

# Pickup Box Inner Side Panel

## 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                              |

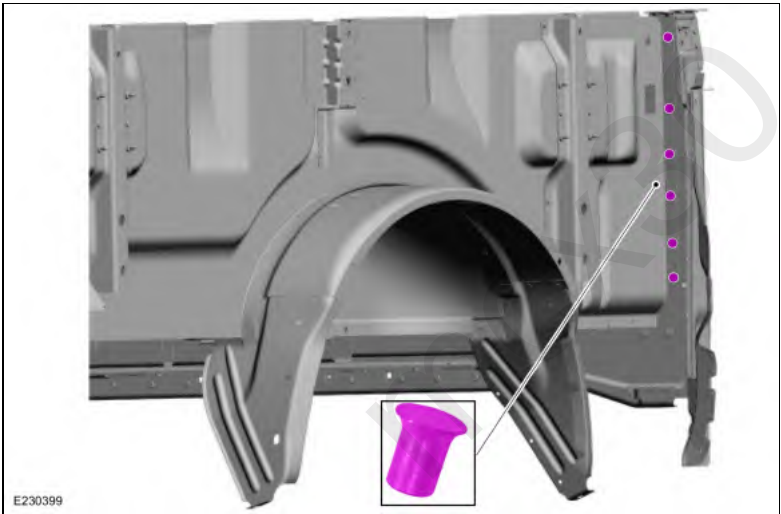
## Removal

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

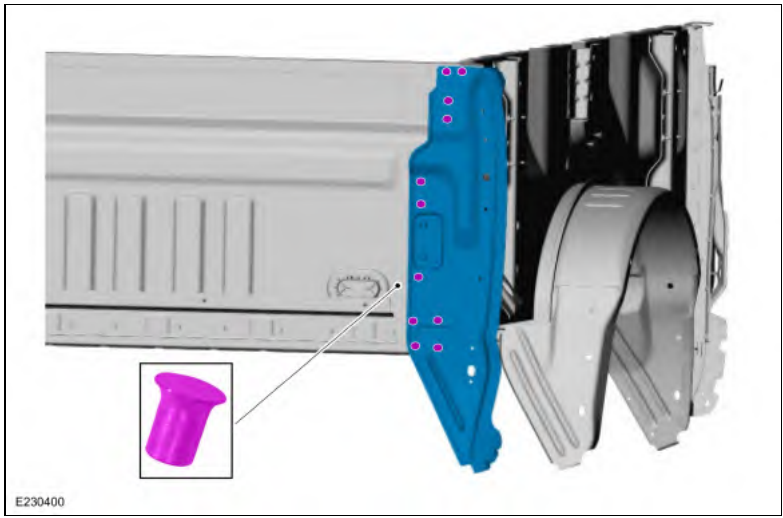
**NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs 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:** LH side 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 SPR fasteners.  
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer  
Use the General Equipment: Belt Sander

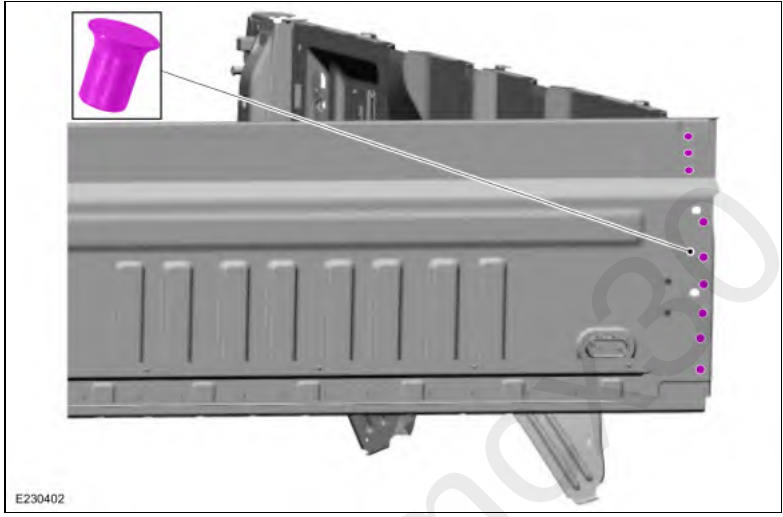


3. Remove the SPR fasteners and the front panel extension.  
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer  
Use the General Equipment: Belt Sander



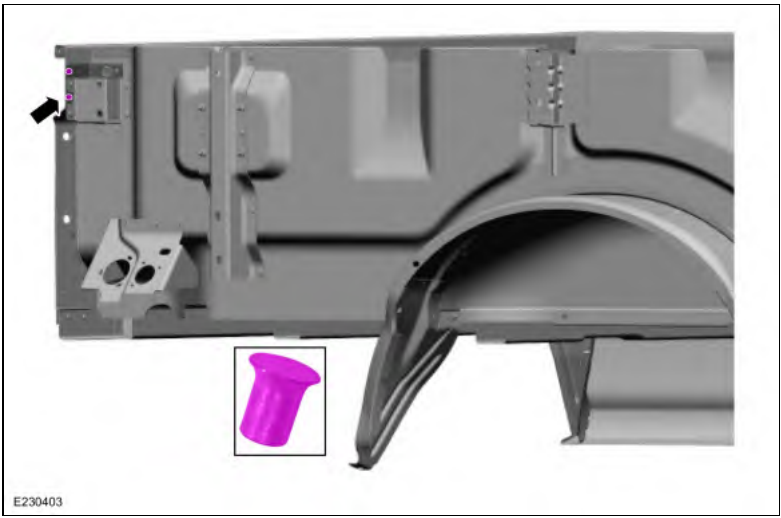
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4. Remove the SPR fasteners.  
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer  
Use the General Equipment: Belt Sander

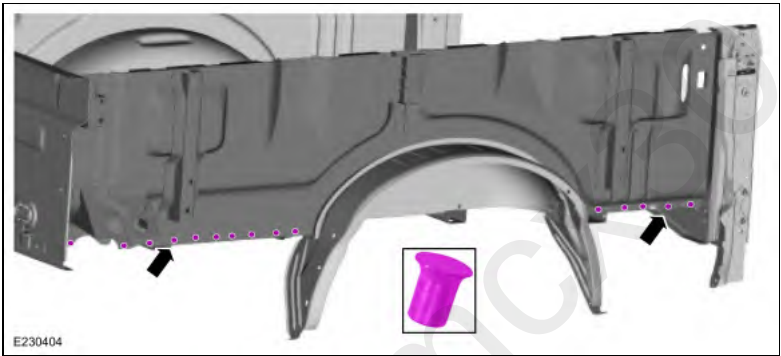


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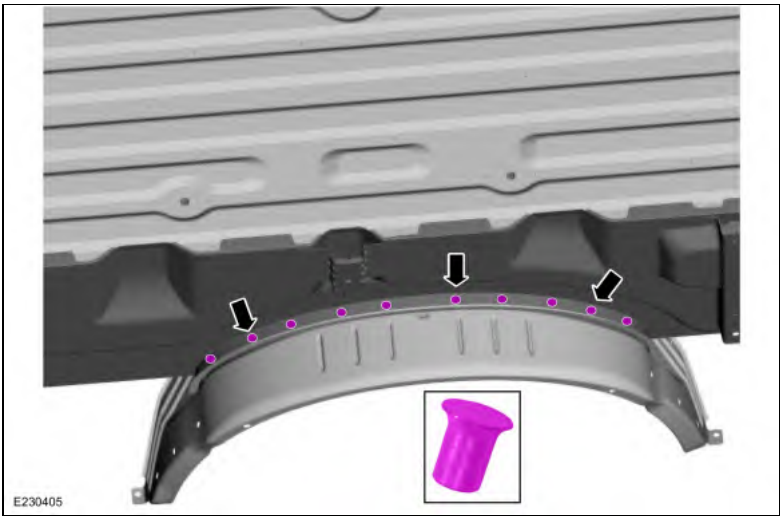
5. Remove the SPR fasteners.  
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer  
Use the General Equipment: Belt Sander



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



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



8. Remove the pickup box inner side panel.



### Installation

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

**NOTE:** LH side shown, RH side similar.

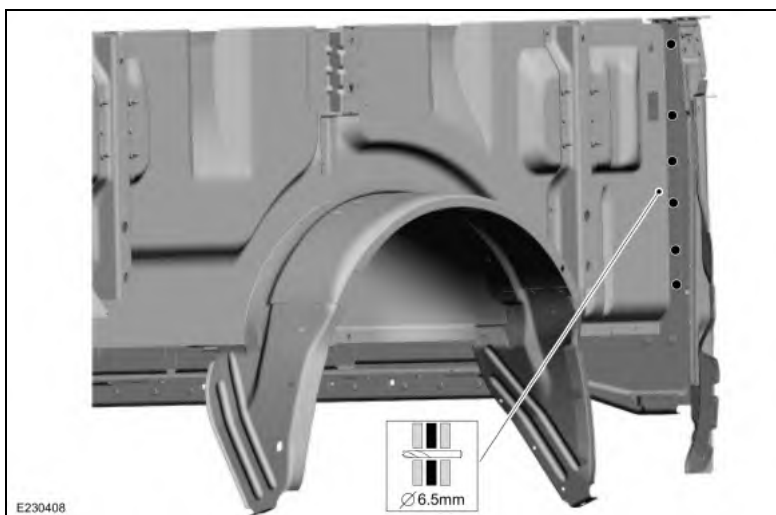
**NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

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

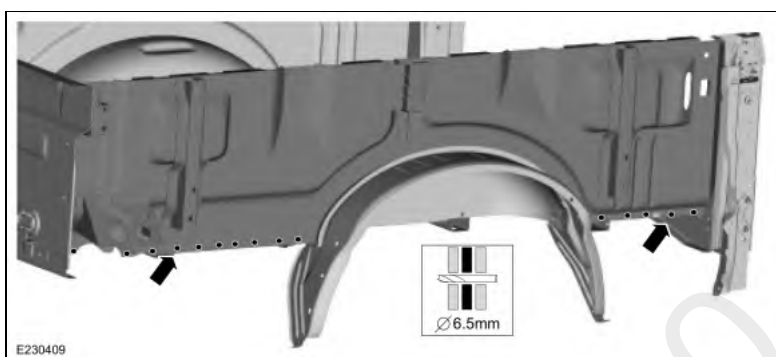
1. Install the pickup box inner side panel, properly position and clamp.  
Use the General Equipment: Locking Pliers



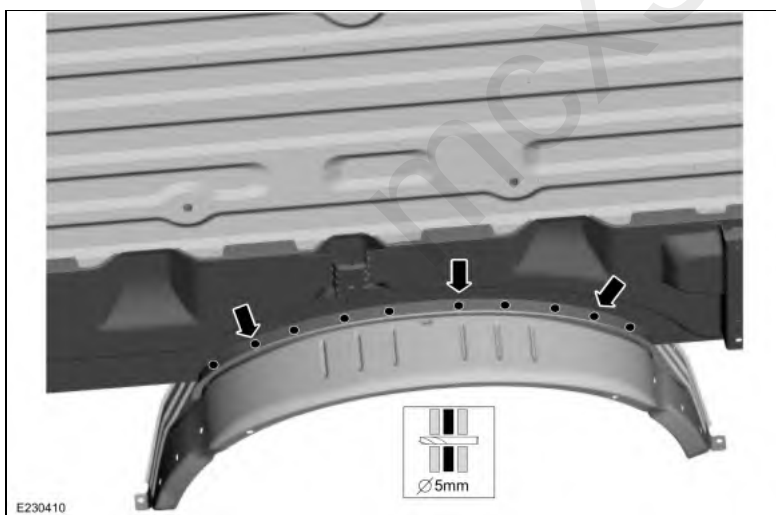
2. Drill for fastener installation.  
Use the General Equipment: 6.5 mm Drill Bit



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



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



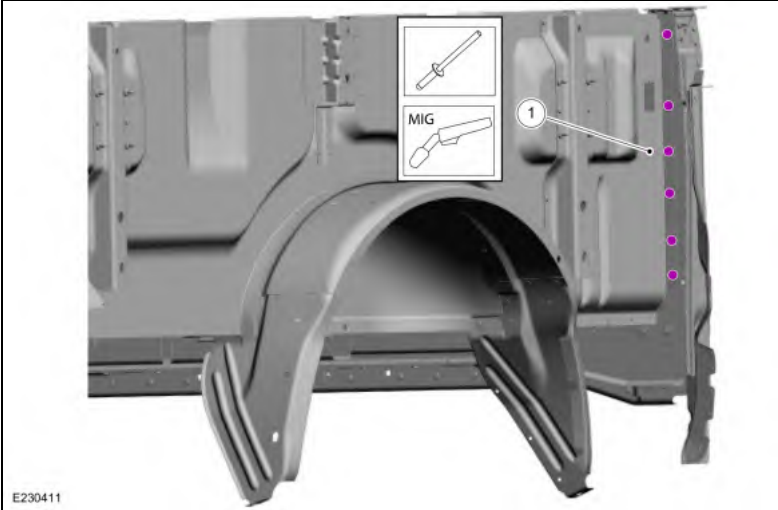
5. Install fasteners or MIG plug welds.

| Item | SPR Number | SPR Code | Henrob® Mandrel | Pro-Spot® Mandrel | Blind Rivet   | Solid Rivet | Rivnut® |
|------|------------|----------|-----------------|-------------------|---------------|-------------|---------|
| 1    | -          | -        | -               | -                 | W708777-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).

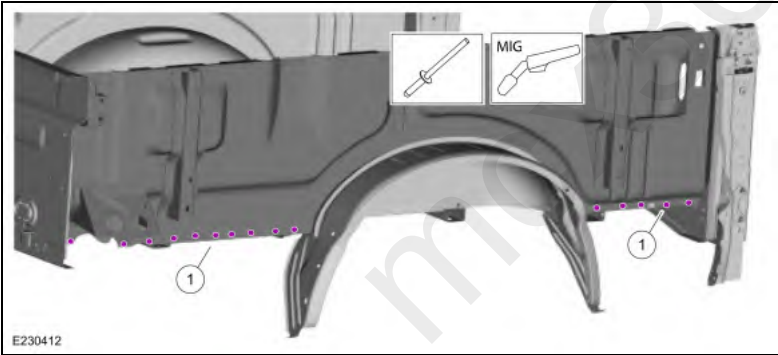
Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).  
Use the General Equipment: MIG/MAG Welding Equipment  
Use the General Equipment: Blind Rivet Gun



6. Install fasteners or MIG plug welds.

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

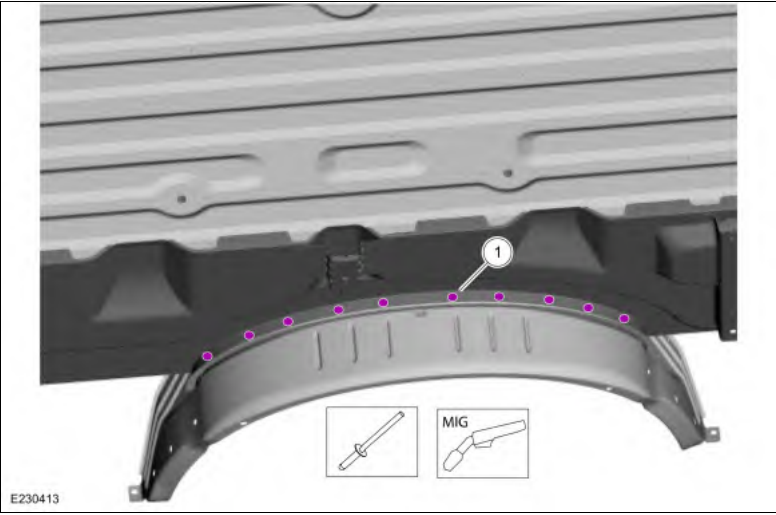
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Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).  
Use the General Equipment: MIG/MAG Welding Equipment  
Use the General Equipment: Blind Rivet Gun



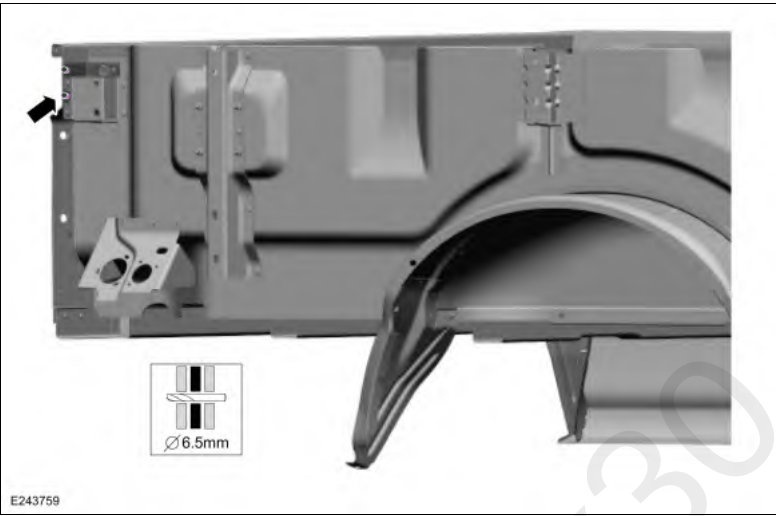
7. Install fasteners or MIG plug welds.

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

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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: MIG/MAG Welding Equipment  
Use the General Equipment: Blind Rivet Gun



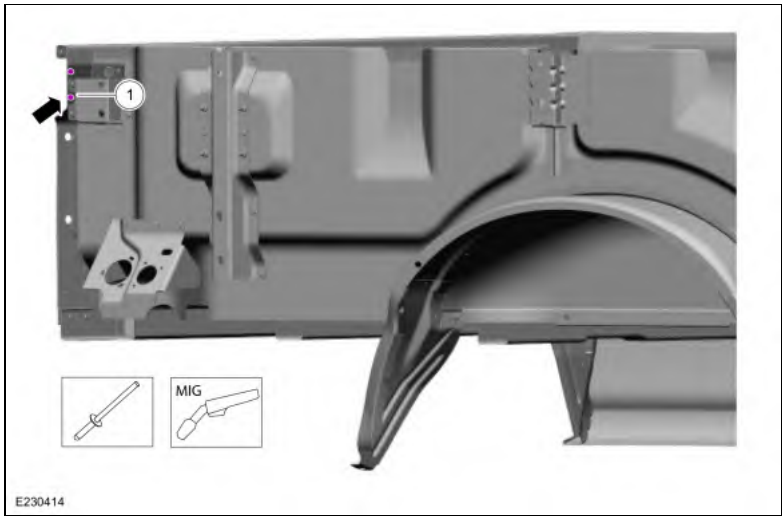
8. Drill for fastener installation.  
Use the General Equipment: 6.5 mm Drill Bit



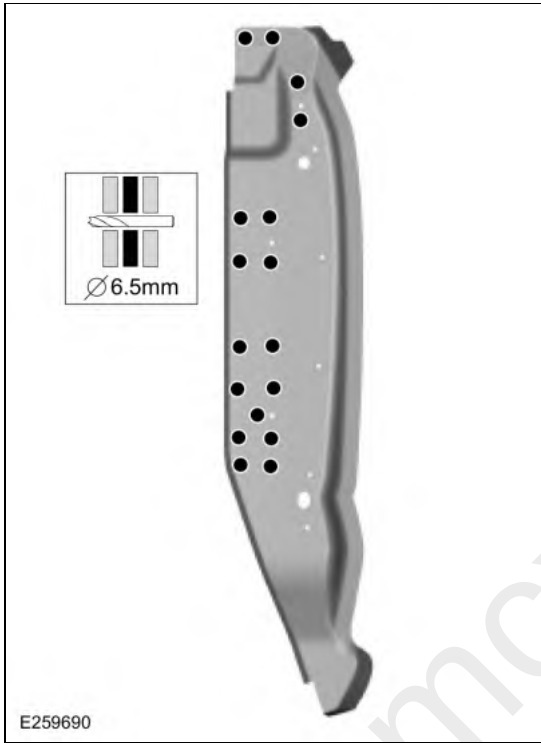
9. Install fasteners or MIG plug welds.

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

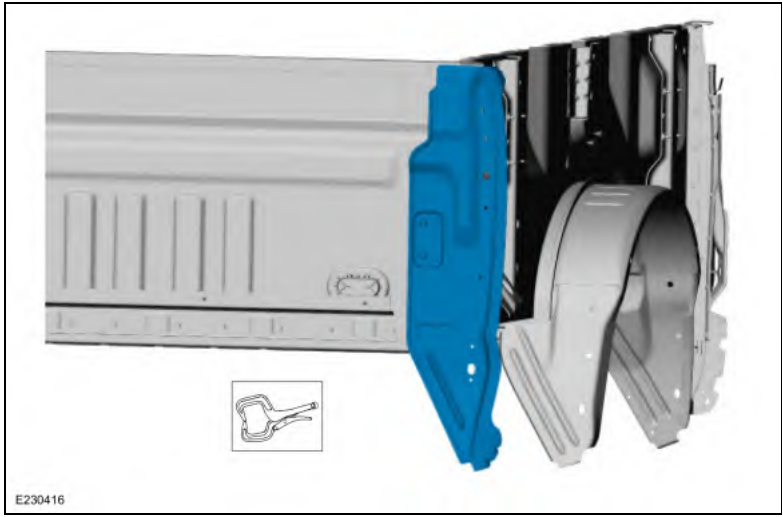
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Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).  
Use the General Equipment: MIG/MAG Welding Equipment  
Use the General Equipment: Blind Rivet Gun



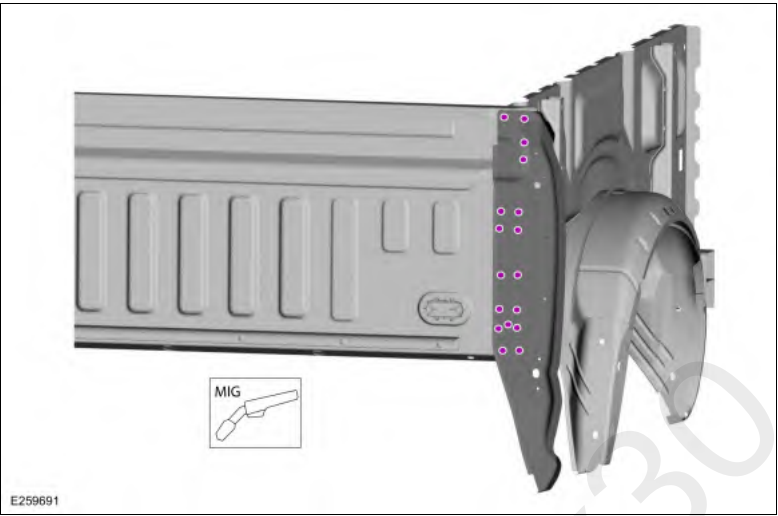
10. Drill plug weld holes.  
Use the General Equipment: 6.5 mm Drill Bit



11. Install, properly position and clamp the front filler panel extension.  
Use the General Equipment: Locking Pliers



12. Install plug welds using a MIG welder set up for aluminum welding.  
Use the General Equipment: MIG/MAG Welding Equipment



13. Install the pickup box outer side panel.  
Refer to: Pickup Box Outer Side Panel (501-30 Rear End Sheet Metal Repairs, Removal and Installation).