

Pickup Box Corner Reinforcement

Special Tool(s) / General Equipment

6.5 mm Drill Bit
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
MIG/MAG Welding Equipment
Locking Pliers

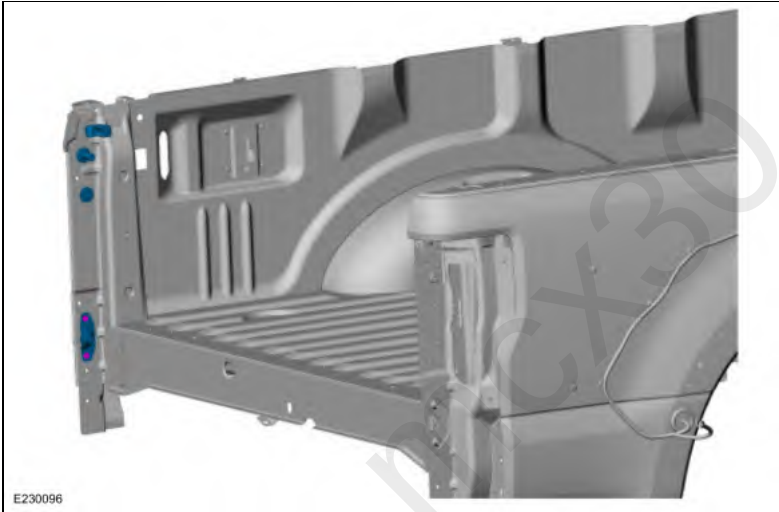
Removal

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

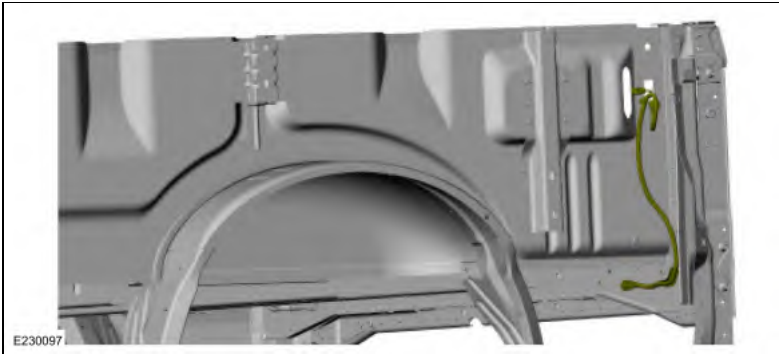
NOTE: 8.0 foot pickup box with dual rear wheels shown, all others similar.

NOTE: LHside shown, RH side similar.

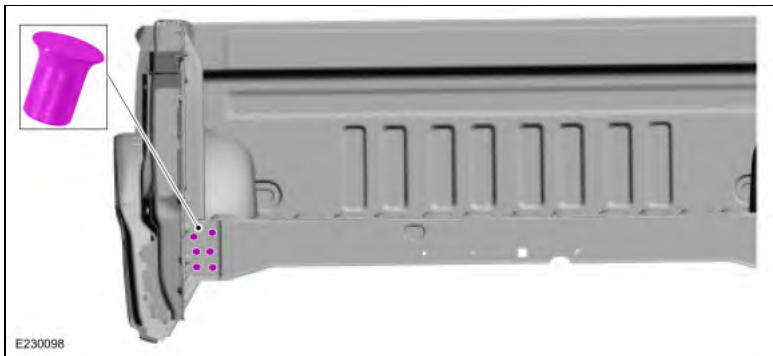
1. Remove the pickup box outer side panel.
Refer to: Pickup Box Outer Side Panel (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
2. Remove the tailgate hinge, tailgate tether bolt, tailgate striker and tailgate bumper.



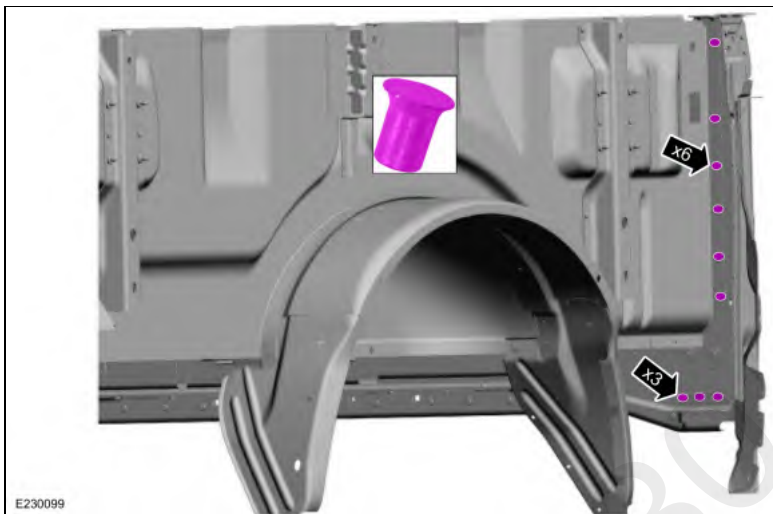
3. Position aside the tail lamp wiring harness.



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



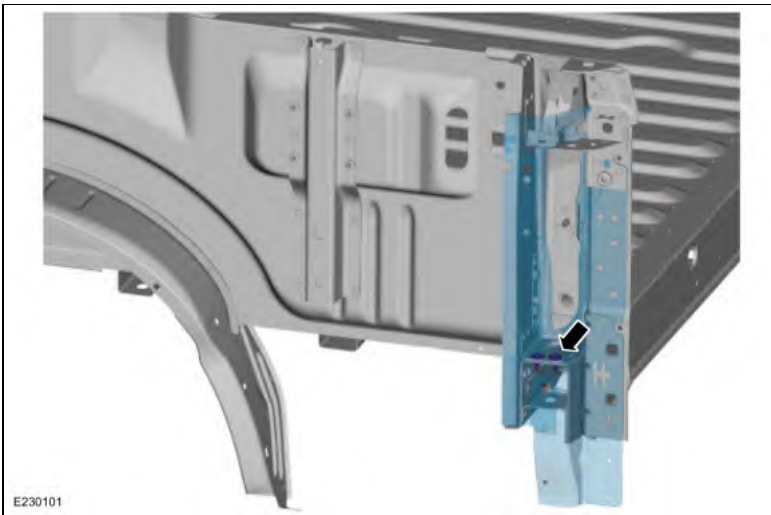
5. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



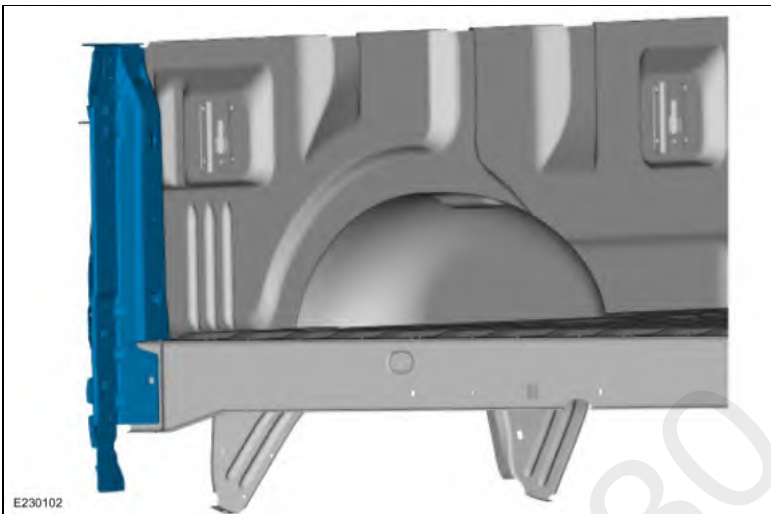
6. Remove the bolts.



7. Remove the bolts.



8. Remove the pickup box corner reinforcement



Installation

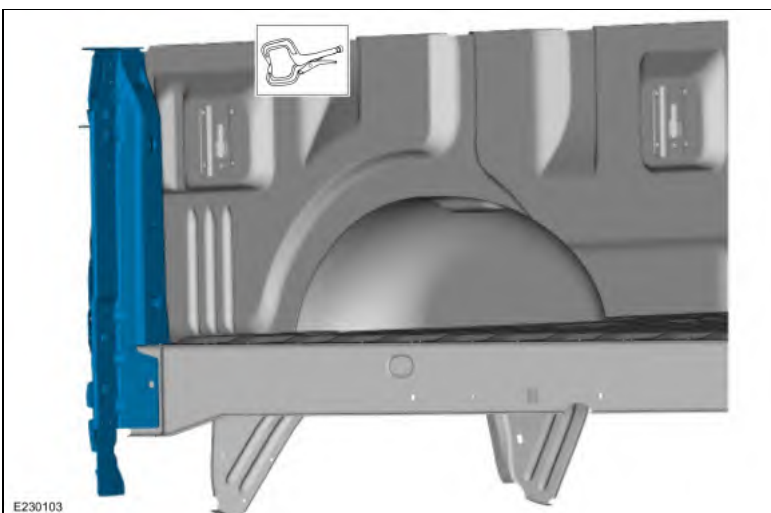
NOTE: SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

NOTE: Blind or solid rivet fasteners or MIG plug welds may be used in place of SPR fasteners if cosmetically correct after enlarging holes to 6.5 mm.

NOTE: 8.0 foot pickup box with dual rear wheels shown, all others similar.

NOTE: LH side shown, RH side similar.

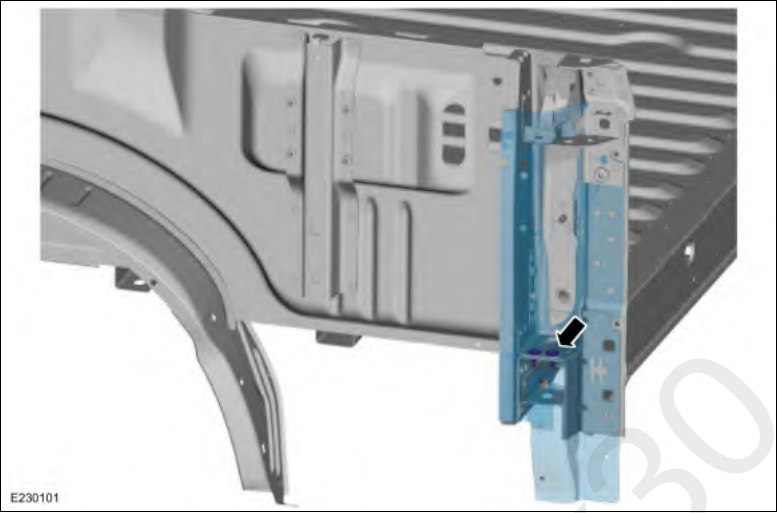
1. Install the pickup box corner reinforcement, properly position and securely clamp.
Use the General Equipment: Locking Pliers



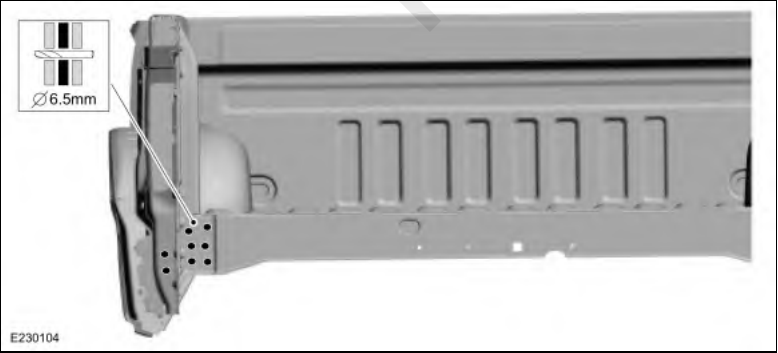
2. Install the bolts.
Torque: 106 lb.in (12 Nm)



3. Install the bolts.
Torque: 106 lb.in (12 Nm)



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



5. Install fasteners or MIG plug welds.

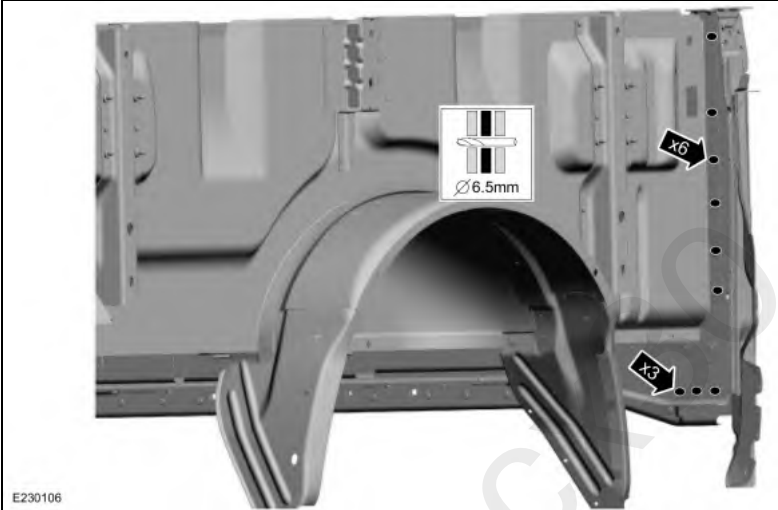
Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708778-S900C	-	-

Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).

Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).
Use the General Equipment: Blind Rivet Gun
Use the General Equipment: MIG/MAG Welding Equipment



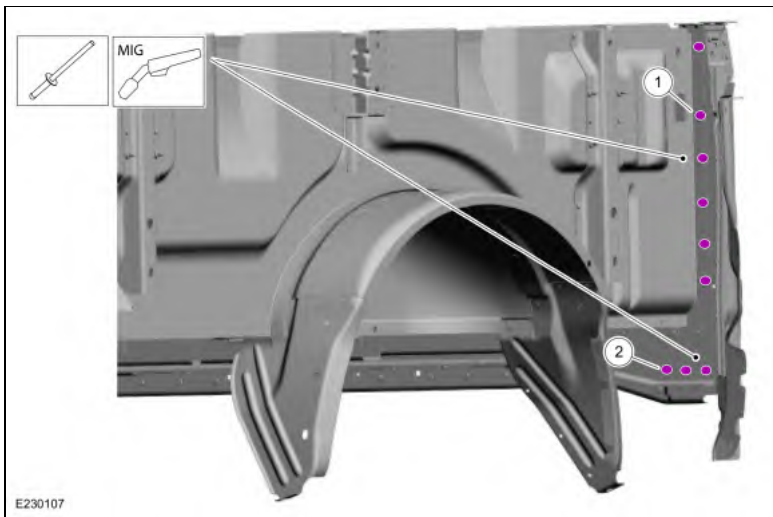
6. Drill holes for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



7. Install fasteners or MIG plug welds.

Item	SPR Number	SPR code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W702512-S900C	-	-
2	-	-	-	-	W702554-S900C	-	-

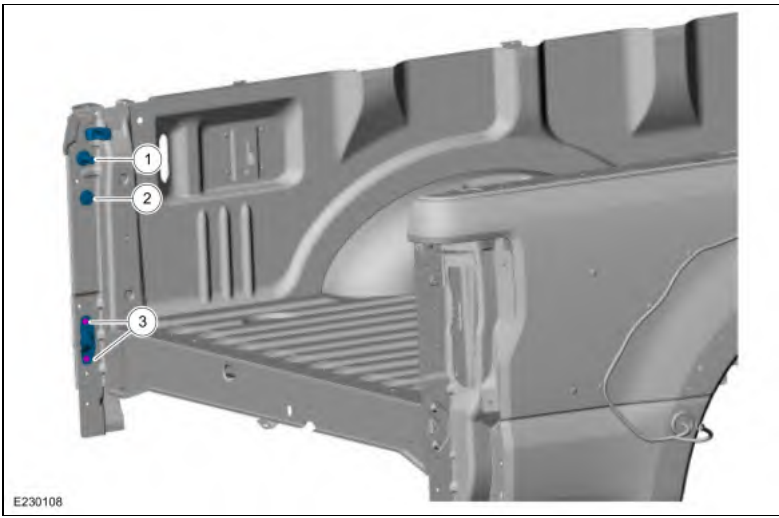
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).
Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).
Use the General Equipment: Blind Rivet Gun
Use the General Equipment: MIG/MAG Welding Equipment



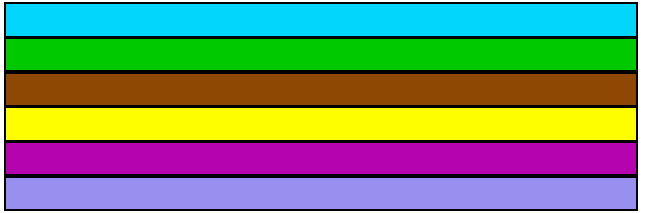
8. Install the outer side panel.
Refer to: Pickup Box Outer Side Panel (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
9. Refinish the entire repair using a Ford approved paint system and typical refinishing techniques.
10. Install the pickup box.
Refer to: Pickup Bed (501-04 Pickup Bed and Platform Body, Description and Operation).
11. Reposition the tail lamp wiring harness to original location.



12. Install the tailgate hinge, tailgate tether bolt, tailgate striker and tailgate bumper.
 1. Tailgate striker:
Torque: 22 lb.ft (30 Nm)
 2. Tailgate tether bolt.
Torque: 30 lb.ft (40 Nm)
 3. Tailgate hinge bolts.
Torque: 41 lb.ft (55 Nm)



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