

Floor Panel Reinforcement

Special Tool(s) / General Equipment

6.5 mm Drill Bit
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	-

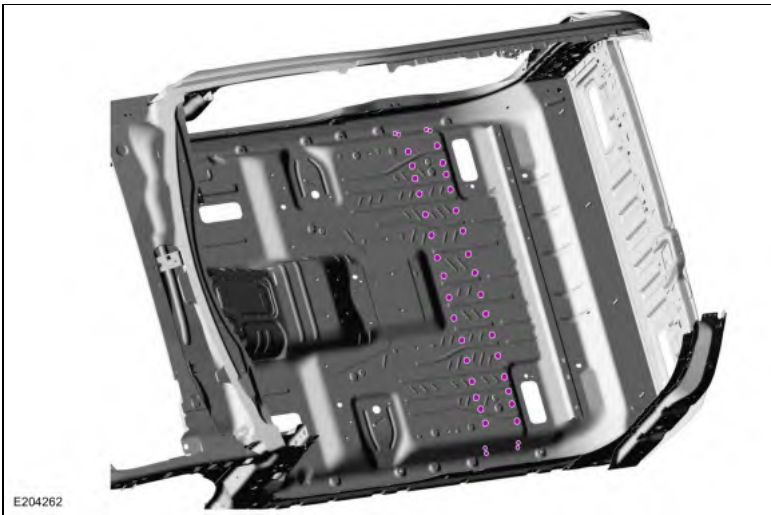
Removal

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 425A° F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

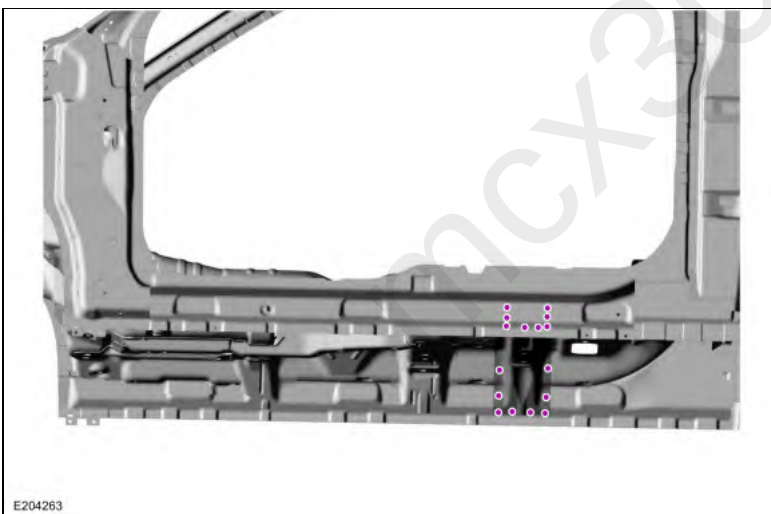
NOTE: SuperCab #3 floor panel reinforcement shown. All reinforcements attach similarly.

1. Remove the floor panel section in the repair area.
Refer to: Floor Panel Section (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
2. Remove the rocker panel inner reinforcement.
Refer to: Rocker Panel Inner Reinforcement - Regular Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
Refer to: Rocker Panel Inner Reinforcement - Super Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
Refer to: Rocker Panel Inner Reinforcement - Crew Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
3. **NOTE:** Floor panel reinforcements may be sectioned providing sectioning does not take place within 50 mm of weld nut or component mounting points. The following procedure assumes full component replacement.

Determine is sectioning is possible and reasonable and adjust procedure accordingly.
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
4. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander

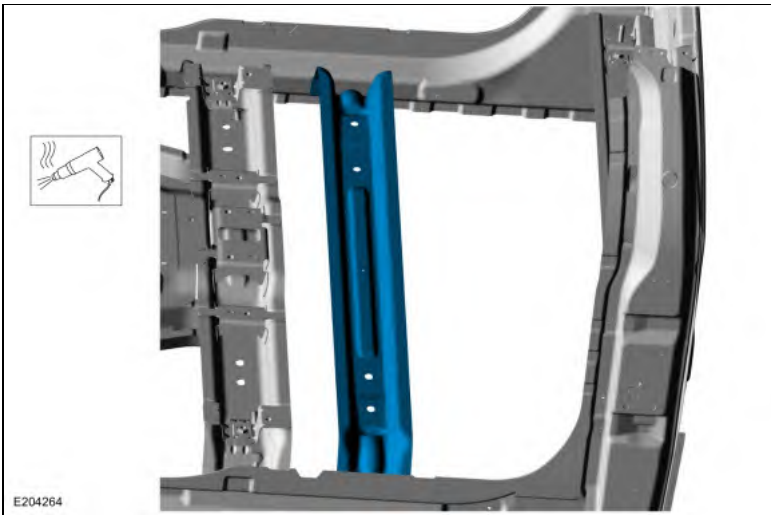


5. On both sides.
Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



6. **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.

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

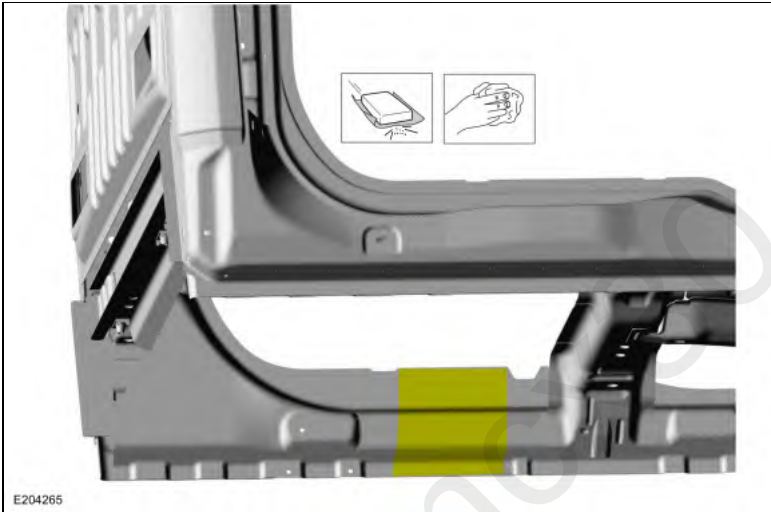


Installation

NOTE: Floor panel reinforcements may be sectioned providing sectioning does not take place within 50 mm of weld nut or component mounting points. The following procedure assumes full component replacement.

NOTE: SuperCab #3 floor panel reinforcement shown. All reinforcements attach similarly.

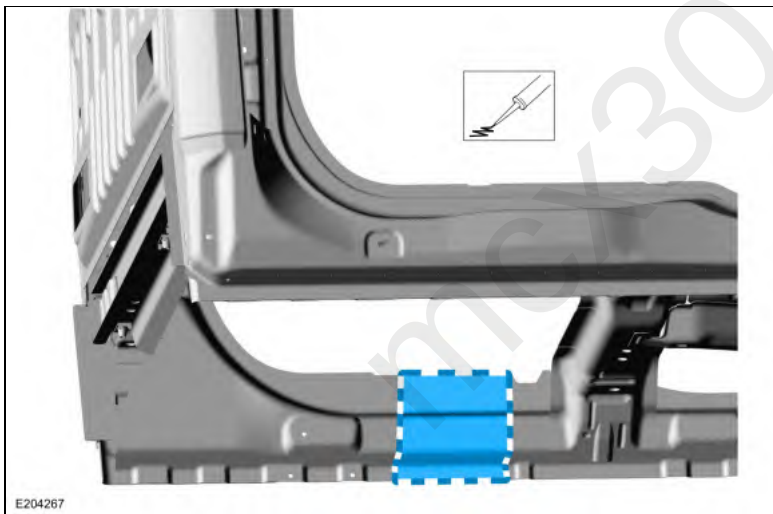
1. 80-120 grit sand paper. On both sides.
Sand to remove old adhesive and clean.



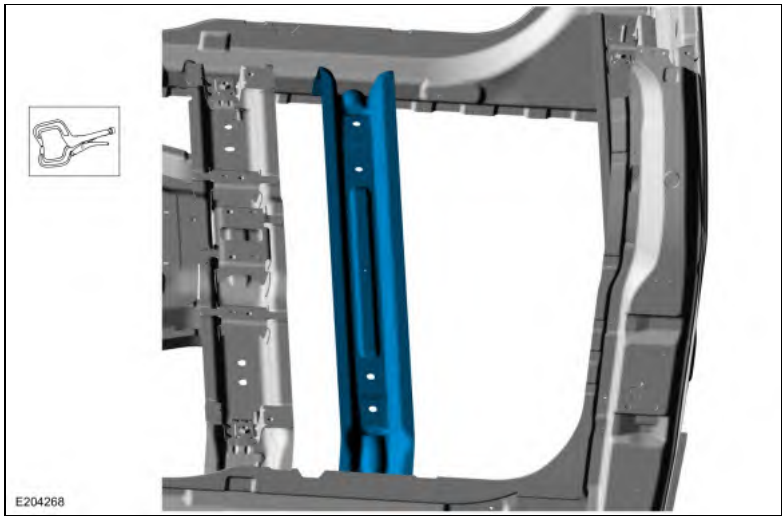
2. 80-120 grit sand paper.
Sand to remove e-coat and clean.



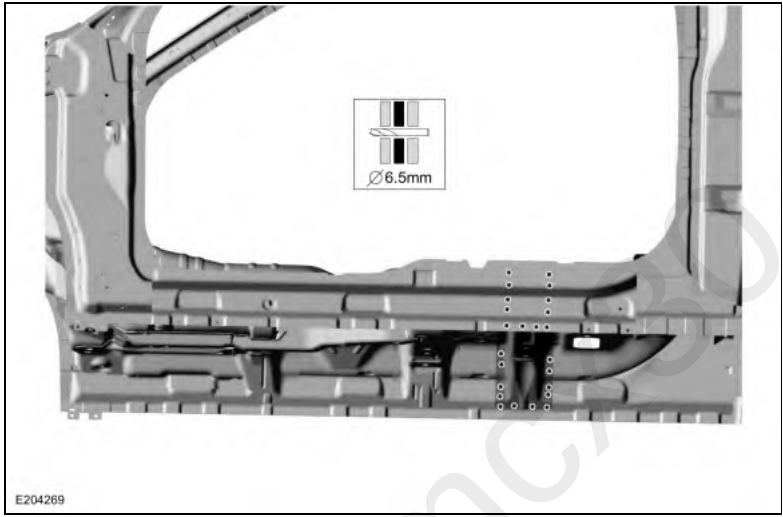
3. If sectioning:
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
4. On both sides.
Apply adhesive.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M, 08115, LORD Fusor® 108B



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



6. Both sides:
 Drill for fastener installation.
 Use the General Equipment: 6.5 mm Drill Bit

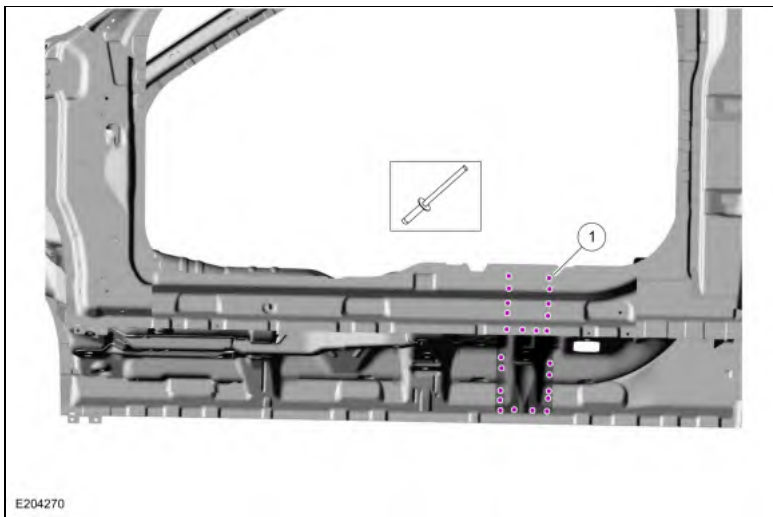


7. **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.
- NOTE:** Blind rivet or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

On both sides.
 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



8. Install the rocker panel inner reinforcement.
 Refer to: Rocker Panel Inner Reinforcement - Regular Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
 Refer to: Rocker Panel Inner Reinforcement - Super Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
 Refer to: Rocker Panel Inner Reinforcement - Crew Cab (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
9. Install the floor panel section.
 Refer to: Floor Panel Section (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

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