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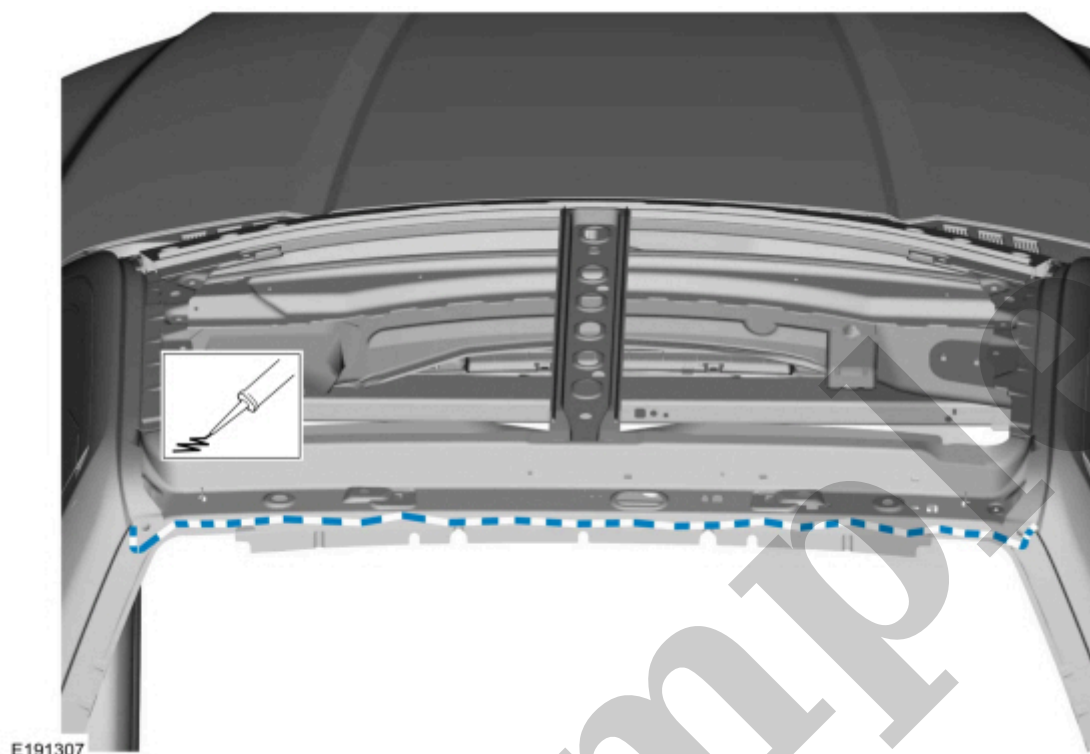
## 2000 FORD Ranger Super Cab OEM Service and Repair Workshop Manual

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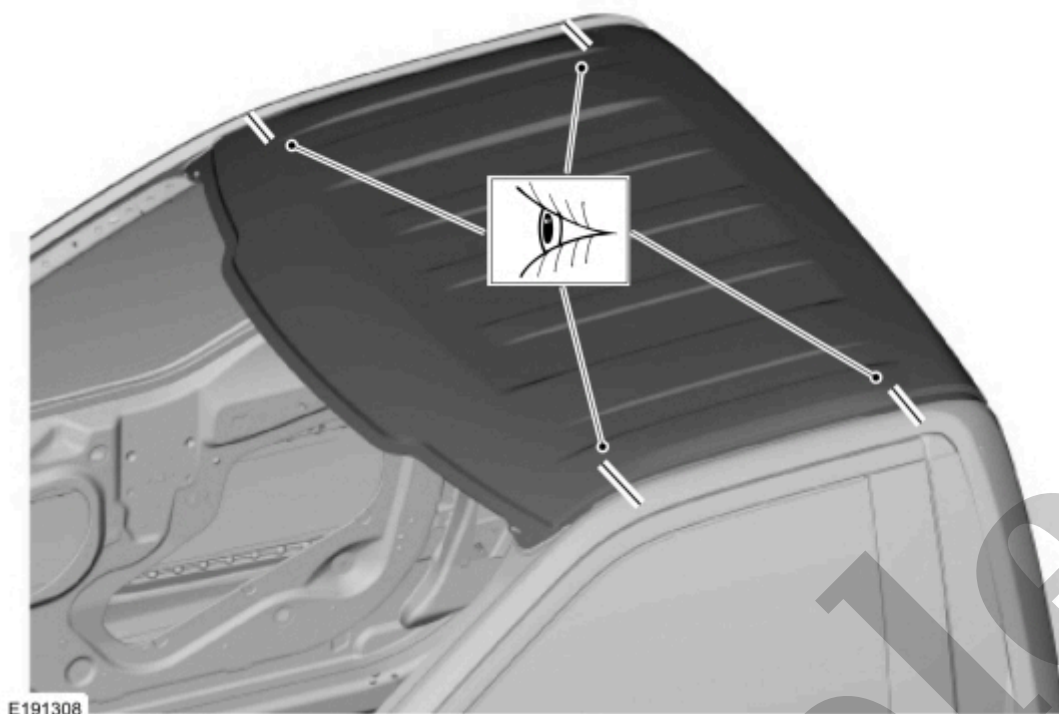
8. Apply adhesive.

**Material** : Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B, Henkel Teroson EP 5055



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9. With the help of an assistant, install the roof panel.



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11. **NOTE**

Do not remove excess adhesive squeeze-out in the roof ditch area, smooth in to the joint to act as additional sealer.

Clamp in position.

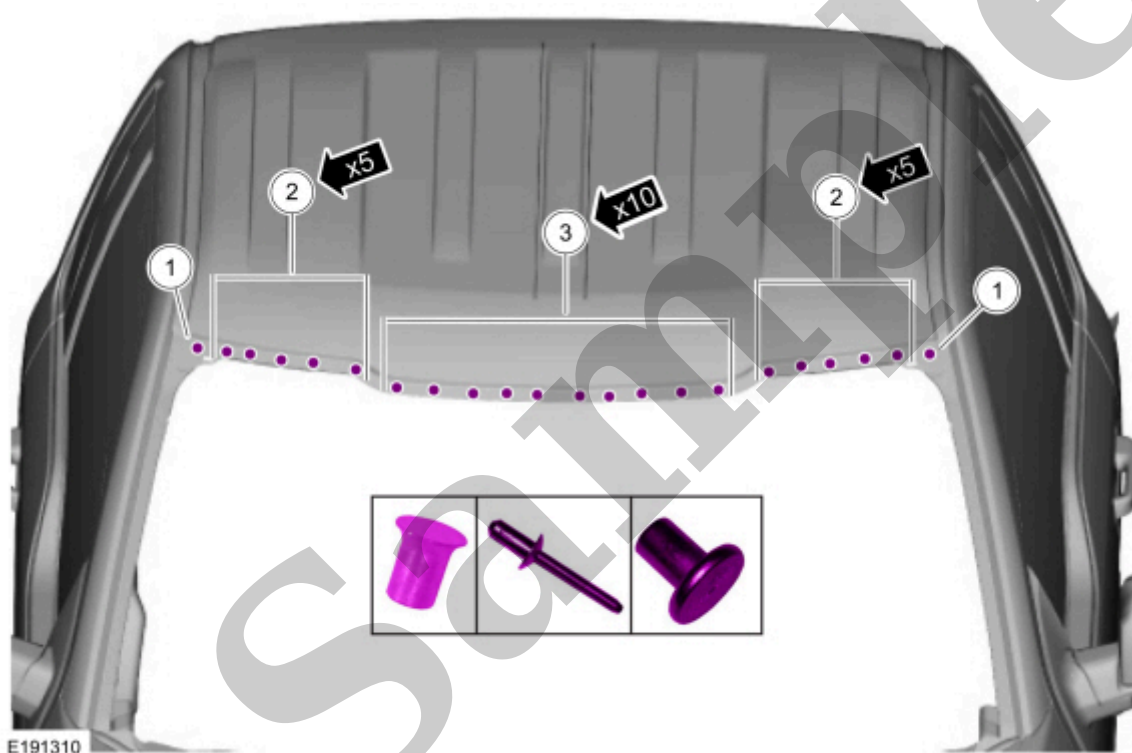
Use the General Equipment: Locking Pliers

2	W717186-S900	EN	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
3	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0401	-	W790376-S900	-

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

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Blind Rivet Gun

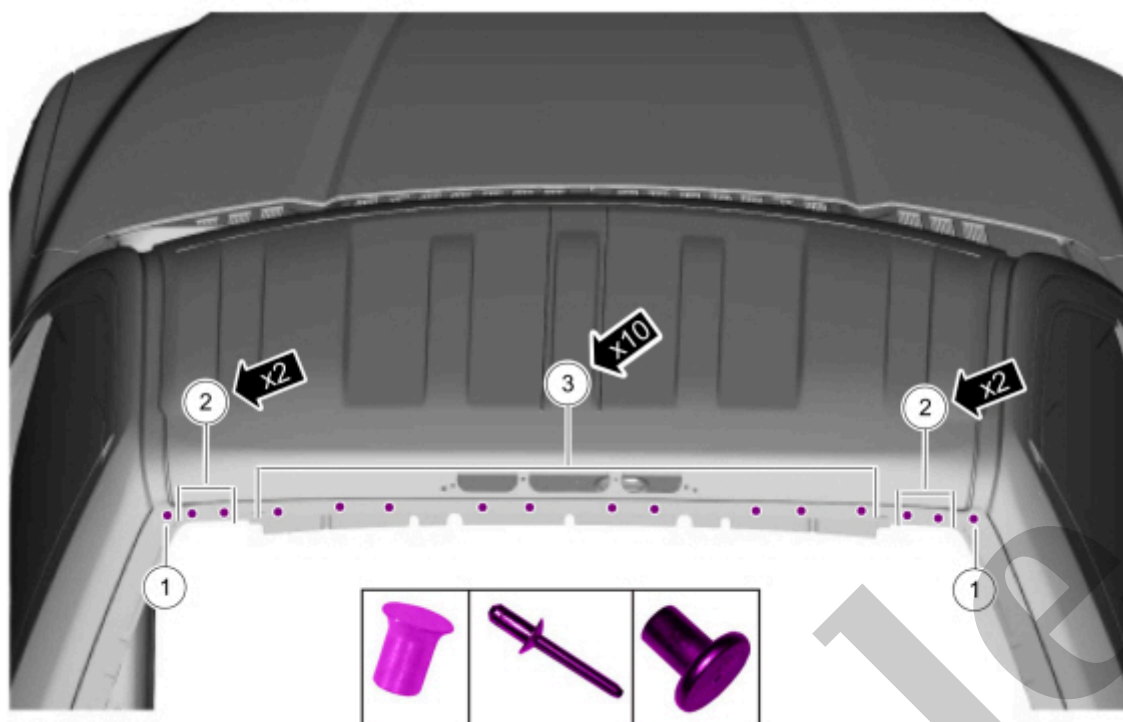


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### 13. NOTE

SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

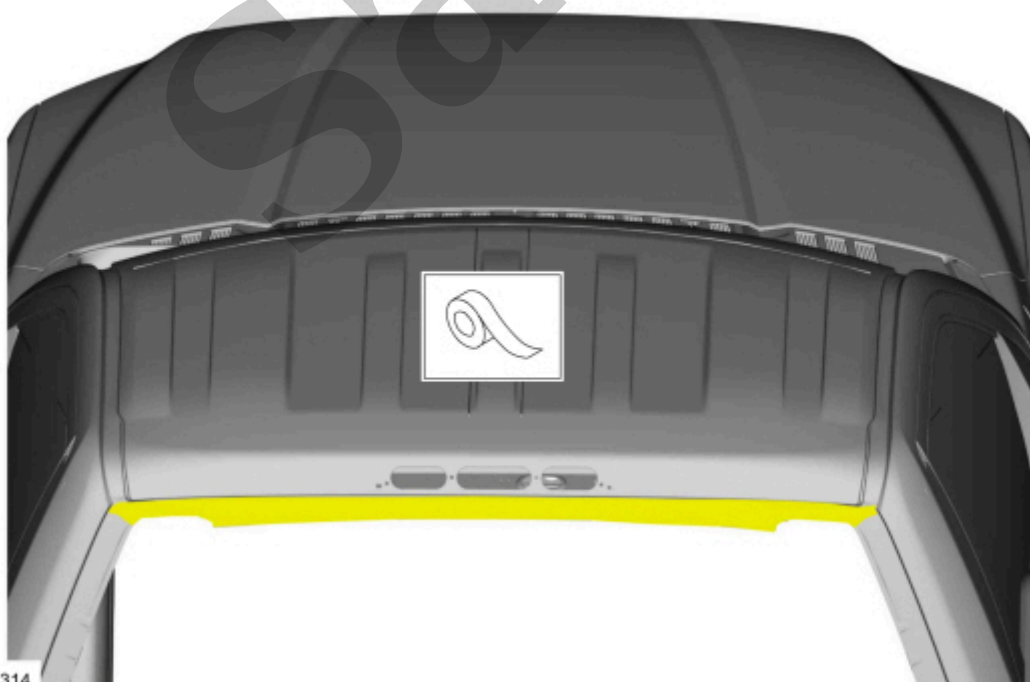
### NOTE



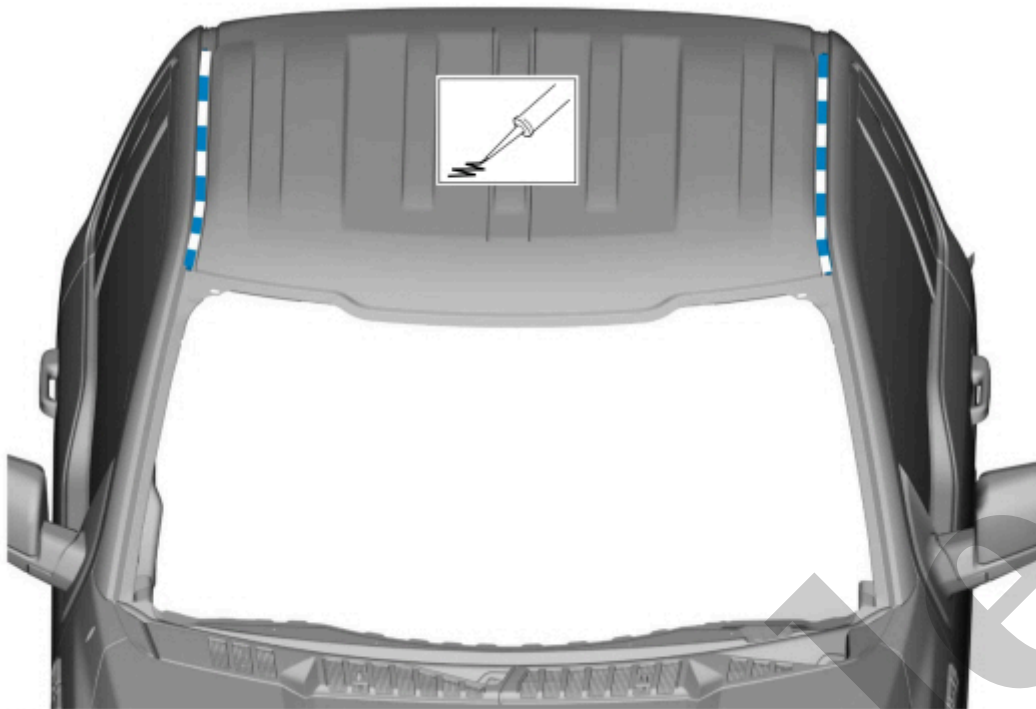
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14. Sand and prime the front and rear window opening channels using a Ford approved epoxy based primer.
15. Mask off the rear window glass channel.



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18. Refinish the entire repair area using a Ford approved paint system and standard refinishing techniques.

19. Remove the masking in the rear window glass channel.



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Refer to: [Headliner - Regular Cab](#)(501-05 Interior Trim and Ornamentation, Removal and Installation).

27. Repower the SRS (supplemental restraint system) .

Refer to: [Supplemental Restraint System \(SRS\) Repowering](#)(501-20B Supplemental Restraint System, General Procedures).

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Sample

Refer to: [High Voltage System Health and Safety Precautions - Overview](#)(100-00 General Information, Description and Operation).

## NOTICE

Adequately protect all glass, exterior finish and interior trim from contamination during entire repair procedure.

## 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.

### 2. Depower the SRS (supplemental restraint system) .

Refer to: [Supplemental Restraint System \(SRS\) Depowering](#)(501-20B Supplemental Restraint System, General Procedures).

### 3. Remove the headliner.

Refer to: [Headliner - SuperCab](#)(501-05 Interior Trim and Ornamentation, Removal and Installation).

### 4. Remove the windshield and rear window glass.

Refer to: [Fixed Glass](#)(501-11 Glass, Frames and Mechanisms, General Procedures).

### 5. Remove the high mount stop lamp.

Refer to: [High Mounted Stoplamp](#)(417-01 Exterior Lighting, Removal and Installation).

### 6. Remove the roof mouldings.

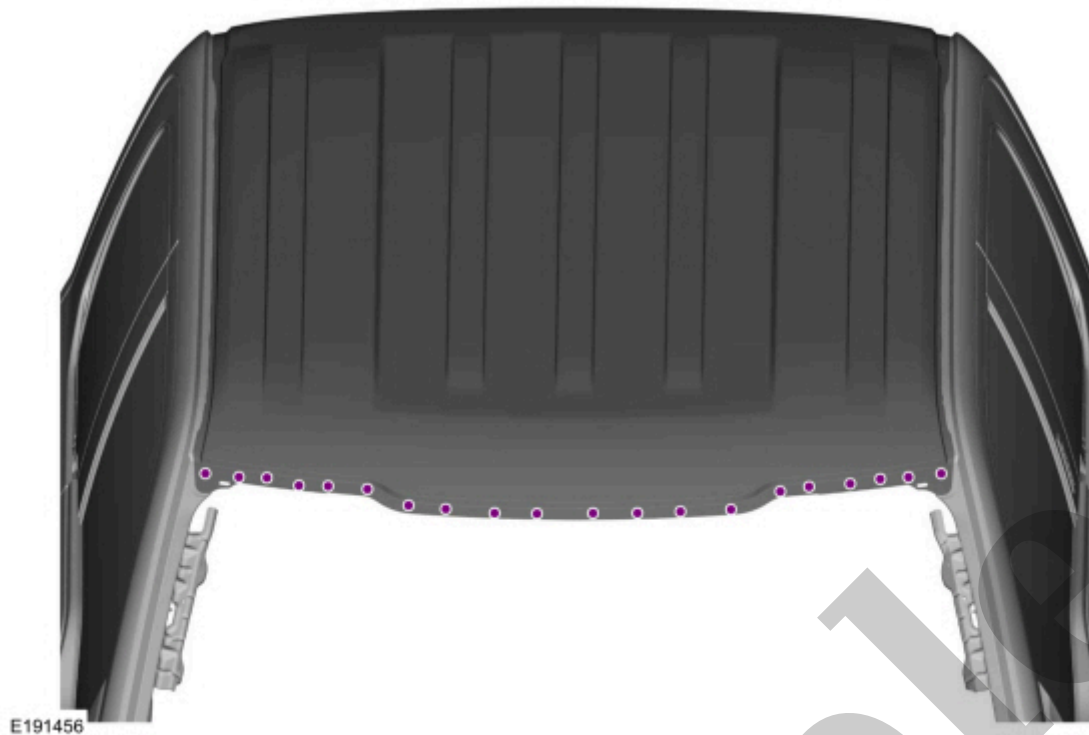
Refer to: [Roof Moulding](#)(501-08 Exterior Trim and Ornamentation, Removal and Installation).

### 7. Remove the side curtain air bag (both sides).

Refer to: [Side Curtain Airbag - SuperCab](#)(501-20B Supplemental Restraint System, Removal and Installation).

### 8. Remove the satellite radio antenna.





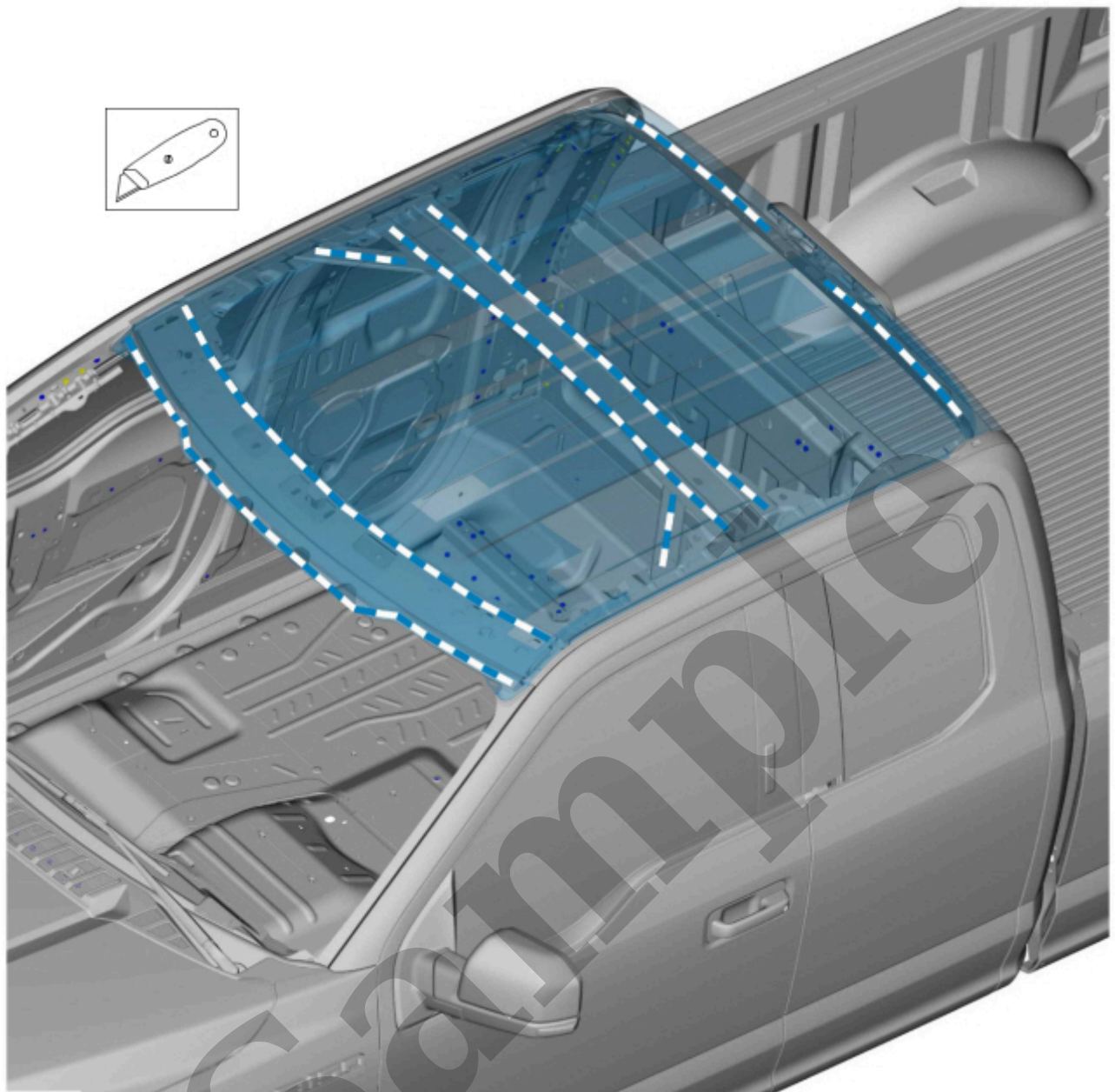
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11. Remove the rear header SPR (self-piercing rivet) fasteners.

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Belt Sander





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14. Separate the roof outer panel from the rear header panel.

Use the General Equipment: Knife