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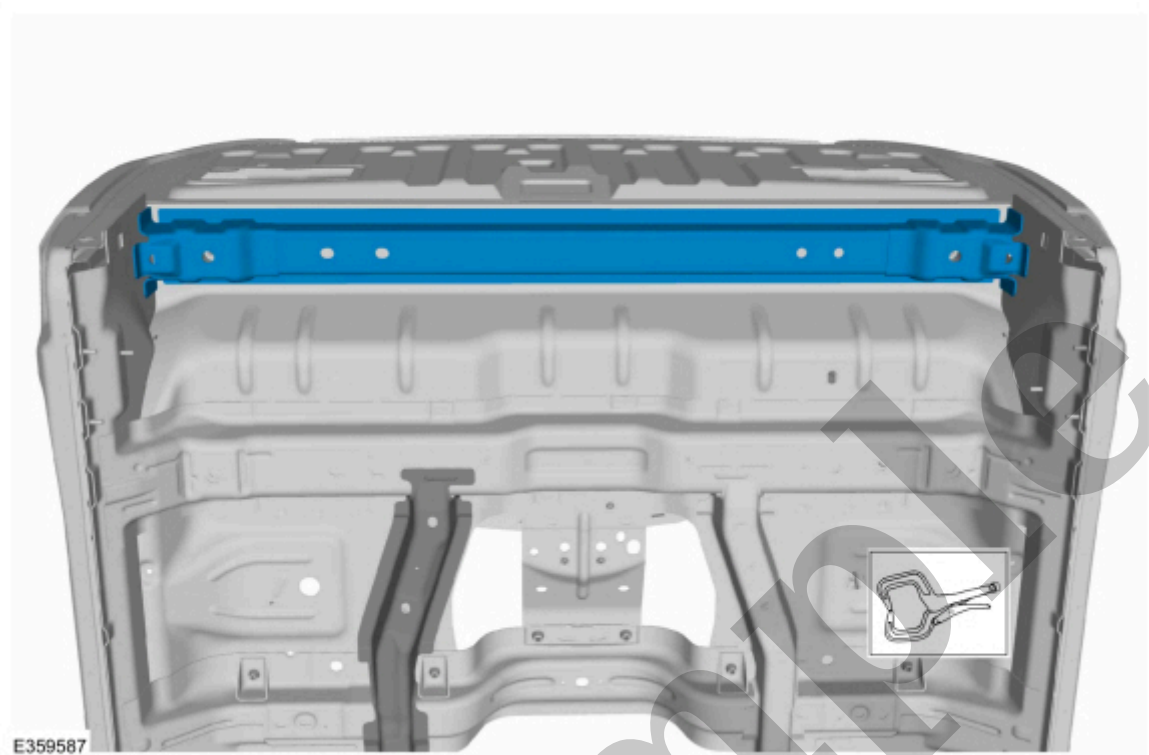
2004 FORD F-150 Super Cab OEM Service and Repair Workshop Manual

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Installation

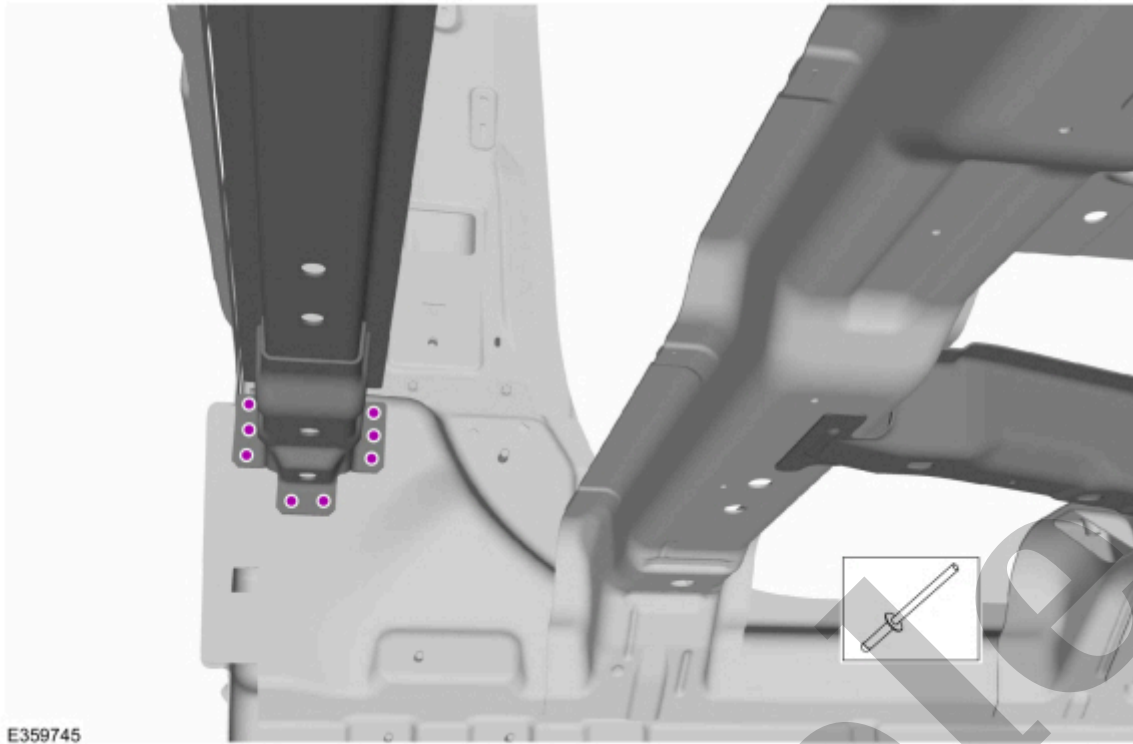
1. Install, properly position and clamp the reinforcement.



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2. Install the fasteners.

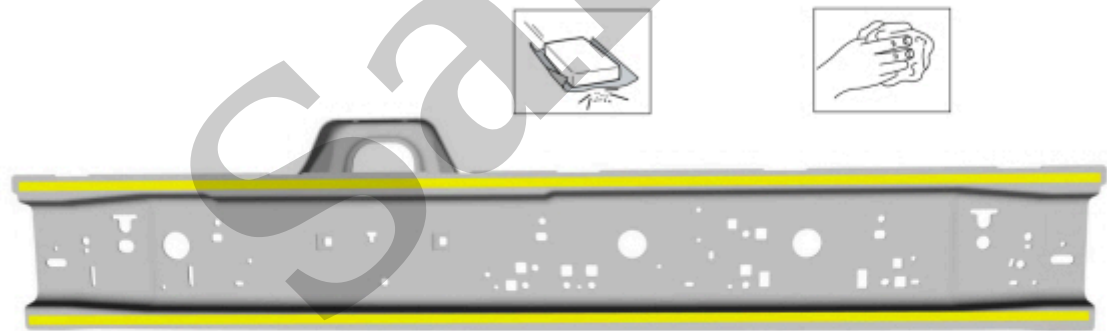
Item	SPR (self-piercing rivet) Number	SPR (self-piercing rivet) Code	Henrob® Car-O-Liner®, CMO®, Chief®, Spanesi® Wielande and Schill® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	-	-



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4. Sand and clean the mating flanges on the reinforcement.



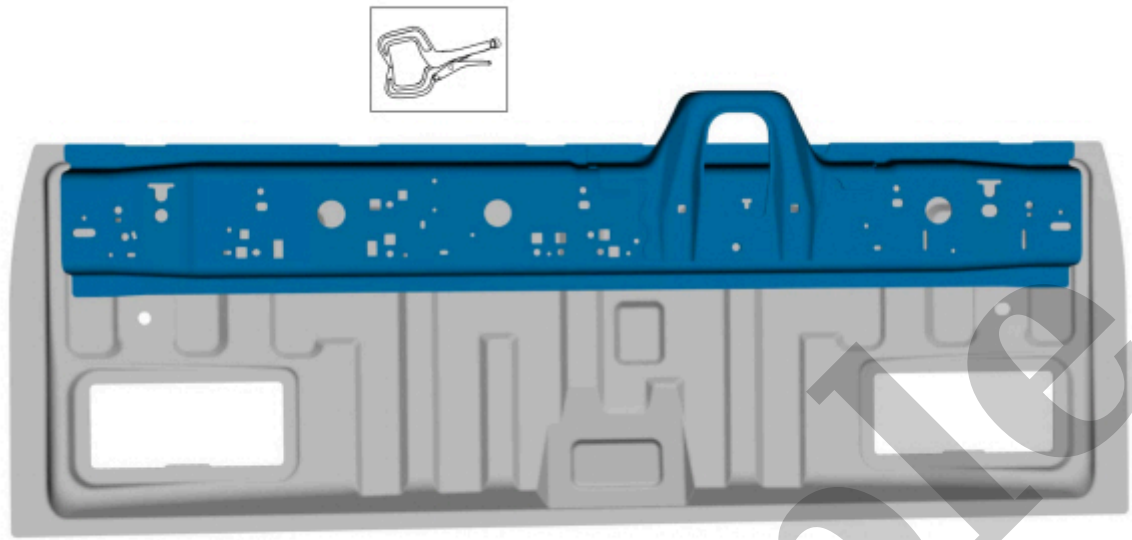
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5. Sand and clean the mating flanges on the back panel.

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7. Install, properly position and clamp the reinforcement on the back panel.



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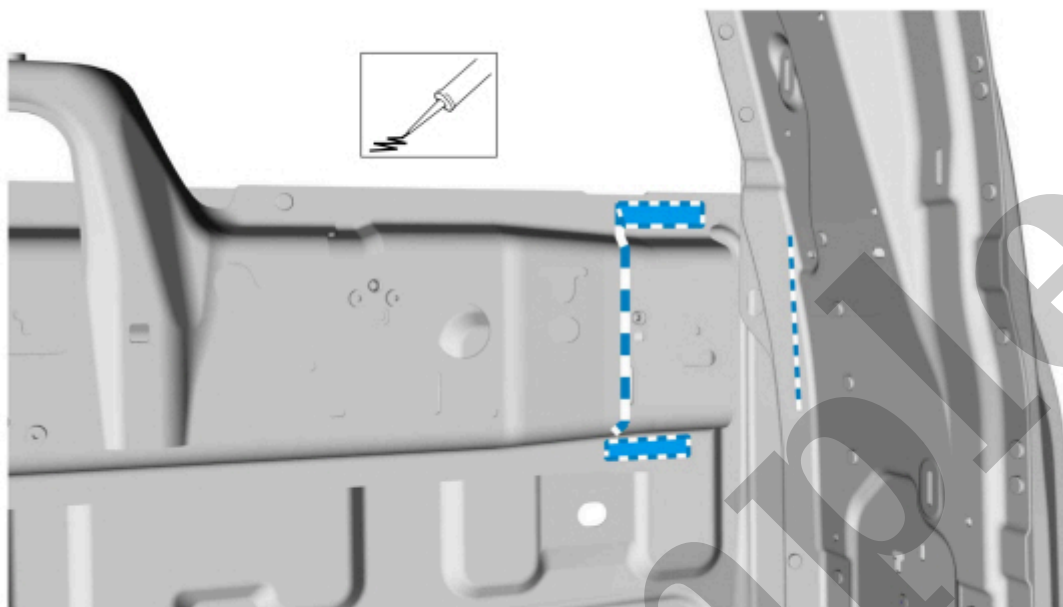
8. Apply adhesive to the mating flanges.

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

10. On Both Sides:

Apply adhesive.

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

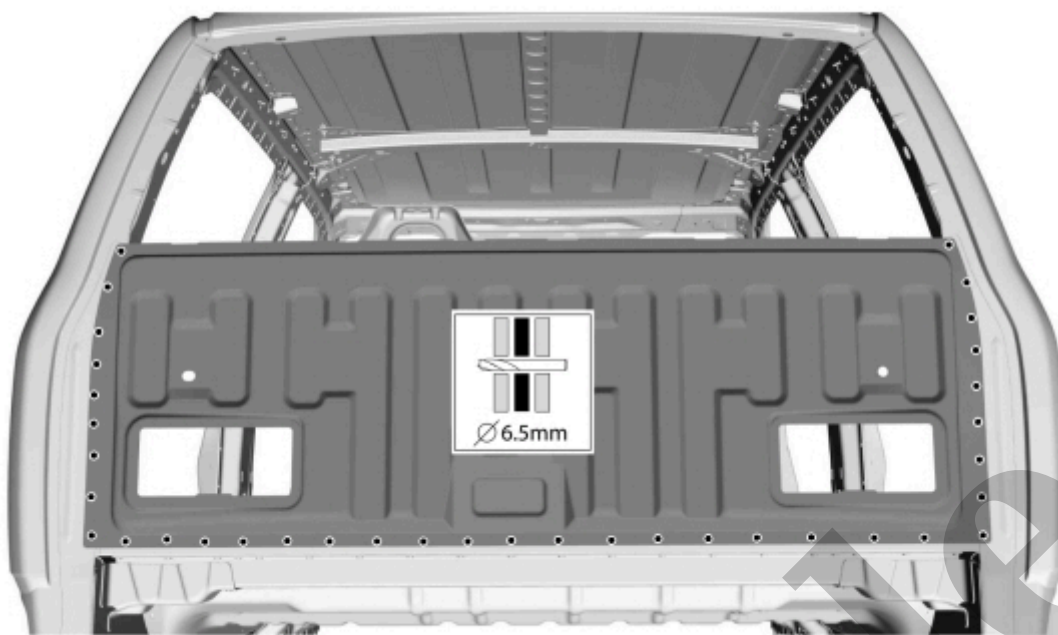


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11. On Both Sides:

Install, properly position and clamp the corner reinforcement.

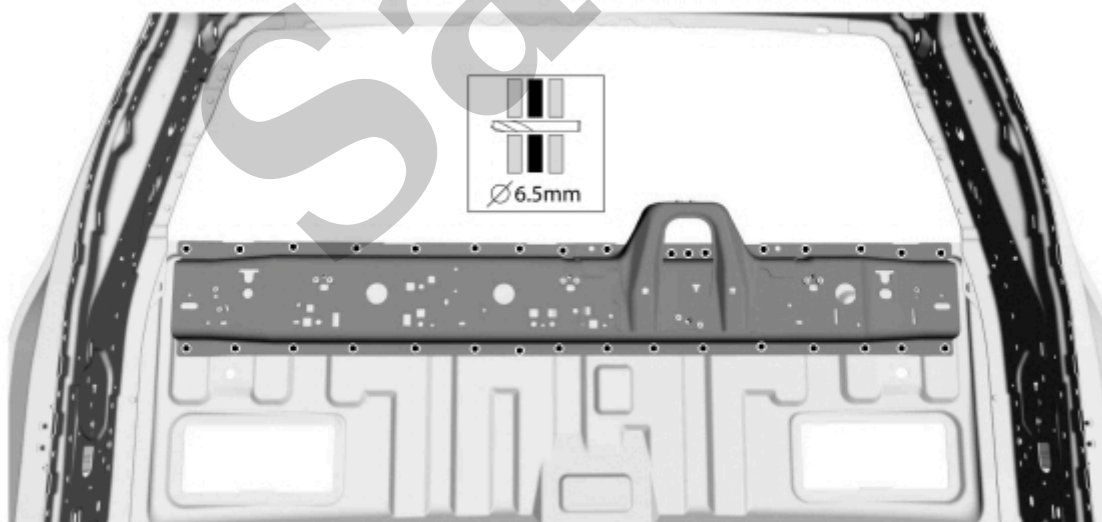


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13. Drill for rivet fasteners.

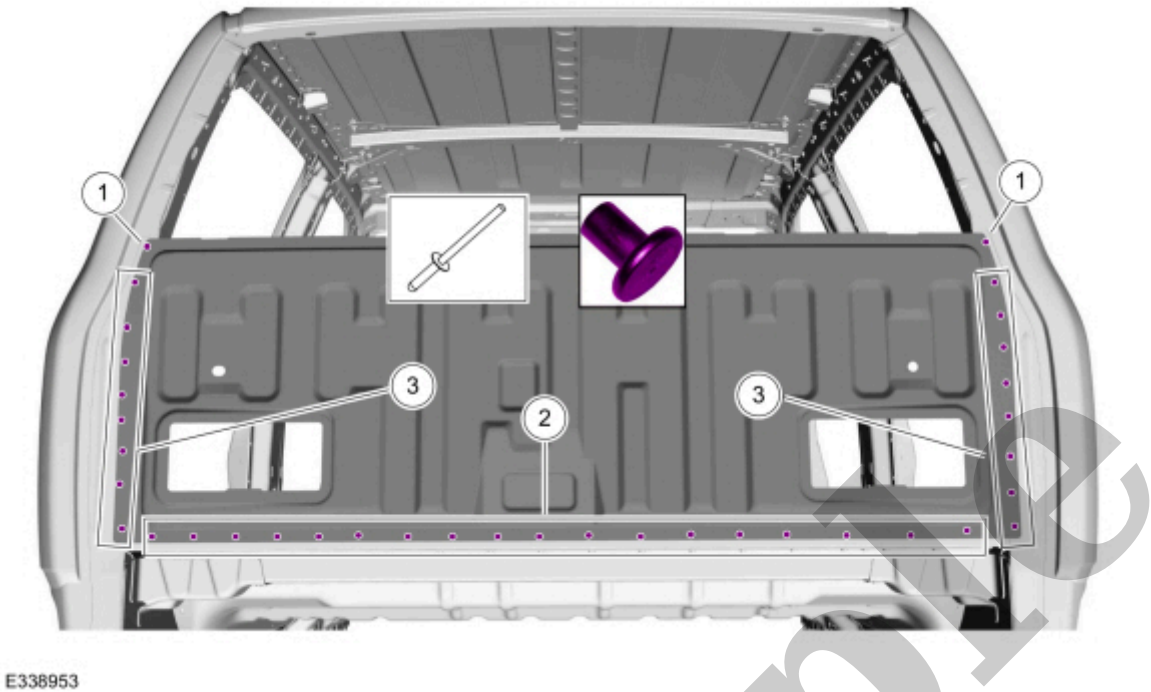
Use the General Equipment: 6.5 mm Drill Bit



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

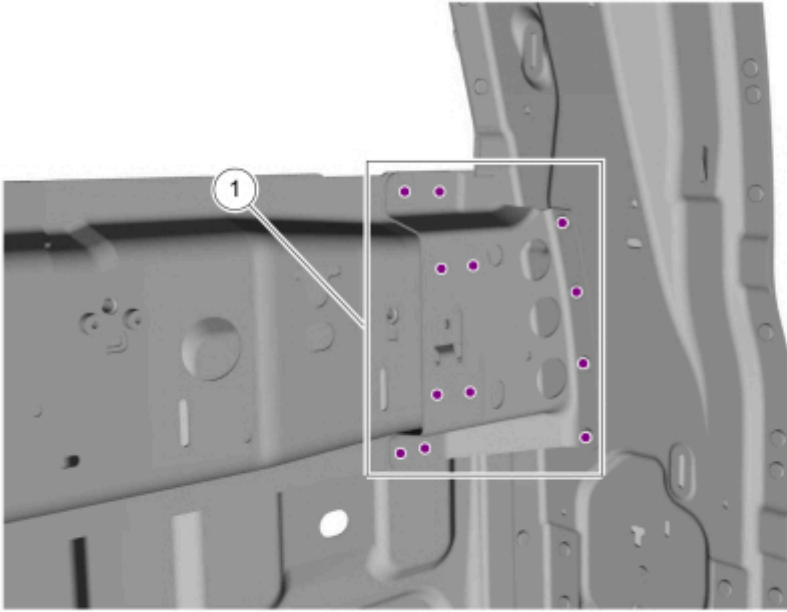


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16. Install the fasteners.

Item	SPR (self-piercing rivet) Number	SPR (self-piercing rivet) Code	Henrob® Car-O-Liner®, CMO®, Chief®, Spanesi® Wielande and Schill® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W708708-S900	AM	DY06-140H	SA-0400/SA-0402	W707638-S900C	W790377-S900	-
2	W710246-S900	BN	DZ07-000/H	SA-0400/SA-0402	W708777-S900C	W790377-S900	-
3	W709559-S900		DZ07-000/H	-	-	-	-

Use the General Equipment: Blind Rivet Gun



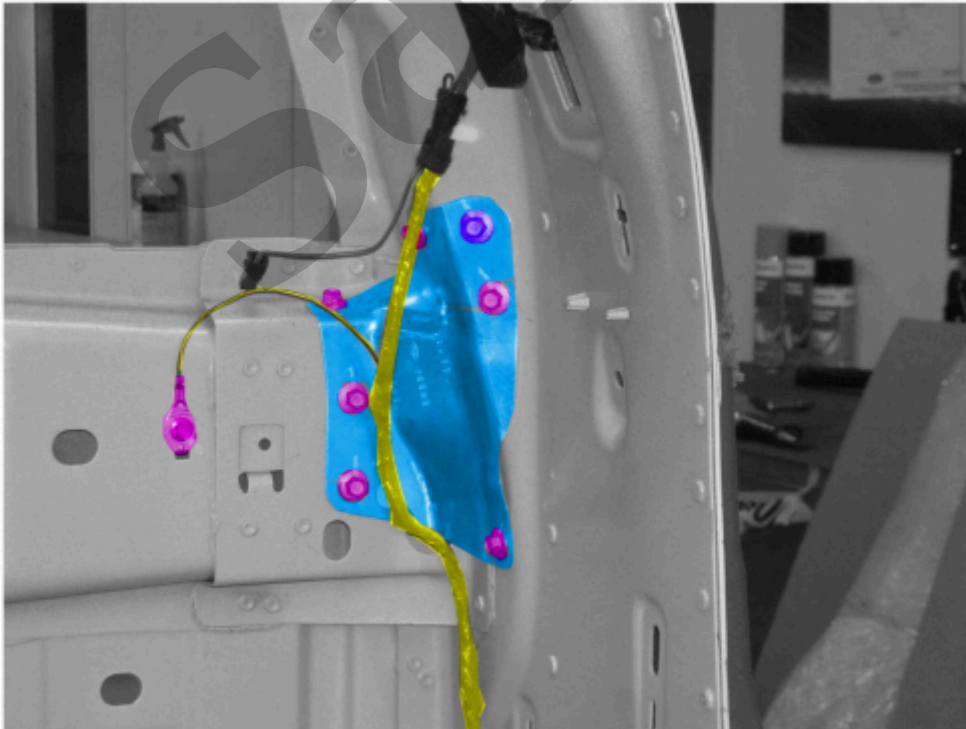
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18. On Both Sides: Regular Cab:

Install the bracket and ground wire.

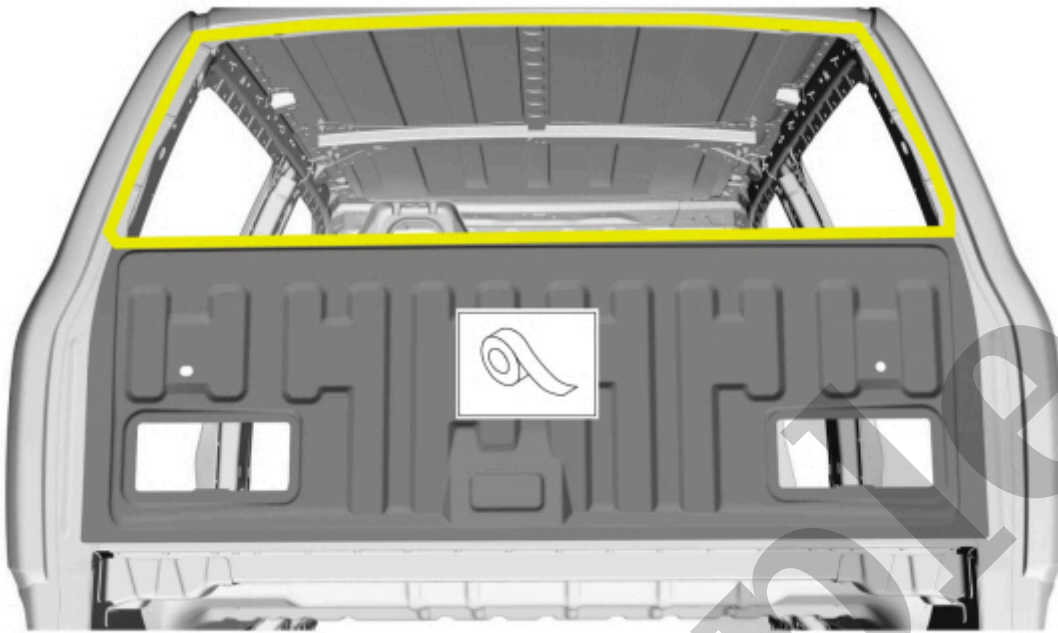
Torque : 18 lb.ft (25 Nm)



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21. Mask off the area.



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22. Refinish the entire repair area using a Ford approved paint system.

23. Unmask the area.

25. Install the rear window glass.

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

26. Install the pickup bed.

Refer to: [Pickup Bed](#)(501-04 Pickup Bed and Platform Body, Removal and Installation).

27. Install the telematics control unit module.

Refer to: [Telematics Control Unit \(TCU\) Module](#)(415-00 Information and Entertainment System - General Information, Removal and Installation).

28. Reposition carpet and wiring harness.

29. **On Both Sides.**

Install the C-pillar trim panel.

Refer to: [C-Pillar Trim Panel](#)(501-05 Interior Trim and Ornamentation, Removal and Installation).

30. Install the loadspace trim panel.

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

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

31. Install the rear seats.

Refer to: [Rear Seat LH - SuperCab](#)(501-10B Rear Seats, Removal and Installation).

Refer to: [Rear Seat RH - SuperCab](#)(501-10B Rear Seats, Removal and Installation).

Refer to: [Rear Seat LH - SuperCrew](#)(501-10B Rear Seats, Removal and Installation).

Refer to: [Rear Seat RH - SuperCrew](#)(501-10B Rear Seats, Removal and Installation).

32. Repower the SRS (supplemental restraint system) .

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