

# Your Ultimate Source for OEM Repair Manuals

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## 2010 FORD Ranger Super Cab OEM Service and Repair Workshop Manual

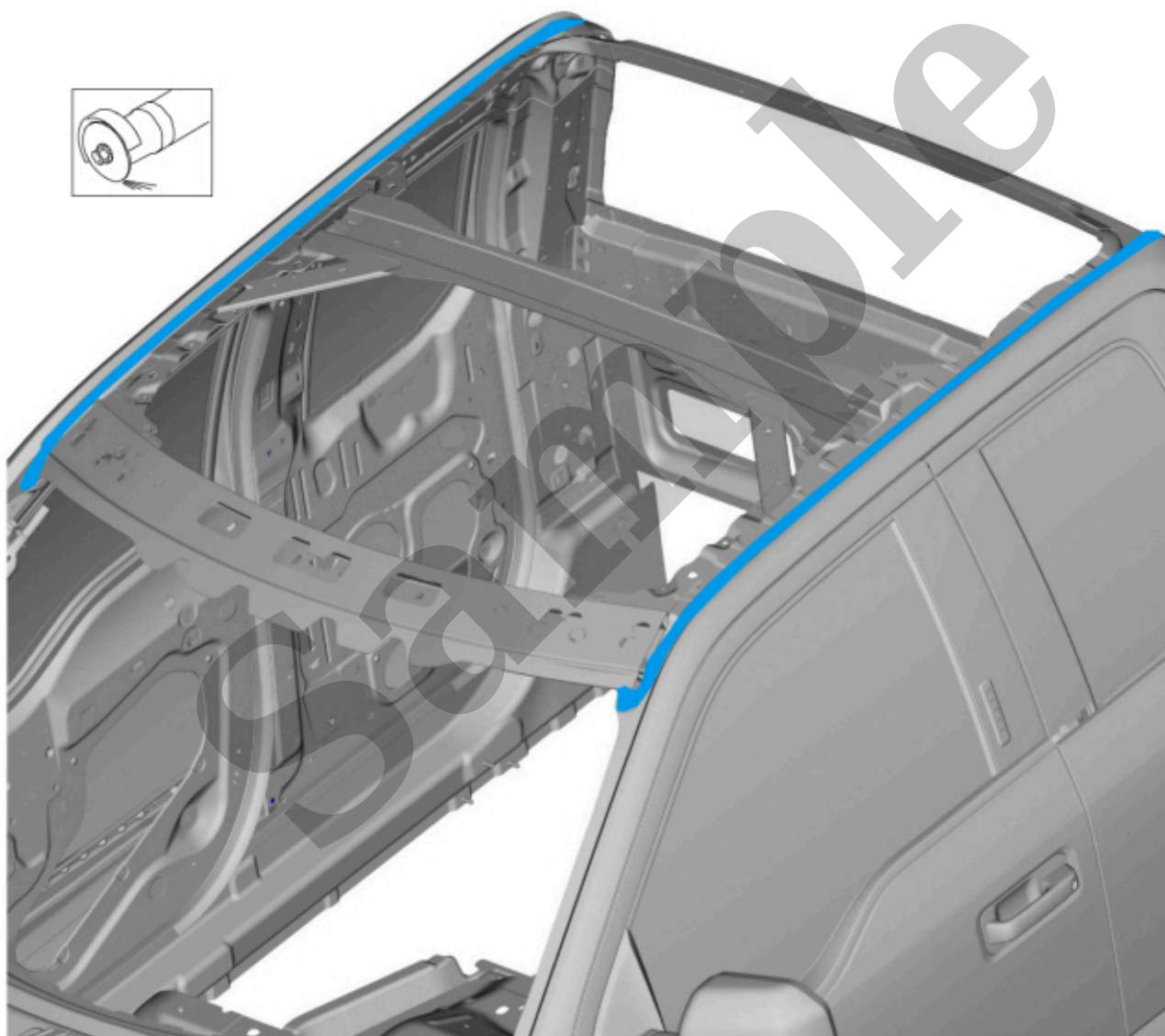
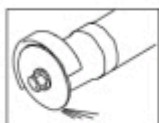
[Go to manual page](#)

16. **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.

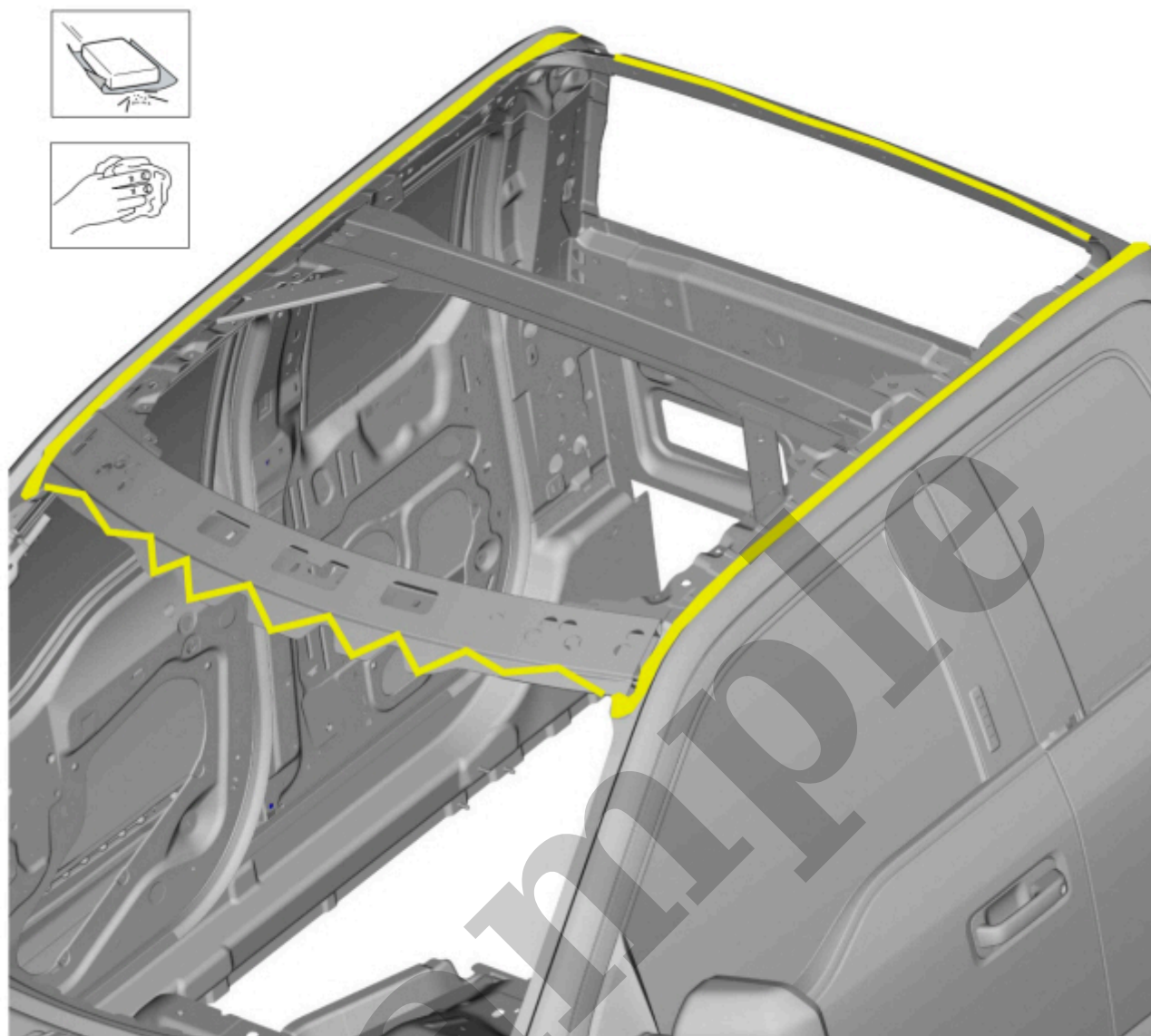
Use the General Equipment: Grinder



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

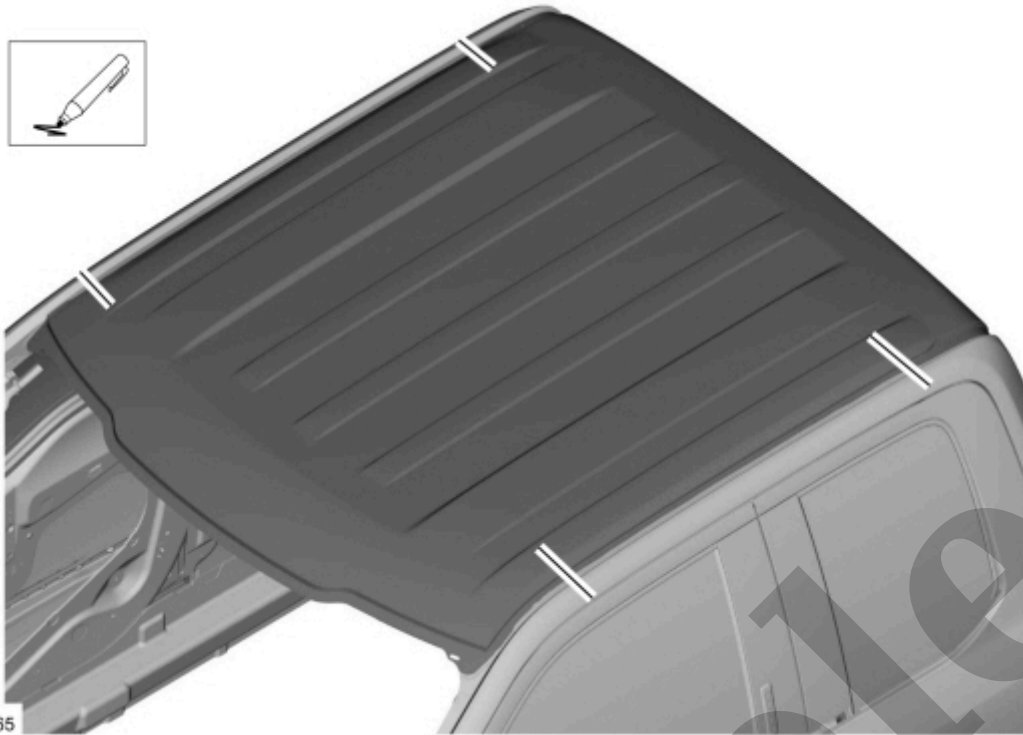
## Installation



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



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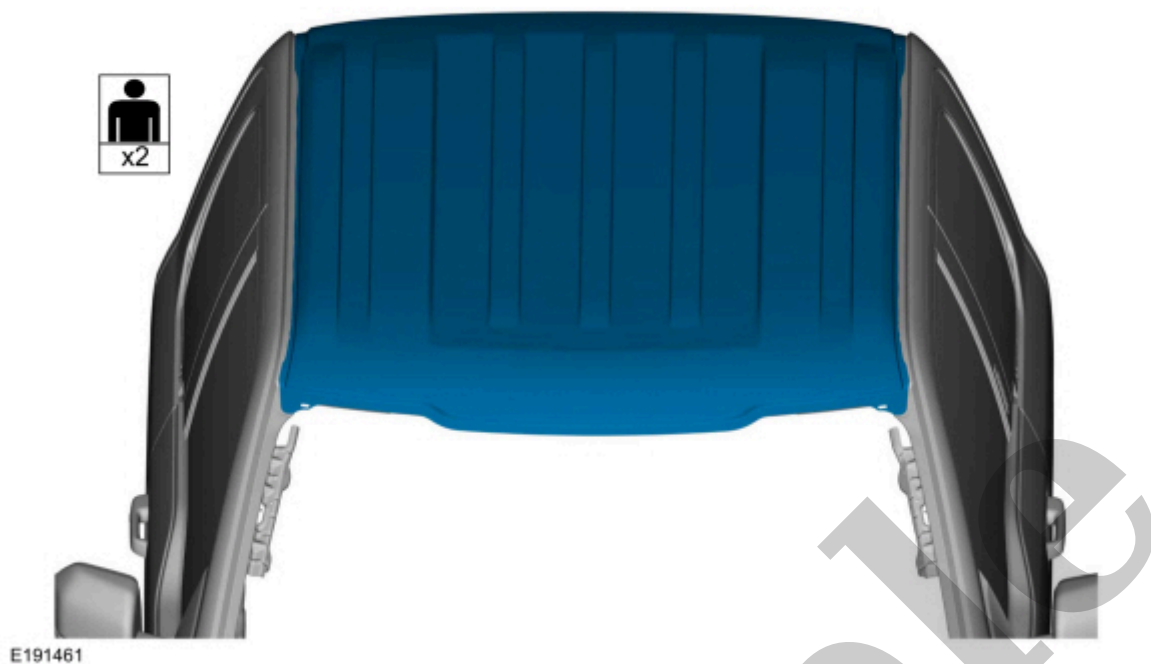
6. With the help of an assistant, remove the roof panel.



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7. Apply adhesive to the roof bows, front header, rear header and roof ditch area mating surfaces.



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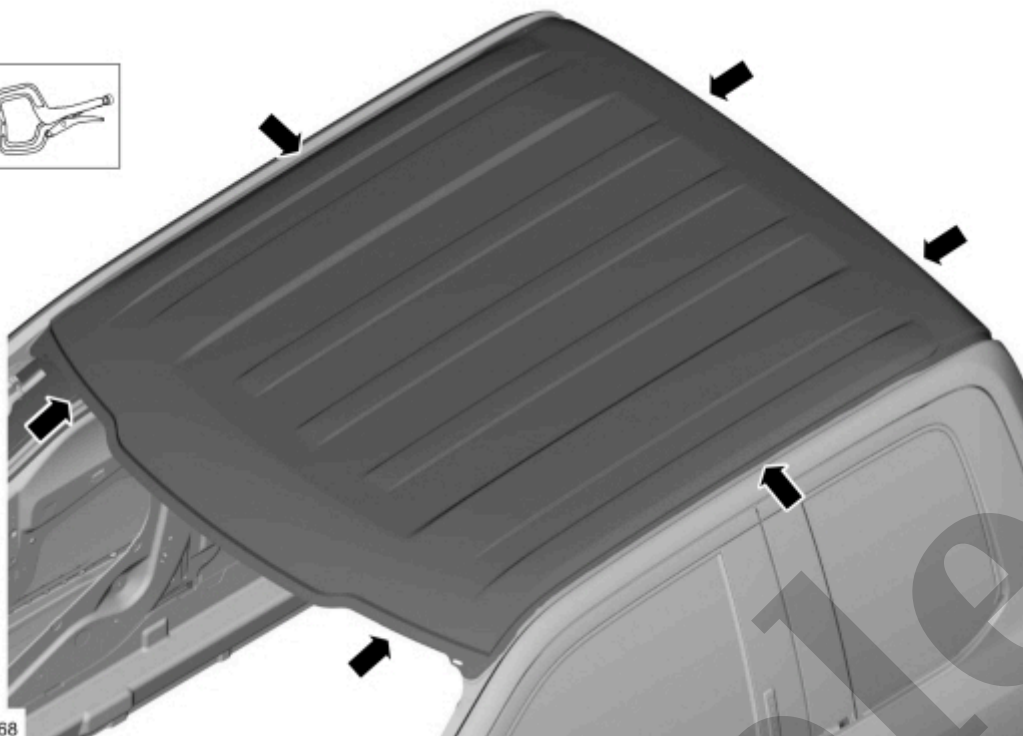
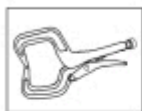
9. **NOTE**

Do not lift the roof panel to align to index marks. Slide the panel in position to reduce the possibility of breaking the adhesive bond.

**NOTE**

Check for full adhesive contact. Add additional adhesive to the roof bows if necessary.

Properly align the roof panel to the index marks.



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#### 11. 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) 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 rivets may be used in place of SPR (self-piercing rivet) 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



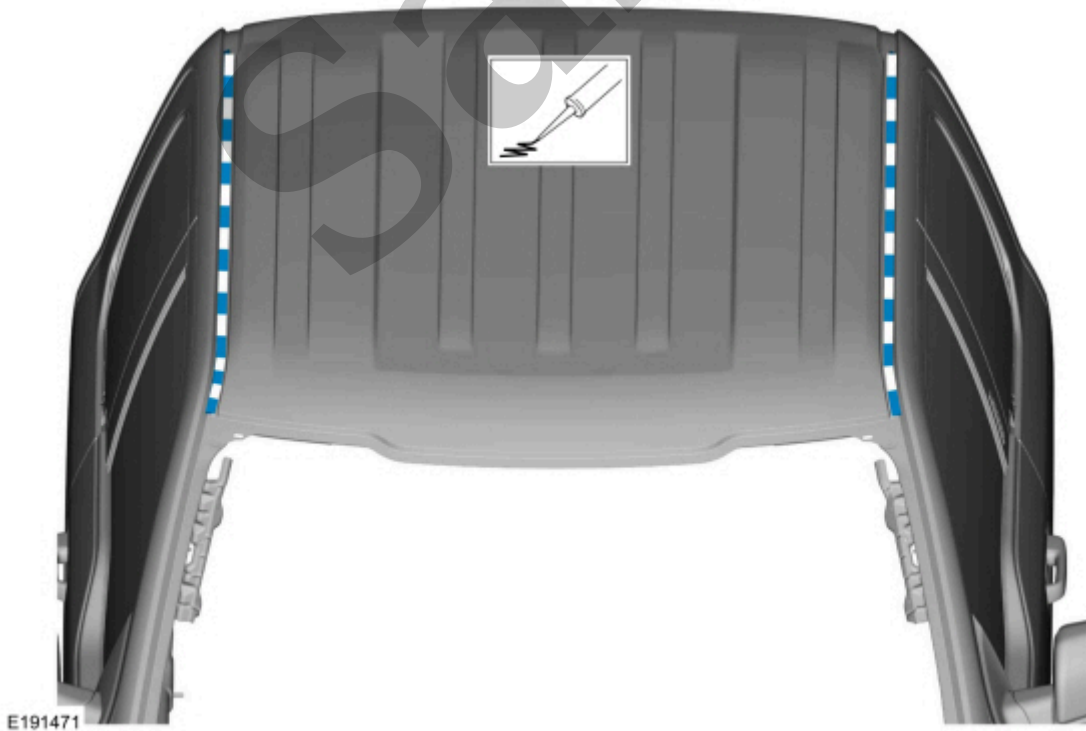
15. Mask off the front window glass channel.



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

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

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







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

20. Install the satellite radio antenna.

Refer to: [Satellite Radio / Global Positioning System \(GPS\) Antenna Cable - Vehicles With: 8 Inch Center Display Screen/12 Inch Center Display Screen](#)(415-00 Information and Entertainment System - General Information, Removal and Installation).

21. Install the windshield and rear window glass.

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

22. Install the roof mouldings.

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

23. Install the high mount stop lamp.

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

24. Install the side curtain airbags.

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

25. Install the headliner.

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



# Roof Panel - SuperCrew, Vehicles With: Roof Opening Panel

501-28 Roof Sheet Metal Repairs	2022 F-150
Removal and Installation	Procedure revision date: 10/8/2020

## Roof Panel - SuperCrew, Vehicles With: Roof Opening Panel

### 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.

#### 1. WARNING

Before beginning any service procedure in this manual, refer to health and safety warnings in section 100-00 General Information. Failure to follow this instruction may result in serious personal injury.

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