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2009 FORD Ranger Super Cab OEM Service and Repair Workshop Manual

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Refer to: [Roof Opening Panel Frame](#)(501-17 Roof Opening Panel, Removal and Installation).

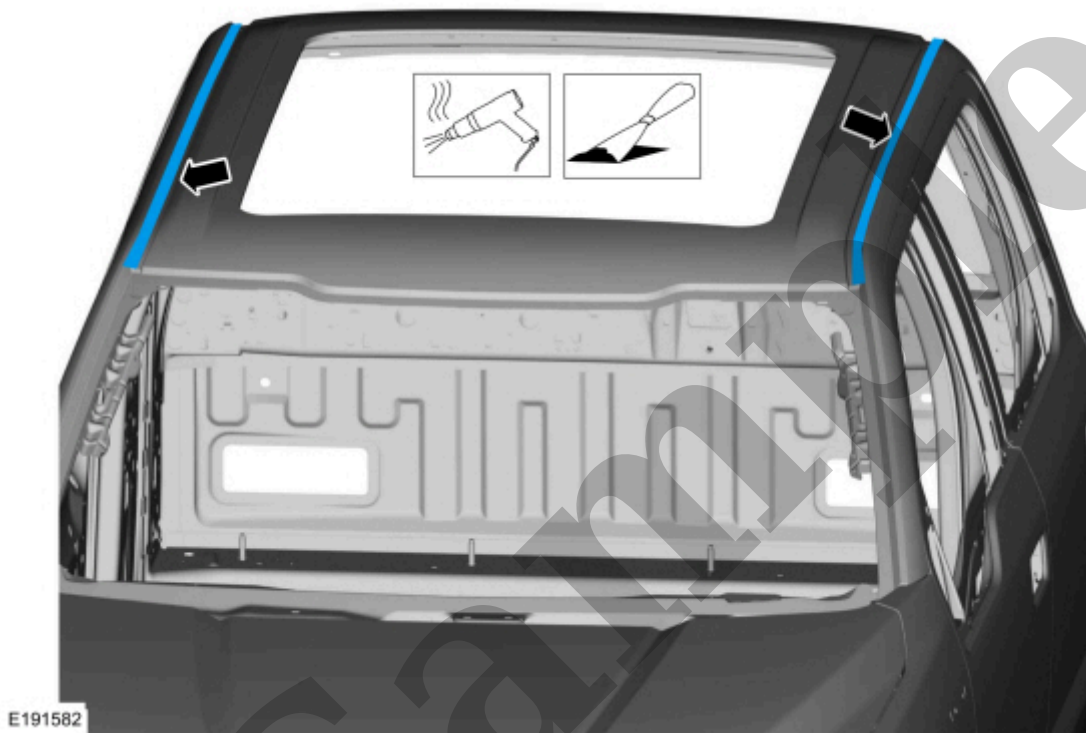
9. Remove the side curtain air bags.

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

10. Remove the roof ditch sealer.

Use the General Equipment: Hot Air Gun

Use the General Equipment: Scraper for Straight Edges



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11. Remove the front 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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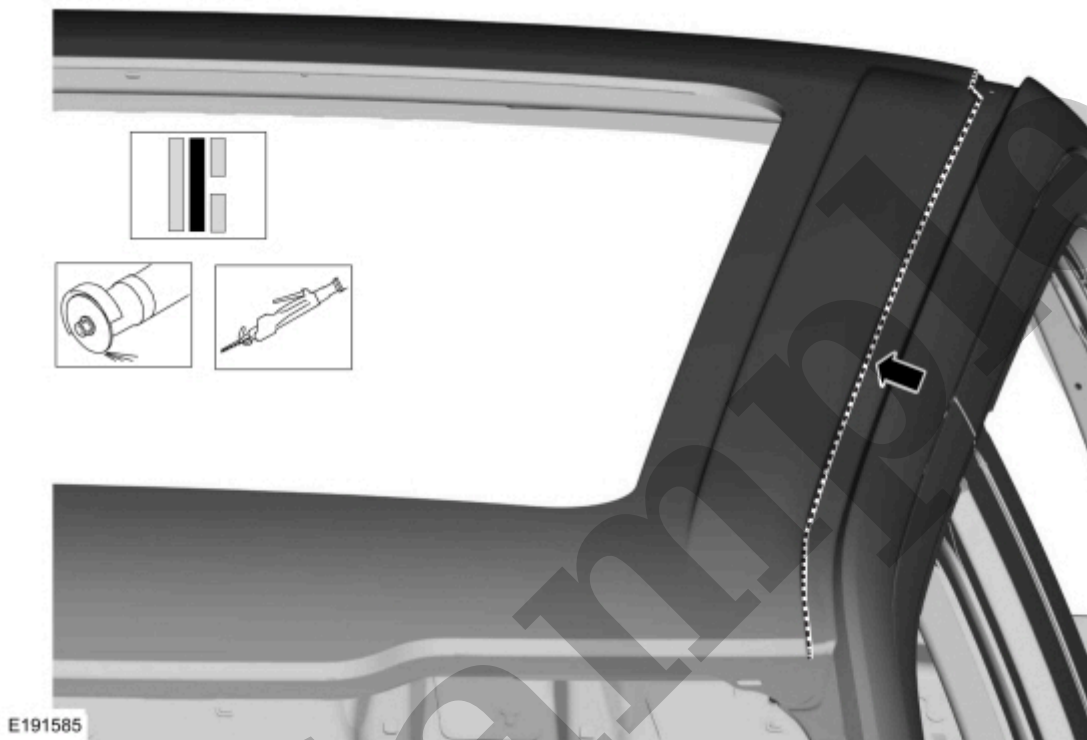
13. Carefully cut the roof

outer panel only

in the area shown (inboard on the roof ditch, both sides).

Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter

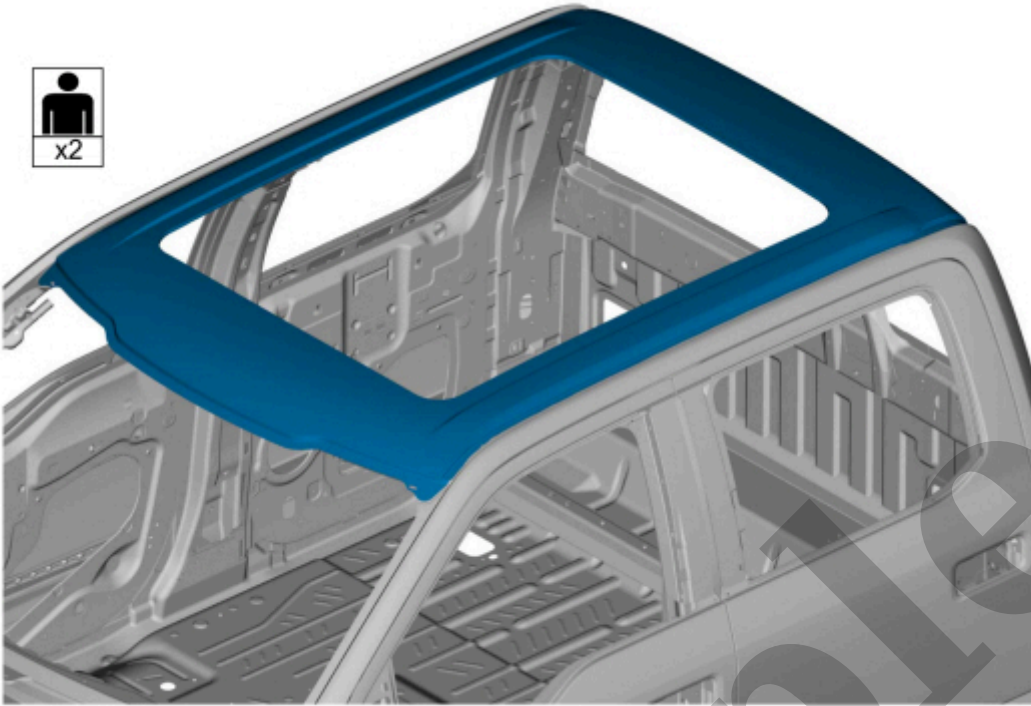


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14. Separate the foam and adhesive between the body and roof panel leaving as much foam intact as possible on the roof supports.

Use the General Equipment: Knife

16. With the help of an assistant remove the roof panel.



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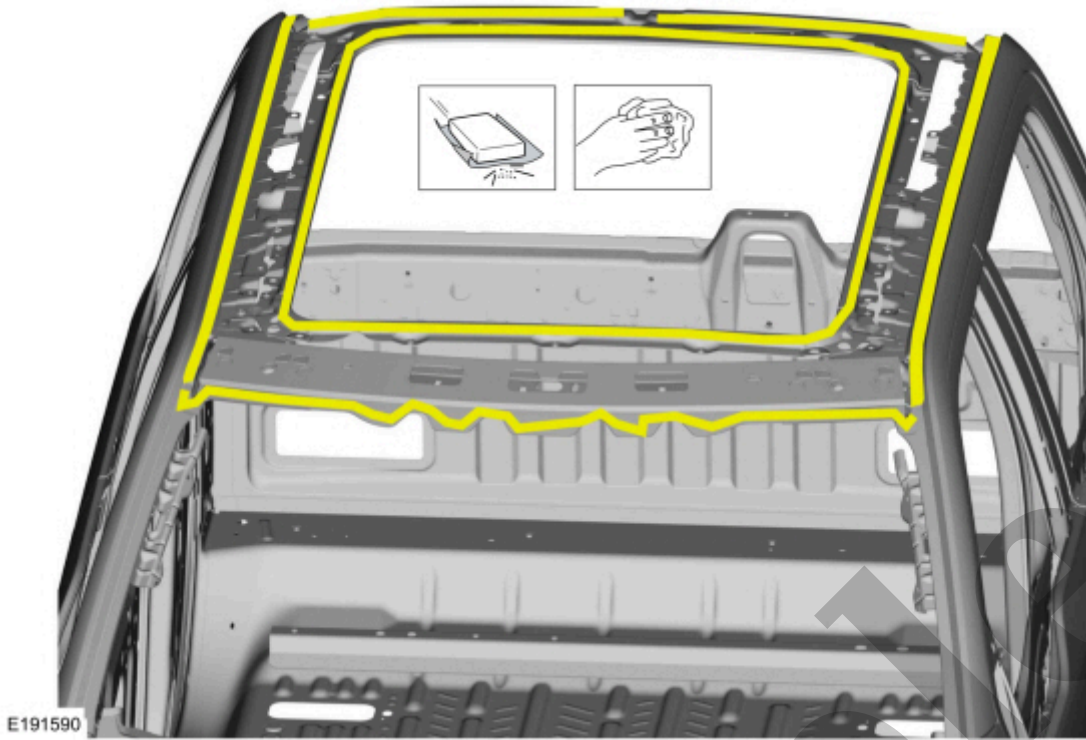
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17. **NOTE**

Carefully grind the area smooth removing remaining portions of the factory laser weld. use caution to avoid thinning of the metal.

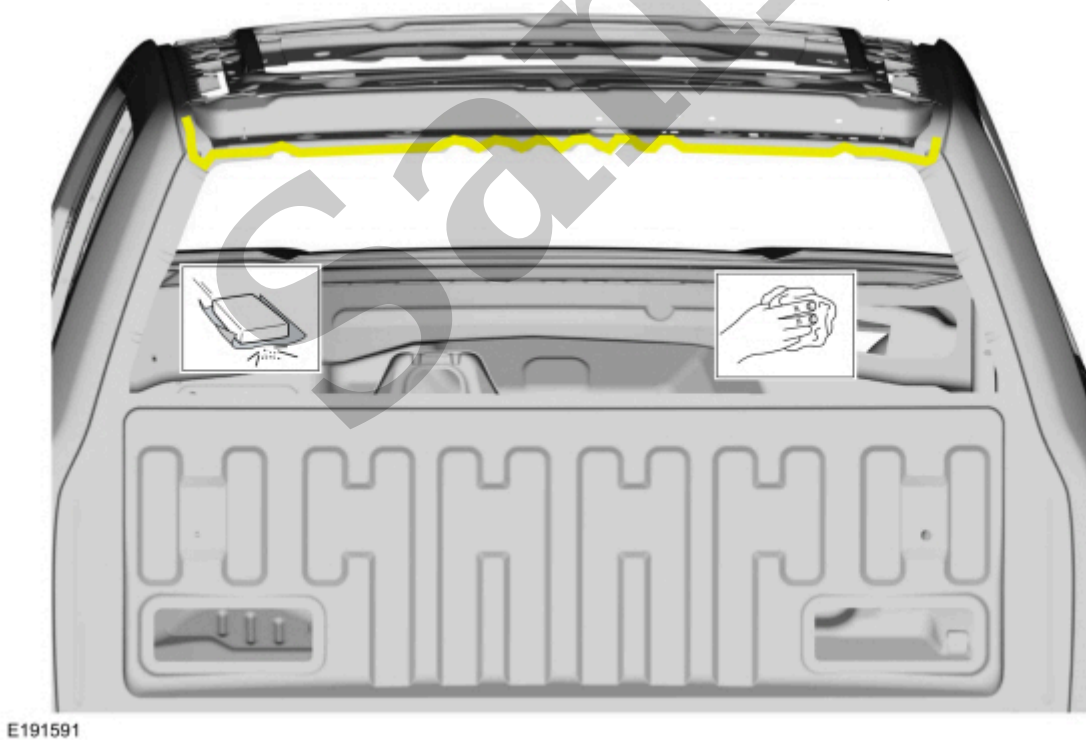
Using a grinder or air chisel, carefully remove the remaining portion of the roof panel flange and laser weld bead.

Use the General Equipment: Grinder



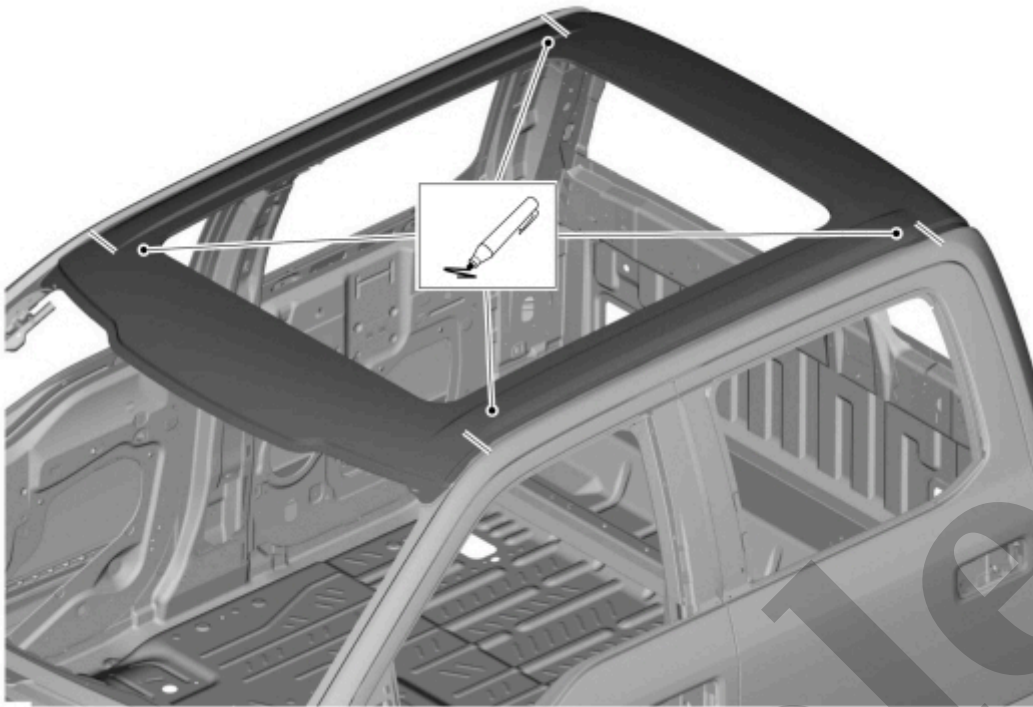
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3. Sand to remove any remaining adhesive in the rear flange and clean.



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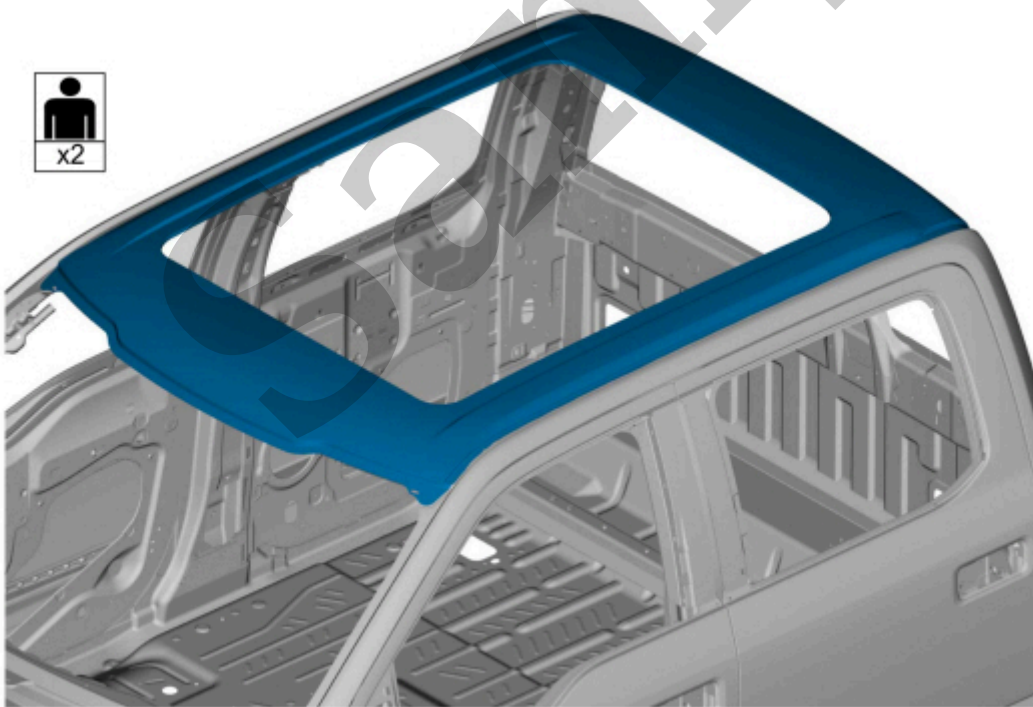
4. Sand to remove the e-coat and clean the roof panel mating surface using 80 grit sandpaper.



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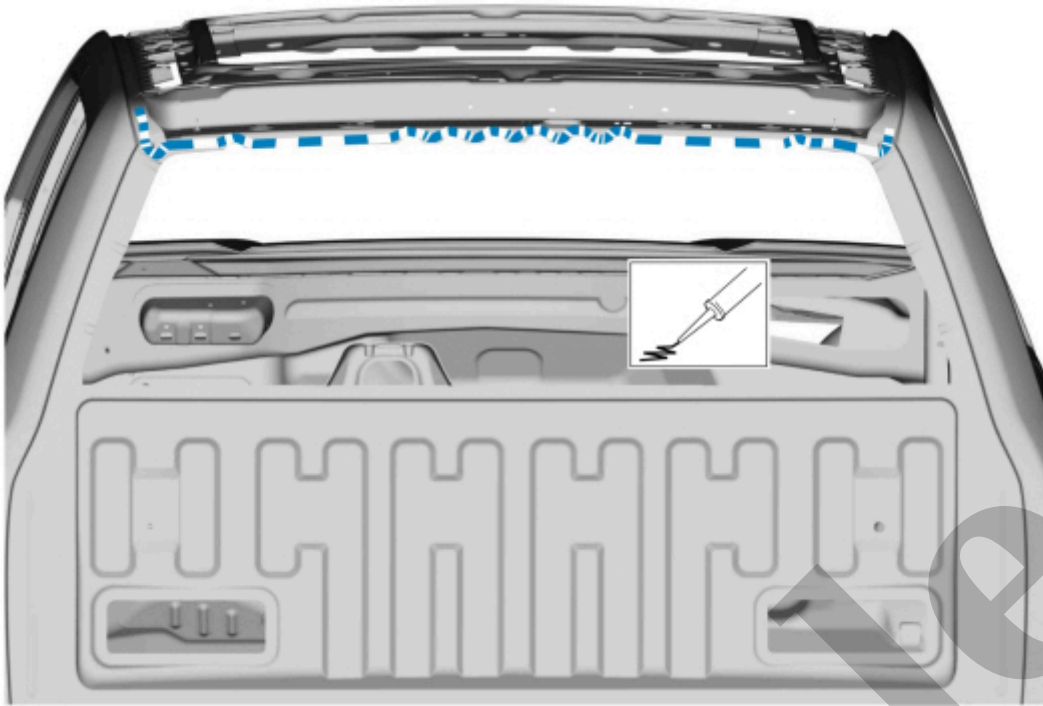
7. With the help of an assistant, remove the roof outer panel.



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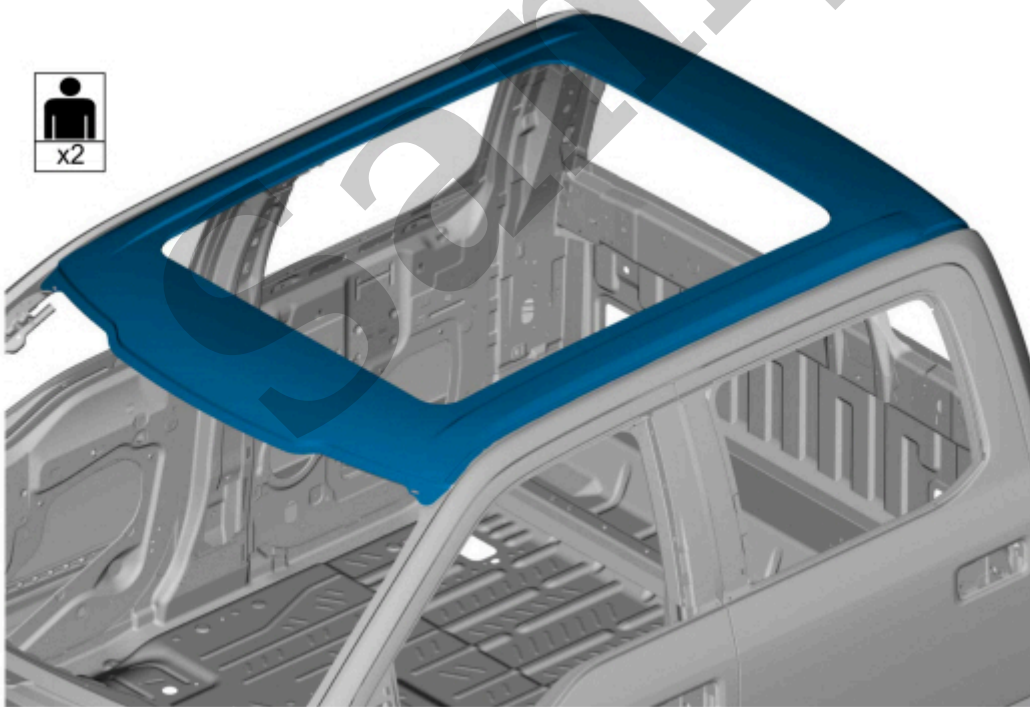
8. Apply adhesive to the roof opening reinforcement, front header and roof ditch area mating surfaces.



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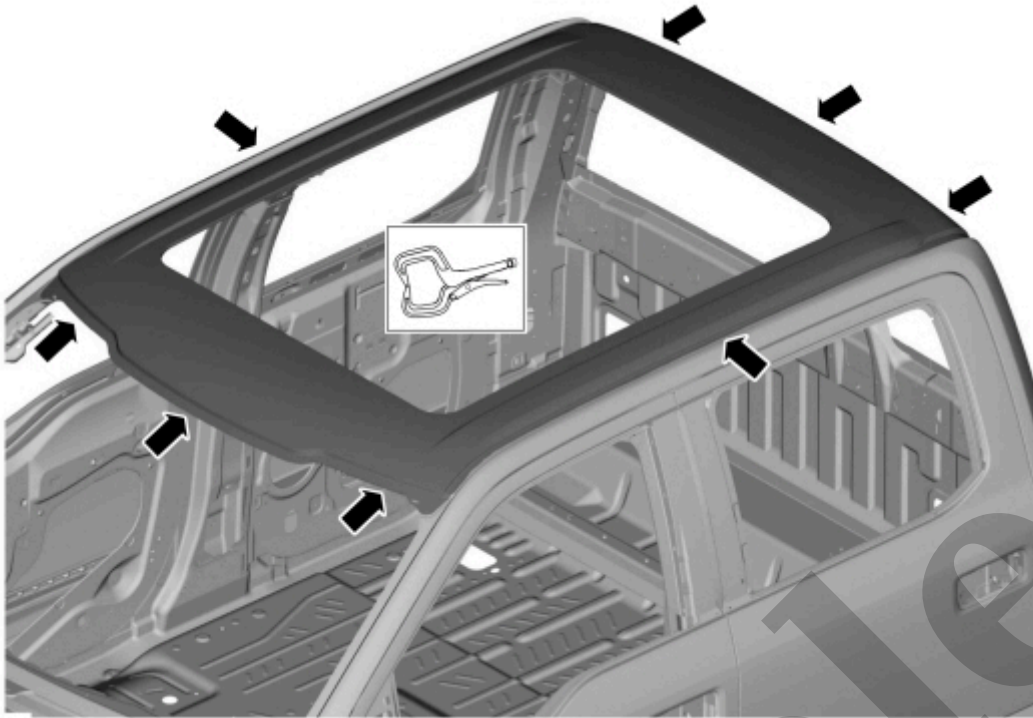
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10. With the help of an assistant, install the roof outer panel.



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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

Solid rivets may be used in place of SPR (self-piercing rivet) fasteners in the original SPR (self-piercing rivet) location after enlarging hole to 6.5 mm.

Install the 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	W708713-S900	AS	DP10-200H	SA-0400/SA-0401	-	W790376-S900	-

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

Install the 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	W709559-S900	AT	DZ07-000/H	SA-0400/SA-0401	-	W790376-S900	-
2	W710246-S900	BN	DP10-200/H	SA-0400/SA-0401	-	W790376-S900	-
3	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0401	-	W790376-S900	-

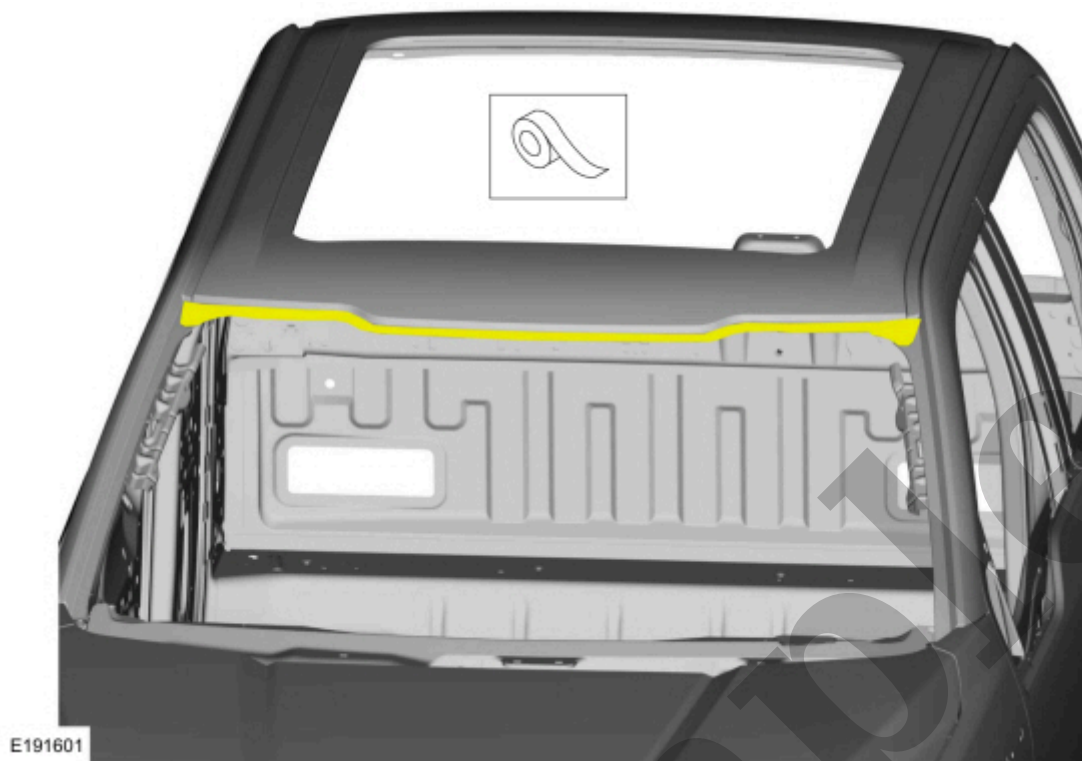
Refer to: [Joining Techniques](#)(501-25 Body Repairs - General Information, General Procedures).

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

Use the General Equipment: Blind Rivet Gun

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

17. Mask off the windshield glass channel.



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18. Apply roof ditch sealer following manufacturer's directions.

Material : Roof Ditch Sealer / 3M™ 08307, LORD Fusor® 129