

Rear Wheelhouse

Special Tool(s) / General Equipment

6.5 mm Drill Bit
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Hot Air Gun
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	-
Flexible Foam Repair 3M [®] , 08463, LORD Fusor [®] 121	-

Removal

NOTE: 8.0 foot pickup box shown, all other 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 425°F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

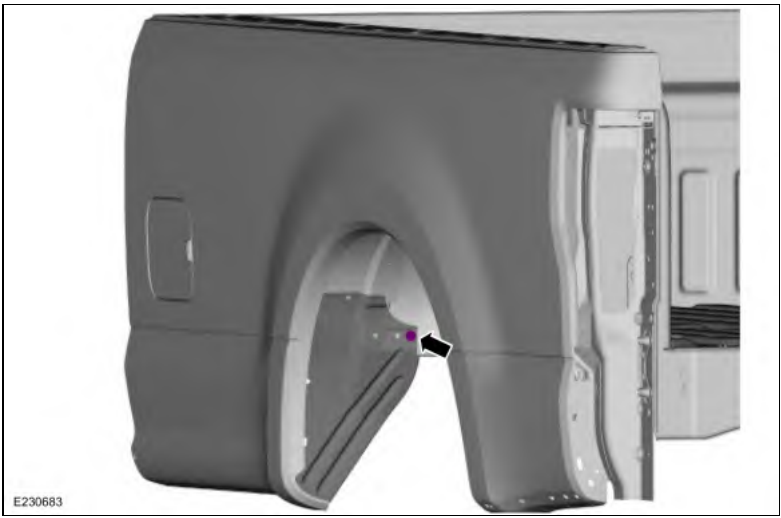
NOTE: LH side shown, RH side similar.

All vehicles

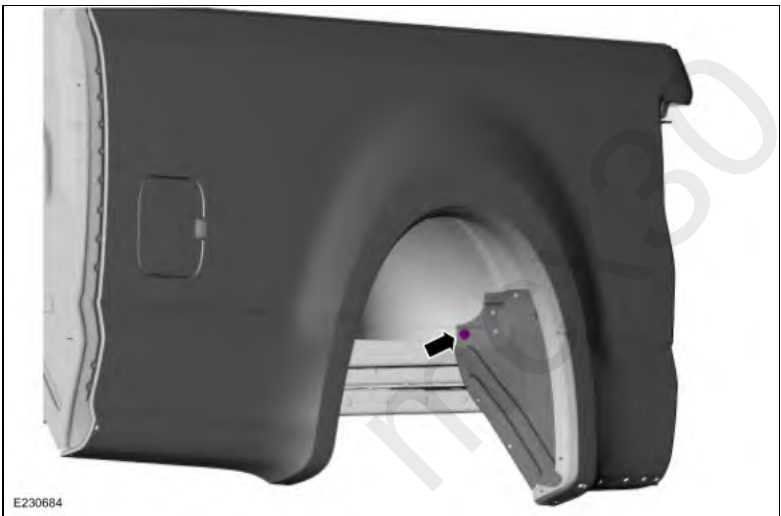
1. If equipped:
Remove the dual rear wheels fender.
Refer to: Fender (501-04 Pickup Bed and Platform Body, Removal and Installation).
2. If equipped: Remove the lower trim panels and wheel opening trim.

Outer Wheelhouse

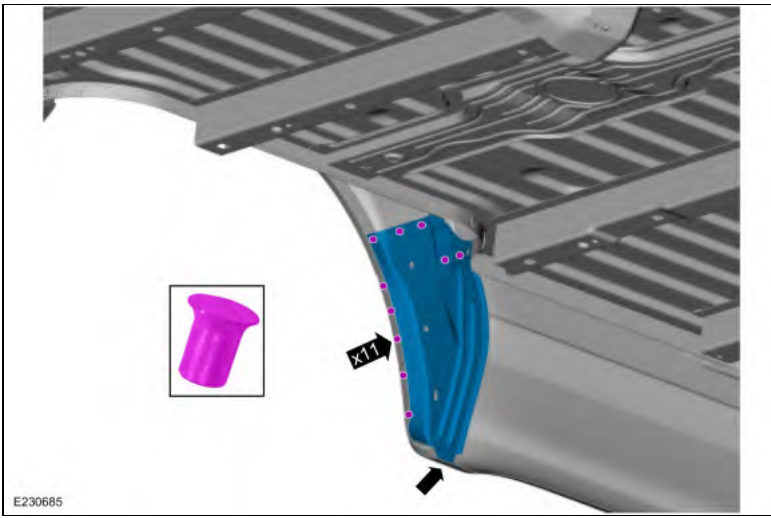
3. Remove the bolt.



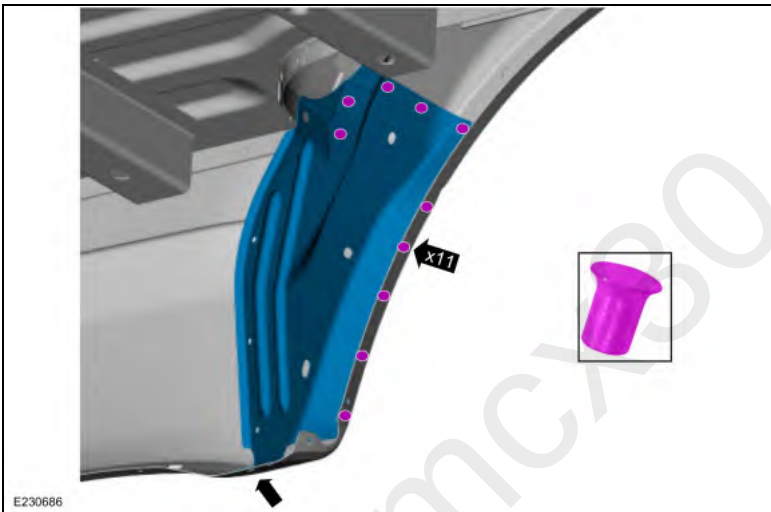
4. Remove the bolt.



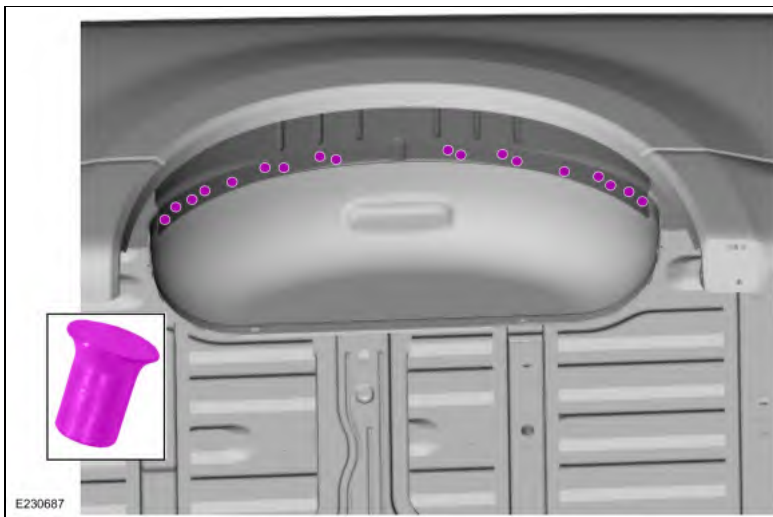
5. Remove the SPR fasteners and the front wheelhouse extension.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



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

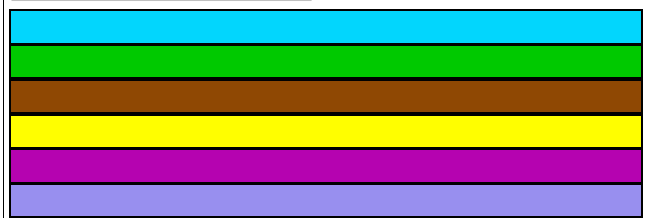
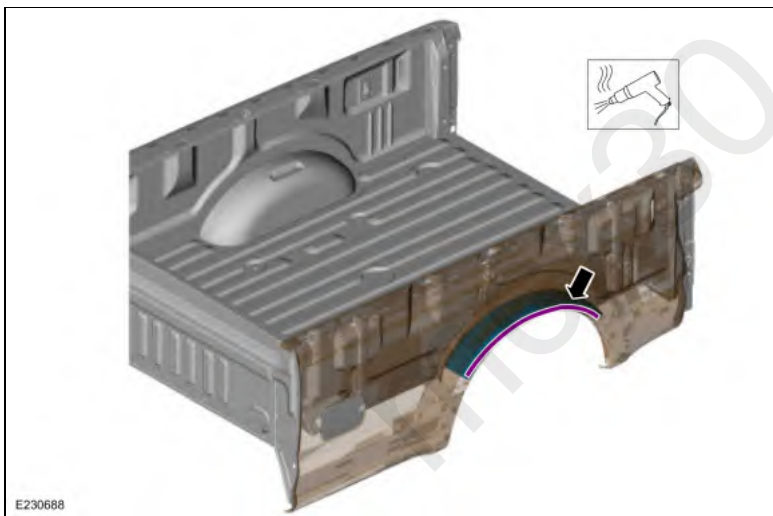


7. Remove the inner to outer wheelhouse SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



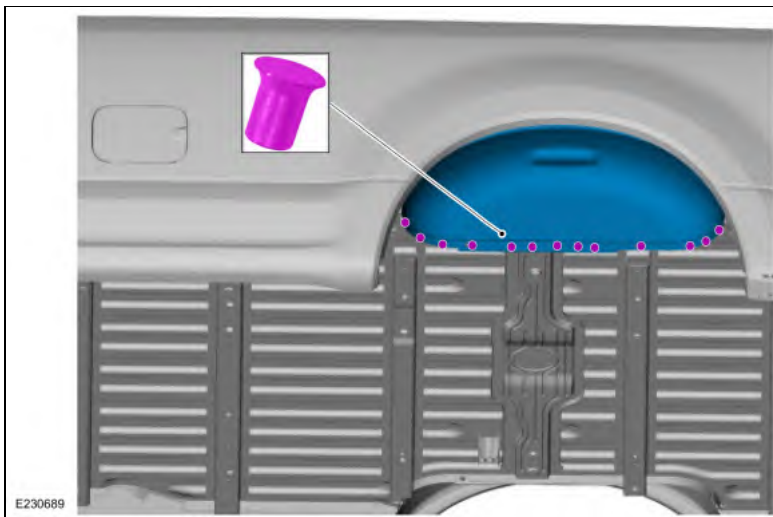
8. **NOTE:** Pay particular attention to location of adhesive and NVH foam to air in installation.

Break the adhesive and sealer bond and remove the outer wheelhouse.
Use the General Equipment: Hot Air Gun



Inner Wheelhouse

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



Installation

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

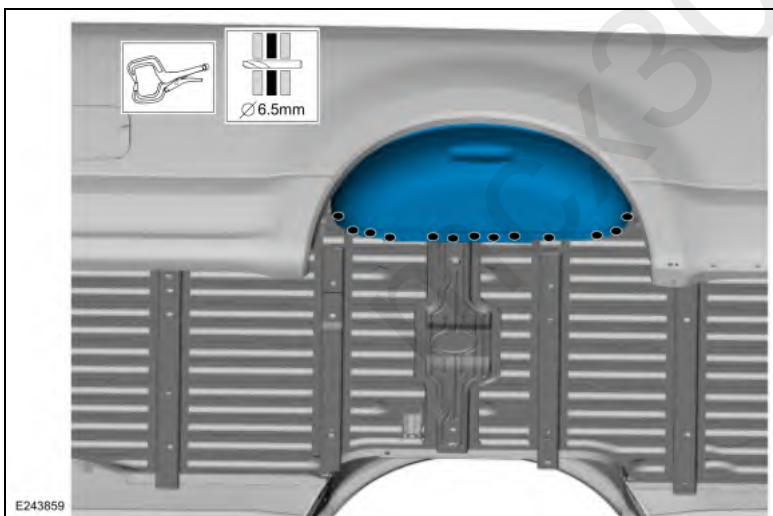
NOTE: SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

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

NOTE: LH side shown, RH side similar.

Inner Wheelhouse

1. Install the inner wheelhouse, properly position, clamp and drill for fasteners.
Use the General Equipment: Locking Pliers
Use the General Equipment: 6.5 mm Drill Bit



2. Install fasteners or aluminum MIG plug welds.

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

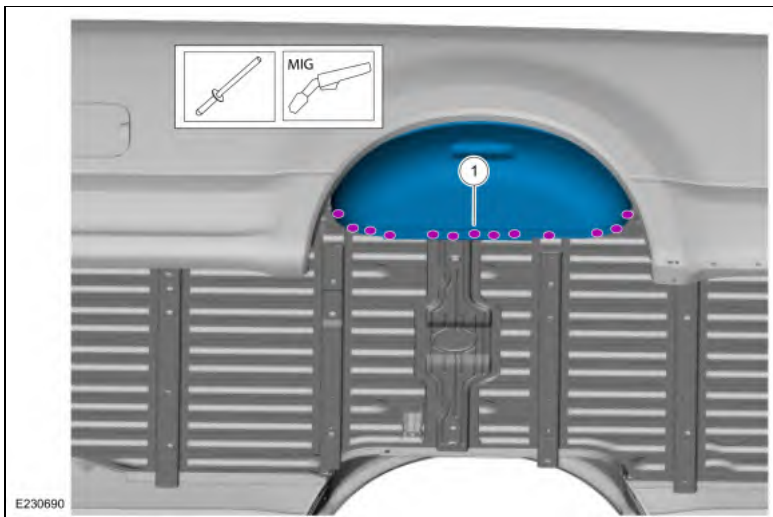
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).

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



Outer Wheelhouse

3. 80-120 grit sand paper.
Sand to remove e-coat and clean.

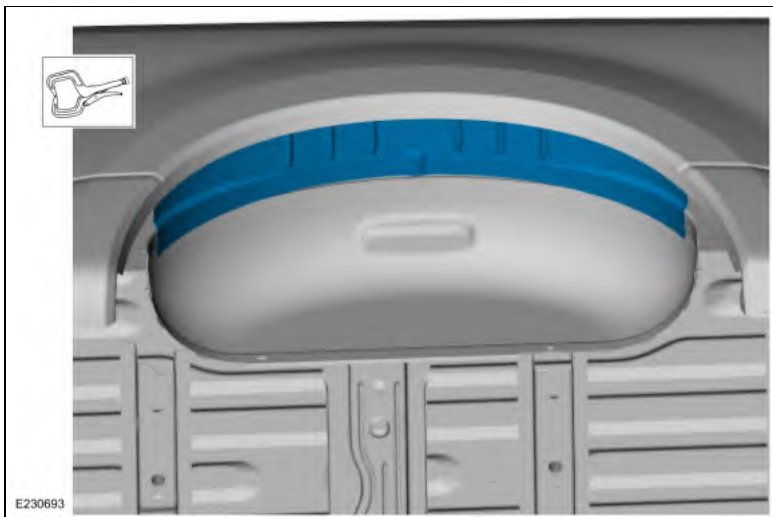


4. Apply adhesive to the outer wheelhouse to body side mating surface.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M, 08115, LORD Fusor® 108B

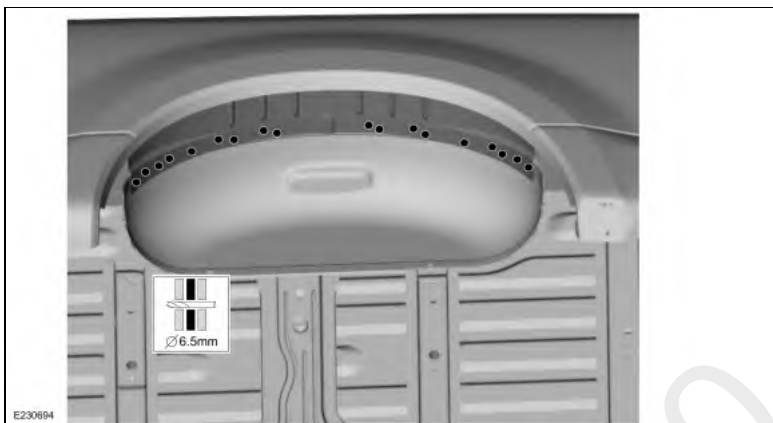


5. **NOTE:** Do not lift the wheelhouse to reposition, to minimize the possibility of breaking the adhesive bond slide the component to its proper location.

Install the outer wheelhouse, properly position and securely clamp.
Use the General Equipment: Locking Pliers



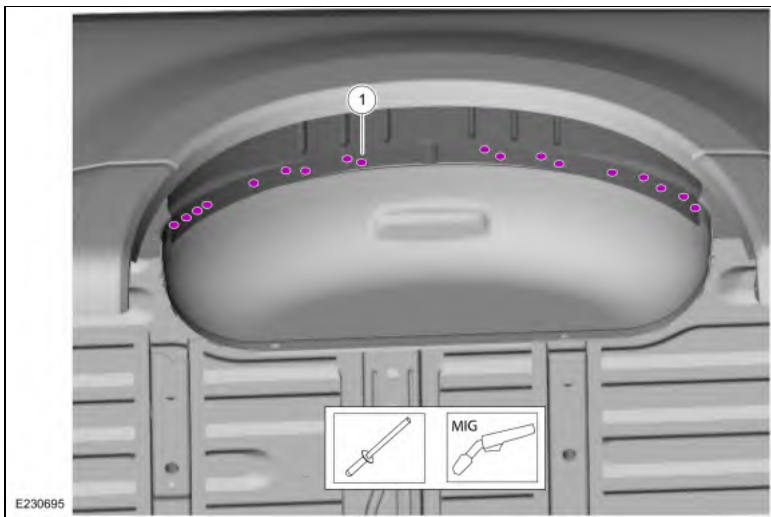
6. Drill for fasteners.
Use the General Equipment: 6.5 mm Drill Bit



7. Install outer to inner wheelhouse fasteners or aluminum MIG plug welds.

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

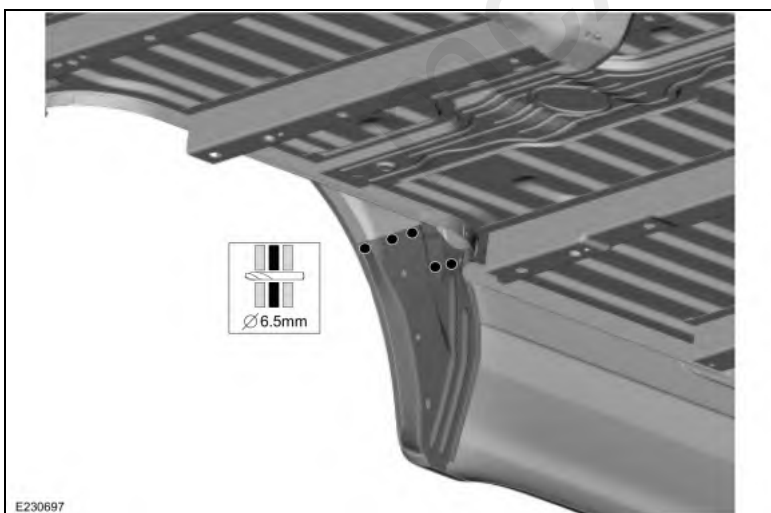
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).
Refer to: Welding Precautions (501-25 Body Repairs - General Information,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



8. Install the rear wheelhouse extension and bolt.
Torque: 106 lb.in (12 Nm)



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



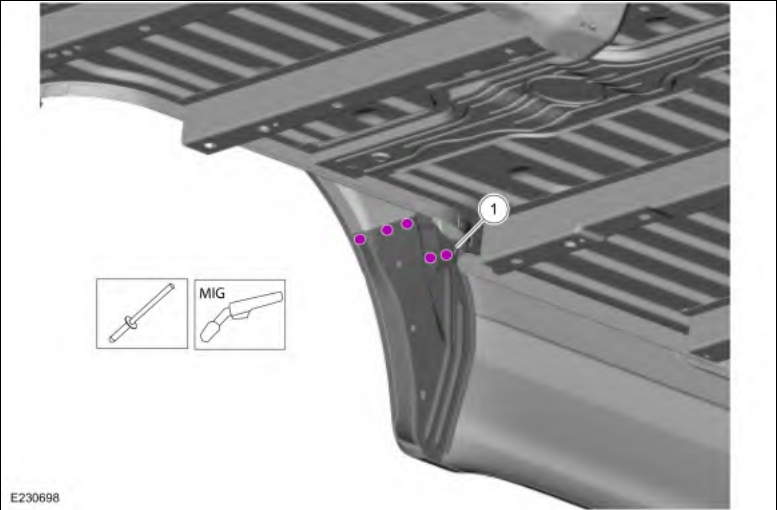
10. Install fasteners or aluminum MIG plug welds.



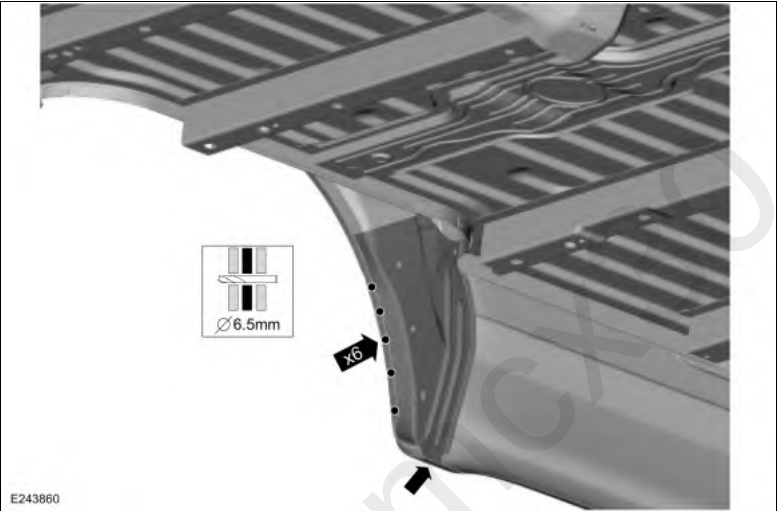
Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	-	-

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



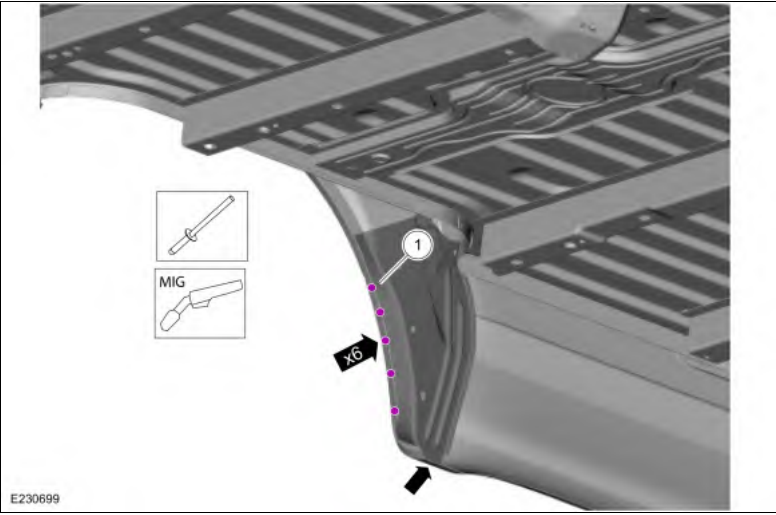
11. Drill for fasteners.
Use the General Equipment: 6.5 mm Drill Bit



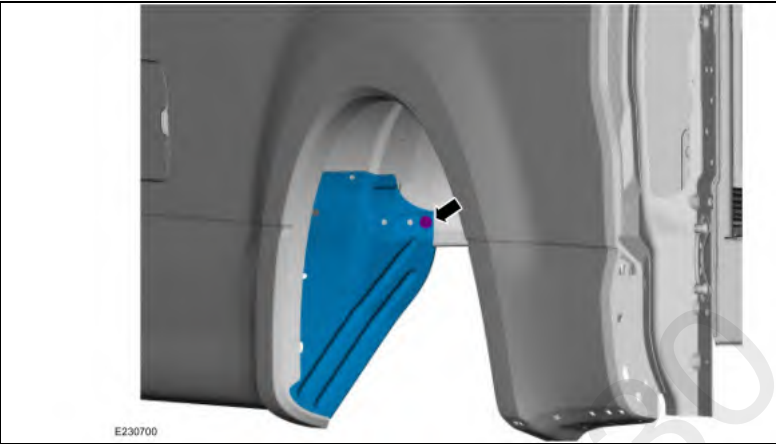
12. Install fasteners or aluminum MIG plug welds.

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

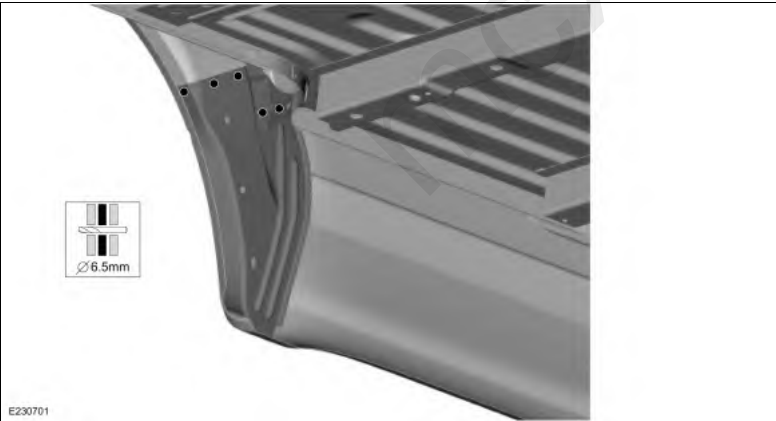
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).
Refer to: Welding Precautions (501-25 Body Repairs - General Information,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



13. Install the front wheelhouse extension and bolt.
Torque: 106 lb.in (12 Nm)



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

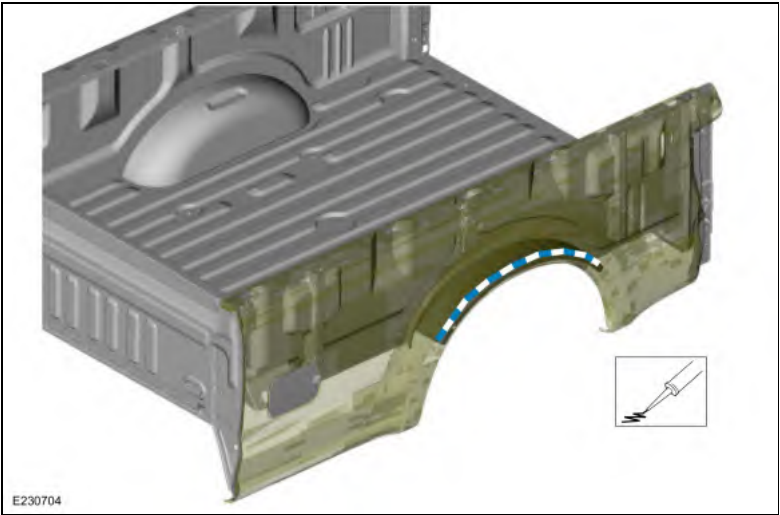


15. Install fasteners or aluminum MIG plug welds.

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

18. Apply NVH foam in area noted during removal.
Material: Flexible Foam Repair / 3M[®], 08463, LORD Fusor[®] 121



All vehicles

19. Metal finish as required use typical metal finishing techniques and materials.
20. Seam sealing:
All seams must be sealed to production level.
Material: Seam Sealer / TA-2-B, 3M[®], 08308, LORD Fusor[®] 805DTM
21. Refinish the entire repair using a Ford approved paint system
22. If equipped:
Install the dual rear wheels fender.
Refer to: Fender (501-04 Pickup Bed and Platform Body, Removal and Installation).
23. If equipped: Install the lower trim panel and wheel opening trim