the wiring harnesses away from the working area.
5. Remove the rocker panel.
Refer to: Rocker Panel - Regular Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
Refer to: Rocker Panel - Super Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
Refer to: Rocker Panel - Crew Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
6. Remove the NVH pads.
Use the General Equipment: Scraper for Straight Edges
Use the General Equipment: Hot Air Gun



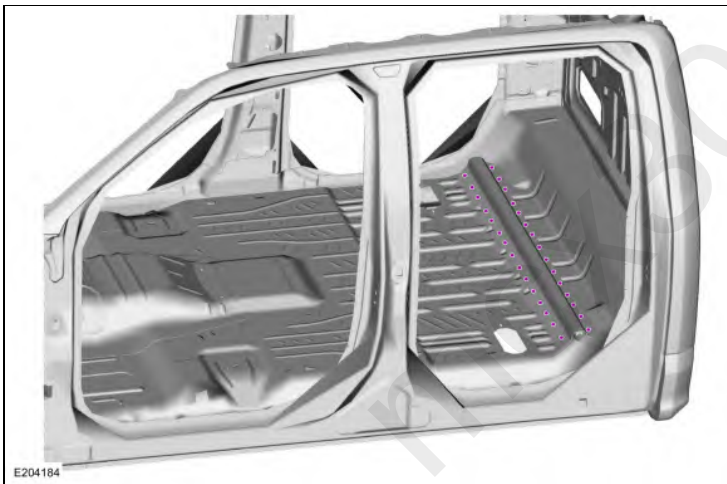
7. Remove the seam sealer.
Use the General Equipment: Scraper for Straight Edges
Use the General Equipment: Hot Air Gun



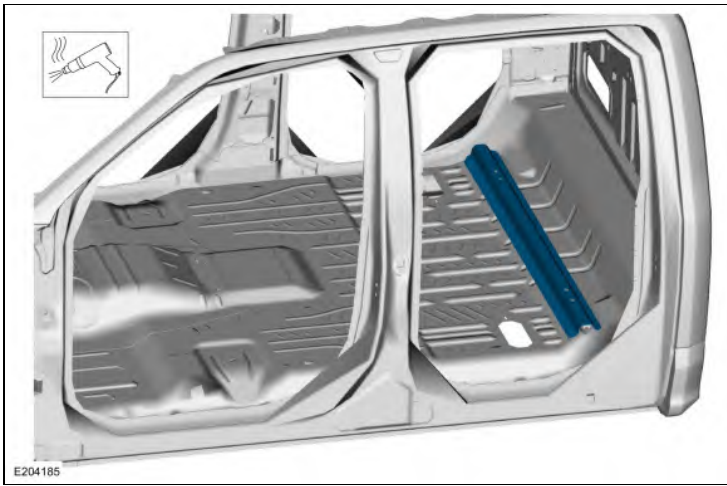
8. Remove the floor inspection covers.
Use the General Equipment: Hot Air Gun



9. SuperCab and Crew Cab only.
 Remove the rear seat brace SPR fasteners.
 Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Belt Sander



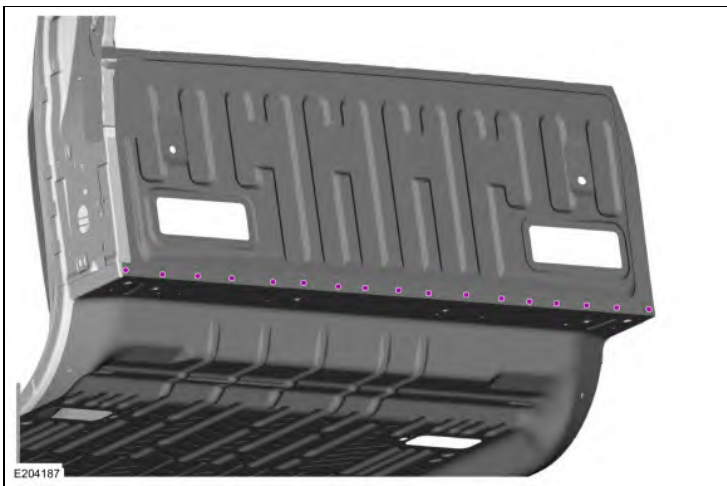
10. SuperCab and Crew Cab only
 Break the adhesive bond and remove the rear seat brace.
 Use the General Equipment: Hot Air Gun



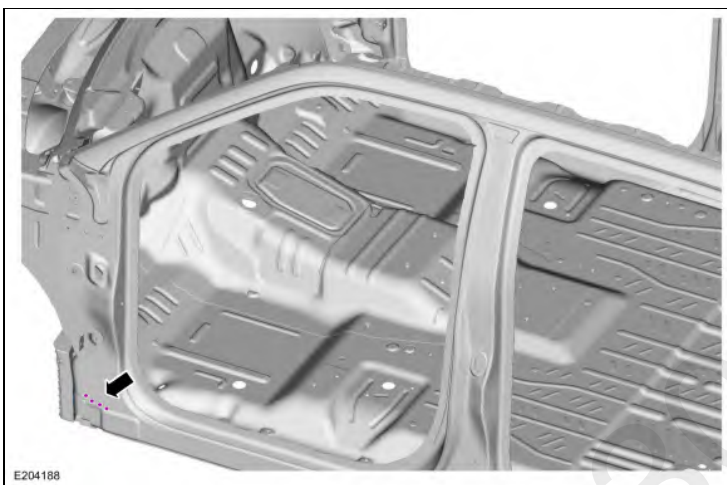
11. Remove the floor panel SPR fasteners.
 Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Belt Sander



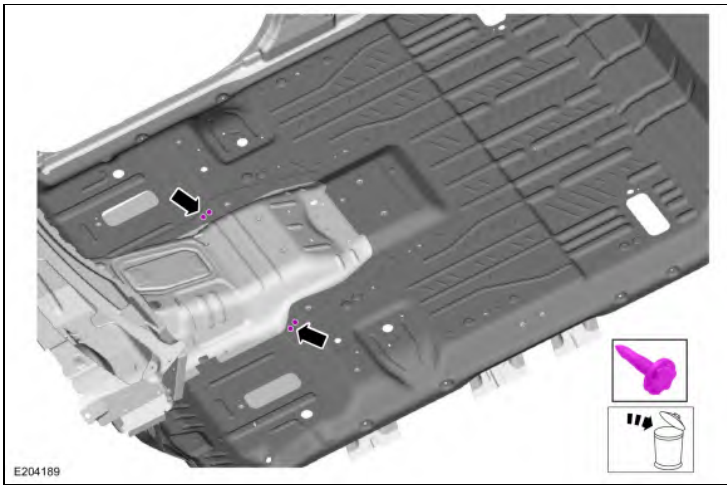
12. Remove the cab back to floor panel SPR fasteners.
 Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Belt Sander



13. On both sides.
 Remove the floor panel to A-pillar SPR fasteners
 Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Belt Sander

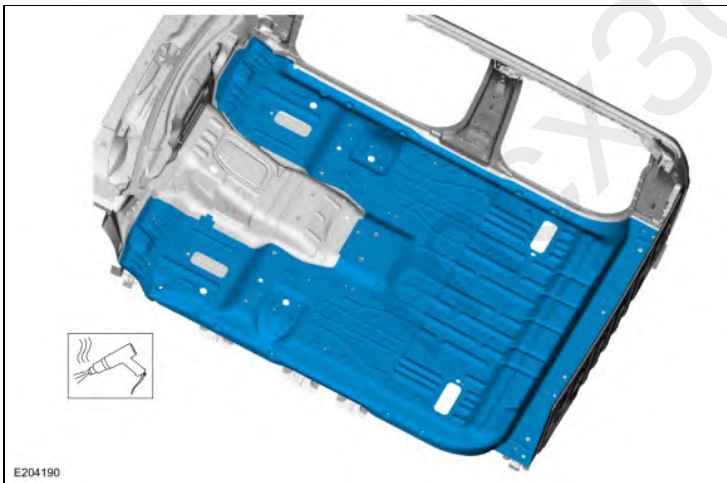


14. Remove and discard the FDS fasteners.
 Use the General Equipment: Polydrive Bit Socket



15. **NOTE:** Body side removed for clarity.

Break the adhesive bond and remove the floor panel assembly.
Use the General Equipment: Hot Air Gun



Installation

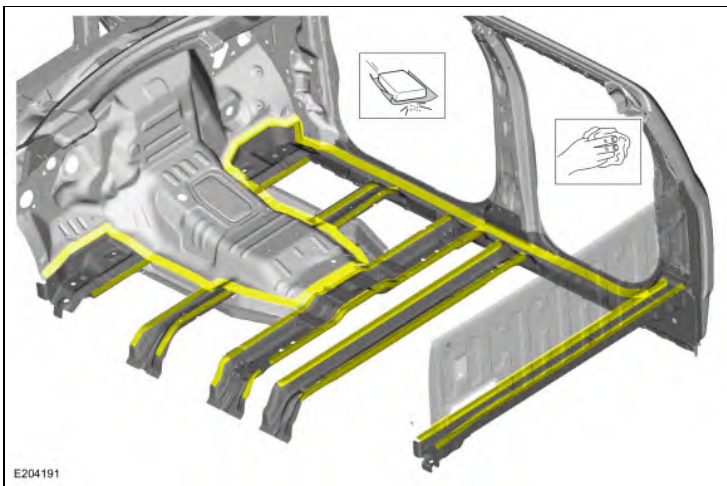
NOTE: Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425.4° F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

NOTE: Crew Cab shown, Regular cab and SuperCab similar.

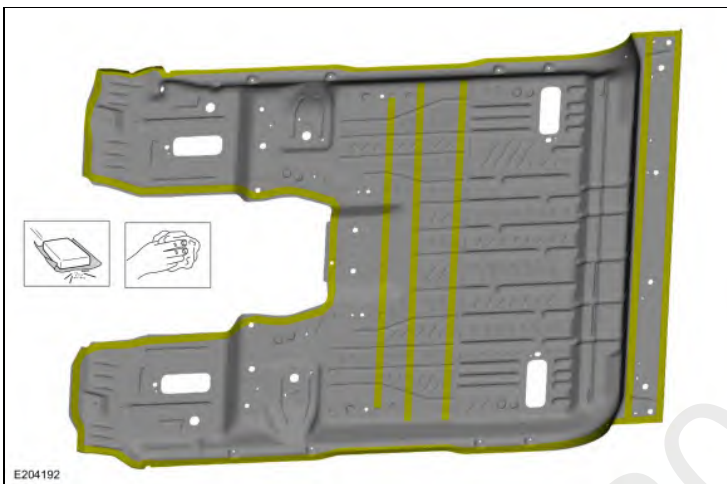
NOTE: SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

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

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



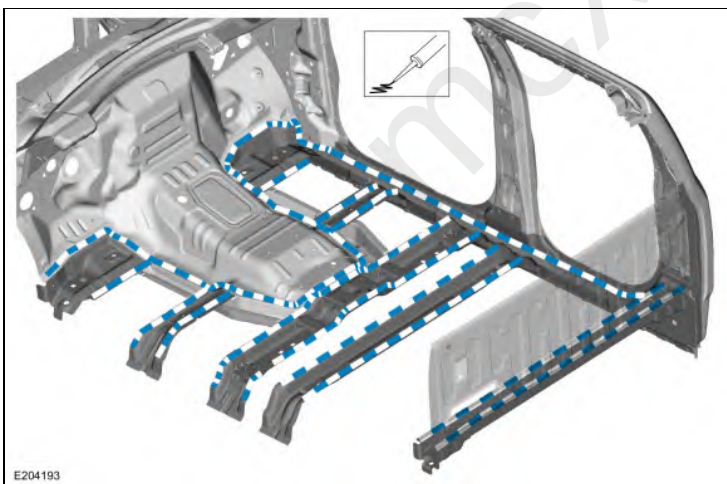
2. 80-120 grit sand paper.
Sand to remove e-coat and clean.



3. **NOTE:** Body side removed for clarity.

Apply adhesive.

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

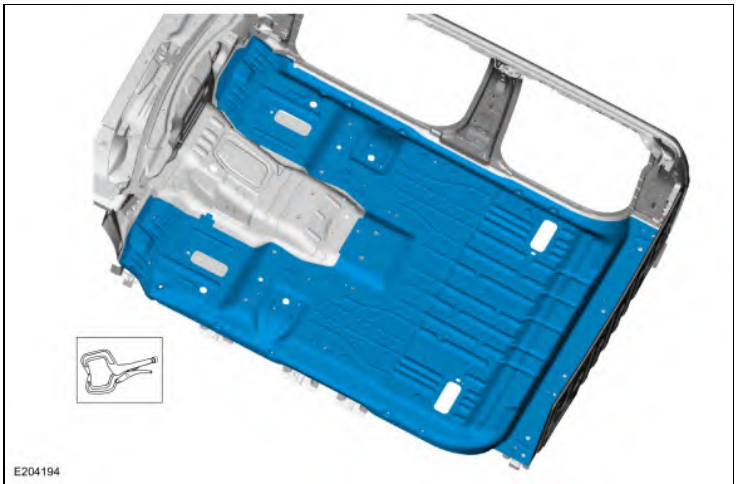


4. **NOTE:** Body side removed for clarity.

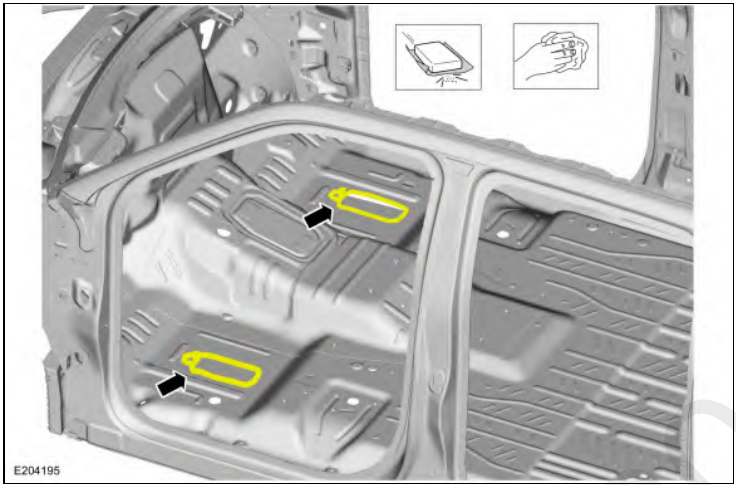
Install and clamp in position.

Use the General Equipment: Locking Pliers

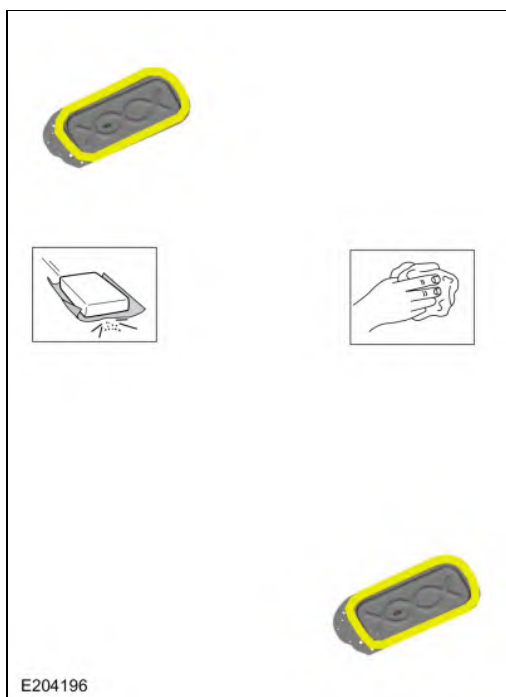




5. 80-120 grit sand paper.
Sand to remove e-coat and clean.



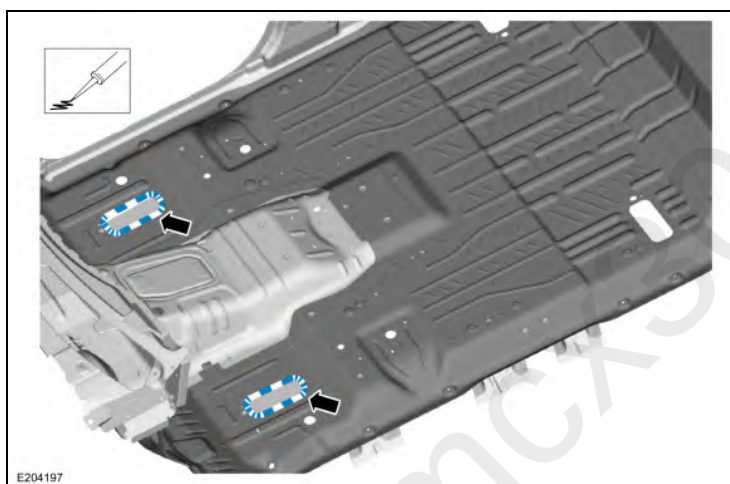
6. 80-120 grit sand paper.
Sand to remove e-coat and clean.



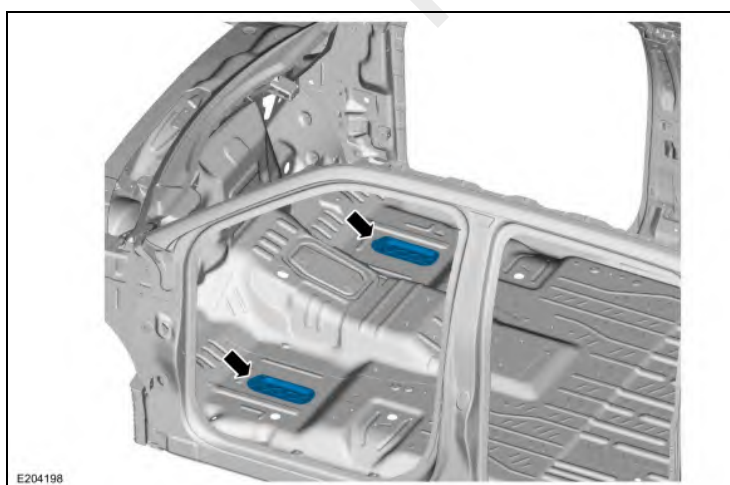
7. **NOTE:** Body side removed for clarity.

Apply adhesive.

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



8. Install the floor panel inspection covers.



9. **NOTE:** Body side removed for clarity.

Drill for fasteners installation.

Use the General Equipment: 6.5 mm Drill Bit

Use the General Equipment: 11 mm Drill Bit

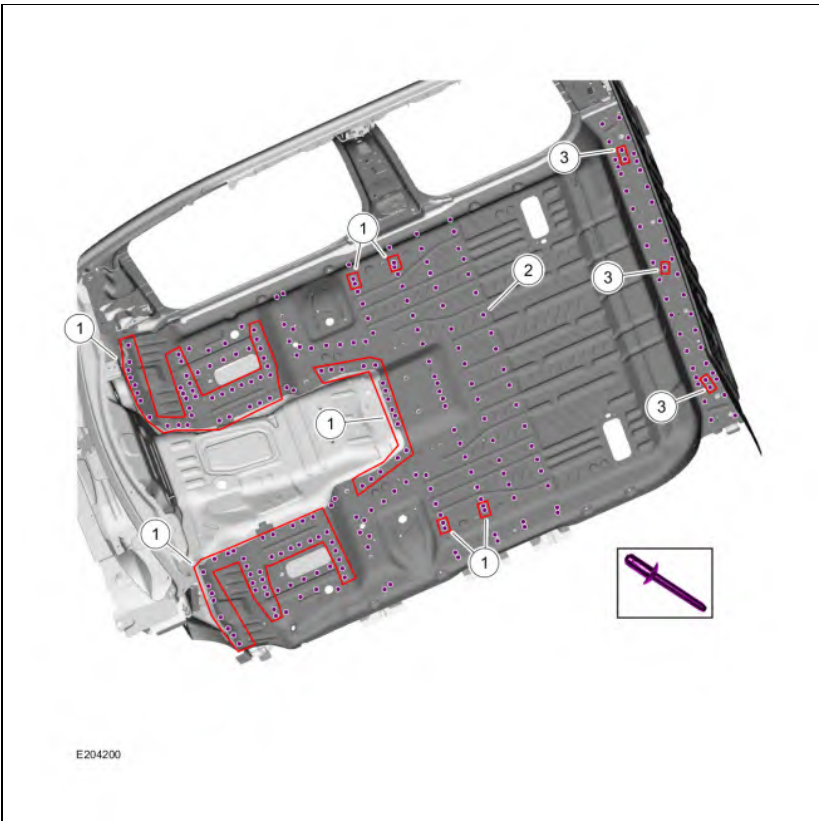


10. **NOTE:** *Body side removed for clarity.*

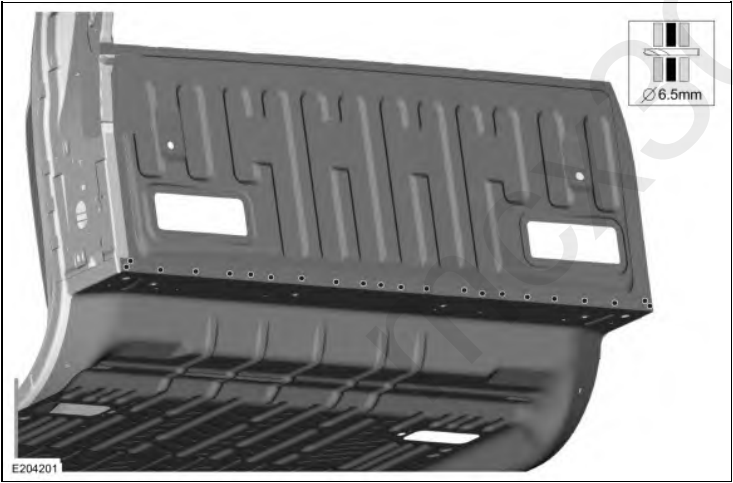
Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W702512-S900C	-	-
3	-	-	-	-	-		W718619-S450 (M8)

Use the General Equipment: Blind Rivet Gun



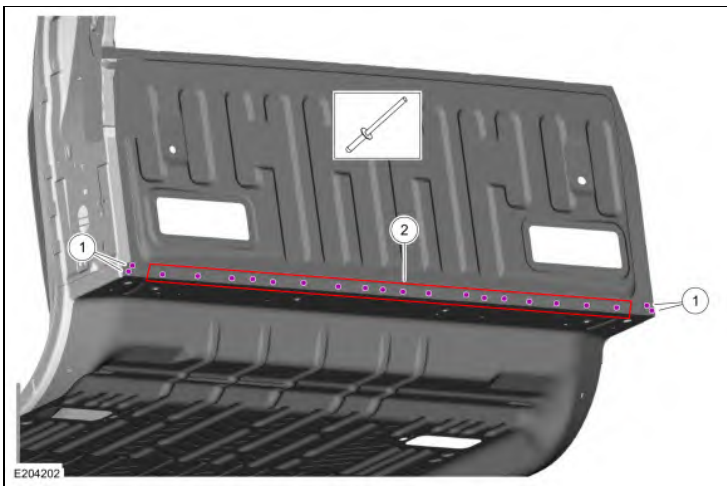
11. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



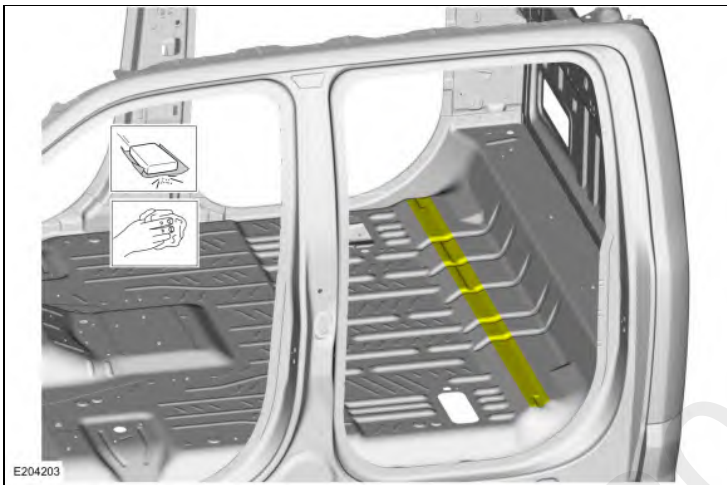
12. Install blind rivet fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W702512-S900C	-	-
2	-	-	-	-	W707638-S900C	-	-

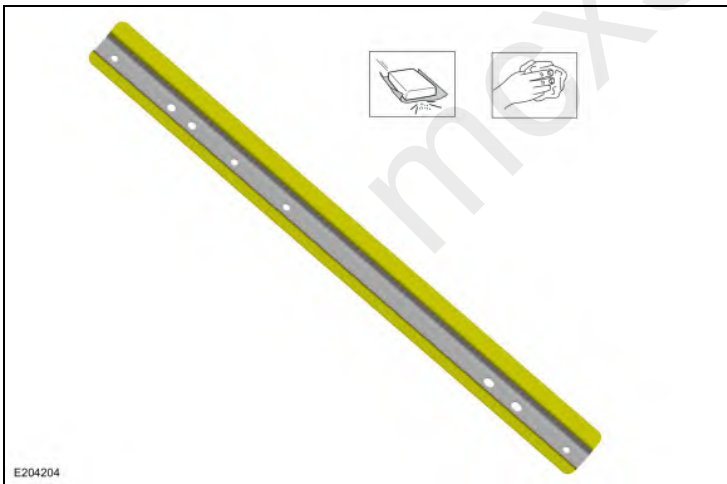
Use the General Equipment: Blind Rivet Gun



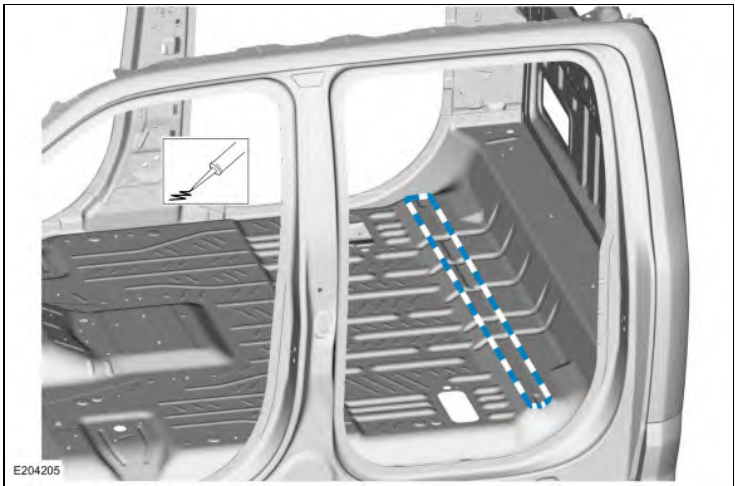
13. 80-120 grit sand paper (SuperCab and Crew Cab only).
Sand to remove e-coat and clean.



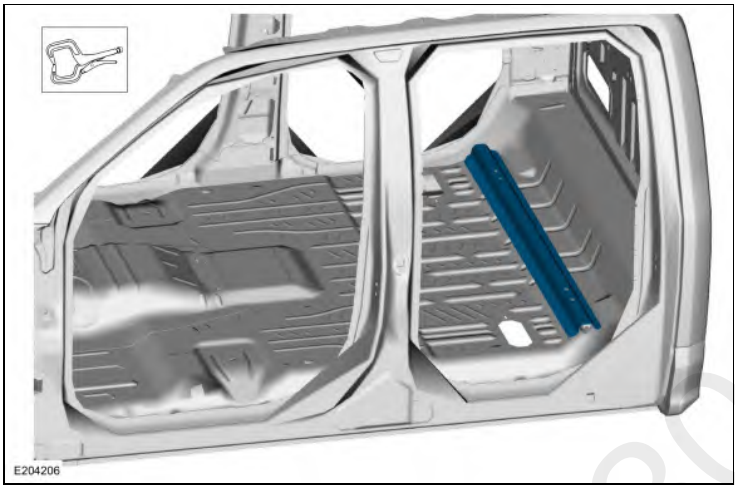
14. 80-120 grit sand paper (SuperCab and Crew Cab only).
Sand to remove e-coat and clean.



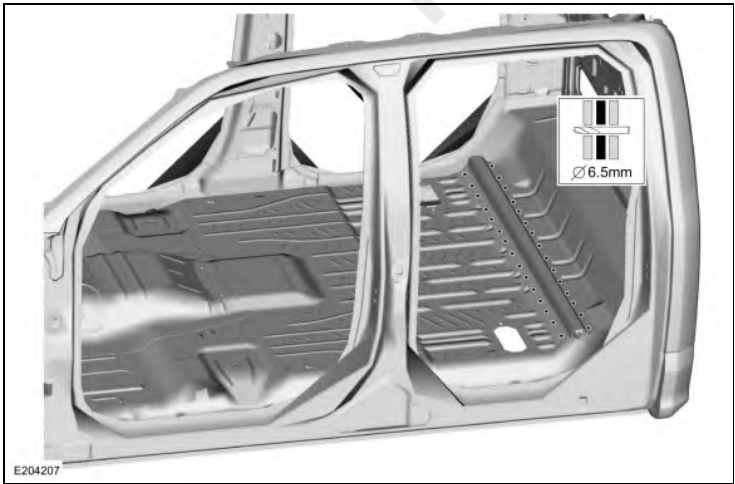
15. SuperCab and Crew Cab only.
Apply adhesive.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M[®] 08115, LORD Fusor[®] 108B



16. SuperCab and Crew Cab only.
Install the rear seat brace and clamp in position.
Use the General Equipment: Locking Pliers



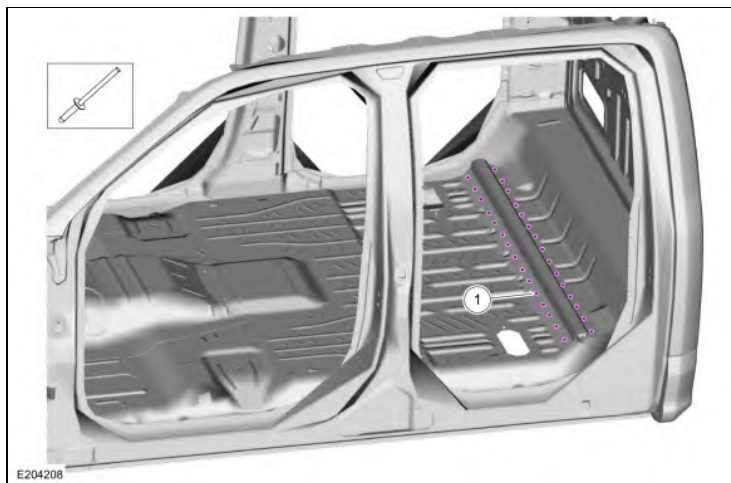
17. SuperCab and Crew Cab only.
Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



18. SuperCab and Crew Cab only.
Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	-	-

Use the General Equipment: Blind Rivet Gun



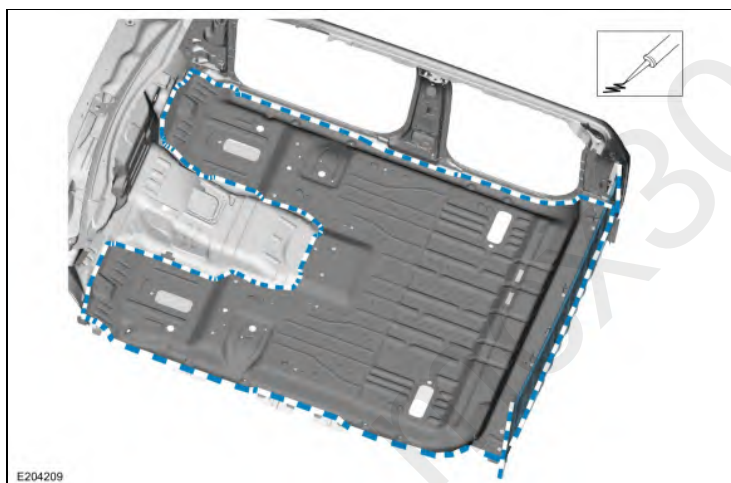
19. Install the rocker panel.
Refer to: Rocker Panel - Regular Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
Refer to: Rocker Panel - Super Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
Refer to: Rocker Panel - Crew Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

20. **NOTE:** Body side removed for clarity.

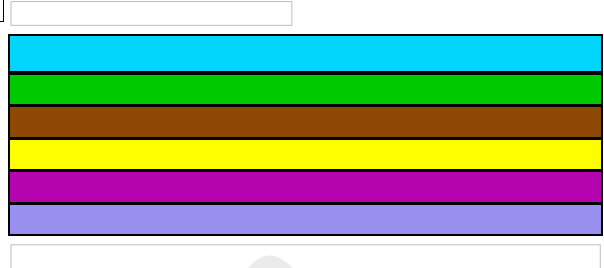
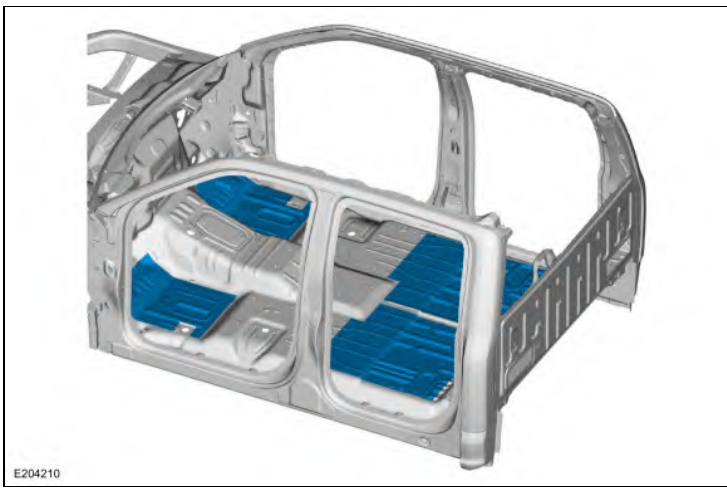
Seam Sealing:

All seams must be sealed to production level.

Material: Seam Sealer / TA-2-B, 3M[®], 08308, LORD Fusor[®] 805DTM



21. Install NVH pads.



22. Refinish the entire repair using a Ford approved paint system and typical refinishing techniques.
23. Reposition the wiring harnesses and install the carpeting.
24. Restore corrosion protection.
Refer to: Corrosion Prevention (501-25 Body Repairs - General Information, General Procedures).
25. Install the console (if equipped).
Refer to: Floor Console (501-12 Instrument Panel and Console, Removal and Installation).
26. Install the seats.
Refer to: Front Seat Track (501-10A Front Seats, Removal and Installation).
27. Repower the SRS.
Refer to: Supplemental Restraint System (SRS) Repowering (501-20B Supplemental Restraint System, General Procedures).