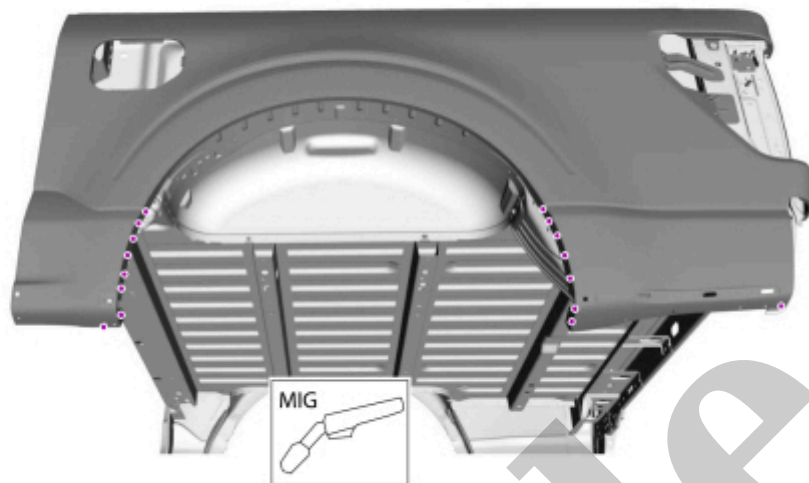


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## 2005 FORD Ranger Regular Cab OEM Service and Repair Workshop Manual

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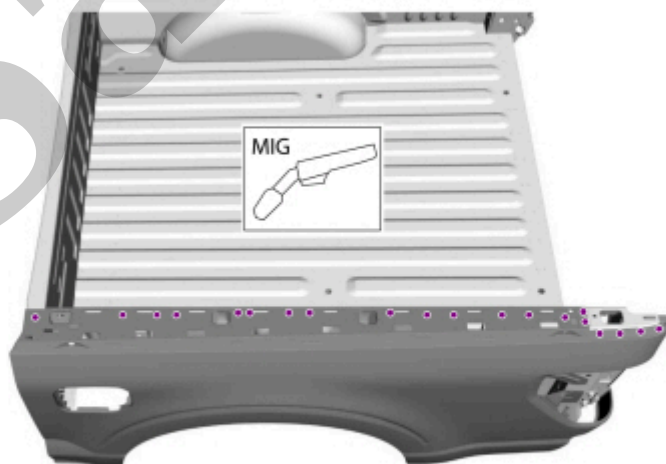


E334453

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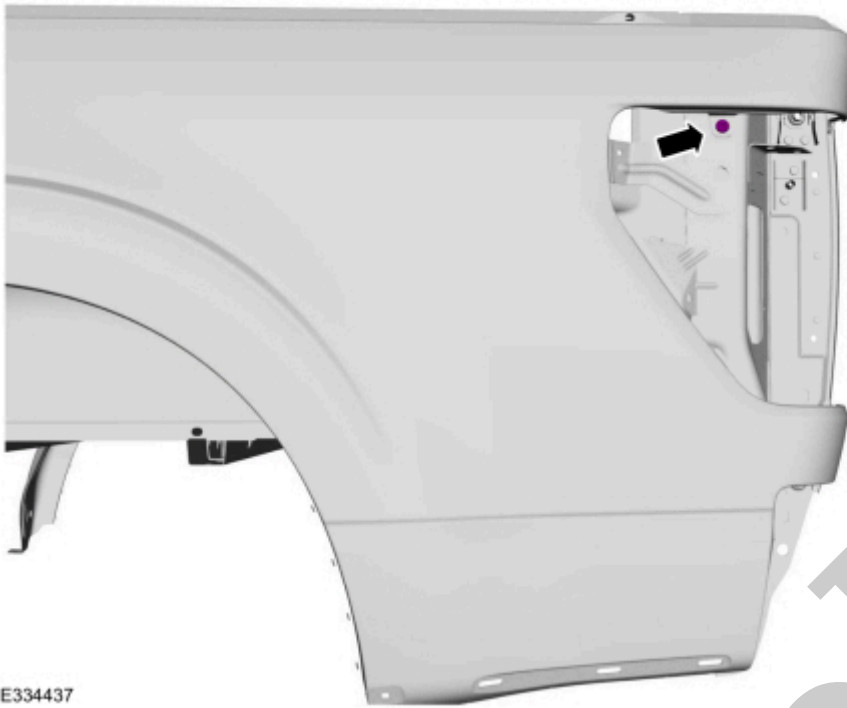
29. Install aluminum MIG (metal inert gas) plug welds.

Use the General Equipment: MIG/MAG Welding Equipment



E334456

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E334437

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33. Seam Sealing: All seams must be sealed to production level.

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

34. Refinish the repair using a Ford approved paint system and typical refinishing techniques.

35. Install the pickup bed.

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

36. LH (left-hand) side only:

Install the fuel fill door and fuel fill cup.

Refer to: [Fuel Filler Door Assembly](#)(501-03 Body Closures, Removal and Installation).

Refer to: [Fuel Filler Door](#)(501-03 Body Closures, Removal and Installation).

37. Install the tail lamp assembly.

Refer to: [Rear Lamp Assembly](#)(417-01 Exterior Lighting, Removal and Installation).

38. **If Equipped:**

Install the top rail cover, wheel house opening and lower side trim.

39. Install the tailgate.



## Rear Wheelhouse

<b>501-30 Rear End Sheet Metal Repairs</b>	<b>2022 F-150</b>
<b>Removal and Installation</b>	<b>Procedure revision date: 09/25/2020</b>

### Rear Wheelhouse

#### Removal

#### WARNING

Electric vehicles damaged by a crash may have compromised high voltage safety systems and present a potential high voltage electrical shock hazard. Exercise caution and wear appropriate Personal Protective Equipment (PPE) safety gear, including high voltage safety gloves and boots. Remove all metallic jewelry, including watches and rings. Isolate the HV system as directed by the Ford Emergency Response Guide for the vehicle. Failure to follow these instructions may result in serious personal injury or death.

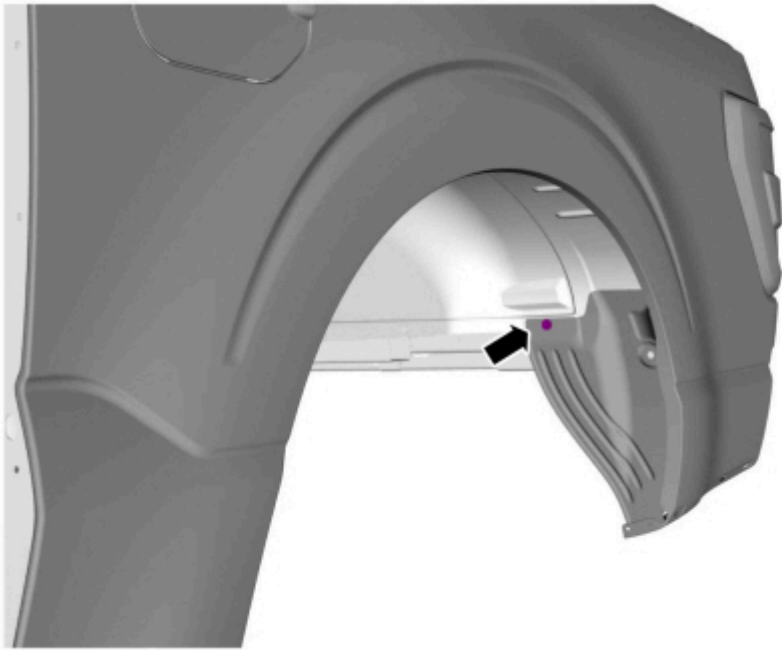
#### NOTICE

Battery electric vehicle (BEV), hybrid electric vehicle (HEV) and plug-in hybrid electric vehicle (PHEV) contain a high-voltage battery. Before cutting or welding near the high-voltage battery it must be removed to avoid damage.

#### NOTE

6.5 foot pickup bed shown, 5.5 foot and 8 foot pickup bed similar.

#### NOTE



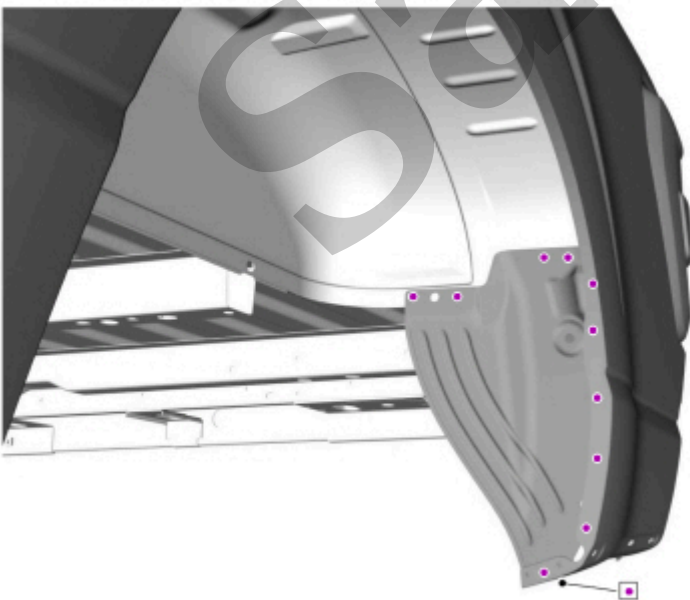
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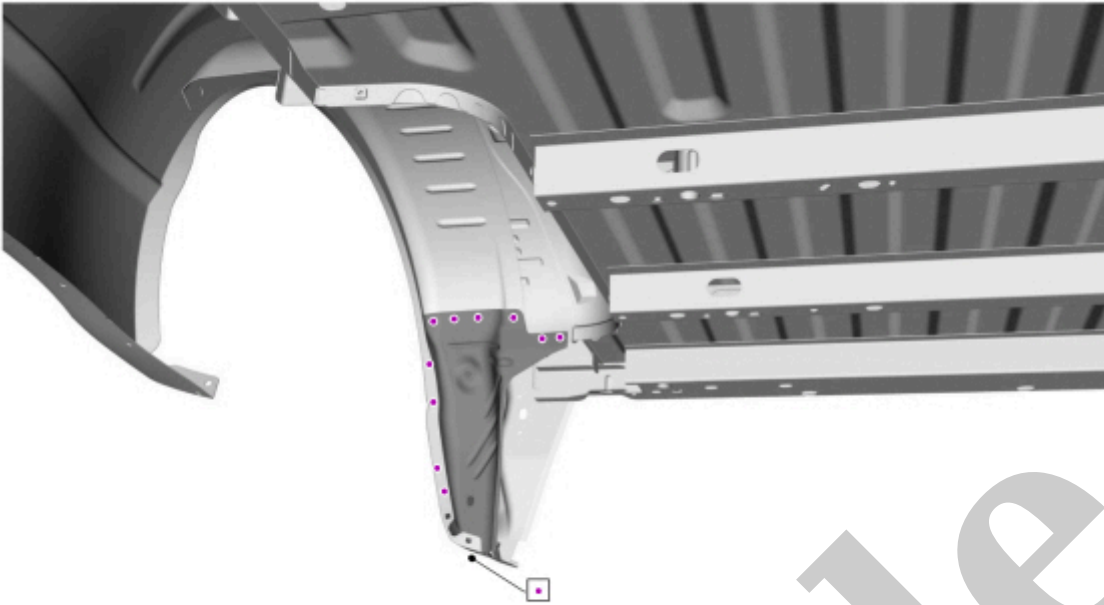
4. Remove the B-brace SPR (self-piercing rivet) fasteners.

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

Use the General Equipment: Belt Sander



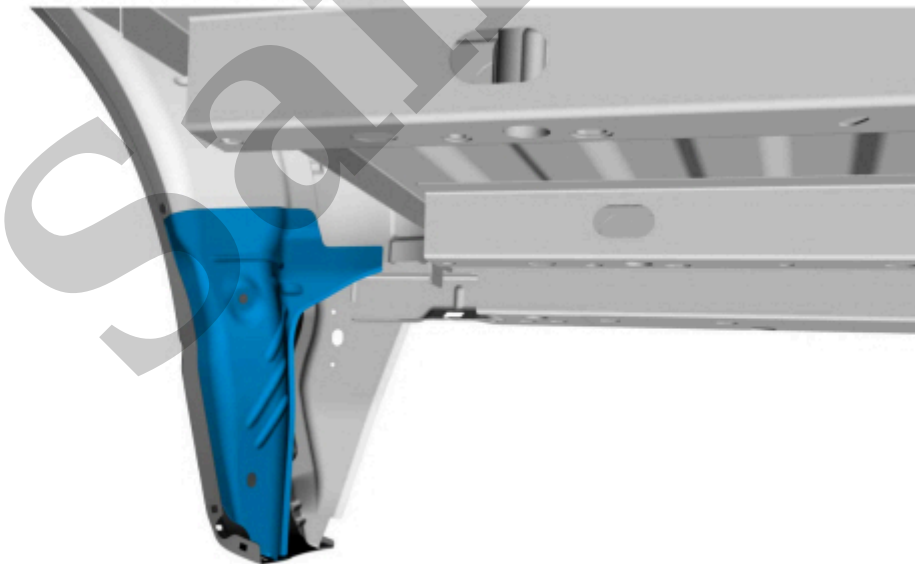
E334698



E334700

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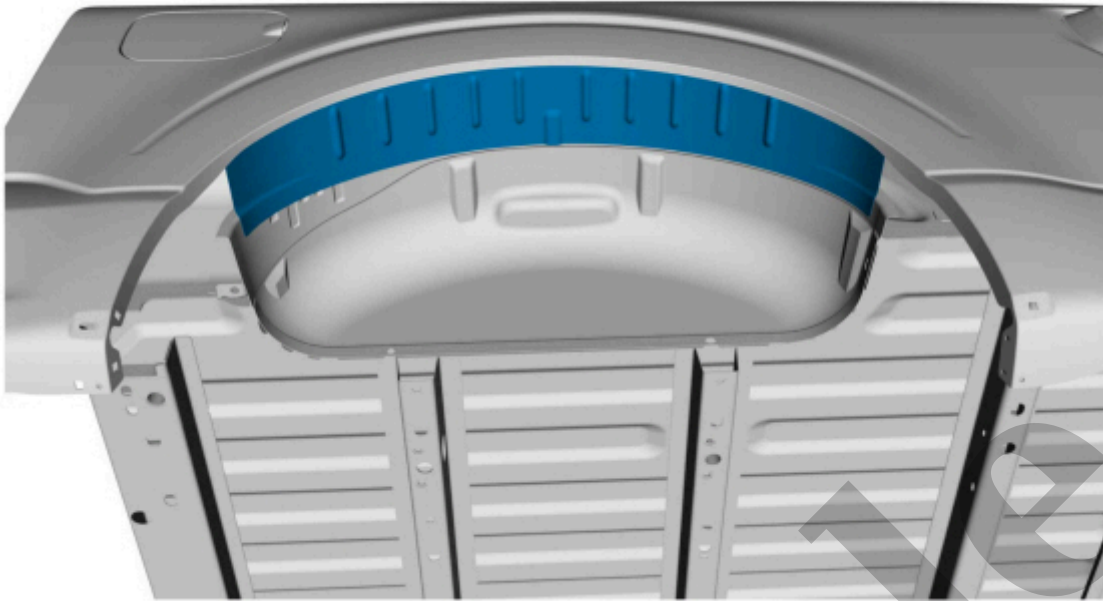
7. Remove the A-brace.



E334701

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8. Remove the inner to outer wheelhouse SPR (self-piercing rivet) fasteners.



E334703

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### **Inner Wheelhouse**

10. Remove the SPR (self-piercing rivet) fasteners.

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

Use the General Equipment: Belt Sander

## NOTE

6.5 foot pickup box shown, 5.5 foot and 8 foot similar.

## 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.

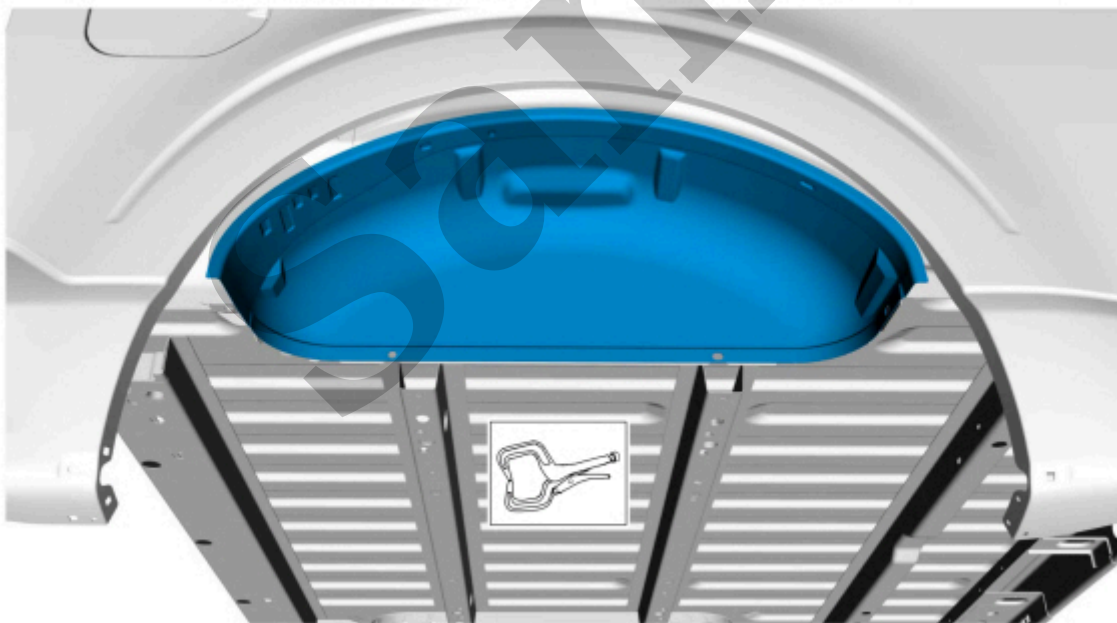
## NOTE

Blind or solid rivet fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging holes to 6.5 mm.

### Inner Wheelhouse

1. Install the inner wheelhouse and clamp in position.

Use the General Equipment: Locking Pliers



E334706

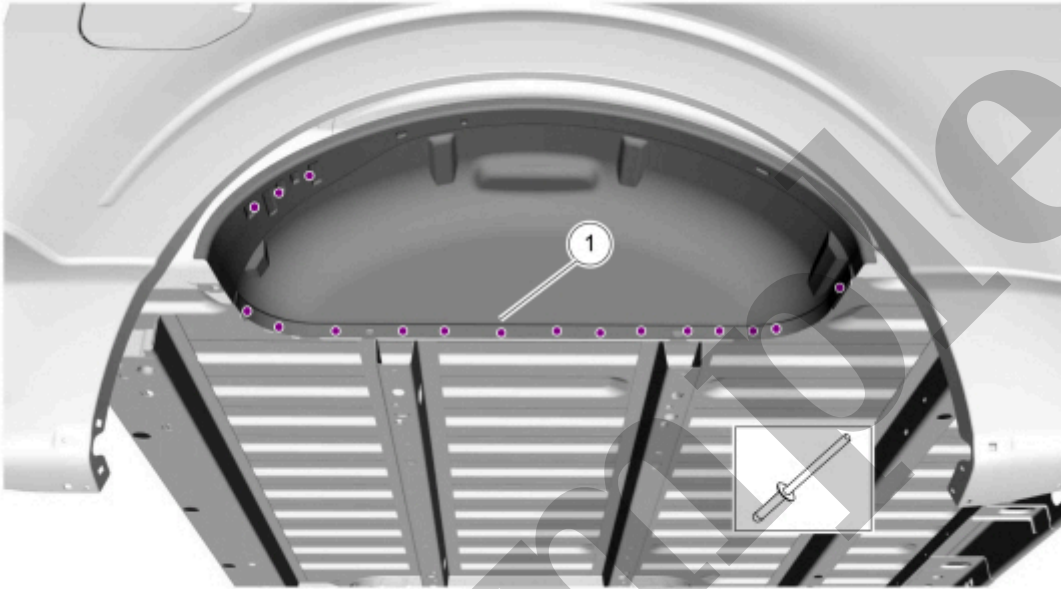
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## 2. NOTE



	rivet) Number	rivet) Code	Spanesi®, Wielander and Schill® Mandrel				
1	-	-	-	-	W707638- S900C	-	-

Use the General Equipment: Blind Rivet Gun



E334708

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### Outer Wheelhouse

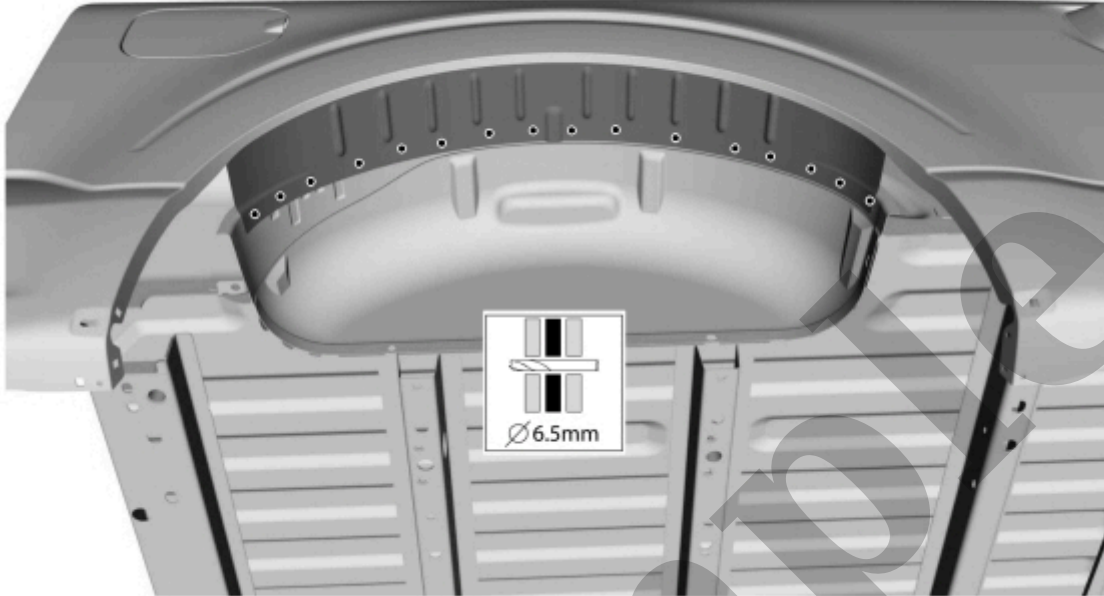
4. Apply adhesive to the outer wheelhouse to body side mating surface.

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

holes to 6.5 mm.

Drill for fastener installation.

Use the General Equipment: 6.5 mm Drill Bit



E334710

[Click here to learn about symbols, color coding, and icons used in this manual.](#)

#### 7. NOTE

Blind or solid rivet fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging holes to 6.5 mm.

Install outer to inner wheelhouse blind rivet fasteners.

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

Use the General Equipment: Blind Rivet Gun