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2011 FORD F-150 Super Cab OEM Service and Repair Workshop Manual

[Go to manual page](#)

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

SuperCab #3 floor panel reinforcement shown. All reinforcements attach similarly.

2. Remove the floor panel or section in the repair area.

Refer to: [Floor Panel](#)(501-30 Rear End Sheet Metal Repairs, Removal and Installation).

Refer to: [Floor Panel Section](#)(501-30 Rear End Sheet Metal Repairs, Removal and Installation).

3. Remove the rocker panel inner reinforcement.

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

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

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

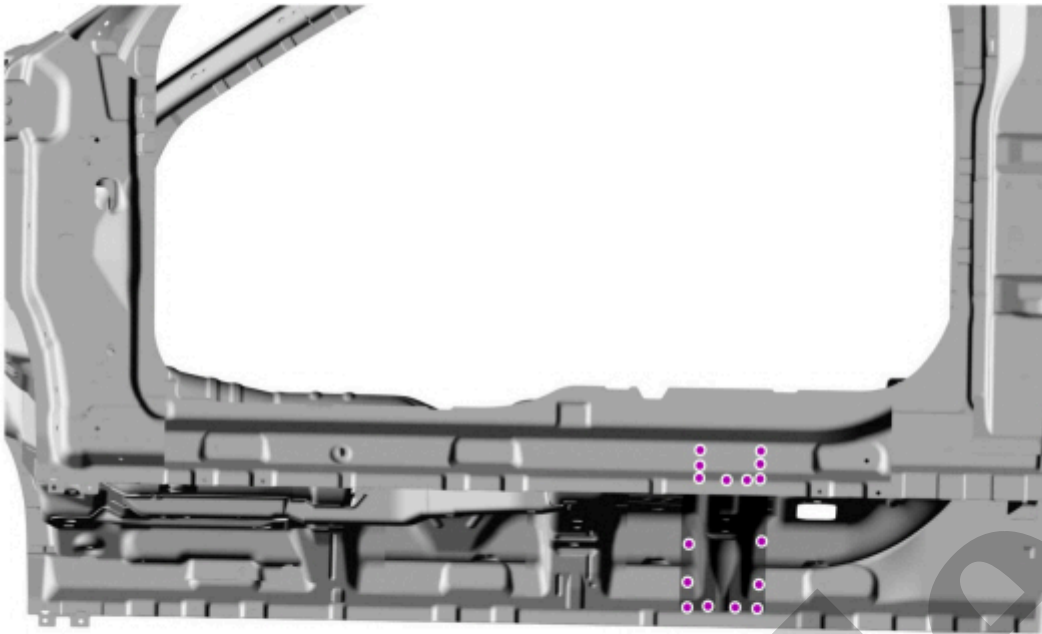
4. **NOTE**

Floor panel reinforcements may be sectioned providing sectioning does not take place within 50 mm of weld nut or component mounting points. The following procedure assumes full component replacement.

Determine if sectioning is possible and reasonable and adjust procedure accordingly.

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

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



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7. 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.

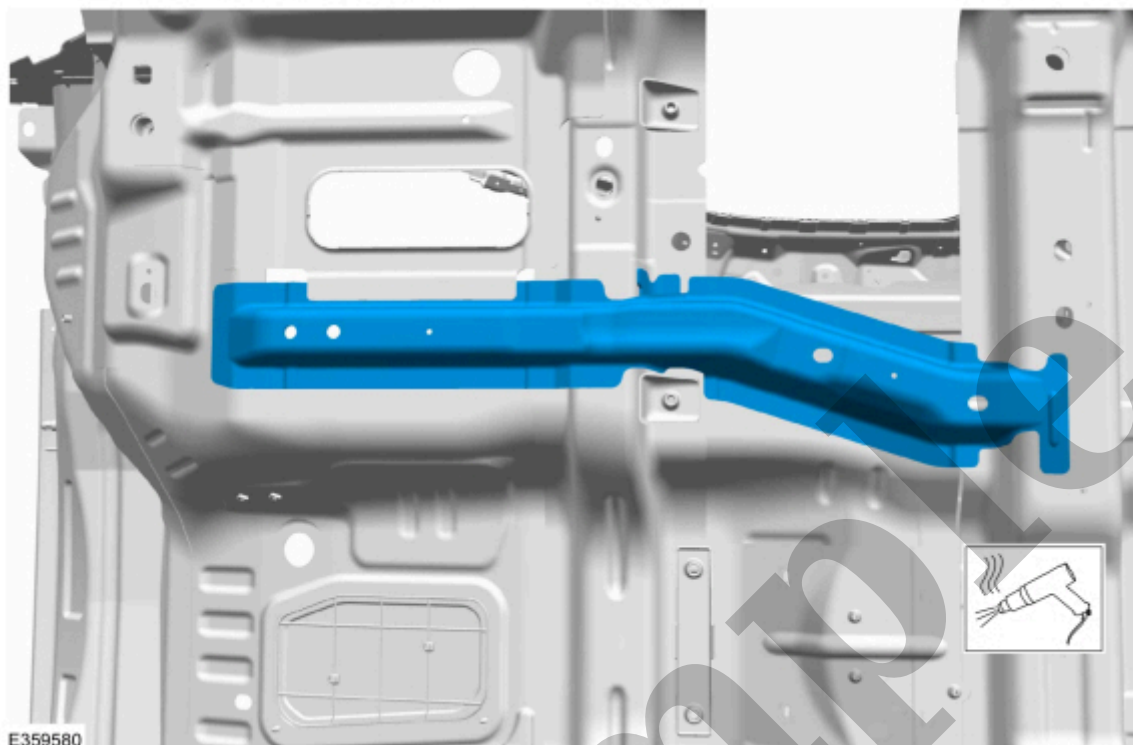
Break the adhesive bond and remove the floor panel reinforcement.

Use the General Equipment: Hot Air Gun

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

9. Break the adhesive bond and remove the floor panel reinforcement.

Use the General Equipment: Hot Air Gun



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Installation

NOTE

Floor panel reinforcements may be sectioned providing sectioning does not take place within 50 mm of weld nut or component mounting points. The following procedure assumes full component replacement.

1. 80-120 grit sand paper.

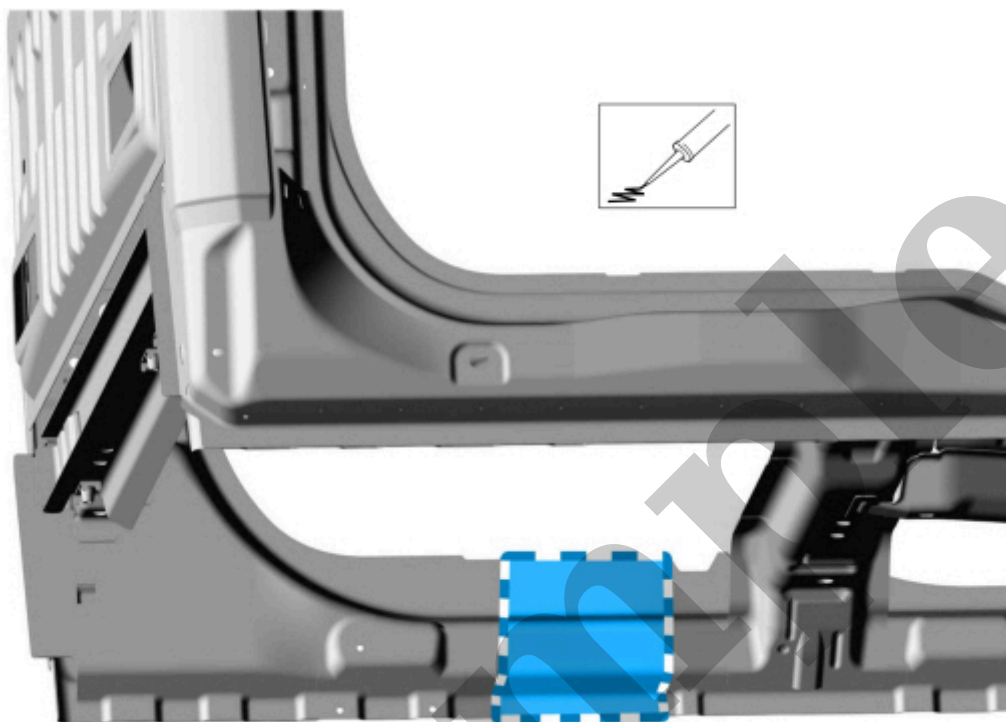
Sand to remove old adhesive and clean (both sides).

3. If sectioning:

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

4. Apply adhesive (both sides)

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



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5. Install the reinforcement and clamp in position.

Use the General Equipment: Locking Pliers

7. **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

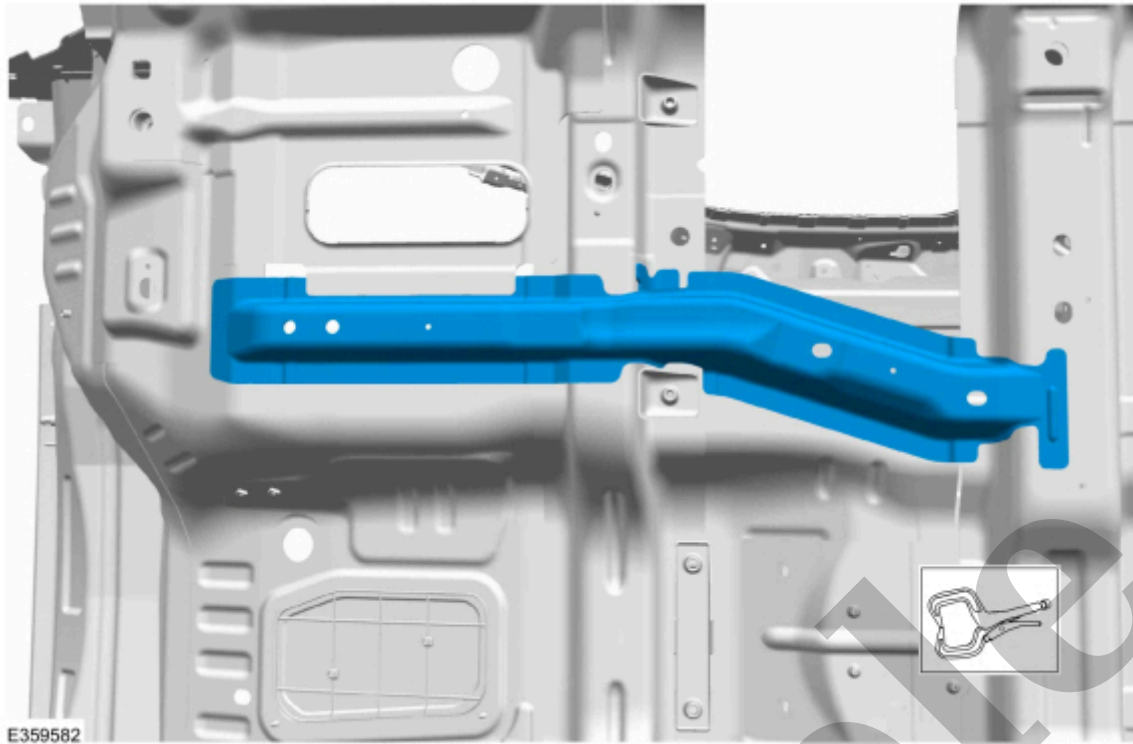
Blind rivet or solid rivet fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging holes to 6.5 mm.

Install fasteners (both sides).

| 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 | - | - | - | - | W708777-S900C | - | - |

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

Use the General Equipment: Blind Rivet Gun



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

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

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

Install fasteners (both sides).

| 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 | - | - | - | - | W708777-S900C | - | - |



Floor Panel Section

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

Floor Panel Section

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).

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).

4. If equipped:

Remove the console.

Refer to: [Floor Console](#)(501-12 Instrument Panel and Console, Removal and Installation).

5. Remove the C-pillar trim panel.

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

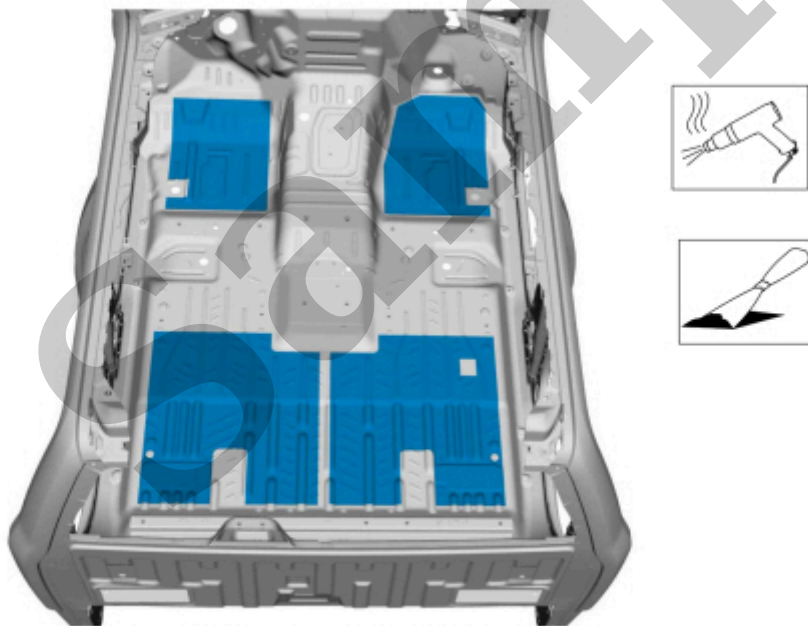
6. Remove the door opening weather strips and scuff plate.

7. Position the carpeting and wiring harnesses away from the work area.

8. Remove the NVH (noise, vibration and harshness) pads as necessary.

Use the General Equipment: Scraper for Straight Edges

Use the General Equipment: Hot Air Gun

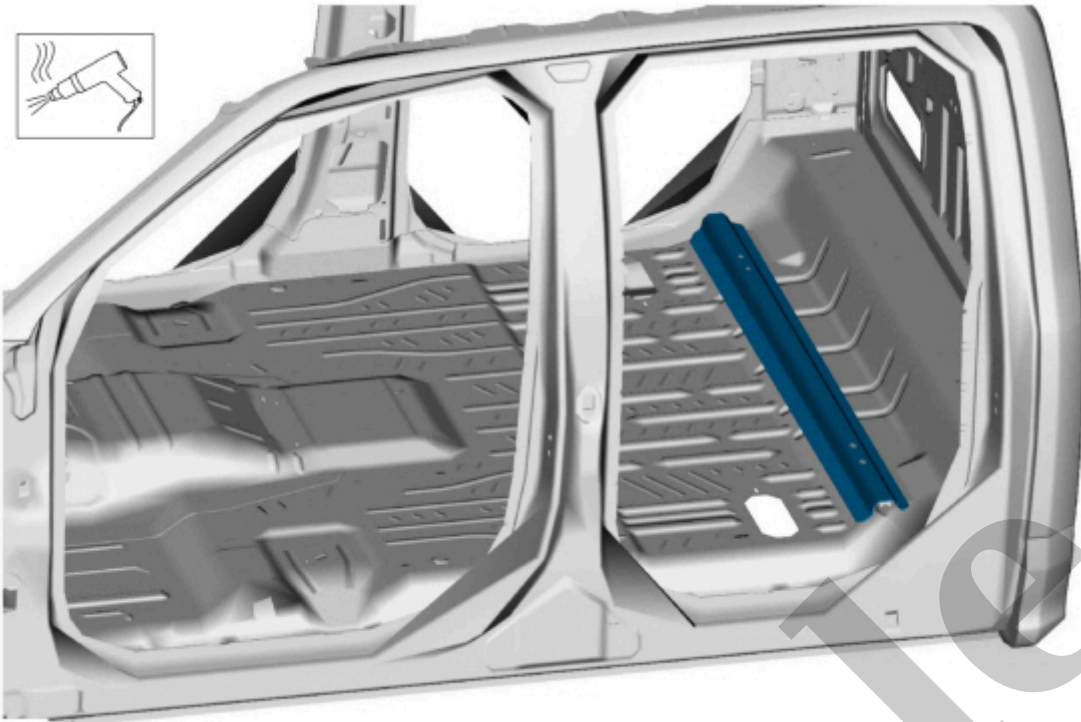


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9. **SuperCab and SuperCrew:**

Remove the SPR (self-piercing rivet) fasteners.



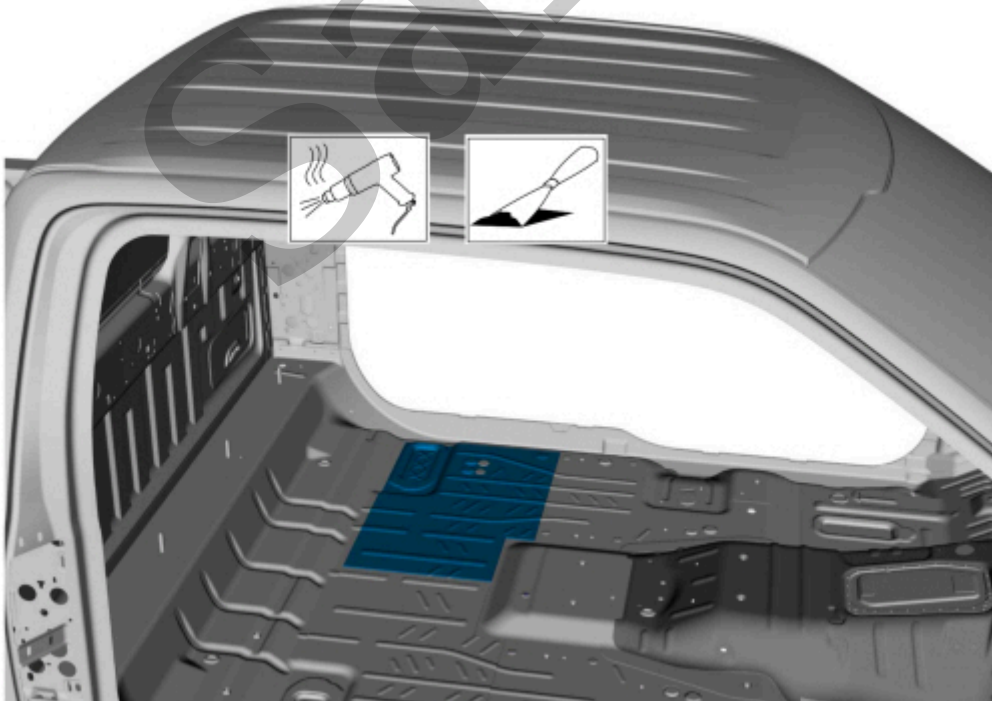
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11. Remove the NVH (noise, vibration and harshness) pad.

Use the General Equipment: Hot Air Gun

Use the General Equipment: Scraper for Straight Edges



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