

# Your Ultimate Source for OEM Repair Manuals

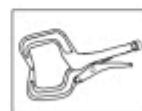
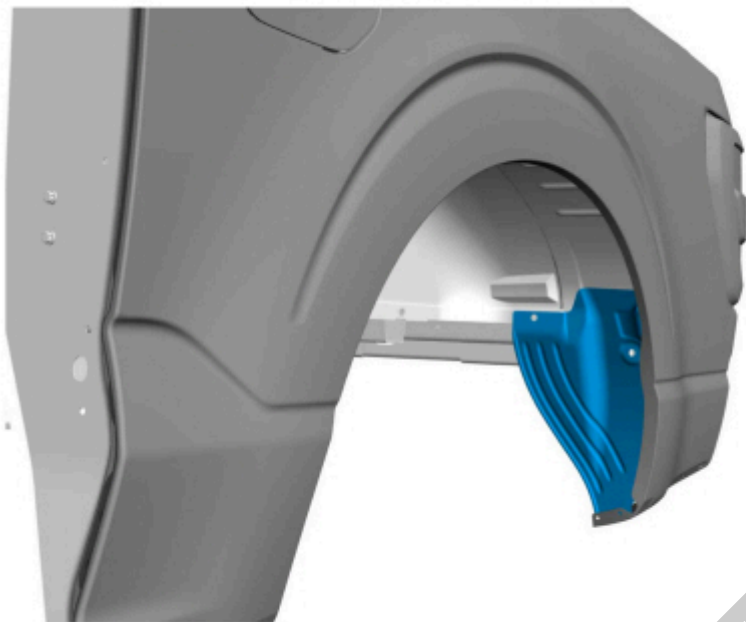
FactoryManuals.net is a great resource for anyone who wants to save money on repairs by doing their own work. The manuals provide detailed instructions and diagrams that make it easy to understand how to fix a vehicle.

## 2004 FORD Ranger Regular Cab OEM Service and Repair Workshop Manual

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9. Install the B-brace and clamp in position.

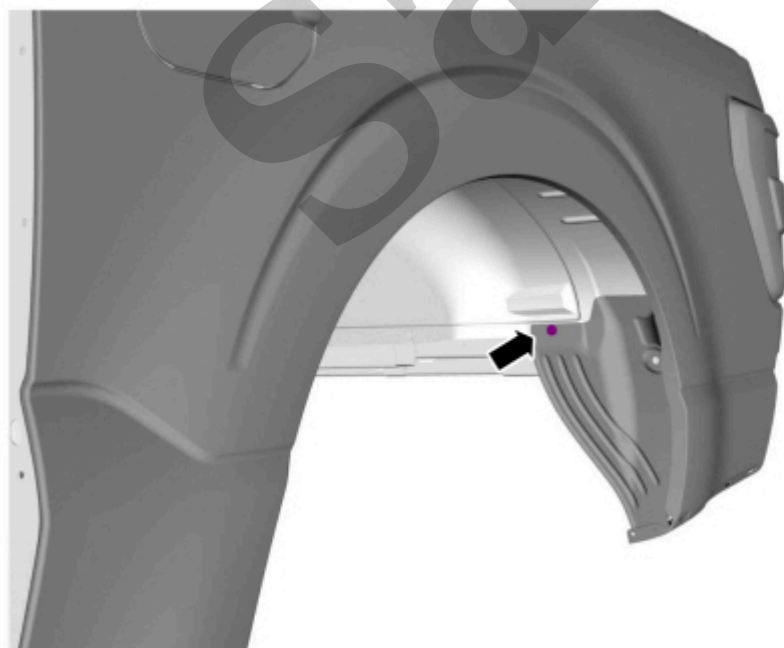
Use the General Equipment: Locking Pliers



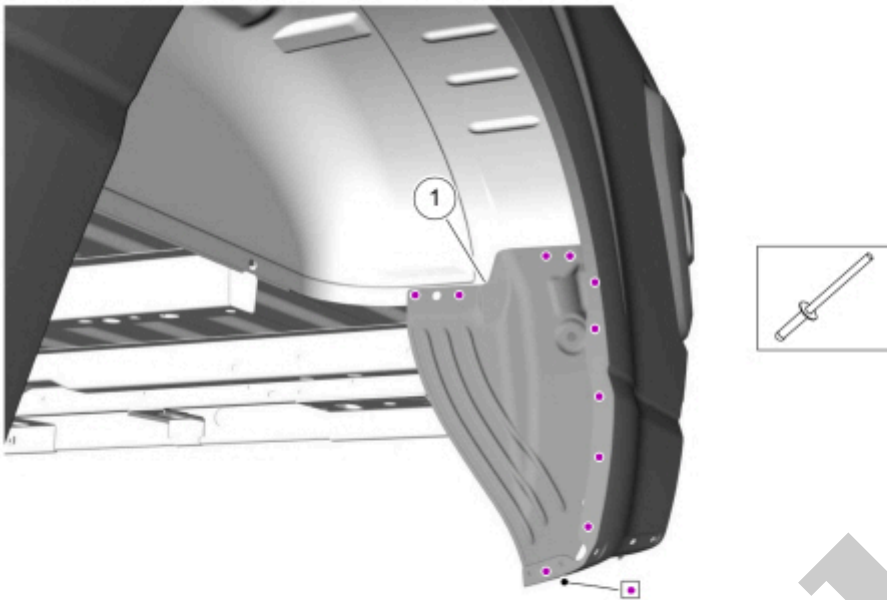
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10. Install the bolt.



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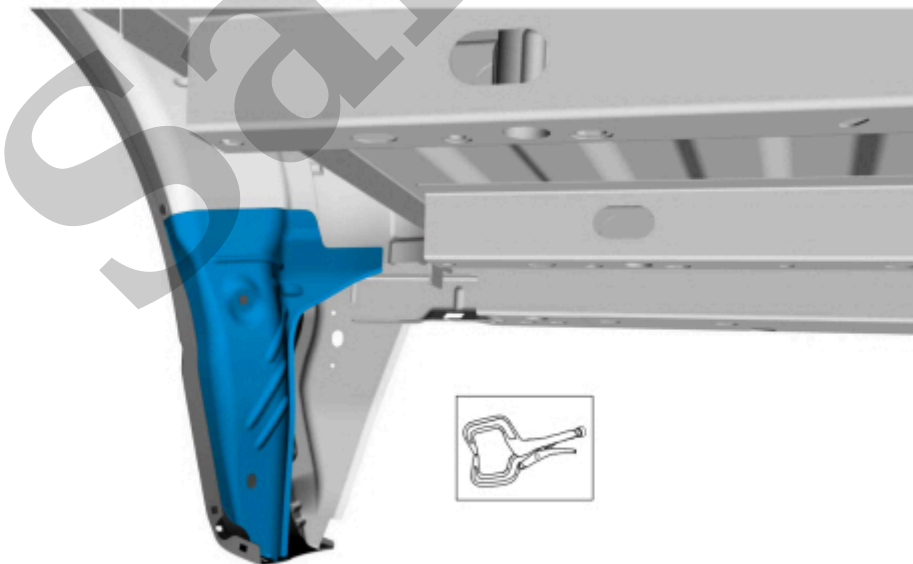


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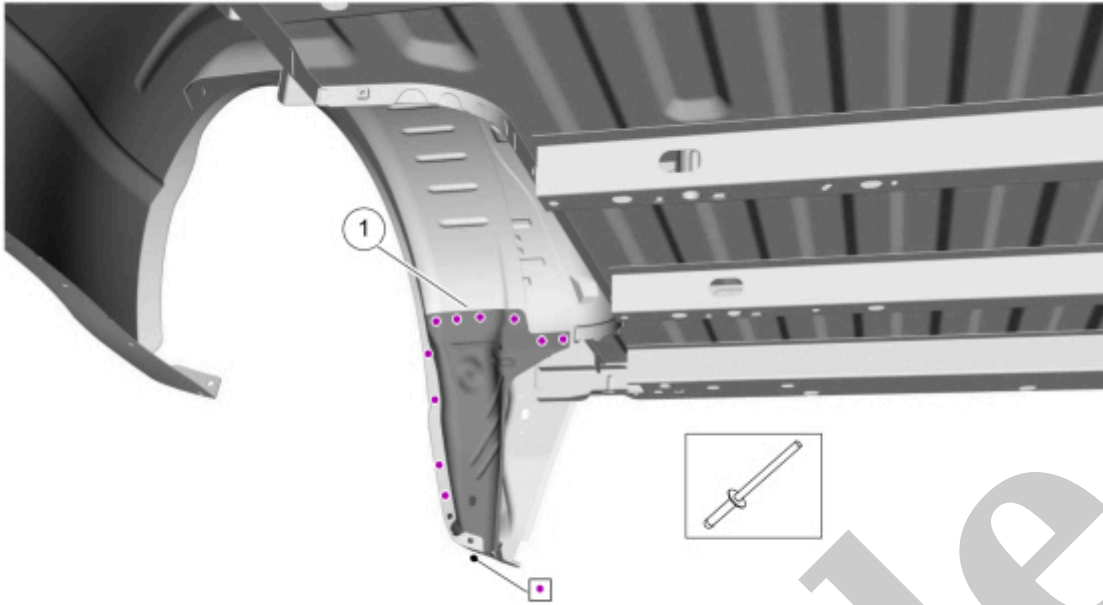
13. Install the A-brace and clamp in position.

Use the General Equipment: Locking Pliers



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#### All vehicles

##### 16. Seam Sealing:

All seams must be sealed to production level.

**Material** : Seam Sealer / TA-2-B, 3M™ 08308, LORD Fusor® 803DTM

##### 17. If Equipped:

Install the lower trim panel and wheel opening trim.

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

#### 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 (left-hand) side shown, RH (right-hand) side similar.

#### NOTE

SuperCrew cab shown, SuperCab and Regular cab similar.

2. Verify the vehicle is dimensionally correct.

Refer to: [Body and Frame](#)(501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).

3. Remove the A-pillar reinforcement.

Refer to: [A-Pillar Outer Panel Section and Reinforcement](#)(501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

4. Remove the B-pillar reinforcement.

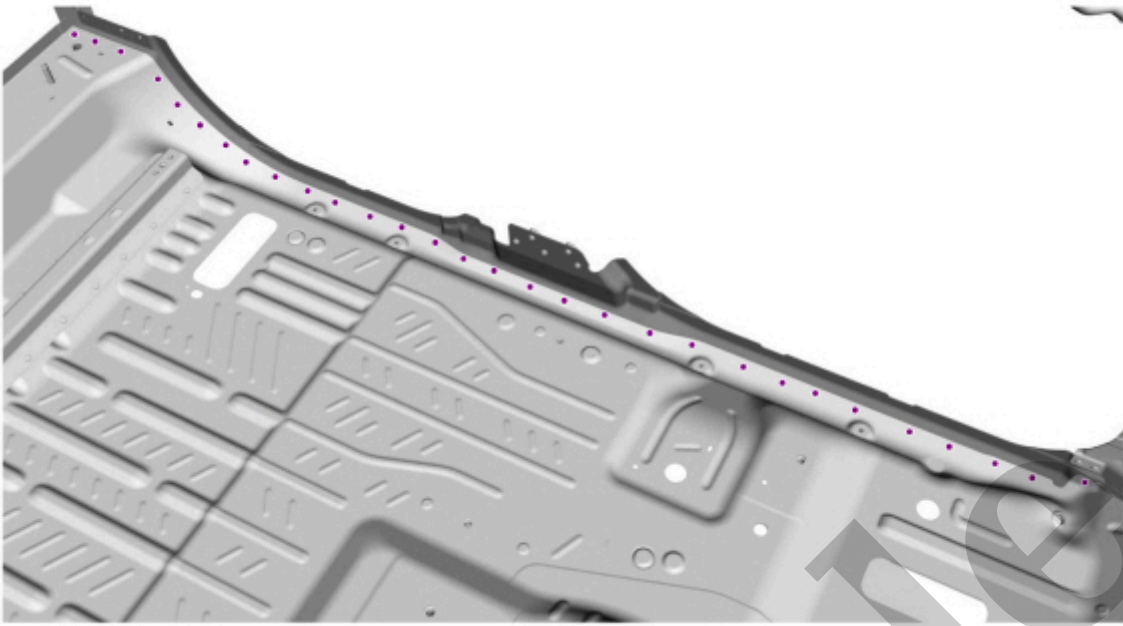
Refer to: [B-Pillar and Reinforcement - SuperCrew](#)(501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

5. **Regular cab and SuperCab.**

Remove the rocker panel inner reinforcement.

Refer to: [Rocker Panel Inner Reinforcement - SuperCab](#)(501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

Refer to: [Rocker Panel Inner Reinforcement - Regular Cab](#)(501-29 Side Panel Sheet Metal Repairs, Removal and Installation).



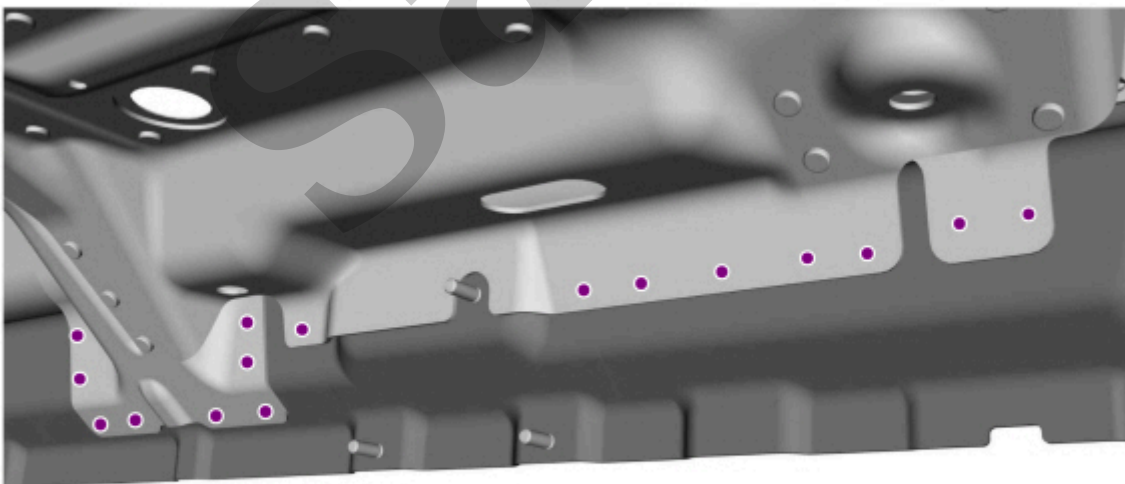
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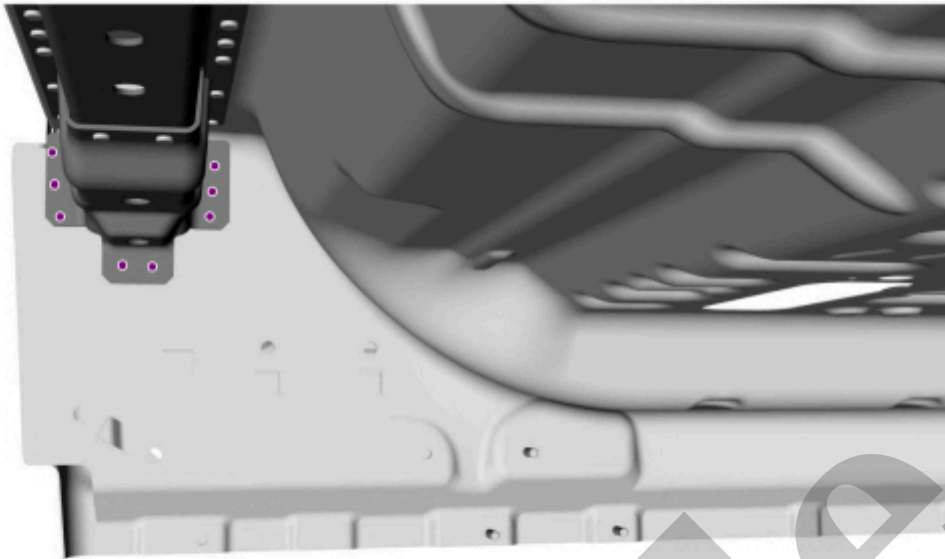
9. Remove the self-piercing fasteners.

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

Use the General Equipment: Belt Sander



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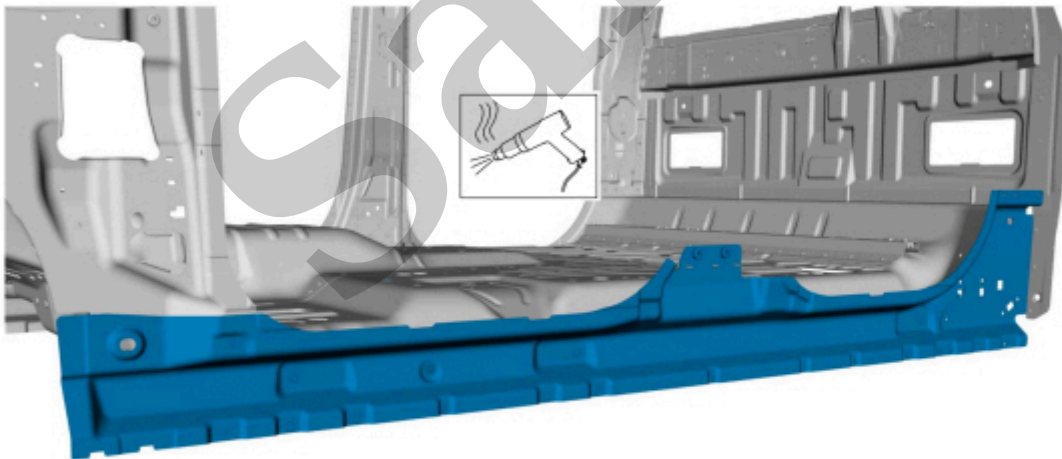


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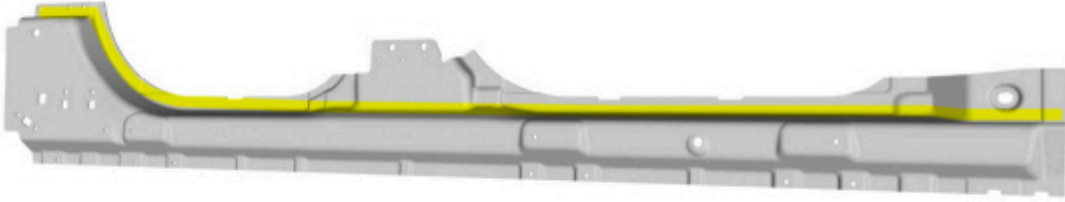
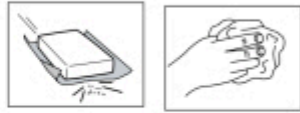
12. Break the adhesive bond and remove the floor side member reinforcement.

Use the General Equipment: Hot Air Gun



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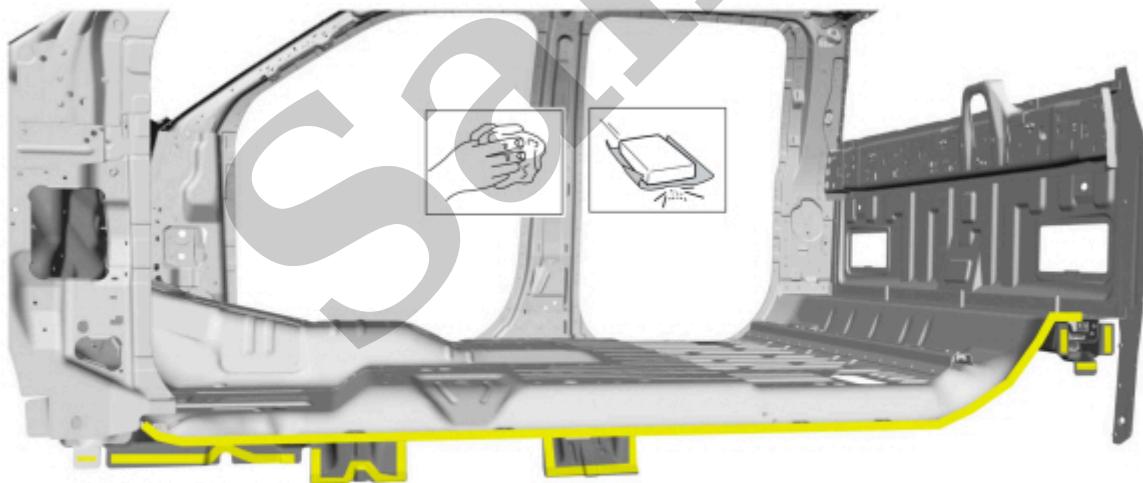
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2. Sand with 80 grit sand paper to remove old adhesive and clean.

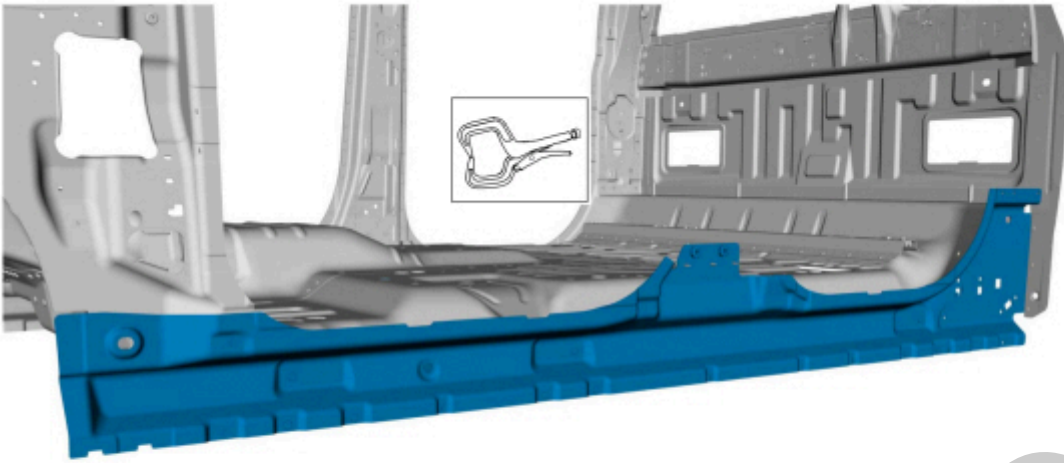


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3. Apply adhesive to the mating flanges.





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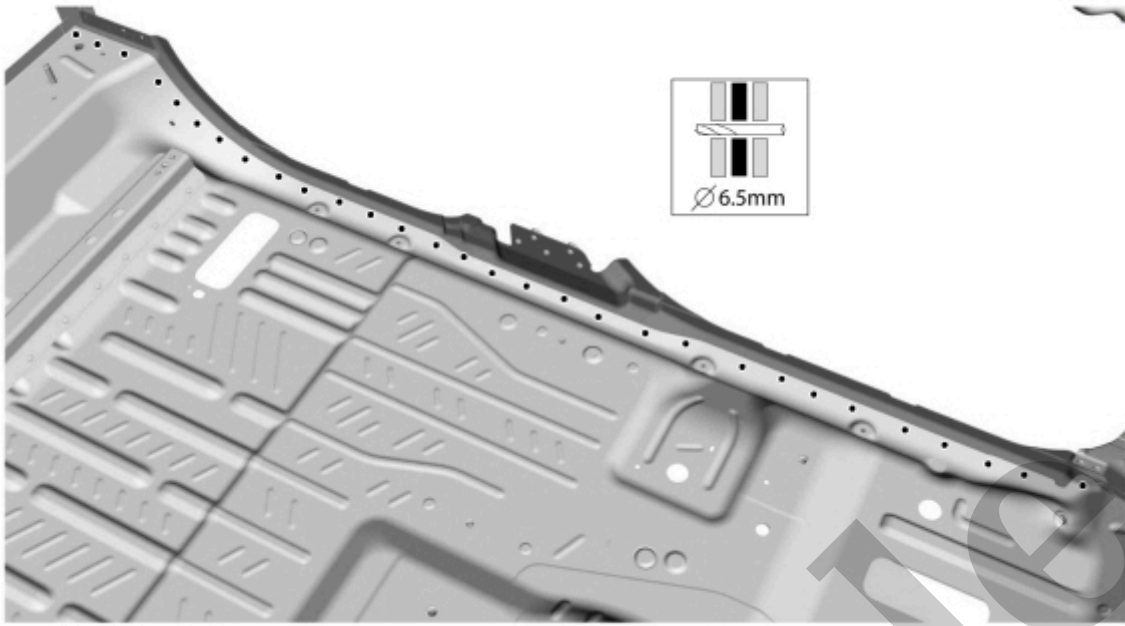
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5. **NOTE**

Solid rivets or blind rivet fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging existing holes to 6.5 mm.

Drill for rivet fasteners.

Use the General Equipment: 6.5 mm Drill Bit



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7. Install rivet 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	W713404-S900	FC	DZ07-000/H	SA-0400/SA-0401	W702512-S900C	-	-

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

Use the General Equipment: Blind Rivet Gun